PART NAME		PATROL INSPECTION SHEET														W	
PART NAIVIE	Main Spri	Main Spring		OPERATOR NAME				DATE			OPED	DATION COL		Helica Springs V			
PART NO.	F1GN01102O - XE		M/C NO.					SHIFT			OPERATION COI		LING Sprin		,		
S. NO Description	Specification	Insp. Method	OBSERVATION PER FOUR HOURS											JUDG.	REM		
Wire Dia.	3.20 ± 0.030	MM/DVC															
Coil OD	23.45 ± 0.10	DVC															
Coil OD-2 (OPEN SIDE END COIL)	22.60 ~ 22.80	DVC															
Taper Coil OD (CLOSED SIDE END COIL)	20.70 ~ 20.90	VC/Gauge															
NO. OF TOTAL COIL	33.1±0.25	COUNTING															
TOTAL CLOSE COIL	16 Ref	COUNTING															
DIRECTION OF WIND	RH	VISUAL															
FREE LENGTH	222.0 ± 2.0 mm	VC/LCG															
NO. OF TAPER COIL	2.0~3.0 TOWARDS CLOSER PITCH SIDE	VISUAL															
HEIGHT AT 16 TH COIL	89.0 ± 1.0 mm	DVC															
APPEARANCE	FREE FROM VISUAL DEFECTS	VISUAL															
ARIFIED BY Q.A. INCHARGE							Sign. Of Q.C. Inspector		1ST Observation		2nd Observation		3rd Observation		4th Observation		
	Wire Dia. Coil OD Coil OD-2 OPEN SIDE END COIL) Taper Coil OD CLOSED SIDE END COIL) NO. OF TOTAL COIL TOTAL CLOSE COIL DIRECTION OF WIND FREE LENGTH NO. OF TAPER COIL HEIGHT AT 16 TH COIL APPEARANCE ARIFIED BY Q.A. INCHARGE	Wire Dia. 3.20 ± 0.030 Coil OD 23.45 ± 0.10 Coil OD-2 OPEN SIDE END COIL) 22.60 ~ 22.80 Faper Coil OD CLOSED SIDE END COIL) 20.70 ~ 20.90 NO. OF TOTAL COIL 33.1±0.25 FOTAL CLOSE COIL 16 Ref DIRECTION OF WIND RH PREE LENGTH 222.0 ± 2.0 mm NO. OF TAPER COIL 2.0~3.0 TOWARDS CLOSER PITCH SIDE HEIGHT AT 16 TH COIL 89.0 ± 1.0 mm APPEARANCE FREE FROM VISUAL DEFECTS ARIFIED BY Q.A. INCHARGE	Wire Dia. 3.20 ± 0.030 MM/DVC Coil OD 23.45 ± 0.10 DVC Coil OD-2 OPEN SIDE END COIL) 22.60 ~ 22.80 DVC Faper Coil OD CLOSED SIDE END COIL) 20.70 ~ 20.90 VC/Gauge NO. OF TOTAL COIL 33.1±0.25 COUNTING FOTAL CLOSE COIL 16 Ref COUNTING DIRECTION OF WIND RH VISUAL FREE LENGTH 222.0 ± 2.0 mm VC/LCG NO. OF TAPER COIL 2.0~3.0 TOWARDS CLOSER PITCH SIDE VISUAL HEIGHT AT 16 TH COIL 89.0 ± 1.0 mm DVC APPEARANCE FREE FROM VISUAL DEFECTS VISUAL ARIFIED BY Q.A. INCHARGE PRODUCTION	Wire Dia. 3.20 ± 0.030 MM/DVC Coil OD 23.45 ± 0.10 DVC Coil OD-2 OPEN SIDE END COIL) 22.60 ~ 22.80 DVC Faper Coil OD CLOSED SIDE END COIL) 20.70 ~ 20.90 VC/Gauge NO. OF TOTAL COIL 33.1±0.25 COUNTING FOTAL CLOSE COIL 16 Ref COUNTING DIRECTION OF WIND RH VISUAL FREE LENGTH 222.0 ± 2.0 mm VC/LCG NO. OF TAPER COIL 2.0~3.0 TOWARDS CLOSER PITCH SIDE VISUAL HEIGHT AT 16 TH COIL 89.0 ± 1.0 mm DVC APPEARANCE FREE FROM VISUAL DEFECTS VISUAL ARIFIED BY Q.A. INCHARGE PRODUCTION QTY-	Wire Dia. 3.20 ± 0.030 MM/DVC Coil OD 23.45 ± 0.10 DVC Coil OD-2 OPEN SIDE END COIL) 22.60 ~ 22.80 DVC Faper Coil OD CLOSED SIDE END COIL) 20.70 ~ 20.90 VC/Gauge NO. OF TOTAL COIL 33.1±0.25 COUNTING FOTAL CLOSE COIL 16 Ref COUNTING DIRECTION OF WIND RH VISUAL FREE LENGTH 222.0 ± 2.0 mm VC/LCG NO. OF TAPER COIL 2.0~3.0 TOWARDS CLOSER PITCH SIDE VISUAL HEIGHT AT 16 TH COIL 89.0 ± 1.0 mm DVC APPEARANCE FREE FROM VISUAL DEFECTS VISUAL ARIFIED BY Q.A. INCHARGE PRODUCTION QTY REJECTION QTY- REJECTION QTY-	Mire Dia. 3.20 ± 0.030 MM/DVC	Wire Dia. 3.20 ± 0.030 MM/DVC Coil OD 23.45 ± 0.10 DVC Coil OD-2 OPEN SIDE END COIL) 22.60 ~ 22.80 DVC Faper Coil OD CLOSED SIDE END COIL) 20.70 ~ 20.90 VC/Gauge NO. OF TOTAL COIL 33.1±0.25 COUNTING TOTAL CLOSE COIL 16 Ref COUNTING DIRECTION OF WIND RH VISUAL PREE LENGTH 222.0 ± 2.0 mm VC/LCG NO. OF TAPER COIL 2.0-3.0 TOWARDS CLOSER PITCH SIDE VISUAL HEIGHT AT 16 TH COIL 89.0 ± 1.0 mm DVC APPEARANCE FREE FROM VISUAL DEFECTS VISUAL ARIFIED BY Q.A. INCHARGE PRODUCTION QTY-REJECTION QTY-REJE	Wite Dia. 3.20 ± 0.030 MM/DVC	Wire Dia. 3.20 ± 0.030 MM/DVC Coil OD 23.45 ± 0.10 DVC <	Wire Dia. 3.20 ± 0.030 MM/DVC	Wire Dia. 3.20 ± 0.030 MM/DVC	Mire Dia. 3.20 ± 0.030 MM/DVC	Wire Dia. 3.20 ± 0.030 MM/DVC	Mire Dia. 3.20 ± 0.030 MM/DVC	Mire Dia. 3.20 ± 0.030 MM/DVC	Mire Dia. 3.20 ± 0.030 MM/DVC	