Springs Technology for High Fatigue Automotive Applications

Power steering
- Spiral spring
- Belleville Spring

Transmission
- Elastic washer
- Cone spring
- Clutch Spring

Fuel Injection
- Max fuel plate
- Injector joint
- Leaf spring

Seat
- Recliner spring
- Seat belt buckle
- Cable clip
- Safety belt power spring

Brakes
- Spring clip
- shoe clamping spring

Starter motor
- Carbon brush spring

Engine
- Camshaft adjuster spring
- Hose spring clamp
Springs for Transmission

4 Wheeler

Slotted Belleville Springs

Slotted Disc springs are used in clutches of automatic, CVT, and dual clutch transmissions. They ensure highest spring return forces in the small space. These springs also minimize the overall size and weight of the transmission. The spring characteristics are designed to meet the specific load and space requirements for different applications.

Cushion Springs

In applications where shift comfort is critical, cushion springs are added in clutch assembly. Both Disc type and wave type springs are used for cushion spring applications. Wave type cushion springs are most commonly used as they typically are lighter than a Disc design cushion spring results in space saving. Wave springs also results in lower hysteresis compare to disc spring.

About Gala

Gala provides an extensive range of springs for Indian as well as Global OEMs in Automotive, Off Highway Vehicles, Power Equipments & Wind Turbines from its TS16949 certified plants. Exports to 25 countries including Germany, Switzerland, Finland, Italy, USA, Singapore, China, etc. contributes 60%+ of company’s sales.

Gala is specialized in Strip Springs for high fatigue applications in two wheelers, four wheelers & off-highway vehicles.

High quality, reliability and design partnership are the 3 factors that have helped us to become preferred partners of our global customers like ABB, Alstom, Bosch, Delphi, Brembo, Mando, Valeo, Dana, Emerson, John Deere, Siemens, Vestas, etc.
Spiral Spring for Clutch Fan

Thermal fan clutches have a built-in thermostat spring that detects the air temperature passing through the radiator and air conditioning condenser. The fan clutch engages and provides air flow, only when cooling is needed. When disengaged, the fan clutch powers down reducing power drain and increasing fuel economy.

2 & 3 Wheelers

Gala offers Judder Plate, Judder Spring (Clutch spring), Plain washer & Belleville washers for 2 & 3 wheeler clutches. Gala is able to meet stringent requirements of flatness, ovality & round edges for free movement of parts inside clutch to achieve optimum performance.

Off-highway Vehicles

We supply belleville springs for transmission of off-highway vehicles like tractor, construction equipment & earth-moving equipment.
Spiral Springs

Seat Height Adjustment

Two Wheeler Kick Start

Engine Camshaft Adjuster Springs

The spiral springs have the task of moving the camshaft adjuster to its early position when switching off the engine.

Clock & Belleville Springs for Steering Wheel

The clock spring is located between the steering wheel and the steering column. We also offer belleville springs, wave springs & spring clamps.
A carbon spring is a sliding electrical contact that carries current to a moving surface. It performs this electric duty while operating within the constraint of a mechanical system.

Carbon brush springs are constant force springs that are specially constructed to ensure consistent & dependable pressure to electric motor commutations. We provide both single coil constant force springs and twin coil constant force springs for carbon brush.

Gala is able to meet customer specific raw material need with options of manufacturing either from annealed & hardened and tempered material.

**Our Advantage**

- Constant pressure for commutator in any brush length
- Increases brush life, reduces electrical wear
- Compact design for overall motor size
  - Meets required load requirements critical for function of starter motors
- Allows longer brushes
- Allows larger commutators
- Reduces spark, lower influence of electromagnetic interference (EMI)

Spiral Springs for

**Seat Recliner**

Spiral springs serve as energy storage units or damping elements.

**Gala offers Spiral Springs for**

- Seat Reclining System
- Seat Height Adjustment System
- Automotive Drive Control Mechanism
- Window Regulator Mechanism

Spiral springs are used as equalizing springs for smaller angles of rotation. The stored energy is used as an equalizing force or righting moment. The spring curve here rises almost linearly.

**Features**

Gala offers thickness ranges from 1.5 to 5.0 mm with variety of options for Surface Coatings.
Gala offers high precision components for Fuel Injection systems for petrol as well as diesel vehicles.

