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| 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 : 24125 / 70 | | | | LOCATION → | | REST →→→ | | CLAMP → N → | | SPL CHAR. (CRITICAL DIMN.) | | <div style="border: 1px solid black; padding: 2px; display: inline-block;">B</div> EEC D <div style="border: 1px solid black; padding: 2px; display: inline-block;">◇</div> CUSTOMER. | | | | | | | | | |
| EFF DATE | | 13.09.17 | | EFF DATE | | | | EFF DATE | | | | <div style="float: right; text-align: center;"> NO OF TEETH :- 32 MODULE :- 2.0 </div> | | | | | | | | | |
| PROTOTYPE | | ✓ | | PRELAUNCH | | | | PRODN | | | | | | | | | | | | | |
| O.E. | | ✓ | | EXPORT | | | | | | | | | | | | | | | | | |
| PART NO. ED 24125 (1570138) | | | | MATERIAL - : 16MnCr5 COMP. WT - : 0.172 Kg. * HEAT-TREATMENT- : * MARKING ; PRE-WASHING ; PRE-HEATING ; CARBURISING ; HARDENING ; POST-WASHING ; TEETH CHAMFERING ; SHOT BLASTING ; | | | | A1 | | B | | | | C | | | | | | | |
| PART NAME | | GEAR 32T- STARTER IDLE NO.2 | | | | | | OPN. NO. | | 70 | | | | D | | E | | F | | | |
| CUSTOMER | | ROYAL ENFIELD | | | | <div style="float: right; text-align: center;"> * MARKING HERE <small>ENSURE STEEL HEAT CODE & PART NO. * 1570138 * & VENDOR CODE (ALREADY MARKED IN BLANK STAGE OTHERWISE TO BE MARKED)</small> </div> | | | | | | | | | | | | | | | |
| OPERATION | | * HEAT - TREATMENT | | | | | | | | | | | | | | | | | | | |
| CELL [OPTIONAL] | | M./C. | | M / C NO. [OPTIONAL] | | | | | | | | | | | | | | | | | |
| FIXTURE | | FIX. NO. | | TOOL | | | | | | | | | | NO. | | | | | | | |
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| SR. NO. | | CHARACTERISTICS | | SPL CHAR CLASS | | PRODUCT SPECIFICATIONS | | EVALUATION MEASUREMENT TECHNIQUE | | SAMPLING | | CONTROL METHOD | | CORRECTIVE ACTION / REACTION PLAN | | | | | | | |
| | | PRODUCT | | PROCESS | | | | INSTRUMENT | | NO. | | SIZE | | FREQ | | | | | | | |
| 1. | | EFF. CASE DEPTH | | | | <div style="text-align: center;"> REFER ABOVE TABLE </div> | | MICRO-HARDNESS TESTER | | --- | | 1 PC | | PER CHARGE | | <div style="border: 1px solid black; padding: 5px; transform: rotate(-5deg); display: inline-block;"> FOR REFERENCE ONLY </div> | | | | | |
| 2. | | SURFACE HARDNESS | | | | | | HARDNESS TESTER | | --- | | 5 PC | | PER CHARGE | | | | | | | |
| 3. | | CORE HARDNESS | | | | | | HARDNESS TESTER | | --- | | 1 PC | | PER CHARGE | | | | | | | |
| 4. | | MICROSTRUCTURE | | | | MICROSCOPE | | --- | | 1 PC | | PER CHARGE | | | | | | | | | |
| 5. | | SHOT BLAST | | | | FREE FROM RUST & SCALE | | VISUAL | | --- | | 100% | | PER CHARGE | | | | | | | |
| 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. | |