VE COMMERCIAL VEHICLES LIMITED. (UNIT:EICHER ENGINEERING COMPONENTS;DEWAS)UNIT:-II									70 - PRE HT INSPECTION 90 - TEETH C				A RE	DC. NO. : PO4 : 160 EV-01 (DATE-05
	ROL PLAN NO: 2483,			1		KEY CONTACT PERSO		.WAD			/A, SRS, IDS, MM, KUN			RE
EFF D	ATE 30.08.2016	EFF DATE	11.09.17	EFF DATE		LOCATION ———	'.=•'		CLAMP -	N>	SPL.CHAR. (CRITICAL DIMN.)	B EE	ECD CUSTO	OMER. A1
PROTOTYPE						MATERIAL - : §	A2	*	ENSURE ST	IO. MARKING HERE EL HEAT CODE		NO OF TEETH :- 51	D A	
						★ HEAT-TREAT	★ HEAT-TREATMENT-:			& VENDOR ALREADY N		ED IN BLANK STAGE		51 A CASE 23.01.4
						₩ MARKING;			E TO BE MARKED.			10 WAS 300-450 HV DEPTH CHECKING 2017		
					PRE-WASHING;		20000	NUVIV						
	CUSTOMER ROYAL ENFIELD OPERATION # HEAT - TREATMENT					PRE-HEATING;		5	XXXXX	15	>			NG LOU
_	[OPTIONAL]	M./C.	ENI	M/C NO.	[OPTIONAL]	CARBURISING; HARDENING; POST-WASHING;			ALREADY MARKED IN BILANK STAGE OTHERWISE TO BE MARKED. MODULE:-1.25					33J-480 WAS 30J-450 HYT REVISED AS PER CUST'S LATEST IPRG. REV. d. BY-VSG. DT-13 IZ 17. 23.01.2017 23.01.2017
		S.Q.F.				TEETH CHAMFER	RING	1-5-1	 - - - - - - - - - 	-}-}	1>		.#	D WAS
-	IXTURE	FIX. NO.	NO. TOOL		NO.	(REFER SEP. COI SHOT BLASTING	NTORL PLAN } ;); } \			/			
											5			'SLATEST DRG. REVd. BY. AT PCD AS PER MAIL BY M:
							(REFER SEP. CONTORL PLAN); SHOT BLASTING;				3Y Mr. S			
										Ú -		-]	SHYAM SIR
								RE HARDNESS		ECTIVE CASE DEPTH		MICROSTRUCTURE		3.12.17. 3/R ON
						ALL AREA		AT RCD	AT RCD		CASE FINE TEMPERED MARTENSITE + RA < 10% AND FREE FROM CARBIDES GBO<20 micron		CORE LOW CARBON MARTENSITE + BAINITE	
						80 ~ 84 HRA 🖄	330) ~ 480 HV1 <u>Á</u>						
						GROUND SURF	GROUND SURFACE: HARDNESS @0.1 mm SHALL BE 650 HV1 MIN							
SR. CHARACTER		RISTICS SI CH		1	RODUCT CIFICATIONS	EVALUATION MEASUREMENT TECHNIQUE		SAM	SAMPLING		CONTROL METHOD	CORRECTIVE ACTION /		,
10.	PRODUCT	PROCESS	PROCESS CLASS		ATIONS	INSTRUMENT	NO.	SIZE	FREQ	RESP.	OONTROE METHOD	REACTION PLAN		
1.	EFF. CASE DEPTH		₿			MICRO-HARDNESS TESTER		1 PC	PER CHARGE	~ INSPTR.	TESTING		RNACE SETTING DAT	A &
2.	SURFACE HARDNESS		₿	REF	ER	HADDNESS TESTED		5 PC	PER CHARGE	~ INSPTR.				
3.	CORE HARDNESS		₿	ABO	OVE .	HARDNESS TESTER		1 PC	PER CHARGE	~ INSPTR.				<u> </u>
	MICROSTRUCTURE		₿			MICROSCOPE		1 PC	PER CHARGE	~ INSPTR.	EOR R	FFER	ENCE ON	_Y
ł.	MICROSTRUCTURE							1 PC	PER CHARGE	~ INSPTR.	FORT			
- 1	SHOT BLAST				ROM RUST CALE	VISUAL		100%	PER CHARGE	~ INSPTR.				
5.				" "	07122							I		