PRO IFCT : RF-P-1 VE COMMERCIAL VEHICLES LIMITED. PREV. OPN. NEXT. OPN. SURFACE FINISH : DOC. NO. : **CONTROL PLAN** APO4:160:20 REV-01 (DATE-05.10.17) 80 - PRE HT INSPECTION 100 - TEETH CHAMFERING (UNIT:EICHER ENGINEERING COMPONENTS:DEWAS)UNIT:-I CONTROL PLAN NO: 2429 / 90 KEY CONTACT PERSON :- S. KOMULWAD CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG REVISION SPL.CHAR. (CRITICAL DIMN. --- N ---> B 24.08.2016 EFF DATE LOCATION ────── EECD CUSTOMER. FFF DATE 11.09.17 FFF DATE RFST В ٢ PRELAUNCH PRODN PROTOTYPE E F MATERIAL -: SAE 8620H. NO OF TEETH :- 30 * CHARGE NO. MARKING HERE MODULE :- 2.25 0.F**EXPORT** COMP. WT -: 0.27 KG ENSURE STEEL HEAT CODE & PART NO. " 575274 " & VENDOR CODE PART NO. ED 2429 (575274/e) (ALREADY MARKED IN BLANK STAGE OTHERWISE TO BE MARKED) **★** HEAT-TREATMENT-: PART NAME OPN. NO. **90** GEAR. 3RD DRIVEN ***** MARKING: CUSTOMER **ROYAL ENFIELD** PRE-WASHING: **OPERATION** * HEAT - TREATMENT PRE-HEATING ; M /ſ M / C NO. [OPTIONAL] CELL [OPTIONAL] CARBURISING ; S.Q.F. HARDENING: POST-WASHING: **FIXTURE** FIX. NO. TEETH CHAMFERING T00L NO. (REFER SEP. CONTROL PLAN): SHOT BLASTING; SURFACE HARDNESS CORE HARDNESS EFFECTIVE CASE DEPTH MICROSTRUCTURE AT RCD ALL AREA AT PCD CASE CORE (MIDDLE OF TEETH) FINE TEMPERED LOW CARBON 80 ~ 84 HRA A PROCESS | 0.7 ~ 0.9 mm 330 ~ 480 HV1 MARTENSITE + RA <10% AND MARTENSITE + REQUIRED CUT OFF 513 HV1 FREE FROM CARBIDES BAINITE GBO<20 micron, FINAL 0.6 ~ 0.9 mm 5%CARBIDES GLOBULE REQUIRED CUT OFF 513 HV1 FORM ALLOWED NOTE:- 1) GROUND SURFACE: HARDNESS @ 0.1mm SHALL BE 650 HV MIN. EVALUATION MEASUREMENT SPL SAMPLING CHARACTERISTICS PRODUCT TECHNIQUE CORRECTIVE ACTION / SR. CHAR RESP. **SPECIFICATIONS** CONTROL METHOD REACTION PLAN **PROCESS** PRODUCT NO. FREQ INSTRUMENT NO. SIZE CLASS MICRO-HARDNESS 1 PC PER CHARGE ~ INSPTR. CHECK FURNACE SETTING DATA & EFF. CASE DEPTH TESTING TESTER CONFIRM FOR CORRECTNESS PER CHARGE 5 PC ~ INSPTR. SURFACE HARDNESS REFER HARDNESS TESTER **ABOVE (B)** CORE HARDNESS ~ INSPTR. 1 PC PER CHARGE FOR REFERENCE ONLY **TABLE** 1 PC PER CHARGE ~ INSPTR. MICROSCOPE MICROSTRUCTURE 1 PC PER CHARGE ~ INSPTR. FREE FROM RUST PER CHARGE ~ INSPTR. 100% 5. SHOT BLAST VISUAL & SCALE PAGE R.PATHAK VIJAY S GIRI CHKD BY B.LEVA DRN BY APRD BY 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.