

NOMENCLATURE
CAM SHAFT INLET (307.06.4A) & EXHAUST (307.21.1A)

DRAWING.NO
307.06.4A
307.21.1A

ISSUE
OPN.NO
230
OPERATION
INDUCTION
HARDENING
MACHINE: HTP

TECHNICAL REQUIREMENTS.

1. HARDNESS OF SURFACE AFTER HEAT TREATMENT TO BE HRC 54-60
2. DEPTH OF HARDENED SURFACE 2.35 - 3.35 OF CAM FLANKS TO BE 5.8 (MAX)
3. HARDNESS OF NON-TREATED SURFACE : BHN = 163 TO 207.
4. RUN-OUT OF SHAFT JOURNALS IS ALLOWED UPTO 1.5 mm MAX AT THE CENTRE OF LENGTH AND DECREASING TOWARDS ENDS.

STD. TOOLS & GAUGES

SPL. TOOLS & GAUGES

QSV					
PRED.	CHD.	APPD.	POSTE REP	ISSUE	DATE