

VE COMMERCIAL VEHICLES LIMITED. (UNIT:EICHER ENGINEERING COMPONENTS;DEWAS)UNIT:-II				CONTROL PLAN		PREV. OPN.		NEXT. OPN.		SURFACE FINISH:		DOC. NO.:																																																						
						60 - PRE HT INSPECTION		80 - TEETH CHAMFERING				AP04 : 160 : 20																																																						
CONTROL PLAN NO : 24113 / 70				LOCATION →		REST →→→		CLAMP → N →		SPL.CHAR. (CRITICAL DIMN.)		<div style="border: 1px solid black; padding: 2px; display: inline-block;">B</div> EECD																																																						
EFF DATE 08.09.17 EFF DATE EFF DATE PROTOTYPE ✓ PRELAUNCH PRODN O.E. ✓ EXPORT				MATERIAL - : 16MnCr5 COMP. WT - : 0.122 KG				<div style="display: flex; justify-content: space-between;"> ABC </div> <div style="display: flex; justify-content: space-between;"> DEF </div>																																																										
PART NO. ED 24113 (1570031) PART NAME GEAR, 5TH DRIVE OPN. NO. 70 CUSTOMER ROYAL ENFIELD OPERATION * HEAT - TREATMENT																																																																		
CELL [OPTIONAL] M./C. M / C NO. [OPTIONAL] <div style="text-align: center; font-weight: bold; font-size: 1.1em;">S.Q.F.</div>				* HEAT-TREATMENT- : * MARKING ; PRE-WASHING ; PRE-HEATING ; CARBURISING ; HARDENING ; POST-WASHING ; TEETH CHAMFERING (REFER SEP. CONTROL PLAN); SHOT BLASTING ;																																																														
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DRN BY		VIJAY S GIRI		CHKD BY		R.PATHAK		APRD BY		B.LEVA		PAGE 01 / 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.																																																						