VE COMMERCIAL VEHICLES LIMITED. (UNIT:EICHER ENGINEERING COMPONENTS;DEWAS)UNIT:—						VAS)HINIT:—					PREV. OPN. NEXT. OPN.) - PRE HT INSPECTION 80 - TEETH CHAMFERING			PROJECT : RI SURFACE FINISH DOC. NO. : APO4 : 160 REV-01 (DATE-0)		
CONTROL PLAN NO: 2428 / 070						1/13/011111	· · · · · · · · · · · · · · · · · · ·				E TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG					05.10 VISIO
EFF D	ATE 24.08.	4.08.2016 EFF DATE EFF DATE			LOCATION			CLAMP	•	.CHAR. ITICAL DIMN		CUSTOME	 	A 2		
PROTOTYPE PRELAUNCH PRODN O.E. EXPORT				MATERIAL -: S COMP. WT -:	AE 8620H 0.447 Kg. A 2		. ^^	•	NO OF TEETH MODULE :- 2.0	:- 39	GEAR TEETH TO BE GROUND IN FURTHER		MATERIAL			
=					★ HEAT-TREAT			M				OPERATION				
					₩ MARKING ;		9	"/	+ 15			/- G	DNESS :	SCM 420 REMOVED REVISED		
UST	OMER						PRE-WASHING; PRE-HEATING;		5/		1 /2) 			80-84 HF	MOVED
PEF							CARBURISING:			1	\ \ \?	>			HRA WAS 80-83 I	REVISE
CELL [OPTIONAL] FIXTURE			M./C. M / C ! S.Q.F.			. [OPTIONAL			2		5	<u>}</u>	3		1-83 HRA STOMER	D AS PER CUST'S LATEST DRG
AVAILABLE AT H.T			FIX. NO. TOOL		TOOL	NO.	(REFER SEP. COI SHOT BLASTIN	NTROL PLAN)		W.	WW.			SEE PUNCH MARK BEFORE JOB LOADING	RDNESS 330-41	EST DRG. REV.+e,
							** GROUND SURFACE - BORE, BOTH OUTER FACES & GEAR TEETH, AS MENTIONED WITH 'G'. CHARGE NO. MARKING WITHIN DIA. 52 - 57 STEEL HEAT CODE & VENDOR CODE ALREADY MARKED - THOUGH THIS WILL BE VANISHED AFTER FACE MACHNING. SO WILL BE MARKED AGAIN ON LASER MACHINE. IT SHOULD BE MARKED AGAIN TO AVOID MIX UP WITH ANOTHER BATCH.								HV1 WAS 300-450 3Y-VSG, DT-04.10	.е, BY-VSGDT13.12.17
							SURFACE HARDNE	SS CORE HAR	DNESS E	FFECTIVE CA	SE DEPTH		MICROSTRUCTUR	E)HV1 &	2.17
							ALL AREA	AT RC	D UNG	ROUND AREA	GROUND AREA 🛨	CA	ISE	CORE		
							80 ~ 84 HRA	330 ~ 480	CUT	0.9 mm OFF 513 HV1 #	0.5 ~ 0.8 mm CUT OFF 513 HV1	FINE TEMPERED MARTENSITE + RA <10% AND FREE FROM CARBIDE GBO<20 micron		LOW CARBON MARTENSITE + S BAINITE		
							NOTE:- 1) GROUND SURFACE :- HARDNESS AT 0.1MM SHALL BE 650 HV1 MIN. # FOR PROCESS CASE 0.7 - 0.9 MM									
SR.	CHARA	CHARACTERISTICS PRODUCT PROC		STICS SPL		UCT	EVALUATION ME TECHNIQUE	ASUREMENT	S.A	AMPLING			CUBBEC.	TIVE ACTION /		
R. - O.	PRODUCT			CHAR	1 SPECIFIC	ATIONS	INSTRUMENT	NO.	SIZE	FREQ	CONTROL M	1ETHOD		ON PLAN		
1.	EFF. CASE DEP	ТН					MICRO-HARDNESS TESTER		1 PC	PER CHAI	RGE TESTING		CHECK FURNACE	E SETTING DATA &		
2.	SURFACE HARDI	VESS			DE I	EED.			5 PC A	PER CHAI	RGE		CONFIRM FOR C	URRECTNESS		
-+	CORE HARDNESS	3		~	REFER ABOVE TABLE		HARDNESS TESTER		1 PC	PER CHAP	RGE	FOR REFEREN		TEDENCE ONLY		
\top	MICROSTRUCTURE				- I	DLE			1 PC	PER CHAF	RGE FO					
4.				$ \diamond $			MICROSCOPE		1 PC							
5.	SHOT BLAST					ROM RUST SCALE	VISUAL		100%	PER CHAF	RGE					
DRN BY		1	VIJAY S GIRI		1	CI	HKD BY	R.PATHAK	HAK		APRD BY		B.LEVA			PAGE 01 / 02