	COMMER					EWAS)UNIT:-	CONT	RO	L PL	AN	PRE 80 - PRE HT	V. OPN. INSPECTION		OPN. CHAMFERING	SURFACE FIN	ISH: DOC. NO. APO4	JECT : RE : : : 160 : DATE-05.10.
CONTI	ROL PLAN NO	: 2482 / 5	90			·	KEY CONTACT PERS	SON :- S. I	KOMULWAD	1	CORE TEAM	1 :- SK, LEV	A, SRS, IDS, MM, KUN	AL, MJ, VSG		11127 01 (2	REVISI
EFF D	ATE 14.0	9.2016 EF	F DATE	11.09.1	7 EFF DATE	=	LOCATION	→	REST -		CLAMP -	-N ->	SPL.CHAR. (CRITICAL DIMN.)	B EE	CD 🔷	CUSTOMER.	A1 B
PROTO	O.E.	+ PR	ELAUNCH	EVDO	PRODN		MATERIAL - : COMP. WT -	SAE 8 : 0.69	620H 🛕		•	ENSURE S	NO. MARKING HERE TEEL HEAT CODE, 575191 " & VENDOR CODE		O OF TEETH :- 73 DDULE :- 2.0		D E
O.E. EXPORT PART NO. ED 2482 (575191 / e)							* HEAT-TREA				ARE ALREADY MARKED IN BLANK STAGE OTHERWISE TO BE MARKED					MATERAIL CUST'S LA	
PART NAME GEAR STARTER CLUTCH OPN. NO. 90							NY MARKINO	* MARKING;			ا ۸ ۵	www.					RAIL SCM
	OMER ROYAL ENFIELD						PRE-WASHING	,			mind		wy C	₃			M 420 R ST DRG.
	ERATION * HEAT - TREATMENT						PRE-HEATING ; CARBURISING ;				35/ 122					EMOVEI REVe.	
CELL [OPTIONAL] M./C. S.Q.F. M/C NO. [OPTIONAL]					HARDENING; POST-WASHING; SUB ZERO TREATMENT; *							G			D, CORE HARDNESS BY-VSG, DT-13.12.1		
FIXTURE			FIX. NO.	NO. TOOL NO.			SHOT BLASTIN	SHOT BLASTING;				X]]][\$		-		330-48 7.
							* SUBZERO TRE			E rs.		www.					VESS 330-480 WAS 300-450 HV1 REVISED .12.17.
												RFACE - BORE & OD AS M					REVISE
							SURFACE HARDNESS		CORE HARDNESS		EFFECTIVE CASE DEPTH			MICROSTRUCTU) AS PER
							ALL AREA	ALL AREA		RCD	AT PCD		CASE		CORE		
							60-64 HRC		330 - 480 HV1 🛕		0.8~1.1 mm CUT OFF 550 HV1		FINE TEMPERED MARTENSITE + RA < 5% AND FREE FROM CARBIDES GBO<20 micron		LOW CARBON MARTENSITE + BAINITE		
							NOTE:- 1) GROUN	NOTE:- 1) GROUND SURFACE - BORE & BOSS OD HARDNESS @ 0.1mm 650 HV MIN									
	CHARACTERISTICS			SPL	DDC	DUCT		EASUREM	MENT 9AH		MPLING			000000000000000000000000000000000000000			
R O.	PRODUCT	CHARACTERISTICS PRODUCT PF		PROCESS CHAI		DDUCT ICATIONS	TECHNIQUE INSTRUMENT		10.	SIZE	FREQ	RESP.	ICONTROL METHOD I		RRECTIVE ACTION / ACTION PLAN		
1.	EFF. CASE DEF	FF. CASE DEPTH		1 227 101	-		MICRO-HARDNESS TESTER	-		1 PC	PER CHARGE	~ INSPTR.	TESTING			-	
2.	SURFACE HARDNESS			┧働		EEED		1		5 PC	PER CHARGE	~ INSPTR.			OR CORRECTN	NESS	
-		ORE HARDNESS		`	A	EFER BOVE ABLE	HARDNESS TESTER	1		1 PC	PER CHARGE	~ INSPTR.					
\dagger						null				1 PC	PER CHARGE	~ INSPTR.	FOR REFERE		NCE O	NLY	
4. MICROSTRUCTURE		JRE		8			MICROSCOPE			1 PC	PER CHARGE	~ INSPTR.	FOR REFERENCE ONLY				
5.	. SHOT BLAST					FROM RUST SCALES	VISUAL			100%	PER CHARGE	~ INSPTR.					
DRN BY VIJAY S GIRI			ı		CHKD BY	R.PA	THAK			APRD BY	,	B.LEVA			PAGE 01 / 02		