**Components for Fuel Injection Systems**
- Max Fuel Plate
- Back Plate
- Injector Joint
- Piston Stop
- TP Back Plate
- Belleville washer
- Leaf Spring

**Our Advantage**
- Flatness upto 0.03 mm
- Parallelism upto 0.02 mm
- Shot peening for high residual stress induction resulting in High Fatigue life
- Edge radiusing for smooth movement of parts inside pump
Precision Springs & Components for Brakes

Gala manufactures components for Caliper & Drum brakes of Passenger cars & two wheelers from Spring steel, Stainless steel & other special steels.

Brake Components
Leaf Spring | Shoe clamping spring | Pawl Lever / Adjuster
Pad Spring | Clip

Our Advantage
Forming with stringent tolerances
Heat Treatment & stress relieving to meet required spring force and load characteristics
Proprietary finishing process for high residual stress induction resulting in High Fatigue life
Edge radiusing
Design & Engineering

At Gala we have 30 years of experience in understanding spring material behavior. We have tie ups with global research institutes & universities in Germany & India for new product testing & new process validations.

Materials

Gala has successfully forged alliances with its suppliers of Steel, which is absolutely vital for maintaining consistency in quality & delivery. Almost 50% of raw materials are imported from leading steel mills from Europe, Brazil, Korea, etc.

Raw materials offered

- Spring Steel Ck55, Ck60, Ck67, Ck70, Ck75, 80C6, 85C6, SWRH62A, SWRS2
- Chrome Vanadium Steel 50CrV4 / 51CrV4
- Precipitation Hardenable Steel 17/7Ph
- Work Hardened Stainless Steel AISI 301, 304 & 316
- Inconel 718 & X750
We have developed tooling technology for shaving of edges for reducing the shear zone upto 20% of material thickness, which is close to fine blanking.

Tool Design & Development

- In-house tool design and development with latest CAD Software.
- Rapid Prototyping
- State-of-the-art CNC Wire Cut Machines for achieving surface finish upto 5 microns on cutting elements.
- Competency of manufacturing tools from variety of materials like HSS, Carbide, Venadis, Powder Metallurgy, etc.
- Different types of Coating & Treatments for tool elements to increase performance & achieve better edge quality.

16 Stage Progressive Tool
Heat Treatment Technology

With years of experience in handling Spring steel & Stainless steel materials, Gala has optimized heat treatment process. Based on grade of steel & end application, Gala offers various options of heat treatment.

Austempering

It is performed to achieve homogeneous Bainite structure by ensuring controlled atmosphere & process parameters. The resultant product is distortion free with uniform hardness & higher endurance life.

Stress Relieving

For stainless steel parts stress relieving is done by heat treatment to remove internal stress induced during blanking, forming, etc.

Vacuum Heat Treatment

For thicker materials & application demanding high fatigue life, Gala offers vacuum heat treatment.
**Surface Finishing**

Based on 30 years of experience in surface engineering, we offer components with fine surface finish - Ra value up to 0.5 microns. This finishing process also ensures uniform edge radius for smooth assembly & movement of parts inside assembly.

**Compressive Stress Induction**

Proprietary process developed by Gala, induces high level of compressive stresses with larger depth of penetration in components resulting in higher fatigue life. This validated by the leading testing laboratories in the USA and Europe.

**A variety of surface treatments & coatings offered by Gala**

- Phosphating
- Mechanical Zinc Plating (Cr 6 free)
- Blackodising
- Dacromating
- Epoxy Coating
- Nickel Chrome Plating

**Inspection & Quality Control**

- Torque Testing
- Load Testing
Gala Precision Engineering Private Limited

Corporate Office & Engineering Centre
A-59, Road No.10, Wagie Industrial Estate, Thane - 400 604, India. Tel: +91 22 2582 1232
Fax: + 91-22-2582-0771
Email: stripsprings@galagroup.com

Plant
Plot No. 295, Village Vadavali at Post Met, Masurne Road, Bhiwandi - Wada Highway, Taluka Wada, Thane - 421 312, India.

Germany Office
Niederlassung Deutschland, Lyoner Strasse 14, 60528 Frankfurt am Main, Germany.
Fax: +49-69-66-55-41-59

China Office
Gala Precision Engineering Shanghai Co. Ltd
No.1, Building No. 668, Yuandong Road Fengxian District, Shanghai - 201 400, China
Tel: +86 21 67107985 810
Email: china@galagroup.com

www.galagroup.com