

Contents

	page
Foreword.....	5
Introduction	6
1 Scope	6
2 Normative references	6
3 Terms, definitions and symbols	8
3.1 Terms and definitions.....	8
3.2 Symbols	9
4 Dimensions, characteristics, designation.....	10
4.1 General.....	10
4.2 Complete spring, form A.....	10
4.2.1 Double spring, form A.....	10
4.2.2 Example of designation.....	16
4.2.3 Materials.....	16
4.3 Complete spring, type B.....	17
4.3.1 Single spring, type B.....	17
4.3.2 Example of designation.....	21
4.3.3 Materials.....	22
5 Individual parts.....	22
5.1 General.....	22
5.2 Spring buckle, type A.....	23
5.3 Spring buckle, type B.....	24
5.4 Pad and compensating pad	25
5.5 Gib-head key.....	26
5.6 Taper key	27
6 Requirements to be defined by the customer.....	27
6.1 Operating conditions.....	27
6.2 Geometrical requirements	28
6.2.1 The design and characteristic curve	28
6.2.2 Space requirement.....	28
6.2.3 Spring buckle height of the spring ready for installation.....	28
6.2.4 Centre distance of the eyes	28
6.3 Mechanical requirements.....	28
6.3.1 Axle load	28
6.3.2 Specific compliance	28
6.3.3 Service life	28
7 Product specification	28
7.1 Technical specification	28
7.1.1 Material cross-section	28
7.1.2 Number of spring leaves.....	29
7.1.3 Rectangularity of the spring eyes	29
7.2 Material.....	29
7.2.1 General.....	29
7.2.2 Chemical composition.....	29
7.2.3 Inclusion cleanliness	29
7.3 Mechanical properties	29
7.3.1 General.....	29
7.3.2 Hardness.....	29
7.3.3 Toughness	29
7.3.4 Compressive stresses in the surface	29

7.4	Physical requirements.....	30
7.4.1	Surface finish	30
7.4.2	Decarburization.....	30
7.4.3	Generation of inherent compressive stresses in the surface.....	30
7.4.4	Grain size	30
7.5	Other	30
7.5.1	Surface protection	30
7.5.2	Handling information.....	31
7.5.3	Marking of spring buckle	31
8	Test methods.....	31
8.1	Requirements	31
8.1.1	General requirements.....	31
8.1.2	Measuring device.....	31
8.2	Requirements for spring test under load	31
8.2.1	Requirements	31
8.2.2	Bend test under test load	32
8.2.3	Testing of specific compliance	32
8.2.4	Testing the spring characteristic	35
8.3	Resistance to slipping of the spring leaves.....	37
8.3.1	Displacement resistance test 1	37
8.3.2	Displacement resistance test 2	38
8.4	Methods of test and taking of samples for general and binding requirements	38
8.4.1	Surface defects	38
8.4.2	Compressive stresses on the surface.....	38
8.4.3	Depth of decarburization	38
8.4.4	Tensile strength	39
8.4.5	Hardness test	40
8.4.6	Impact strength on U-notch test pieces	40
8.4.7	Chemical composition.....	40
8.5	Testing of the spring buckle.....	40
8.5.1	Hardness test	40
8.5.2	Bending test on the spring buckle.....	40
8.5.3	Expanding test piece on the spring buckle	40
8.6	Testing and design of the spring eye	40
9	Product quality and final inspection.....	41
9.1	General.....	41
9.2	Control and monitoring of production quality	41
9.2.1	General.....	41
9.2.2	Quality assurance plan	42
9.2.3	Batch control	42
9.3	Requirements for the final inspection	42
9.3.1	General.....	42
9.3.2	Documentation.....	44
9.4	Nonconformity	44
10	Marking of the spring buckle	45
11	Packaging	45
Annex A (normative)	Materials for hot formed and treated parabolic springs	46
A.1	General.....	46
A.2	Material for parabolic springs, steel	46
Annex B (normative)	Magnetic particle testing on spring leaves	47
B.1	General.....	47
B.2	Method for detecting defects.....	47
B.2.1	Principle.....	47
B.2.2	Tests.....	48
Annex C (normative)	Testing the efficiency of the shot peening by the ALMEN method	50
C.1	Field of application	50
C.2	Testing of the method	50
C.3	Device and installation.....	50

C.3.1	ALMEN A2 sensor	50
C.3.2	Specimen holder	51
C.3.3	ALMEN measuring apparatus	51
Annex D	(normative) Testing for inclusions	53
D.1	Object	53
Bibliography		54
Foreword		
1	Scope	
2	Normative references	
3	Terms, definitions, symbols	
4	General requirements	
5	Test methods	
6	Test results	
7	Marking of spring buckle	
8	Handling information	
9	Test methods	
10	General requirements	
11	Measuring device	
12	Requirements for spring test under load	
13	Requirements	
14	Bend test under load	
15	Testing of specific compliance	
16	Testing the spring characteristic	
17	Resistance to slipping of the spring leaves	
18	Displacement resistance test	
19	Methods of test and taking of samples for general and bending requirements	
20	Surface defects	
21	Compressive stresses on the work	
22	Depth of decarburization	
23	Tensile strength	
24	Hardness test	
25	Impact strength on U-notch test piece	
26	Chemical composition	
27	Testing of the spring buckle	
28	Hardness test	
29	Bending test on the spring buckle	
30	Expanding test piece on the spring buckle	
31	Testing and design of the spring	
32	Product quality and final inspection	
33	General	
34	Control and monitoring of production quality	
35	General	
36	Quality assurance plan	
37	Batch control	
38	Requirements for the final inspection	
39	General	
40	Documentation	
41	Marking of the spring buckle	
42	Packaging	
43	Annex A (normative) Materials for hot forming and cold forming	
44	General	
45	Material for parabolic springs	
46	Material for parabolic springs	
47	Material for parabolic springs	
48	Material for parabolic springs	
49	Material for parabolic springs	
50	Material for parabolic springs	
51	Material for parabolic springs	
52	Material for parabolic springs	
53	Material for parabolic springs	
54	Material for parabolic springs	
55	Material for parabolic springs	
56	Material for parabolic springs	
57	Material for parabolic springs	
58	Material for parabolic springs	
59	Material for parabolic springs	
60	Material for parabolic springs	
61	Material for parabolic springs	
62	Material for parabolic springs	
63	Material for parabolic springs	
64	Material for parabolic springs	
65	Material for parabolic springs	
66	Material for parabolic springs	
67	Material for parabolic springs	
68	Material for parabolic springs	
69	Material for parabolic springs	
70	Material for parabolic springs	
71	Material for parabolic springs	
72	Material for parabolic springs	
73	Material for parabolic springs	
74	Material for parabolic springs	
75	Material for parabolic springs	
76	Material for parabolic springs	
77	Material for parabolic springs	
78	Material for parabolic springs	
79	Material for parabolic springs	
80	Material for parabolic springs	
81	Material for parabolic springs	
82	Material for parabolic springs	
83	Material for parabolic springs	
84	Material for parabolic springs	
85	Material for parabolic springs	
86	Material for parabolic springs	
87	Material for parabolic springs	
88	Material for parabolic springs	
89	Material for parabolic springs	
90	Material for parabolic springs	
91	Material for parabolic springs	
92	Material for parabolic springs	
93	Material for parabolic springs	
94	Material for parabolic springs	
95	Material for parabolic springs	
96	Material for parabolic springs	
97	Material for parabolic springs	
98	Material for parabolic springs	
99	Material for parabolic springs	
100	Material for parabolic springs	