CONTI	ROL PLAN NO	ENGIN	EEDINIO OO		MITED.		CONT	ΓRΩI	ΡΙ ΔΝ		REV. OPN.				SURFACE FIN	APO		<u> </u>
EFF D		(UNIT:EICHER ENGINEERING COMPONENTS;DEWAS)UNIT:-										100 - PRE HT INSPECTION 120 - CENTER LAPPING CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG					DATE	-05.10.
PROTO					KEY CONTACT PERSON :- S. KOMULWAD LOCATION —										·	REVISION		
					EFF DATE		LOCATION			CLAMP	— N →	(CRIT	THAR. FICAL DIMN.)) B EECD		CUSTOMER.	Α	В
PARI	PROTOTYPE PRELAUNCH PRODN O.E. EXPORT					MATERIAL -	DIN 172	10 4 SEPARAT	NOTE :- # SEPARATE CONTROL PLANS AVAILABLE.							D	E	
	T NO.	ED 241	00 (1570030/	a)	,		COMP. WT -		(g. PLANS AV	/AILABLE.								
PART NAME SHAFT - COUNTER (INPUT) OPN. NO. 110					★ HEAT-TREAT MARKING ;	IMENI-:		NOTE:										
CUST	TOMER	MER ROYAL ENFIELD					PRE-WASHIN	•	1.7	1. APPLY STOP OFF PASTE / ANTICARB PASTE IN THE AREA SHOWN "X" (i.e in 17.3 mm)								
OPEF	PERATION * HEAT - TREATMENT					PRE-HEATING CARBURISING		ONLY										
CELL [OPTIONAL] M./C. S.Q.F.					HARDENING; POST-WASHI SHOT BLAST	FOR REFERENCE ONLY APPLY STOP OFF PASTE HERE "X"=17.3												
FIXTURE		FIX. NO.	TI	DOL	NO.	CENTRE LAPF STRAIGHTNIN	1 7	#	Z=13 (ON THREAD AREA)						→			
												<u> </u>	<u> </u>		///// /////			
							MARK CI NO. HER		<u> </u>	Z=15				Z=18				
							SURFACE HARDNESS	CORE HARDN	SS EFFECTIVE CASE D	EPTH	MICROSTRUCT			THREAD AREA HARDNESS				
							ALL AREA	AT RCD	AT PCD		CASE		CORE	AT ROOT 0.2 mm DEPTH THREAD ROOT DEPTH				
							80-84 HRA	330-480 HV1 CUT OFF 513 HV1 <10% AND FREE FROM CARBIDES MARTE		LOW CARBON MARTENSITE + BAINITE	300-450 HV1	10-450 HV1						
							NOTE:- 1) GROUND SU	URFACE :- HARD	NESS AT 0.1MM SHALL BE	0.1MM SHALL BE 650 HV MIN.					•			
\Box	CHARACTERISTICS		STICS	SPL	PROD	RODUCT	EVALUATION MEASUREMENT TECHNIQUE		T SAI	MPLING				CUBBEC	TIVE ACTION /			
SR NO.	PRODUCT		PROCESS	CHAR CLASS	SPECIFICATIONS		INSTRUMENT	NO.	SIZE	FREQ	RESP.	RESP. CONTROL MET		ORRECTIVE ACTION / REACTION PLAN		UN /		
1.	EFF. CASE DI	. CASE DEPTH					MICRO-HARDNESS TESTER		1 PC	PER CHARG	GE ~INSPTR	. TEST	TING		ACE SETTING DATA &			
2.	SURFACE HARDNESS			₿	REFER ABOVE TABLE		IESIEK		5 PC	PER CHARG	GE ~INSPTR	!		CONFIRM FOR	CORRECTA	RRECTNESS		
-+	CORE HARDNE	-		`			HARDNESS TESTER		1 PC	PER CHARG	SE ~INSPTR	- 						
"	MICROSTRUCTURE			-			MICROSCOPE		1 PC	PER CHARG	_							
5.	HARDNESS ON AREA "X"				1		HARDNESS TESTER	?	1 PC	PER CHARG		4						
-+	SHOT BLAST	SHOT BLAST			FREE FROM RUST & 3		VISUAL		100%	PER CHARG	SE ~INSPTR							
6B.			SHOT BLAS- TING TIME		5 MIN	MAX.	SET-UP ON M/C		EVERY BATCH	EVERY BATCH								
DRN BY						СН	KD BY	R. PATI				APRD BY		B.LEVA				——— AGE 1 / 0: