(UNIT:EICH		ERING CO			EWAS)UNIT:-				80 - PR	PREV. OPN. 80 - PRE HT INSPECTION 100 - TEETH CHAMFERING CORE TEAM :- SK, LEVA, SRS, IDS, MM, KUNAL, MJ, VSG				04 : 16 -01 (DATE	160 E-05.
ONTROL PLAN NO: 2475 / 90 FF DATE 31.08.2016 EFF DATE 11.09.17 EFF DATE					KEY CONTACT PERSON :- S. KOMULWAD LOCATION REST → → → → →			CLAMP -N -> SPL.CHAR. (CRITICAL DIMN.) B EECD CUSTOME						REVIS	
ROTOTYPE	PRELAUNCH PRODN			MATERIAL - : S. COMP. WT - :	AE 862	OH,	CLAPIF	₩ CHA	ARGE NO. MARKING JRE STEEL HEAT CODE,	HERE	NO OF TEETH :- 2 MODULE :- 2.5	25 D	A2 E		
O.E. EXPORT						* HEAT-TREATMENT-:			PART NO. " 575433 " & VENDOR CODE ALREADY MARKED IN BLANK STAGE OTHERWISE TO BE MARKED					A1 30 SE	<u>A</u> 2 ₹ ≸
PART NO. ED 2475 (575433/c)						** MARKING ;									MATERIAL SCM 420 REMOVED REVISED AS PER COSTS LATEST DRG. REVBY-VSG, DT-13.12.17.
ART NAME	GEAR, 4TH DRIVEN OPN. NO. 90				PRE-WASHING;				-57/V	2			HARDN 11 ASP	SCM 4	
USTOMER ROYAL ENFIELD					PRE-HEATING;				1/1	7			ESS 80 ER CUS	20 KEN	
	ERATION * HEAT - TREATMENT					CARBURISING;			<u> </u>	}	12	##		STOME	04.0
CELL [OPTIONAL]		M./C. M./ C. NO. [OPTIONAL]			HARDENING;			$ \downarrow $ $ $		12			A WAS	7 4 5	
		S.Q.F.				POST-WASHING TEETH CHAMFER	•	/ 2/			\mathcal{C}			80-83 F TEST D	3
FIXTURE		FIX. NO. TOOL		DOL	NO.	(REFER SEP. CON	AN);			>		<u></u>	HRA & C	5	
						SHOT BLASTING	i ;		VII	7/1/			4	G REV	
									اً ا					b. BY-V	5
						SURFACE HARDN	IESS	CORE HARDNESS	EFFECTIVE CASE DEPTI		TH MICROSTRUCTU		IDE	ESS 330 'SG DT-	2
							1200	AT RCD	EFFECTIVE CASE BEFT		TI WIIOKOOTKOOTA		/// /	80-84 HRA WAS 80-83 HRA & CORE HARDNESS 330-480 HV1 WAS USTOMER'S LATEST DRAWING REV-b. BY-VSG DT-14.07.17	
						ALL AREA		(MIDDLE OF TEETH)	A	T PCD		CASE	CORE	V1 WAS	
								^	PROCESS	0.7 ~ 0.9 mm	FINE TEMPERED MARTENSITE + RA <10% AND FREE FROM CARBIDES		LOW CARBON MARTENSITE + BAINITE		
						80 ~ 84 HRA		330 ~ 480 HV1	REQUIRED	CUT OFF 513 F					
								330 - 400 1171		0.6 ~ 0.9 mm	GBO<20 mi	cron, 5%			
						-			REQUIRED	CUT OFF 513 F	IV1 CARBIDE IN				
					+	NOTE:- 1) GROUND SURFACE : HARDNESS @ 0.1mm SHALL BE 650 HVI MIN.									
R. CHARACTE		ERISTICS		1	ODUCT	EVALUATION MEAS TECHNIQUE	SUREMENT	SAM	1PLING	RESP.	CONTROL METHOD		RECTIVE ACTION /		
O. PROI	PRODUCT PROCE		CHAR CLASS	SPELIF	ICATIONS	INSTRUMENT	NO.	IO. SIZE	FREQ	CONTROL METH	REA	CTION PLAN			
. EFF. CAS	SE DEPTH		- (₿)			MICRO-HARDNESS TESTER		1 PC	PER CHAR	GE ~ INSPTR.	00		FURNACE SETTING DATA & I FOR CORRECTNESS		
SURFACE HARDNESS CORE HARDNESS			₿			UADDNESS TESTES		5 PC	PER CHAR	GE ~ INSPTR.					
			(₿)] `A	BOVE ABLE	HARDNESS TESTER		1 PC	PER CHAR	GE ~ INSPTR.]		_		
4. MICROSTRUCTURE			₿		JULL			1 PC	PER CHAR	GE ~ INSPTR.	FOR REFERE		NCE ONL	Y	
						MICROSCOPE -		1 PC	+	GE ~ INSPTR.	FOR	REFERE	INOL G	+	
. SHOT BL	AST				FROM RUST SCALE	VISUAL		100%	_	GE ~ INSPTR.					
DRN BY		VIJAY S GIRI				L L L R.PATHAK		IK		APRD BY	,	B.LEVA		P.A	AGE