VE COMMERCIAL VEHICLES LIMITED.
(UNIT:EICHER ENGINEERING COMPONENTS;DEWAS)UNIT:–II

CONTROL PLAN

PREV. OPN.	NEXT. OPN.	SURFACE FINISH :	DOC. NO. :
70 - PRE HT INSPECTION	100 - Q. S. FINAL		APO4 : 160 : 20

CONTROL PLAN NO : *2466 / 080*

LOCATION	REST	CLAMP	SPL.CHAR. (CRITICAL DIMN.)	B EECD	CUSTOMER.	REVISION
		N				

EFF DATE	22.08.2014	EFF DATE	~~03.01.15~~ 06.07.15	EFF DATE	22.12.15
PROTOTYPE	✓	PRELAUNCH	✓	PRODN	✓
O.E.	✓	EXPORT			

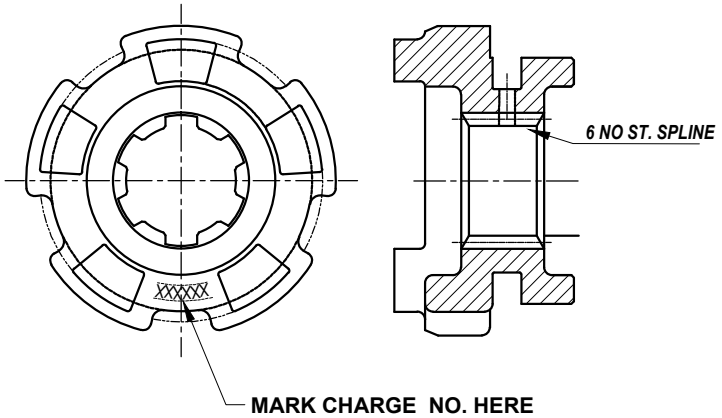
PART NO.	***ED 2466 (574246)***		
PART NAME	***WHEEL, SLIDING DOG***	OPN. NO.	***080***
CUSTOMER	***ROYAL ENFIELD***		
OPERATION	**** HEAT - TREATMENT***		

CELL [OPTIONAL]	M./C.	M / C NO. [OPTIONAL]
	S.Q.F.	

FIXTURE	FIX. NO.	TOOL	NO.

MATERIAL - : 16MnCr5
COMP. WT - : 0.22 Kg.

*** HEAT-TREATMENT- :**
MARKING ;
PRE-WASHING ;
PRE-HEATING ;
CARBURISING ;
HARDENING ;
POST-WASHING ;
SHOT BLASTING ;



SURFACE HARDNESS	CORE HARDNESS	EFFECTIVE CASE DEPTH	MICROSTRUCTURE	
ALL AREA	@ SPLINE RCD (SPLINE TOOTH CENTER)	@ SPLINE RCD (SPLINE TOOTH GAP CENTER)	CASE	CORE
80 ~ 83 HRA	300 ~ 450 HV1	0.6 ~ 0.9 mm CUT OFF 513 HV1	FINE TEMPERED MARTENSITE + RA <10% AND FREE FROM CARBIDES GBO<20 micron,5% CARBIDE IN GLOBULE FORM IN ALLOWED.	LOW CARBON MARTENSITE + BAINITE , 10% FERRITE / FERRITIC PRODUCTS ALLOWED.

SR. NO.	CHARACTERISTICS PRODUCT	CHARACTERISTICS PROCESS	SPL CHAR CLASS	PRODUCT SPECIFICATIONS	EVALUATION MEASUREMENT TECHNIQUE INSTRUMENT	NO.	SAMPLING SIZE	SAMPLING FREQ	CONTROL METHOD	CORRECTIVE ACTION / REACTION PLAN
1.	EFF. CASE DEPTH		B	REFER ABOVE TABLE	MICRO-HARDNESS TESTER	---	1 PC	PER CHARGE	TESTING	CHECK FURNACE SETTING DATA & CONFIRM FOR CORRECTNESS
2.	SURFACE HARDNESS				HARDNESS TESTER	---	1 PC	PER CHARGE		
3.	CORE HARDNESS					---	1 PC	PER CHARGE		
4.	MICROSTRUCTURE				MICROSCOPE	---	1 PC	PER CHARGE		
						---	1 PC	PER CHARGE		
5.	SHOT BLAST			FREE FROM RUST & SCALE	VISUAL	---	100%			

FOR REFERENCE ONLY

A	B	C
A CONTROL PLAN UPDATED AS PER CUST'S LATEST PART DRG. REV.-e. M.W. 21.05.15	B TEMPERING TEMPRATURE RELATED NOTE, REMOVED AS PER CUST'S LATEST PART DRG.REV. (f). (MUKESH 21.12.15)	

DRN BY	Meena		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.