



## Standard Specification for Steel Springs, Helical, Heat-Treated<sup>1</sup>

This standard is issued under the fixed designation A 125; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

$\epsilon^1$  NOTE—Paragraph 4.4.1 was added and the year date changed in January 1996.

### 1. Scope

1.1 This specification covers hot-coiled, heat-treated helical compression springs with tapered, closed, squared and ground ends made of hot-wrought round steel bars  $\frac{3}{8}$  in. (9.5 mm) and larger in diameter.

1.2 This specification also serves to inform the user of practical manufacturing limits, mechanical tests, and inspection requirements applicable to the type of spring described in 1.1.

1.3 Supplementary Requirements S1 to S8 inclusive of an optional nature are provided. They shall apply only when specified by the purchaser. Details of these supplementary requirements shall be agreed upon by the manufacturer and purchaser.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only).

### 2. Referenced Documents

#### 2.1 ASTM Standards:

- A 29/A 29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought and Cold-Finished, General Requirements for<sup>2</sup>
- A 689 Specification for Carbon and Alloy Steel Bars for Springs<sup>2</sup>
- E 10 Test Method for Brinell Hardness of Metallic Materials<sup>3</sup>
- E 112 Test Methods for Determining Average Grain Size<sup>3</sup>
- E 709 Guide for Magnetic Particle Examination<sup>4</sup>

### 3. Ordering Information

3.1 Orders for springs under this specification shall include the following information:

- 3.1.1 Quantity,
- 3.1.2 Name of material,

3.1.3 A drawing or list showing required dimensions and loads, and part number,

3.1.4 Packaging, marking and loading, and

3.1.5 End use.

NOTE 1—A typical ordering description is: 500 springs Drawing 3303 Rev. A. to ASTM A 125, 1095 steel, for cyclical machine operation. Palletize, maximum weight 4000 lb.

### 4. Materials and Manufacture

#### 4.1 Material:

4.1.1 Unless otherwise specified, the springs shall be made of carbon steel bars conforming to the requirements of Specification A 689. Due to hardenability limitations of carbon steel, it is suggested that the bar diameter be limited to  $1\frac{5}{8}$  in. (41.8 mm) max in order to withstand the maximum test stress requirements of this specification.

4.1.2 If alloy steel is specified, the springs shall be made from alloy steel bars conforming to Specification A 689. Any of the alloy steel grades referred to may be used at the option of the spring manufacturer, providing that a minimum as-quenched hardness of Rockwell HRC-50 will be achieved at the center of the bar section representing the spring when quenched in the same media and manner as the spring.

4.1.3 *Springs Made from Bars Over 2 in. (50.8 mm)*—Note that the bias tolerance (reference A29/A 29M, Table A1.1 on Permissible Variations in Cross Section for Hot-Wrought Round, Square, and Round-Cornered Square Bars of Steel) of the bar diameter shall be taken into consideration when designing and calculating the solid height, spring rate, solid stress, and solid capacity.

#### 4.2 Hardness:

4.2.1 The springs must be quenched and tempered to a sufficiently high hardness (strength) to withstand the stresses developed in testing the finished spring. The maximum hardness shall not exceed 477 Brinell numbers (2.80 mm indentation diameter).

4.2.2 When hardness limits are specified, the total range or spread may not be less than 0.15 mm difference in indentation diameters. The specified or indicated minimum hardness must be sufficient to develop the required strength to withstand the solid stresses of the spring design involved.

4.2.3 Hardness shall be read on a prepared flat surface in an area not detrimental to the life of the spring at a full section

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<sup>2</sup> Annual Book of ASTM Standards, Vol 01.05.

<sup>3</sup> Annual Book of ASTM Standards, Vol 03.01.

<sup>4</sup> Annual Book of ASTM Standards, Vol 03.03.



**TABLE 3 Permissible Variations in Outside Diameter of Helix  
(For springs with D/d ratio not exceeding 8)**

NOTE 1— (for design information) These permissible variations, exclusives of manufacturing taper, should be used as a guide in the design of concentrically-nested helical-spring units for free assembly. The diametrical clearance desired is 1/16 in. (1.59 mm) less than the sum of the applicable tolerances of the nested spring units, but in no case should it be less than 1/8 in. (3.17 mm).

