

VE COMMERCIAL VEHICLES LIMITED.
(UNIT : EICHER ENGINEERING COMPONENTS; DEMAS)

CONTROL PLAN

PREV. OPN. 115 - STRAIGHTENING
NEXT. OPN. 125 - BURR-FILING
SURFACE FINISH
DOC. NO. : APCV-100-20
ISSUES-3 REV: 00 (01/100)

CONTROL PLAN NO: 1016/120

EFF. DATE	22.01.12	EFF. DATE	22.12.12	EFF. DATE	12.03.13
PROO-TYPE	<input checked="" type="checkbox"/> PRE-LUNCH	<input checked="" type="checkbox"/> PRODUCTION	<input checked="" type="checkbox"/>		

LOCATION → REST → → →
MATERIAL - : 20 Mncr 5
COMP. WT. = 1.483 KG.

CLAMP — N →
SPL CHAR (CRITICAL DIM.)

9 B EEOO

CUSTOMER'S

REVISION
A B C
D E F

OE ☒ EXPORT

PART NO. ED 1016 (LVU23483)

PART NAME SUN GEAR OPN. NO. 120

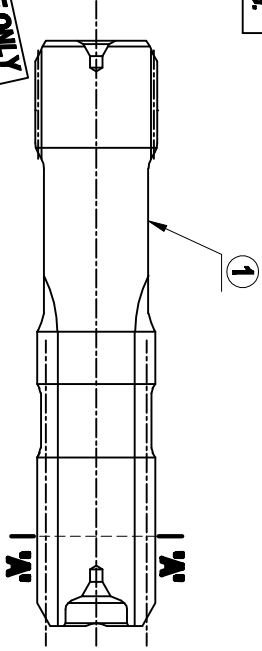
CUSTOMER JOHN DEERE

OPERATION AFTER H/T INSPECTION

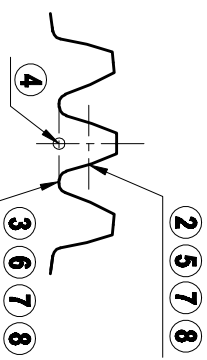
CELL [OPTIONAL.] M/C. M/C NO. [OPTIONAL.]
INSP. DEPTT.

FIXTURE FIX. NO. TOOL NO.

FOR REFERENCE ONLY
DATE - 14.02.18



NOTE : - 1. IF CASE DEPTH FOUND LOWER OR HIGHER LIMIT OF SPECIFICATION TWO PART CHECK.
2. SAMPLE SHOULD BE CHECK BEST & WORST LOCATION FOR CASE DEPTH & MICROSTRUCTURE.
3. IN CASE RA IS MORE THAN 25% CHECK HARDNESS (WITH 100 GM LOAD VICKER HARDNESS) AT 0.1mm. IN SHOULD BE 58 HRC. MIN.



SECTION - 'A-A'

SR. NO.	CHARACTERISTIC		SPL CHAR CLASS	PRODUCT / PROCESS SPECIFICATIONS	MEASUREMENT		SAMPLING		CONTROL METHOD	CORRECTIVE ACTION / REACTION PLAN
	PRODUCT	PROCESS			TECHNIQUE INSTRUMENT	NO.	SIZE	FREQ.		
1.	SURFACE HARDNESS			58 - 64 HRC. A	ROCK WELL HARDNESS TESTER	—	1 PC.	PER CHARGE	SELF INSPECTION	SORT / REWORK;
2.	CUT PART FOR CASE DEPTH ON PCD			1.1 ~ 1.3 mm. (AT 315Hv)	AUTOMATC VICKER HARDNESS TESTER	—	1 PC.	PER CHARGE	SELF INSPECTION	
3.	CUT PART FOR CASE DEPTH ON RCD			0.55 mm. Min (AT 315Hv)	AUTOMATC VICKER HARDNESS TESTER	—	1 PC.	PER CHARGE	SELF INSPECTION	
4.	CORE HARDNESS AT RCD			25 ~ 45 HRC.	ROCK WELL HARDNESS TESTER	—	1 PC.	PER CHARGE	SELF INSPECTION	
5.	MICROSTRUCTURE AT CASE			TM WITH 25% RA Max. (FREE FROM CARBIDES)	MICROSCOPE AT 500X	—	1 PC.	PER CHARGE	SELF INSPECTION	
6.	MICROSTRUCTURE AT CORE			LCM + BANITE	MICROSCOPE AT 500X	—	1 PC.	PER CHARGE	SELF INSPECTION	
7.	IGO & NITP (Max. IN MICRON)			< 25 MICRON	MICROSCOPE 100X	—	1 PC.	PER CHARGE	SELF INSPECTION	
8.	ITP (Max. IN MICRON)			0% AT SURFACE 5% Max. AT ECD/2 AT PCD 5% Max. AT ECD/4 AT RCD	MICROSCOPE 100X	—	1 PC.	PER CHARGE	SELF INSPECTION	