- (Format No:- AP04:460:10Z						
							MA	TERL	AL I A	BORA	TORY	REPO	ORT								
Repo	rt No	U2F5	518040)94																	
	No/Pa		800 /		30400	5	Part I	Name	MAIN SHAFT					Date:			2018-04-28				
Qty - Customer:								mer:	ZF				Batch			·:		E2D18661			
1) Raw Material : ZF7B Heat No:									24KM4								J575				
_	hemis		21 7 2				ricat	140.		ZTINIVIT				oteel Code.				3010			
_		_							С	Mn	s	P	Si	Ni	Cr	Мо	V	AI	В	Cu	
Elements (%) →											0.020	<u>. </u>	01	INI	1.0	IVIO	V	0.028		Cu	
Min Max										1.40	0.020		0.20	0.30		0.000	0.003	0.028		0.30	
IVIAX									0.20	1.40	0.033		MAX		1.30	MAX		0.050	Ī	MAX	
Obsc	rvotio								0.18	1.23	0.02		0.22	_	1.06	IVIAA	3	0.02		0.06	
Observation 2) Heat Treatment: Case carburised, hardened & tem										1.23	0.02	0.02	0.22	0.06	1.00	ļ-	ļ-	0.02	<u> </u>	0.00	
2) П	at He	aumer						x temp	berea			2411	ordoo								
			HAR	DNESS	TRAV	ERSE G	RAPH					—	ardne	SS	lo	<i>c</i> : <i>c</i> : _	_	0			
	00											Location			Speci		<u>n</u>				
												SURFACE			59-63 HRC			61			
75	so 🔨											AT Machine area						60			
												CORE AT RCD			265 MIN, HBW			362			
£ 7		_								- PCD		?265HBW/						ļ			
E 700										+ RO	D	(27HRC) Min (5MM BELOW									
E 830										SURFACE)											
															L L L L L L L L L L L L L L L L L L L						
	00				7/															<u> </u>	
- \												Local	Location			Specification (mm)			Observation (mm)		
0.1 0.2 0.2 0.4 0.5 0.6 0.7 0.5 0.9 1.0 1.1 1.2 1.2 1.4 1.5 1.6 1.7 1.5												At Spline RCD			` '			1.0			
0.1 0.2 0.2 0.4 0.3 0.6 0.7 0.8 0.9 1.0 1.1 1.2 1.2 1.4 1.5 1.6 1.7 1.8 Distance in MM										At Spline K			<u> </u>	0.00-1.0			1.0				
													AT FINIOU			O CO MINI			-		
											AT FINISH MACHINE A			٨٥Ε٨	0.60 MIN.			0.94			
2 2 4	ordno	oo tro	vese re	nort								IVIACI	IIINE /	ANLA							
Dista		0.2		0.4	0.5	0.6	0.7	0.8	0.9	1	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2.0	
nce	0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.6	0.9	'	'-'	1.2	1.3	11.4	1.5	1.6	1.7	1.0	1.9	2.0	
from																					
surfa																					
ce in																					
mm																					
PCD																					
RCD	767	758	731					650	634	610	575										
B/G	755	734	720	t	1	1	1		624	589		t				l		1		+	
OD	1	1		1				1	1	1										1	
2.4 N	licrost	ructur	e:		•		•	•	•		•	•		•	•	-	•	•	•	•	
Loca	ion						Spec	ificatio	n						Observation						
											ensite with 5 - 30 % RA				T.M+R.A.5-10%						
Carbides Network Nil																					
COR		201					+	carbor	Mart	ensite + Bainite Low L.C				LCN	∩ M±Rainite						
	_									ensite + Bainite Low carbon					L.C.M+Bainite						
										Bainite Low carbon											
										Bainite											
IGO- RCD <20															18						
- 1															<u>-</u>						
Disno	sition	- ACC	EPTE	D			1														
			/LI IL	ر.																	
Remarks :- OK												ulo.									
Checked by :- Jai narayan Verified by :										Rajvardhan gautam Ap					proved by :- Ravindra kale						