(L	E COMMERCIAL					90 - PRE I	PREV. OPN. NEXT. OPN. 90 - PRE HT INSPECTION 110 - TEETH CHAMFERING CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSC				PROJECT NA NO. : PO4 : 16 7-01 (DATE-05.)				
CONTROL PLAN NO: 2443 / 100  EFF DATE								REST -	υ 	CLAMP	AM :- SK, LE N>	SPL.CHAR. ( CRITICAL DIMN.			RE
				MATERIAL -: SAE 8620H				CHARGE NO. MARKING HERE							
0.E. EXPORT  PART NO. ED 2443 (575408/c)					COMP. WT -: 0.34 Kg (A)3				ENSURE STEEL HEAT CODE & PART NO. * 575408 * & VENDOR CODE (ALREADY MARKED IN BLANK STAGE OTHERWISE TO BE MARKED)						
PART NAME   GEAR, 6th DRIVEN   OPN. NO. 100						* HEAT-TREATMENT-:  * MARKING;					$M_{\lambda}$			}	150 HV VGES 1 4.04.17
OPE		TREATMENT	Γ			PRE-WASHIN PRE-HEATIN	•		S			75			AS PER
CE	CELL [ OPTIONAL ] M./C. M / C NO. [ OPTIONAL ] S.Q.F.					CARBURISING; HARDENING; POST-WASHING;								R INPUTS GIVEI	
	FIXTURE	FIX. NO.	IX. NO. TOOL		NO.	TEETH CHAMFERING;		;							S PER INPUTS GIVEN BY NPD EXECUTION TEAM.
									RDNESS   EFFECTIVE CASE DE			TH MICROSTRUCTU		JRE	TTION TEAM.
						ALL AREA		AT RCD (MIDDLE OF TEET		AT PCD. A		CASE		CORE	G, D1-14.00
						58 ~ 62 HRC (TARGET 60 - 6	AÀ AÀ 2 HRC)	330 ~ 4	180 HV1 🞪		T OFF 513 HV RGET 0.8-0.85mm 5 ~ 0.95 mm	FREE FROM CA GBO<20 MICRO	RA <10% AND ARBIDES ON, 5%	LOW CARBON MARTENSITE + BAINITE	SURFACE HARDNESS 58 - 62 HRC WAS 80 - 84 HRA & ECD 30,60,9 MM REVISED AS PER DCR NO1115, DT-29.01.18, B'
C D	LHARALTERISTILS		SPL	PRODUCT		EVALUATION TECHNI	MEASUREM	REMENT		IPLING			CORRECTIVE ACTION /		ARDNES
SR. NO.	PRODUCT	PROCESS	CHAR CLASS	SPECIFICATIONS	5	INSTRUMENT		NO.	SIZE	FREQ	RESP.	CONTROL METHOD		TION PLAN	3S 58 - 6; AS PER
1.	EFF. CASE DEPTH					MICRO-HARDNESS TESTER			1 PC	PER CHARG	E ~ INSPTR.	TESTING		NACE SETTING DATA	DCR NO.
2.	SURFACE HARDNESS		$\langle B \rangle$	☆ REFER		HARDNESS TESTE			5 PC	PER CHARG	E ~ INSPTR.		JOIN INW FO	ON CONNECTIVE CO	S 80 - 8 -1115, D
3.	CORE HARDNESS			ABOVE TABLE		THE TENEDO TESTE			1 PC	PER CHARG	E ~ INSPTR.			- 21    1/	4 HRA & T-29.01.
4.	MODOSTRUOTUSE		₿			MICROSCOPE			1 PC	PER CHARG	E ~ INSPTR.	FOR RE	FERENCE ONLY		ECD 0. 18. BY-1
	MICROSTRUCTURE		~			13.10.100001 E			1 PC	PER CHARG	E ~ INSPTR.	10111			65-0.95 /SG, D1
5.	SHOT BLAST			FREE FROM RU & SCALE	FREE FROM RUST & SCALE				100%	PER CHARG	E ~ INSPTR.				0.65-0.95 MM WAS Y-VSG, DT-29.01.18.
	DRN BY	VIJAY S GIRI					R. PA				•	'			PAI