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Inspection No: 41551
Inspection Type: Operation Inspection

Check No: 1 / 20

Drawing Number: Part Number: BINNS7900-15SS Issue Number: Employee: Part Description: STST CONICAL FOR F 12 (V2)	Operation No: 40 Customer: S2143 Works Order No: 32966.00 Inspector: 030 Date: 01/05/2019	Material Spec: EN 10270-3 (X10CRNi18-8) Batch No: SD265069
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Grid Ref	Characteristic	Expected Value	Tolerance	Measured Value	Remarks
	WIRE SIZE	0.315 mm	+/- 0.008 mm	0.315 mm	
	OUTSIDE DIAMETER LARGE END	7.80 mm	+/- 0.15 mm	7.75 mm	
	INSIDE DIAMETER SMALL END	3.30 mm	+/- 0.15 mm	3.40 mm	
	FITS OVER 3.00mm	Yes	+/-	Yes	
	TOTAL TURNS	6.00	+/- 0.10	6.10	
	FREE LENGTH BEFORE LOAD TEST	15.00 mm	+ 0.50 mm - 0.00 mm	15.42 mm	
	SOLID LENGTH	0.000 mm	+/- 0.315 mm	0.315 mm	
	SPRING MUST GO FLAT WITHOUT COILS CATCHING	Yes	+/-	Yes	
	RATE AFTER LOAD OF 106N APPLIED	0.123 N/mm	+/- 0.005 N/mm	0.120 N/mm	
	LOAD AT 12.00mm AFTER LOAD OF 106N APPLIED	0.360 N	+/- 0.069 N	0.310 N	
	LOAD AT 5.20mm AFTER LOAD OF 106N APPLIED	1.200 N	+/- 0.085 N	1.120 N	
	CONICAL SPRING WITH TELESCOPING ENDS	Yes	+/-	Yes	
	FINISH PLAIN	Yes	+/-	Yes	