




VENKATESWARA STEELS & SPRINGS <small>An ISO 9001:2015 Certified Company</small>				MANUFACTURING FEASIBILITY REVIEW (MFR)							NPD/DI/R/02	
SUPPLIER		VENKATESWARA STEELS & SPRING PVT.LTD		PART NO. / ISSUE NO.		29328249 / 04		PROJECT		DATE		
CUSTOMER		BIPL		PART NAME :		SPRING V		PRODUCT		12.07.2021		
S NO.	GRID REF. / NOTES	PFD	PARAMETERS AS PER DRAWING	SPECIFICATION AS PER DRG WITH TOLERANCE	SC/CC, FFF, Past trouble & TGW	SUPPLIER INSPECTION METHOD		FEASIBILITY CONFIRMATION (If not feasible mention change required with reason for change)	CPK CMK	REMARKS		
		CON.IN.PRO.SEQ.NO				@ INITIAL SAMPLE LAYOUT INSPECTION	@ MASS PRODUCTION					
1	E2		MATERIAL	SUS 304 -WPB		Supplier TC	Supplier TC	OK				
2	E2		Wire Dia	Ø 1.40 mm		Micrometer	Micrometer	1.4± 0.015mm				
3	A4		Dimension "a"	40 mm ref		Profile Projector	Profile Projector	OK				
4	A4		Radius	R 70-90 mm		Profile Projector	Profile Projector	77.50mm Set condition R 60 / 80 Required to achive load F1.				
5	B4		Dimension	3 ± 0.5 mm		Profile Projector	Profile Projector	3 + 1.5 / - 0.5 mm (to avoid the missing operation)				
6	B4		Radius	R 1.5 -2.5 mm		Profile Projector	Profile Projector	OK				
7	B4		Radius	R 2.5-3.5mm		Profile Projector	Profile Projector	OK				
8	A6		Radius	R 3 mm		Profile Projector	Profile Projector	R 5±1.0 Required				
9	A7		Radius	R 1.2 mm		Profile Projector	Profile Projector	R 1.5 ± 0.5 req (to avoid the crack)				
10	A7		Radius	R 1.2 mm		Profile Projector	Profile Projector	R 1.5 ± 0.5 req (to avoid the crack)				
11	B7		Angle	88°- 92°		Profile Projector	Profile Projector	90° ± 3° req				
12	B6		Dimension	2.7 ± 0.5 mm		Profile Projector	Profile Projector	OK				
13	B6		Dimension	2.2 + 0.5 / -0.1 mm		Profile Projector	Profile Projector	OK				
14	B6		Dimension	3.50 ± 0.5 mm		Profile Projector	Profile Projector	OK				
15	B6		Dimension	6.5 - 7.5 mm		Profile Projector	Profile Projector	OK				
16	A6		Dimension	1.7-2.7 mm		Profile Projector	Profile Projector	OK				
17	C4		Dimension	2.7-3.5 mm		Profile Projector	Profile Projector	2.0/3.5 mm Required				
18	D3		Dimension	10.40 (Ref)		Profile Projector	Profile Projector	OK				

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19	C4		Dimension	10.60 ±1.0 mm		Profile Projector	Profile Projector	OK		
20	D3		Free length X	NA		0	-	-		
21	E3		Free length Y	NA		Digital vernier	Digital Vernier	Ref. (To achieve Load)		
22	E4		Measuring Condiation Lm - 65.4 mm	F1 - 7 ± 1 N		Load Test Machine	Load Test Machine	F 11.00 N Ref Réquired (Significant Character to be removed)		
23	E5		Installed Condiation L1- 59.40 mm	F2 - 12 ± 1.5 N		Load Test Machine	Load Test Machine	OK		
24	E6		Wornout Condiation L2 - 36.20 mm	F3 - 14 ±3 N		Load Test Machine	Load Test Machine	14.00 N Ref Required (Significant Character to be removed)		
25	N1		All Dimensions in mm and Unlimited dimensions are for reference only.	-		-	-	OK		
26	N2		This drawing continues line indicate dimension when deflected to load measuring as per table.	-		-	-	OK		
27	N3		Heat Treatment	To be stress releived after forming		HT Ledger	HT Ledger	VSS to be followed 370°C / 30 mins based to the (29327714)		
28	N4		Unspecfied Tolerance 6 Max Dim - ± 0.50 mm Over 6 mm - ± 1 .0 mm	-		-	-	OK		
29	N5		Spring Load Measuring method shall confirm to TD 3 - 40 - 76.	-		-	-	OK		
30	N6		For signifciant & Critical characteristics TS C_045_BRK_3_002_289_EN to be followed	-		-	-	OK		

 VENKATESWARA STEELS & SPRINGS <small>AN EYE FOR DESIGN...</small>				MANUFACTURING FEASIBILITY REVIEW (MFR)						NPD/DI/R/02	
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31	N7		No crack etc shall be allowed in each bent portion	-		-	-	OK			
32	D4		Radius	R		Profile Projector	Profile Projector	OK			
33	F5		Finish	NA		-	-	OK			
REMARKS											
CUSTOMER SPECIFIC REQUIREMENTS											
DEPARTMENT		DIRECTOR/ TECHNICAL									
NAME		DHANAPAL L									
SIGN											
DATE											