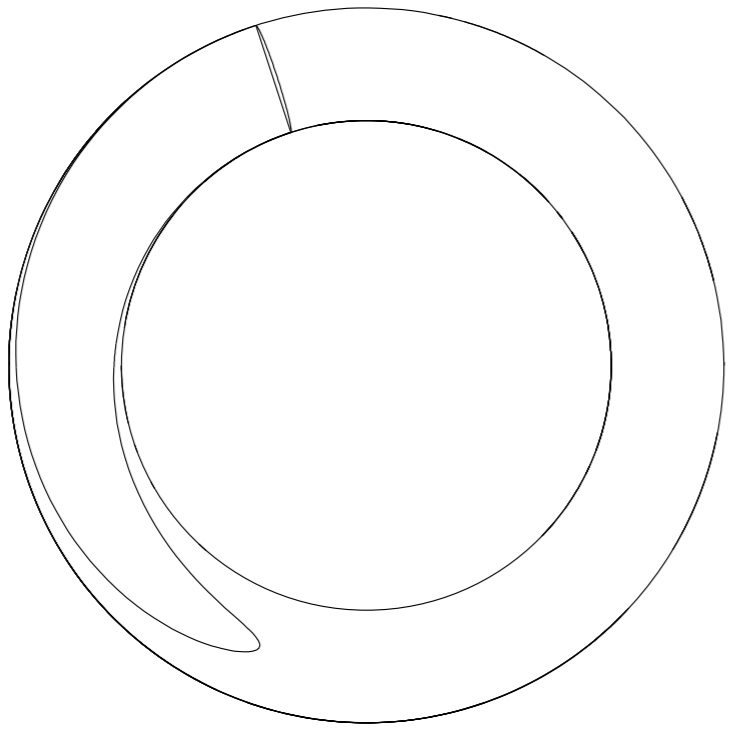


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
SYMBOL												
VALUE	0.025	0.05	0.1	0.2	0.4	0.6	0.8	1.0	1.25	1.6	2.0	2.5
ROUGHNESS												

