| | 500 | 7. | Ģ5 | Ċ1 | 4: | έπ | 2 | .1 | ₹ | ş | | | CE | <u>유</u> | S | PAR | PART NO. | | P801 | # | 8 | (UNIT C | |
|------------|---|-----------------------------|------------------------|---|------------------------------|-------------------------------------|----------------------------------|------------------------------|-------------------------------------|---------------------|---|----------------|--------------------------|--------------|------------|--|--------------------|--------|-----------------------|---|--------------------|--|---|
| אם אפר | ITP (Max. IN MICRON) | IGO & NMTP (Max. IN MICRON) | MICROSTRUCTURE AT CORE | MICROSTRUCTURE AT CASE | CORE HARDNESS AT RCD | CUT PART FOR C | CUT PART FOR C | SURFACE HARDNESS | PRODUCT | ž | | FIXTURE | CELL [OPTIONAL] | OPERATION | CUSTOMER | PART NAME SI | NO. | 0.E | PROTO-TYPE | EFF. DATE 22.0 | CONTROL FLAN NO: | COMMERC IIT : EICHER | |
| M PATE | (אסא) | ex. IN MICRON) | IRE AT CORE | IRE AT CASE | IS AT RCD | CUT PART FOR CASE DEPTH ON RCD | CUT PART FOR CASE DEPTH ON PCD | DNESS | | CHARACTERISTIC | | FIX. NO. | M.C. INSP. DEPTT. | AFTER H/T IN | SKEED NHOF | SUN GEAR | ED 1016 (LVU23493) | 7 | < PRE-L/LINCH | 22.01.12 EFF. DATE | 1016/120 | ENGINEERING | |
| | - | | | | | | | | PROCESS | | | 7001 | | INSPECTION | | OPN. NO. | 123493) | EXPORT | PRODUCTION | 20 12 12 EFF. DATE | - | COMPONENTS; | |
| | | | | | | | | | CLASS | SH SH SH | | | M/C NO. | | | | | | | | | l I | |
| | 0% AT 5% Ma 5% Ma | Į ^ | 70 | TM W (FREE | 25 | 0.55 m | 1.1-1 | Ç _i | 3 | 3 € 3 | | NO. | NO. [OPTIONAL] | | | 128 | | | 5 | 10.02.13 | | DEWAS) | |
| CHICORY | 0% AT SURFACE 5% Max. AT ECD/2 AT PCD 5% Max. AT ECD/4 AT RCD | <_ 25 MICRON | LCM + BANITE | TM WITH 25% RA Max. (FREE FROM CARBIDES) | 25 ~ 45 HRC | 0.55 mm. Min (AT515Hv) | 1.1 ~ 1.3 mm. (AT515Hv) | 58 - 64 HRC. | PRODUCT / PROCESS SPECIFICATIONS | | | | | | | | | | 8 | | 5 | | |
| | | | | RA Max. ARBIDE | | 47515Hv | 7515Hv) | ► | | | NOTE:- | B. | | | | | | | ₹ XT | TERIAL | LOCATION | CONT | |
| | | | | | | | | | _ | 1 | 1. IF CA: SPECI 2. SAMP LOCA 3. IN CA LOAD | DATE: 14.04.15 | | | | | | | COMP. WT. = 1.483 KG. | MATERIAL -: 20 MnCr 5 | | TROL | |
| R. PATHAK | MICROSCOPE 100X | MICROSCOPE 100X | MICROSCOPE AT 500X | MICROSCOPE AT 500X | ROCK WELL HARDNESS TESTER | AUTOMATIC VICKER HARDNESS TESTER | AUTOMATIC VICKER HARDNESS TESTER | ROCK WE | INSTRUMENT | | 1. IF CASE DEPTH FOUND LOWER OR HIGHER L SPECIFICATION TWO PART CHECK. 2. SAMPLE SHOULD BE CHECK BEST & WORST LOCATION FOR CASE DEPTH & MICROSTRUG 3. IN CASE RA IS MORE THAN 25% CHECK HAR LOAD VICKER HARDNESS) AT 0.1mm. IN SHK | E | FOR REFERENCE ONLY | | | | | | G. | 를 다. 5 5 5 5 5 5 5 5 5 5 5 5 5 5 7 5 7 5 7 5 | REST | • | |
| | | | | OPE AT 50 | LL HARDN | AUTOMATIC VICKER HARDNESS TESTER | IC VICKER | ROCK WELL HARDNESS TESTER | 37 | TECHNIQUE | H FOUNI N TWO P JLD BE (R CASE NORE 1 | , | | | W ! | | | | | | 57 | PLAN | - |
| | | | × | ă | IESS | ~~~ | | IESS | | MEASUREMEN! | D LOWER ART CHE HECK B DEPTH & THAN 259 | | , | | | -# | | | | | | Z | |
| | | ı | ı | 1 | ı | ı | ı | 1 | NO. | Į. | ER OR HIG HECK. (BEST & W I & MICRO! 15% CHECH | | | | | - | • | | <u></u> | | CLAMP | 115-ST | |
| | 1 B | 1 PC | 1 PC | 1 PC. | 1 B | 1 PC. | 1 B | 1 PC. | SIZE | 8 | 1. IF CASE DEPTH FOUND LOWER OR HIGHER LIMIT OF SPECIFICATION TWO PART CHECK. 2. SAMPLE SHOULD BE CHECK BEST & WORST LOCATION FOR CASE DEPTH & MICROSTRUCTURE. 3. IN CASE RA IS MORE THAN 25% CHECK HARDNESS (WITH 100 GM LOAD VICKER HARDNESS) AT 0.1mm. IN SHOULD BE 58 HRC. Min. | | | A | <u> </u> | A | | 16 | <u> </u> | | | PREV. OPN. 115 - STRAIGHTENING | |
| APRD BY | | PER CHARGE | PER CHARGE | PER CHARGE | | C. PER CHARGE | PER CHARGE | PER CHARGE | E FREQ. | SAMPLING | T OF RE. BESS (WII | | | | | <u> </u> | | | | | V ₩ | | |
| | | | _ | | | ନ୍ଧ | | _ | 5 | | 품 100 Q | | | | - | $+ \parallel$ | | | | | CRITICA CRITICA | NEXT. OPN. | |
| 3 0 | SELF INSPECTION | SELF INS | SELF INSPECTION | Self inspection | SELF INSPECTION | SELF INSPECTION | SELF INSPECTION | SELF INSPECTION | | CONTROL METHOD | | | _ * | - | <u> </u> | - i - i | _ > | | | | CRITICAL DIMN.) | NEXT. OPN. - BURRFILING | |
| B. LEVA | PECTION | INSPECTION | PECTION | PECTION | PECTION | PECTION | PECTION | PECTION | 3 | NETHOD CO- | SECTION - 'A-A' | | _ | | 4 | اللا | | | | | - (a) | - | |
| | | | | | | | | _ | 8 % | | Ž | - \ | | | | | | | | | 8 | SURFACE FINISH | |
| | | | | | | | | SORT/REWORK; | ACTION F | VARECTIVE | A (3) | | 3) A) | | | | | | | | \Diamond | | |
| | | | | | | | | :WORK; | Y | CORRECTIVE ACTION / | ? | | 7) 2) | | | | | | | | CUSTOMER'S | DOC. NO. : APO4 : 180 : 20 ISSUE-3 REV : 00 (01/11/0) | |
| PAGE | | | | | | | | | | _ | NEW DRIG (REY-ES) (DATE 19.02.13) | CETTACHI | n saemousick | AS PER C | CEISIA | H NY | i TONU | ——— | 0 | 7 | 66 | REV: | |