

# Process Specification



2135 West Maple Road  
Troy, MI 48084-7186

Specification: 240-D-1  
Revision Date: 3/5/2007

## CARBURIZING EFFECTIVE CASE - MODIFICATION

### 1. GENERAL SPECIFICATIONS

P.S.1 & P.S.100

### 2. Application: Drive pinion

### 3. PROCESS REQUIREMENTS

3.1 Case Depth: 0.040" - 0.060"

3.2 Hardness:

- Surface must be file hard
- Surface hardness HRC 57-65

**Thread and spigot must be softened per P.S.496.**

Date	Change
3/5/2007 Level D Request 26801-11	Clarified hardness requirement, moved application section and numbered sections.
6/15/2001 Level C Request 21206-60	Created an individual document for process specification 240-D-1. It was originally included on P.S. 240.

Approved By: S. Foster  
Director-Materials Engineering