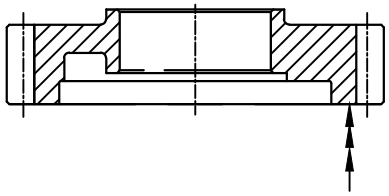
PROJECT : RE-P-1

VE COMMERCIAL VEHICLES LIMITED. (UNIT : EICHER ENGINEERING COMPONENTS; DEWAS)	CONTROL PLAN	PREV. OPN.	NEXT. OPN.	SURFACE FINISH :	DOC. NO. :
		80 - PRE HT INSPECTION	100 - TEETH CHAMFERING		AP04 : 160 : 20 REV-01 (DATE-05.10.17)

CONTROL PLAN NO : 2429 / 90						KEY CONTACT PERSON :- S. KOMULWAD			CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG					REVISION	
EFF DATE	24.08.2016	EFF DATE	11.09.17	EFF DATE		LOCATION	REST	CLAMP	N	SPL.CHAR. (CRITICAL DIMN.)	B EECD	CUSTOMER.		A	B	C
PROTOTYPE	✓	PRELAUNCH	✓	PRODN											
O.E.	✓	EXPORT													
PART NO.	ED 2429 (575274 / e)														
PART NAME	GEAR, 3RD DRIVEN	OPN. NO.	90												
CUSTOMER	ROYAL ENFIELD														
OPERATION	* HEAT - TREATMENT														
CELL [OPTIONAL]	M./C. S.Q.F.	M / C NO. (OPTIONAL)													

FIXTURE.	FIX. NO.	TOOL	NO.

LOADING PATTERN :-



PART TO BE LOADED IN BASKET

FOR REFERENCE ONLY

SR. NO.	CHARACTERISTICS PRODUCT	CHARACTERISTICS PROCESS	SPL CHAR CLASS	PRODUCT / PROCESS SPECIFICATIONS	EVALUATION MEASUREMENT TECHNIQUE		SAMPLING		CONTROL METHOD	CORRECTIVE ACTION/ REACTION PLAN
6.		CHARGE NO. MARKING		REFER MARKING W.I. NO. AP03 : 460 : 02 FOR SQF.						
7.		CARBURISING & HARDENING		REFER H. T. W.I. NO. AP03 : 460 : 05 , STANDARD CYCLE SHEET No. AP03 : 460 : 44 , H.T. PROCESS SHEET No. AP04 : 460 : 02 .						
8.		TEMPERING / PRE HEATING		REFER H. T. W.I. No. AP03 : 460 : 16 , STANDARD CYCLE SHEET No. AP03 : 460 : 44						
9.		SHOT BLASTING		REFER H. T. W.I. No. AP03 : 460 : 06						
10.		WASHING		GENERAL PROCEDURE , REFER H.T. W.I. No. AP03 : 460 : 04						

DRN BY	VIJAY S GIRI		CHKD BY	R.PATHAK		APRD BY	B. LEVA		PAGE 02 / 02

UNSPECIFIED TOLERANCES AS PER IS : 2102 (PART-1) : 1993 MEDIUM CLASS. | ALL DIMENSIONS ARE IN MILLIMETERS. | DO NOT SCALE, IF IN DOUBT, PLEASE ASK. | BREAK SHARP CORNERS.