NOTE 2—In cases where radical clearance on existing concentrically-nested helical-spring units will not accommodate these tolerances, the nominal inside diameters shall be adhered to as closely as practicable, with plus variation on the outer springs and minus variation on the inner springs to guarantee free assembly. Drawings must show reference to the complete nested spring units.

NOTE 3— (For springs with D/d ratio not exceeding 8) For D/d ratio greater than 8, increase tolerance 50 %.

Nominal Outside Diameter, in. (mm)	Nominal Free Height or Length of Spring, in. (mm)					
	Up to 10 (254) incl, ±	Over 10 to 18 (254 to 457), incl, ±	Over 18 to 26 (457 to 661), incl, ±	Over 26 to 34 (661 to 874), incl, ±	Over 34 to 42 (874 to 1067), incl, ±	Over 42 to 60 (1067 to 1524), incl, ±
Up to 6 (152), incl	1/16 (1.59)	3/32 (2.38)	1/8 (3.17)	5/32 (3.97)	3/16 (4.76)	...
Over 6 to 8 (152 to 203), incl	3/32 (2.38)	1/8 (3.17)	3/16 (4.76)	1/4 (6.35)	1/4 (6.35)	...
Over 8 to 12 (203 to 305), incl	1/8 (3.17)	3/16 (4.76)	1/4 (6.35)	1/4 (6.35)	1/4 (6.35)	...
Over 12 to 16 (305 to 406), incl	...	1/4 (6.35)	1/4 (6.35)	1/4 (6.35)	1/4 (6.35)	5/16 (7.94)
Over 16 to 20 (406 to 508), incl	...	...	5/16 (7.94)	5/16 (7.94)	5/16 (7.94)	3/8 (9.53)
Over 20 to 24 (508 to 610), incl	...	...	3/8 (9.53)	3/8 (9.53)	3/8 (9.53)	7/16 (11.00)
Over 24 to 28 (610 to 701), incl	...	...	7/16	7/16	7/16	1/2
Over 28 (701), incl	...	...	1/2	1/2	1/2	1/2

**TABLE 4 Permissible Variations in Solid Height**

Nominal Solid Height, in. (mm)	Deviation Above Nominal Solid Height, max, in. <sup>A</sup> (mm)
Up to 7 (178), incl	1/16 (1.59)
Over 7 to 10 (178 to 254), incl	3/32 (2.38)
Over 10 to 13 (254 to 330), incl	1/8 (3.17)
Over 13 to 16 (330 to 406), incl	5/32 (3.97)
Over 16 to 19 (406 to 483), incl	3/16 (4.76)
Over 19 to 22 (483 to 559), incl	7/32 (5.56)
Over 22 to 25 (559 to 635), incl	1/4 (6.35)
Over 25 to 28 (635 to 711), incl	5/32 (7.14)
Over 28 to 31 (711 to 787), incl	5/16 (7.94)

<sup>A</sup> For additional 3-in. (76-mm) increase in solid height, the deviation shown should be increased by 1/32 in. (0.79 mm).

determined by placing a straightedge across the top of the spring and measuring the perpendicular distance from the plate on which the spring stands to the bottom of the straightedge at the approximate center of the spring. Tolerances are shown in Table 5.

5.1.3 *Loaded Height*—The loaded height is the perpendicular distance between the plates of the testing machine when the specified working load has been applied in compression. Tolerances are shown in Table 5.

5.1.4 *Permanent Set*—After determining the free height as specified in 5.1.2, the permanent set is the difference between this free height and the height after the spring has been compressed solid three additional times under the test load specified in 7.3, measured at the same point and in the same manner. Tolerances are shown in Table 5.

