




TD-106-1 Rev No. 5	Form No.	 <p style="text-align: center;">PRODUCT STANDARD PULVERISERS HYDERABAD</p>	Product STD NO.	BA75019
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<p><u>TDC FOR BOWL MILL PRESSURE SPRINGS</u></p> <p>1.0 <u>SCOPE:</u></p> <p>1.1 This specification deals with the Quality requirements and other technical delivery conditions for Hot formed helical compression springs meant for Bowl Mills.</p> <p>1.2 Any special requirement, not covered under this specification shall be indicated in the Design drawing or contract.</p> <p>1.3 This specification is generally based on BS 1726. Additional points have been taken from ASTM A 125. DIN 1652 has also been referred for certain clauses.</p> <p>2.0 <u>MATERIAL:</u></p> <p>2.1 The bars used for making helical springs shall conform to the specification mentioned in the drawing/ contract. Commonly used specifications for spring round are listed below unless specified in drawing.</p> <p style="padding-left: 40px;">a. LOW ALLOY ASTM A-322 GR. 4161 H.F QUENCHED AND TEMPERED TO 429 TO 477 BHN or AISI 1095 or equivalent grades EN 44, 44B, 44D- BS 970; IS 3195/ 1965 GR.C 98 and IRS M 24.</p> <p>2.2 The rounds shall be free from harmful defects like cracks, laps, pitting, piping etc.</p> <p>2.3 The Bars for pressure springs for Bowl Mills need peeling/ grinding.</p> <p>2.3.1 The peeling off or grinding shall be done to the extent that all seams or other surface defects are completely removed. The manufacturer should carry out MPI/ LPI on a few ground bars in each size to ensure that bulk being removed in grinding or peeling operation is sufficient to eliminate all surface defects.</p> <p>2.4 No substitution of material shall be done without written consent of BHEL.</p>				
<p>Revisions:</p> <p>Refer to record of revisions:</p>		<p>Prepared: S.Ghatge</p>	<p>Approved: J.G.Kulkarni</p>	<p>Date: 04.06.2003</p>

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<p style="text-align: center;">COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED, It must not be used directly or indirectly in any way detrimental to the interest of the company.</p>		<p>11.4 After protective coating has been applied, all the springs shall be stenciled (in white paint) with serial number and spring designation.</p> <p>11.5 Any additional identification by way of colour coding etc, if required by contractor, shall be adopted.</p> <p>12. <u>PACKING & DESPATCHING :</u></p> <p>The inner and outer coil of the springs shall be matched for length and the inner coil shall be placed inside the outer coil while dispatching. Both the springs shall be tied together with wire string to facilitate using as a matched set. A record showing the serial numbers of the matched set shall accompany the dispatch. The spring sets shall be properly packed to avoid transit damage.</p>			

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