



SURFACE FINISH- OILING													
Surface Finish- Oiling	80	Proper rust preventive oil on part	Nox Rust Gr- 823 (Daubert)	Operator	Visual	100%	---						
FINAL INSPECTION/ PDI													
Final Inspection	90	Wire Dia	ø 3.40 ± 0.03	Inspector	MM	5 Pcs per lot	HS06QFO09						
		Inside Dia. D1	ø 11.3 +0.3/-0.0	Inspector	VC/ Pin Gauge	5 Pcs per lot	HS06QFO09						
		Inside Dia. D2	ø 11.3 +0.3/-0.0	Inspector	VC/ Pin Gauge	5 Pcs per lot	HS06QFO09						
		Coil OD	ø 18.60 Max.	Inspector	VC	5 Pcs per lot	HS06QFO09						
		Free length	17.7 ± 0.5	Inspector	VC	5 Pcs per lot	HS06QFO09						
		Squareness e1	0.50 mm Max.	Inspector	RA & FG	5 Pcs per lot	HS06QFO09						
		Parallelism e2	0.40mm MAX.	Inspector	Dial	5 Pcs per lot	HS06QFO09						
		Solid Height	14.3mm Max.	Inspector	LTM	5 Pcs per lot	HS06QFO09						
		No. of Active Coils	2.2 Ref.	Inspector	Visual Count.	5 Pcs per lot	HS06QFO09						
		No. of Total Coils	4.2 Ref.	Inspector	Visual Count.	5 Pcs per lot	HS06QFO09						
		Direction of winding	RH	Inspector	Visual	5 Pcs per lot	HS06QFO09						
		Load at 2.0 mm def.	39.3 Kg ± 7%	Inspector	LTM	5 Pcs per lot	HS06QFO09						
		Load at 3.3 mm def.	64.9 Kg ± 7%	Inspector	LTM	5 Pcs per lot	HS06QFO09						
		Spring Rate	19.67 Kgf/mm	Inspector	LTM	5 Pcs per lot	HS06QFO09						
		Scragging Height	15 mm	Inspector	LTM	5 Pcs per lot	HS06QFO09						
		Tip Thickness	0.85-1.13	Inspector	VC	5 Pcs per lot	HS06QFO09						
		End Condition	Square & Ground (270° Min)	Inspector	Visual	5 Pcs per lot	HS06QFO09						
Shot Peening	90% Coverage	Inspector	Visual	5 Pcs per lot	HS06QFO09								
Surface Finish	Oiled	Inspector	Visual	5 Pcs per lot	HS06QFO09								
Material	Grade-DH as per IS 4454 part1	Inspector	RMTC	5 Pcs per lot	HS06QFO09								
PACKING & DISPATCH													
Packing & Dispatch	100 & 110	Qty. per bin	2000 Nos	Operator	Counting	Every lot	--						
		No damage during transport	Packing as per WI	Operator	Visual	Every lot	--						