A



SPECIFICATIONS

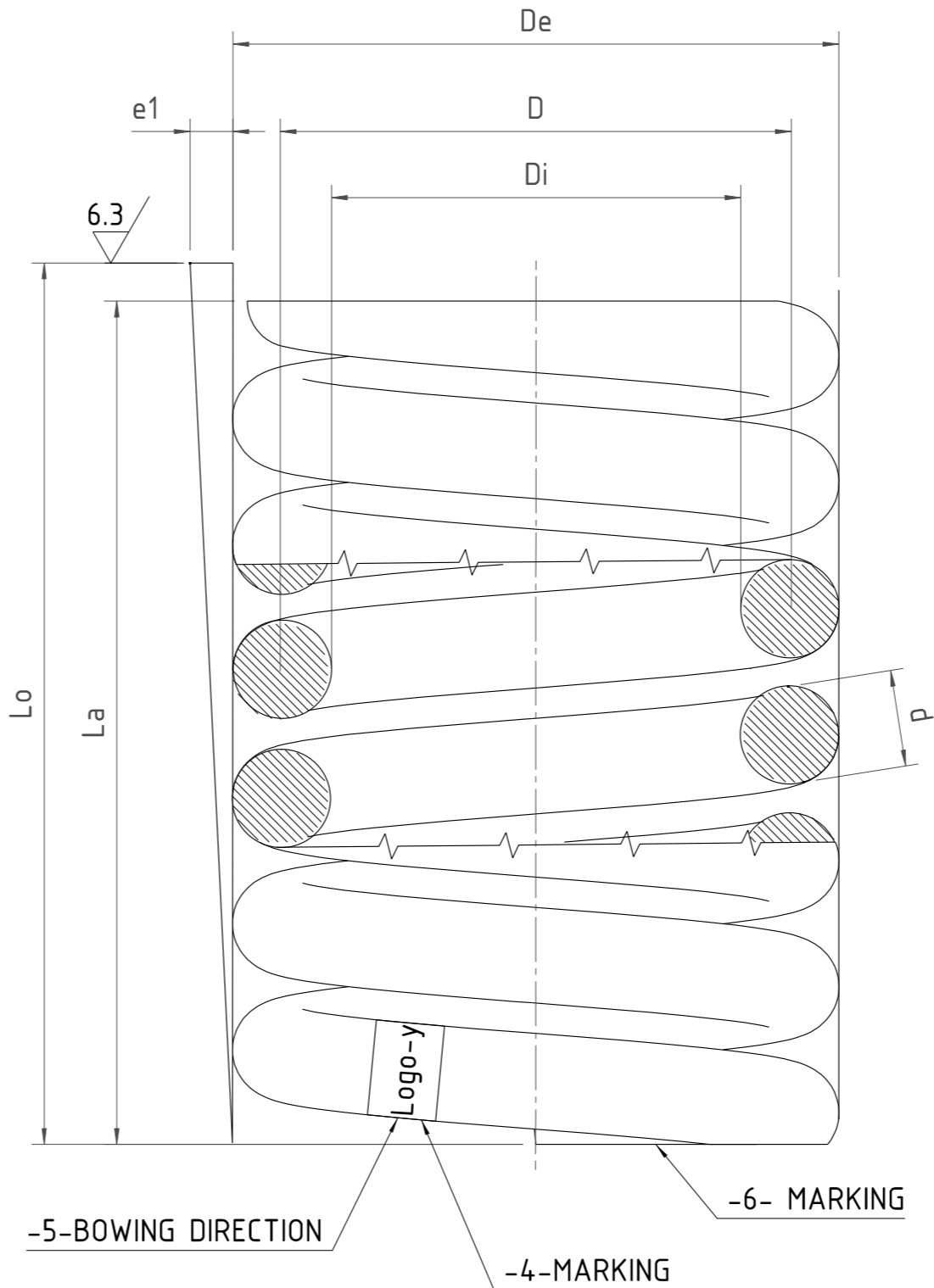
EN 13298 CATEGORY B

MANUFACTURING DATA

WIRE DIAMETER	d (mm)	31.5
MEAN DIAMETER	D (mm)	173
UNLOADED LENGTH	L ₀ (mm)	310
HEAT TREATMENT - HARDNESS		(45/51) HRC 426/507 HB
DIRECTION OF HELIX		RIGHT
ACCEPTANCE DATA OF THE SPRING		
PERPENDICULARITY OF SPRING	e1 (mm)	<4.7
LATERAL STIFFNESS AT F _A =AW0 [N]	(N/mm)	(266.7)±15%
AXIAL STIFFNESS BETWEEN "FU:FV"	Ks= $\frac{F_v - F_u}{L_u - L_v}$	(396)

SPECIFIC MANUFACTURING INSTRUCTIONS

1. THE SPRINGS TO BE ACC. TO "EN 13298 CATEGORY B".
2. ENDS OF THE SPRING TO BE CLOSED AND GROUND ACC. TO "ISO 2162-2 TAB 2.D".
3. SHOT PEENING 0.4/0.6 mm ALMEN A.
4. MARKING : HEIGHT OF SPRING SET L_A - NO SPRING SET - GROUP OF SPRING SET TO BE MARKED ON OUTER SPRING BY C_u LABEL. ON INNER SPRING NO. SPRING SET BY C_u LABEL
 - GROUP I = L (F_A) = 263.5/265.5 mm (for information only, will be finalized in detail design stage)
 - GROUP II = L (F_A) = 265.5/267.5 mm (for information only, will be finalized in detail design stage)
5. BOWING DIRECTION TO BE MEASURED AT F_{A0} (SEPERATE SPRING). MARKED BY WHITE PAINT STRIPE ON THE FIRST BOTTOM ACTIVE COIL.
6. MARKING : LOGO - YEAR/MONTH BT HOT STAMP ON INACTIVE COIL
7. ANTICORROSION PROTECTION : ROKOPOX MASTIC. RK301 NCS 8500N SEMI GLOSS. TOTAL THICKNESS MIN. = 80µm.



VIEW A

ISOMETRIC VIEW

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I/S	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF. DRG			
			MATERIAL	51CrV4 as per EN 10089		
			HEAT TREAT.	APPD	MS	
			SURFACE TREAT.	REVD	SSB	
			TITLE	CHKD	RSS	
				DRWN	VSE	
				SCALE	1:2	
				SHEET	1 OF 1	
				Wt.	18.4kg	
				DRG No.	525-81107	
				ALT	1	

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