	COMMERCI						CON	TRC)I P	I AN	90 - PRE 1	EV. OPN.	TION 110 (NEXT. OPN.		JRFACE FINIS			
	NIT:EICHER EN ROL PLAN NO:24			MPONI	ENTS;DEV	VAS)UNII:-I	'										REV-01	(DATE-	-05.1
EFF [00.47	EFF DATE		LOCATION -					1:- SK, LE N>	VA, SRS, IDS, I SPL.CHAR.			\top	CUSTOMER.	—	EVISI
				.09.17	+				REST		CLAMP -	_ N - D	SPL.CHAR. (CRITICAL D	IMN.)	> 5550		CUSTUMER.	A1	A2
PRUT	OTYPE \	PRELAU			PRODN		MATERIAL -		<u> </u>	NOTE :- # SEPARA PLANS								D	E A
O.E. EXPORT						COMP. WT	COMP. WT -: 0.72 Kg.			ATE CONTRO AVAILABLE.	-						ASP	AAA BY MATI	
PART NO. ED 2452 (575419/d)							★ HEAT-TREA	TMENT	• :	NOTE:								Y ANTH	MATERIAL SCM 420 REMOVED REVISED AS PER CUST'S LATEST DRG. REVd BY-VSG. DT-13.12.17.
PART NAME SHAFT, COUNTER (INPUT) OPN. NO. 100					MARKING ;		_	1. APPLY STOP OFF PASTE / ANTICARB PASTE IN THE AREA SHOWN "X" (i.e in 15.1 mm)								ARBUR	M 420 R		
CUSTOMER ROYAL ENFIELD					PRE-WASHII PRE-HEATIN			(,								EMOVE			
OPE	OPERATION * HEAT - TREATMENT					CARBURISING ;											PASTE 1	REVISE	
CEL	L [OPTIONAL]		M./C. M./C NO. [OPTIONAL]				HARDENING;				FOR REFERENCE ONLY							5.1 WAS	D ASPE
		S.	.Q.F.				POST-WASH SHOT BLAS	-								"" 15	. 🖍	17.3 & P /-c) DT-2	RCUST
FIXTURE		FI	FIX. NO. TO		DOL	NO.	course same i								Y STOP OFF PASTE HERE "X"=15.1 ATT			: 17.3 & PICTORIAL \ V-c) DT-27.07.17 BY	'S LA TES
							STRAIGHTNI		#									BY-VSG	T DRG.
							\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	ر کی			7//////	Transista	7//		70777	777	7	CHANGED	REVd.
] { \$ \$ }			· / / / / / / / / / / / / / / / / / / /						j	В		
							\ \rangle \lambda \rangle \ran									<u>4</u>			
							_	MARK CHARGE NO. HERE Z=13										<u>s</u> _	
							SURFACE HARDNESS CORE HARDNESS EF		FECTIVE CASE DEPTH		MICROSTRUCTURE		THREAD AREA HARDNESS						
							ALL AREA	AT RCD	١	AT PCD	CASE		CORE	AT ROOT 0.2 mm DEPTH THREAD ROOT DEP					
							80-84 HRA	330-480	LIV4	0.6-0.9 mm	FINE TEMPER	RED	LOW CARBON	300-450 HV1					
							- 00-04 MA	330-460 HV I		CUT OFF 513 HV1	MARTENSITE AND FREE FI GBO<20 micr	OM CARBIDE	MARTENSITE + ES BAINITE	(AFTER THREADING	;)				
							NOTE:- 1) GROUND SURFACE :- HARDNESS AT 0.1MM SHALL BE 650 HV MIN.												
١	CHARAC	TERISTICS			PROD	UCT	EVALUATION TECHNI	MEASURE	MENT	SAMI	PLING			CORRECTIVE ACTION		ıN /			
SR 10.	PRODUCT	PRO	OCESS	CHAR CLASS	SPECIFIC	ATIONS	INSTRUMENT		NO.	SIZE	FREQ	RESP.	CONTROL METH	HOD REACTION PLAN			J. 7		
1.	EFF. CASE DEPTH	IRFACE HARDNESS					MICRO-HARDNESS TESTER	S .		1 PC	PER CHARGE	~INSPTR.	TESTING			URNACE SETTING DATA]	
2.	SURFACE HARDNE			₿	REFER ABOVE					5 PC	PER CHARGE	~INSPTR.		CONFI	CONFIRM FOR CORRECTNESS		-88		
3.	CORE HARDNESS			~			HARDNESS TESTE	R -		1 PC	PER CHARGE	~INSPTR.							
4.	MICROSTRUCTURE				TAL	BLE	MICROSCOPE			1 PC	PER CHARGE	-							
5.	HARDNESS ON THR AREA " X "	PEAD			1		HARDNESS TESTE	R R		1 PC	PER CHARGE								
6A.	SHOT BLAST				FREE FROM RUST & SCALE		VISUAL			100%	PER CHARGE	~INSPTR.							
6B.		SHOT TING	T BLAS-		5 MIN MAX.		SET-UP ON M/C			EVERY BATCH		~INSPTR.							
																_		PA	۰GE
D	RN BY	VIJAY	VIJAY S GIRI			CH	KD BY	R.Pathak				APRD B	Υ	B.Leva				01	11