

827954/2023/HEP-SWM20961



PRODUCT STANDARD

SWITCHGEAR ENGINEERING DIVISION

SG 12753 REV.00

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SPRING CLIP

1.0 INTRODUCTION

The spring clip to drg. No. 45211001552 is an important mechanical component of spring operating mechanism of vacuum circuit breaker products. It is used to provide sufficient spring action to pawl for timely latching with support roller during closing operation of breaker. VCB products have maintenance free mechanical life of 50,000 operations, hence the spring clip shall have performance characteristic matching this life.

2.0 MATERIALS

The spring clip is made out of half hard phosphor bronze strip as per IS7814 – 1985: Gr III, condition HB.

3.0 SUPPLY CONDITION OF MATERIAL

The spring clip to dimensions as per drg. No. 45211001552 –001 shall be supplied with natural finish and free of burrs.

4.0 NOTES FOR MANUFACTURING

The blank of spring clip to drg. No. 45211001605 shall be free from any cracks burrs on the edges or surface before bending. Bending is to be carried out without annealing for achieving final shape with desired dimensions.


5.0 ACCEPTANCE CRITERION

I. VISUAL CHECKS: There should not be any cracks, burrs on the edges or surfaces of the finished material.

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REV.	00	PRINTS TO: -		APPROVED –		
ALTD.		SWM (P) SWM (Testing) QCX Contacts Group Design Group		INDRA PAL		
APPD.				PREP	ISSUED	DATE
DATE.				RKM	RKK	02.06.2003

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		II. <u>SUPPLIER’S TEST CERTIFICATE:</u> Supplier shall send the test certificate of the material used meeting the specifications mentioned in para 2. Certificate of hardness (170 ±10 HV) & tensile strength (500 N/mm ² min) shall be sent along with dimensional report of samples from the lot.		
		III. <u>AT BHEL:</u> Hardness test is to be carried out on spring clip for LOT SIZE: 100, AQL: 4%, INSPECTION LEVEL: S2, INSPECTION: NORMAL.		
<div><div>COPYRIGHT AND CONFIDENTIAL</div><div>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 interest of Co.</div></div>		6.0 <u>IDENTIFICATION MARKINGS FOR TRACEABILITY</u>		
		Supplier identification mark is to be provided on the material as per drg. No. 45211001552.		
		7.0 <u>PACKING</u>		
		The material shall be suitably packed in order to avoid transit damage.		

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