

DRAWING NUMBER

315-635-1

EXPLANATORY NOTE:-

MATERIAL QUOTED: STEEL 12XH3A TY 14-1-381-72.

CHROMIUM-NICKEL STEEL

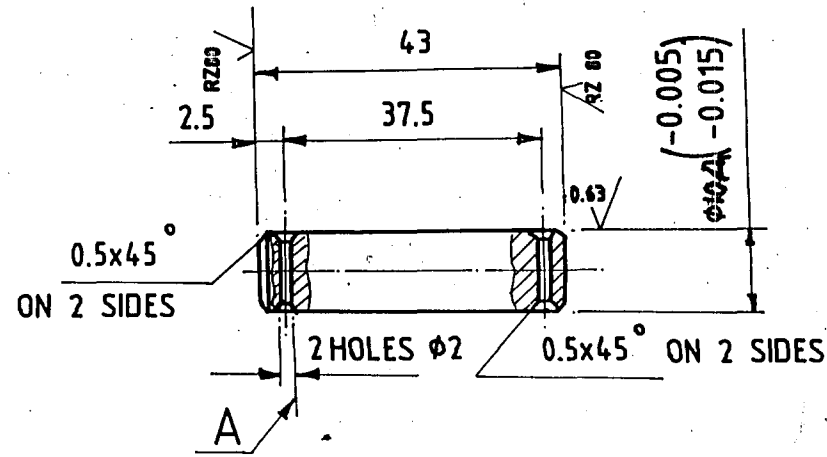
12XH3A = GRADE OF STEEL.

CHEMICAL COMPOSITION: % (AS PER GOST 4543-71)

CONTENT OF ELEMENTS %								
C	Si	Mn	Cr	Ni	P	S	Cu	Ni
					MAXIMUM			
0.09 - 0.16	0.17 - 0.37	0.30 - 0.60	0.60 - 0.90	2.75 - 3.15	0.035	0.035	0.30	0.30

MECHANICAL PROPERTIES:

- a) HARDENING: (i) FIRST HARDENING OR NORMALIZING = 860°C.
 (ii) SECOND HARDENING = 760-810°C.
 (iii) COOLING MEDIUM = WATER OR OIL.
- b) TEMPERING: (i) TEMPERATURE °C = 180.
 (ii) COOLING MEDIUM = AIR OR OIL.
- c) YIELD POINT kgf/mm² (MIN) = 70
- d) ULTIMATE TENSILE STRENGTH kgf/mm² (MIN) = 95
- e) RELATIVE ELONGATION % (MIN) = 11
- f) RELATIVE REDUCTION ALONG ACROSS SECTION = 55
- g) IMPACT STRENGTH kgf.m/cm² (MIN)^(MIN) = 9



1. INSPECTION GROUP III TT-11
2. TO BE CARBURIZED h 0.7 TO 1.2 mm.
3. HARDNESS ~~HRC ≥ 58~~. HRC ≥ 59
4. DIMENSION WITH UNSPECIFIED TOLERANCE SHOULD BE OBTAINED AS PER ACCURACY CLASS-7, OST 1010.
5. SURFACE 'A' SHOULD BE PROTECTED FROM CASE HARDENING.
6. COATING:- CHEMICAL OXIDIZING, OIL FINISHING.

DRAWING INDIANISED BASED ON ISSUE 3

KYD.NO. 63500

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. WT 0.025 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN		MATERIAL: STEEL 12XH3A	USED ON
CHD	<i>Dring. P. J. J.</i>	TY 14-1-381-72	CB 315-662-3
TCD	<i>Dring. P. J. J.</i>		CB-20-15-662-5
APPD DATE	<i>Dring. P. J. J.</i> 09-5-86	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
SCALE	1:1	TITLE STOP PIN	DRAWING NUMBER 315-635-1
DIMENSIONS	IN mm		
TOLERANCE ON DIMNS	UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER
ALL THREADS TO CONFORM TO			
ISSUE	A	DATE	7.12. 87
		NATURE OF AMENDMENTS	AUTHY BK 62-394.

A6

SIZE A3