

PLANNING SHEET - PDO / EFA

FORM No: EFA/P-0

NOMENCLATURE

CAMSHAFT INLET (20.07.06 A) & EXHAUST (20.07.15 A)

DRAWING.NO

20.07.06A

20.07.15 A

ISSUE

OPN.NO

230

OPERATION

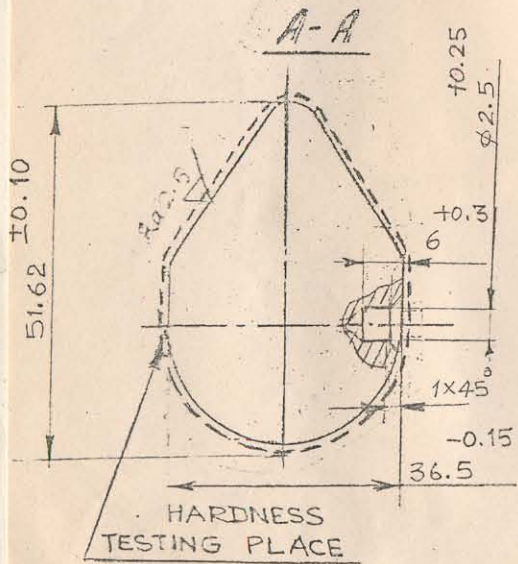
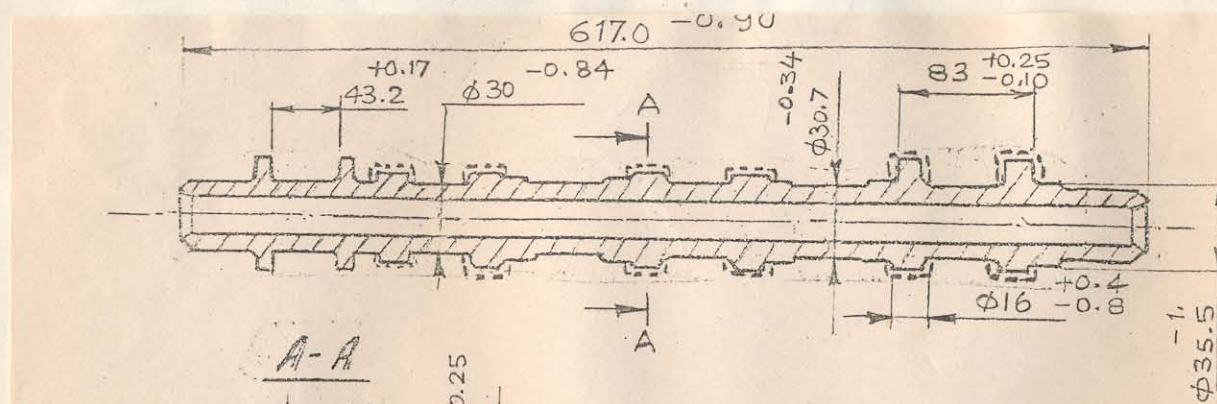
INDUCTION HARDENING

MACHINE:

HTP.

STD. TOOLS & GAUGES

SPL. TOOLS & GAUGES



TECHNICAL REQUIREMENTS

1. HARDNESS OF THE HARDENED SURFACE SHOULD BE HRC 56 TO 62.
2. DEPTH OF HARDENED AREAS SHOULD BE 2.25 TO 3.6 MM ON TOP CAM SURFACES.
3. DEPTH OF HARDENED LAYER SHOULD BE 5.8 MM.
4. CHECK THE DEPTH OF HARDENED LAYER AND HARDNESS OF ALL CAMS ON ONE FINALLY POLISHED CAM SHAFT FROM A BATCH OF 200 NOS

DESIGN	CHKD	APPD	71	1	25.12.98
PRED.	CHD.	APPD.	PETE REF	ISSUE	DATE