

VE Commercial Vehicles Ltd. Unit : Eicher Engineering Components, Dewas		GAS NITRIDING FURNACE STANDARD CYCLE SHEET FOR CIPL Parts			Doc No		AP03:460:44 A	
					Rev. No.		0 (25.08.2016)	
					Rev. Date			
S.N.	Parameters	Set Value	Process Tolerance		S.N.	Parameters	Set Value	Process Tolerance
1	Preoxidation Temp	330°C	± 5		5	NH ₃ Boosting Temp	≥450°C	--
2	Preoxidation Time	60 mins	± 5		6	NH ₃ Boosting Time	60 mins	± 5
3	Nitrogen Purging Time	60 mins	± 5		7	NH ₃ Boosting Flow	6 m3/hr	± 1
4	Nitrogen Purging Flow	6.5 m3/hr	± 1		8	Unloading Temp	100°C	± 20

Note : 1. Ensure furnace pressure 3-6 mbar throughout the process.

2. Check and record dissociation by manual method at frequency every 2 hours.

	ITEM CODE	EECD PART NO.	Material Grade	Nitriding 1 Temp. (± 5°C)	Nitriding 1 Time (± 1 Hrs)	Nitriding 1 Constant Kn (± 2)	Nitriding 2 Temp (± 5°C)	Nitriding 2 Time (± 1 Hrs)	Nitriding 2 Constant Kn (± 2)	Remarks Page No.
1	105-0226	3100	1E1286A	510	4	10	525	10.5	3	1
2	187-8196	3123	1E1286A	510	4	10	525	10.5	3	1
3	187-8197	3124	1E1286A	510	4	10	525	10.5	3	1
4	9Y-1982	3125	1E1286A	510	4	10	525	10.5	3	1
5	100-2851	3126	1E1286A	510	4	10	525	10.5	3	1
6	9Y-1986	3127	1E1286A	510	4	10	525	10.5	3	1
7	7W-0993	3136	1E1286A	510	4	10	525	10.5	3	1
8	1W-5431	3137	1E1286A	510	4	10	525	10.5	3	1
9	9Y-2093	3144	1E1286A	510	4	10	525	10.5	3	1
10	2W-0499	3148	1E1286A	510	4	10	525	10.5	3	1
11	1T-1227	3152	1E1286A	510	4	10	525	10.5	3	1
12	225-4286	3153	1E1286A	510	4	10	525	10.5	3	1
13	155-2946	3156	1E1286A	510	4	10	525	10.5	3	1
14	187-8194	3157	1E1286A	510	4	10	525	10.5	3	1
15	215-1816	3165	1E1286A	510	4	10	525	10.5	3	1
16	287-8357	3167	1E1286A	510	4	10	525	10.5	3	1
17	287-8358	3168	1E1286A	510	4	10	525	10.5	3	1
18	161-2513	3177	1E1286A	510	3	10	525	8	3	2
19	4W-9985	3178	1E1286A	510	4.25	10	525	12.75	3	3
20	465-1863	31113	1E1286A	510	4	10	525	10.5	3	1
21	249-3359	31119	1E1286A	510	4.5	10	525	11	3	4
22	365-6812	31128	1E1286A	510	4.5	10	525	11	3	4
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