5.1.5 *Uniformity of Pitch*—The pitch of the coils shall be sufficiently uniform so that when the spring is compressed without lateral support to a height representing a deflection of 85 % of the nominal total travel, none of the coils shall be in contact with one another, excluding the inactive end coils. Under 85 % deflection, the maximum spacing between any two adjacent active coils shall not exceed 40 % of the nominal free

**TABLE 5 Permissible Variations in Free Height, Loaded Height and Permanent Set**

Nominal Total Deflection, in. (mm)	Deviation From Nominal Free Height, max, in. (mm), ±	Deviation From Nominal Loaded Height, <sup>A</sup> max, in. (mm), ±	Permanent Set, max, in. (mm)
Up to 3 (76.2), incl	5/32 (3.97)	1/32 (3.17)	3/64 (1.19)
Over 3 to 4 (76.2 to 102), incl	5/32 (6.35)	5/32 (3.97)	1/64 (1.59)
Over 4 to 5 (102 to 127), incl	5/32 (6.35)	5/32 (4.76)	1/64 (1.59)
Over 5 to 6 (127 to 152), incl	11/32 (8.73)	7/32 (5.56)	5/64 (1.99)
Over 6 to 7 (152 to 179), incl	11/32 (8.73)	5/32 (6.35)	5/64 (1.99)
Over 7 to 8 (179 to 203), incl	14/32 (11.0)	5/32 (7.14)	5/64 (2.38)
Over 8 to 9 (203 to 228), incl	14/32 (11.0)	10/32 (7.94)	5/64 (2.38)
Over 9 to 10 (228 to 254), incl	17/32 (13.49)	11/32 (8.73)	7/64 (2.78)
Over 10 to 11 (254 to 279), incl	17/32 (13.49)	12/32 (9.53)	7/64 (2.78)
Over 11 to 12 (279 to 305), incl	20/32 (15.87)	13/32 (10.32)	9/64 (3.17)
Over 12 to 13 (305 to 330), incl	20/32 (15.87)	14/32 (11.00)	9/64 (3.17)
Over 13 to 14 (330 to 356), incl	23/32 (18.25)	15/32 (11.91)	9/64 (3.17)
Over 14 to 15 (356 to 381), incl	23/32 (18.25)	16/32 (12.70)	9/64 (3.57)
Over 15 to 16 (381 to 406), incl	26/32 (20.64)	17/32 (13.49)	9/64 (3.57)
Over 16 to 17 (406 to 431), incl	26/32 (20.64)	18/32 (14.28)	10/36 (3.97)
Over 17 to 18 (431 to 457), incl	29/32 (23.01)	19/32 (15.08)	10/64 (3.97)
Over 18 to 19 (457 to 483), incl	29/32 (23.01)	20/32 (15.87)	11/64 (4.37)
Over 19 to 20 (483 to 508), incl	1 (25.40)	21/32 (16.67)	11/64 (4.37)
Over 20 to 21 (508 to 533), incl	1 (25.40)	22/32 (17.46)	12/64 (4.76)
Over 21 to 22 (533 to 559), incl	13/32 (27.78)	23/32 (18.25)	12/64 (4.76)
Over 22 to 23 (559 to 584), incl	13/32 (27.78)	24/32 (19.05)	13/64 (5.16)
Over 23 to 24 (584 to 610), incl	15/32 (30.16)	25/32 (19.84)	13/64 (5.16)
Over 24 to 25 (610 to 635), incl	15/32 (30.16)	26/32 (20.64)	14/64 (5.56)
Over 25 to 26 (635 to 661), incl	19/32 (32.54)	27/32 (21.43)	14/64 (5.56)
Over 26 to 27 (661 to 685), incl	19/32 (32.54)	28/32 (22.22)	15/64 (5.96)
Over 27 to 28 (685 to 711), incl	113/32 (34.93)	29/32 (23.01)	15/64 (5.96)
Over 28 to 29 (711 to 746), incl	113/32 (34.93)	30/32 (23.81)	16/64 (6.35)
Over 29 to 30 (746 to 772), incl	115/32 (37.19)	31/32 (24.61)	16/64 (6.35)

<sup>A</sup>If two loads are specified, no tolerance shall apply to the free height.

coil spacing. The nominal free coil spacing is equivalent to the specified total travel divided by the number of active turns. When the design is such that it cannot be compressed to solid height without lateral support, these requirements do not apply.

5.1.6 *Outside Diameter*—The outside diameter shall be measured on a spring in the free condition and across any full