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11.31.2010 Cylindrical helical springs made of round wire – Quality specifications for cold coiled compression springs English version of DIN EN 15800:2009-03 The purpose of the DIN EN 15800 is to establish minimum requirements for the quality of cylindrical helical springs made of round wire with a diameter in the range of 0.40 to 0.64 mm and a length of minimum 0.6 m for applications in compression. The following basic requirements are defined for the quality of helical springs: 1. The helical spring shall be manufactured from round wire at a material temperature not exceeding 15 degrees Celsius in the manufacturing process. The wire is spun to the required diameter and wrapped into a helix, followed by punching. 2. In the course of its winding process, the spring shall be cooled to a temperature of not less than 15 degrees Celsius in the best possible manner. 3. The quality of the spring shall be checked immediately after it is finished, i.e. the spring shall be tested without contact to metal parts. 4. Each helical spring shall be tested in a borehole with a pressure of 20 kPa and the spring shall not yield. 5. If a spring yields, it shall be removed from the installation. 6. No knot shall be present at the top of the spring. 7. The helical spring shall be checked after each winding in order to verify that no wire breakage has occurred during the winding process. 8. The helical spring shall be free of any stress and shall not be damaged due to excessive length. 9. The springs shall be free of plastic deformation. 10. The helical spring shall be glued to the metal cap, to the metal jacket or to the plastic holder with a peel strength of not less than 5 kN in the standard test situation. 11. The helical spring shall withstand during operation at the rated load pressure of not less than 200 kPa an axial pressure of not less than 500 kPa. 12. The helical spring shall withstand the pullout force of not less than 6 kN with a cross section of a minimum of 15 mm<sup>2</sup> in the standard test situation. The helical spring shall have a minimum number of breaks and be free of bending. 15. The helical spring shall have a minimum modulus of elasticity of 82157476af

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