

CONTROL PLAN

CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG



CLAMP	—N→	SPL.CHAR. (CRITICAL DIM.)	 EECD	 CUSTOMER.				
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MATERIAL - : SAE 8620H
COMP. WT - : 0.447 Kg. ^{A2}

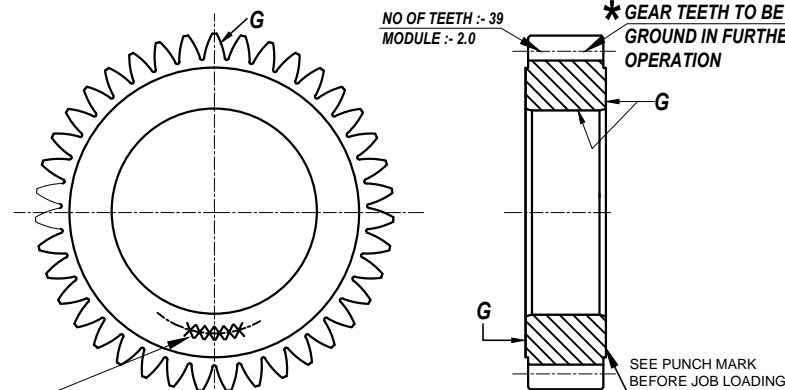
*** HEAT-TREATMENT-:**


- * MARKING ;
- PRE-WASHING ;
- PRE-HEATING ;
- CARBURISING ;
- HARDENING ;
- POST-WASHING ;
- TEMPERING ;
- TEETH CHAMFERING
(REFER SEP. CONTROL PLAN);
- SHOT BLASTING ;

* GROUND SURFACE - BORE, BOTH OUTER FACES & GEAR TEETH, AS MENTIONED WITH 'G':


SURFACE HARDNESS	CORE HARDNESS	EFFECTIVE CASE DEPTH		MICROSTRUCTURE	
ALL AREA	AT RCD	UNGROUND AREA	GROUND AREA *	CASE	CORE
80 ~ 84 HRA 	330 ~ 480 HV1 	0.6 ~ 0.9 mm CUT OFF 513 HV1 #	0.5 ~ 0.8 mm CUT OFF 513 HV1	FINE TEMPERED MARTENSITE + RA <10% AND FREE FROM CARBIDES GBO<20 micron	LOW CARBON MARTENSITE + BAINITE

NOTE:- 1) GROUND SURFACE :- HARDNESS AT 0.1MM SHALL BE 650 HV1 MIN.
FOR PROCESS CASE 0.7 - 0.9 MM



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.*

SR. NO.	CHARACTERISTICS		SPL CHAR CLASS	PRODUCT SPECIFICATIONS	EVALUATION MEASUREMENT TECHNIQUE		SAMPLING		CONTROL METHOD	CORRECTIVE ACTION / REACTION PLAN
	PRODUCT	PROCESS			INSTRUMENT	NO.	SIZE	FREQ		
1.	EFF. CASE DEPTH		◇	REFER ABOVE TABLE	MICRO-HARDNESS TESTER	---	1 PC	PER CHARGE	TESTING	CHECK FURNACE SETTING DATA & CONFIRM FOR CORRECTNESS
2.	SURFACE HARDNESS				HARDNESS TESTER	---	5 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

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A7	SURFACE HARDNESS 80-90 HRA HAS MAX 0-3 HRA & CORE HARDNESS 50-60 HRY HAS 30-60 HRY RADIAL LOCATION DEFINED AS PER CUSTOMER LATES DRAWING REV. 4 BY: ASG, DT: 04-10-17
A7	MATERIAL SCM 420 REMOVED REVISED AS PER CUSTS LATEST DRG. REV. 4, BY: VSG, DT: -13.12.17.

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