


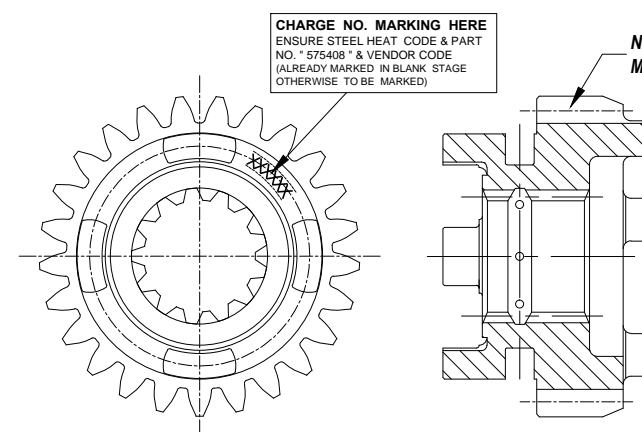
DRN BY	VIJAY S GIRI		CHI
--------	--------------	--	-----





KEY CONTACT PERSON :- S. KOMULWAD

MATERIAL - : SAE 8620H
COMP. WT - : 0.34 Kg 

*** HEAT-TREATMENT-:**

- * MARKING ;
- PRE-WASHING ;
- PRE-HEATING ;
- CARBURISING ;
- HARDENING ;
- POST-WASHING ;
- TEETH CHAMFERING ;
- SHOT BLASTING ;



SURFACE HARDNESS		CORE HARDNESS		EFFECTIVE CASE DEPTH		MICROSTRUCTURE	
ALL AREA		AT RCD (MIDDLE OF TEETH)		AT PCD 		CASE	
58 ~ 62 HRC   (TARGET 60 - 62 HRC)		330 ~ 480 HV1 		PROCESS REQUIRED	0.75 ~ 0.95 mm CUT OFF 513 HV1 (TARGET 0.8-0.85mm)	FINE TEMPERED MARTENSITE + RA <10% AND FREE FROM CARBIDES GBO<20 MICRON, 5% CARBIDE IN GLOBULE FORM ALLOWED	
				FINAL REQUIRED	0.65 ~ 0.95 mm CUT OFF 513 HV1		


EVALUATION MEASUREMENT TECHNIQUE		SAMPLING		RESP.	CONTROL METHOD	CORRECTIVE ACTION / REACTION PLAN
INSTRUMENT	NO.	SIZE	FREQ			
MICRO-HARDNESS TESTER	---	1 PC	PER CHARGE	~ INSPTR.	TESTING	CHECK FURNACE SETTING DATA & CONFIRM FOR CORRECTNESS
HARDNESS TESTER	---	5 PC	PER CHARGE	~ INSPTR.		
	---	1 PC	PER CHARGE	~ INSPTR.		
MICROSCOPE	---	1 PC	PER CHARGE	~ INSPTR.		
	---	1 PC	PER CHARGE	~ INSPTR.		
VISUAL	---	100%	PER CHARGE	~ INSPTR.		

FOR REFERENCE ONLY

FOR REFERENCE ONLY

APPROVED BY	<i>R. PATHAK</i>		APPROVED BY	<i>B. LEVA</i>	
-------------	------------------	--	-------------	----------------	--

REVISION	
A1	MANUAL SCUM 420 REMOVED REWELD AS PER COST'S LATEST DRWG. REV.-C. (BY-VSG, DT-13.12.17)
A2	SURFACE HARDNESS 80-84 HRA WAS 80-83 HRA & CORE HARDNESS 330-480 HVT WAS 300-450 HVT AS PER CUSTOMER'S LATEST DRAWING REV.B. (BY-VSG, DT-14.08.17)
A3	CHANGES DONE AS PER INPUTS GIVEN BY NPD EXECUTION TEAM. (DT-04.04.17 BY-VSG.

 SURFACE HARDNESS 66 - 62 HRC WAS 80 - 84 HRA & ECD 0.65-0.95 MM WAS 0.6-0.9 MM REVISED AS PER DCR NO.-1115, DT-29.01.18, BY-VSG, DT-29.01.18.