`			MPON	ENTS;DE	WAS)UNIT:-I	CONTR	OL I	_/\\\	070 - PRE H	T INSPECTIO	ON 090 - CENTER	R LAPPING			160 TE-05.1	
CONTROL PLAN NO: 2472 / 080					KEY CONTACT PERSON	CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG						REV	/IS			
F DATE	16.09.2016 E	FF DATE	11.09.17	EFF DATE		LOCATION			CLAMP -	-N ->	SPL.CHAR. (CRITICAL DIMN.)	B EECD	CUSTOM	ER.	41 E	_
OTOTYPE	L+ PI	RELAUNCH	<u></u>	PRODN		MATERIAL - : S									D E	=
O.E. EXPORT					COMP. WT -:								A	MATERIAL		
PART NO. ED 2472 (575423/e)					MARKING:	<u> LINIT.</u>		NOTE								
ART NAME	OTAL 1, BRITE (0011 01)					PRE-WASHING ; PRE-HEATING ;	1. APPLY STOP OFF PASTE / ANTICARB PASTE							30 nc. 1		
USTOMER						CARBURISING; IN THE AREA SHOWN "X" (19.5 ±1 h						(19.5 ±1 mm)		EWONE	SCM 420 REMOVED REVISED	
PERATION	TION * HEAT - TREATMENT					HARDENING; POST-WASHING;								VIE VIOL	DE WATER	
CELL [OPTIONAL]		M./C. M./C NO. [OPTIONAL] S.Q.F.			TEMPERING; SHOT BLASTING; 13 NO. ST. SPLINE APPLY STOP OFF PASTE HERE (ON THREAD AREA)						STE HERE "X"-19.5±0	0.1 AS PER COST SEA TEST UNIO, REV. 4. DI 1980.	יי אפ פבפ רוופדיפ			
FIXTURE		FIX. NO. TOOL NO.			NO.		MARK CHARG	GE /					15 NOS.			
						SURFACE HARDNESS	NO. HERE CORE HARDNE	SS EFFECTIVE	VE CASE DEPTH	MICROSTRUCTUR		INV.	SPLINE THREAD AREA HARDNESS	VSG, DT-13.12.17.		
					ALL AREA	AT SPLINE R (SPLINE TOO CENTER)			AT CASE		AT CORE	AT ROOT 0.2 mm DEPTH (THREAD ROOT DEPTH)		1		
						80-84 HRA	330-480 HV1		0.6-0.9 mm CUT OFF 513 HV1		MPERED ISITE + RA <10% EE FROM CARBIDES micron	LOW CARBON MARTENSITE + BAINITE	300-450 HV1 (AFTER THREADING)			
						NOTE:- 1) GROUND SURFACE :- HARDNESS AT 0.1MM SHALL BE 650 HV1 MIN.										
₹.	CHARACTERIS	SPL CHAR		1	DUCT	EVALUATION MEAS TECHNIQUE	SUREMENT	SAN	SAMPLING		CONTROL METHOD	ור	ECTIVE ACTION /			
O. PRO	DUCT PROCESS		CLASS	SPECIFICATIONS		INSTRUMENT	NO.	SIZE	FREQ	RESP.	OOM THOE METHOE	REAC1	TION PLAN			
EFF. CA	ASE DEPTH					MICRO-HARDNESS TESTER		1 PC	PER CHARGE	~ INSPTR.	TESTING		IACE SETTING DATA &			
SURFAC	CE HARDNESS		₿	RE	FER	HARDNESS TESTER —		5 PC	PER CHARGE	~ INSPTR.						
CORE HA	IARDNESS			ABOVE TABLE				1 PC	PER CHARGE	~ INSPTR.						
MICROSTRUCTURE						MICROSCOPE		1 PC	PER CHARGE	~ INSPTR.	FOR REFERENCE ONL'		CE ONLY			
4. MICROSTRUCTURE 5. HARDNESS ON THREAD AREA "X"		₿				HARDNESS TESTER		1 PC	PER CHARGE	~ INSPTR.	FOICE					
SHOT BL	BLAST			FREE FROM RUST & SCALE		VISUAL		100%	PER CHARGE	~ INSPTR.						
DRN BY VIJAY S			Cŀ			KD BY R.PATHAK				APRD BY		B.LEVA			PAG 01 / 0	