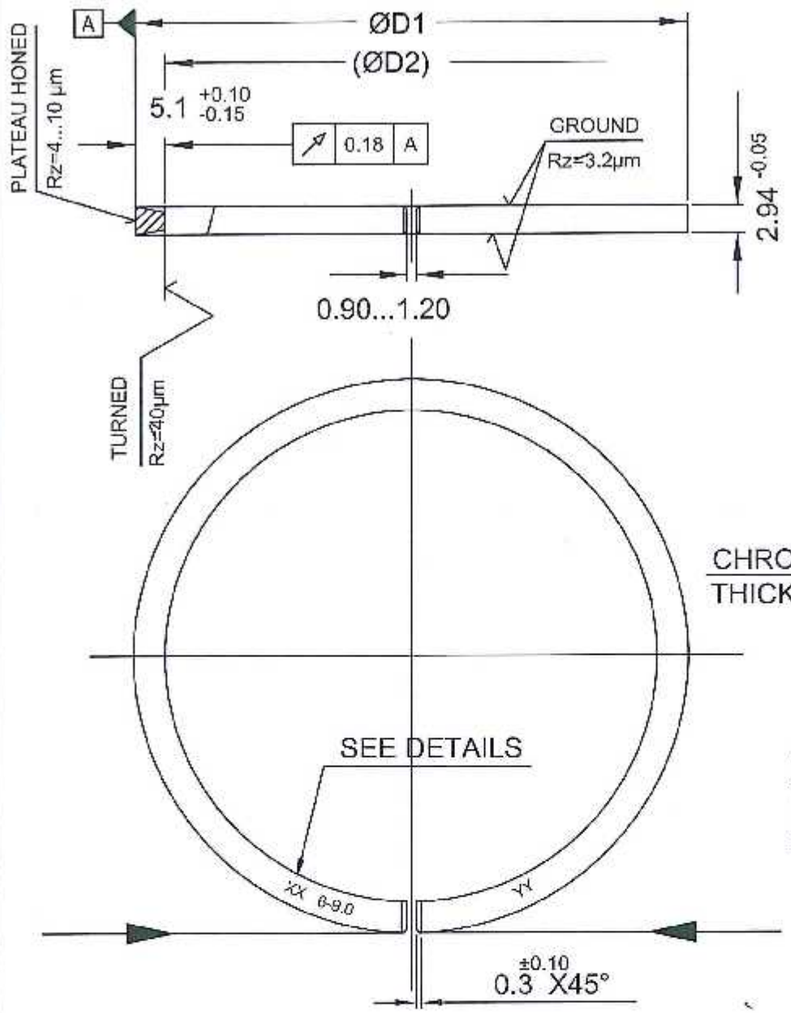
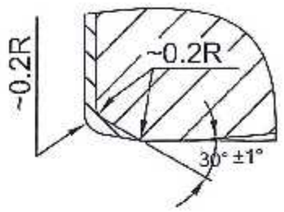
DRG.No
6-90-4033

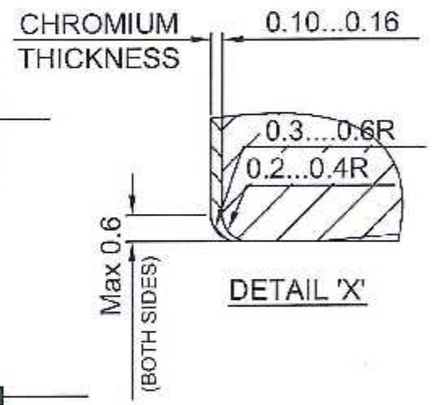
ISSUE	DDO.REF.	AMENDMENT	SIGN	DATE



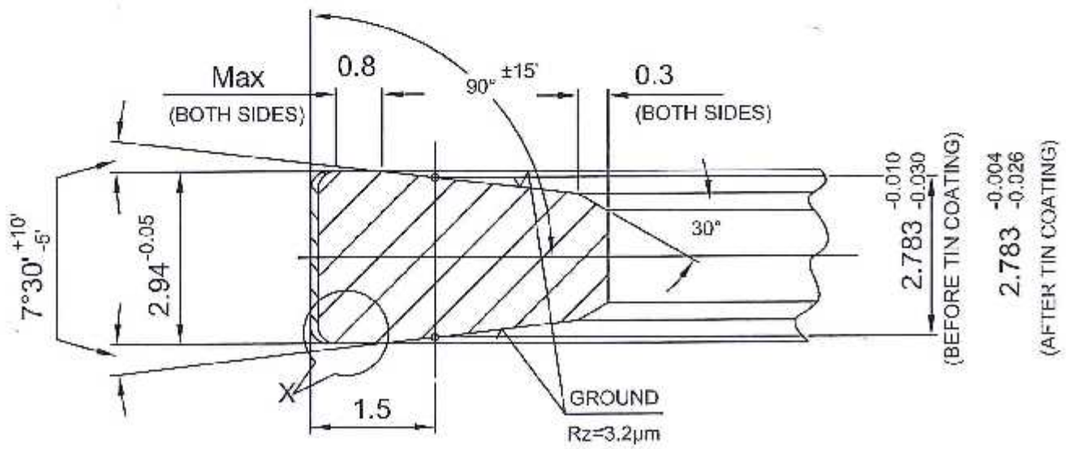


(BEFORE PLATING)

ALTERNATIVE DESIGN FOR DETAIL 'X'



DETAIL 'X'



TECHNICAL CONDITIONS

1. RING HARDNESS SHOULD BE MIN. 40 HRC.
2. THE RING WILL BE HEAT TREATED ON A SPECIAL FURNACE/FIXTURE.
3. BUCKLING OF BOTH FLANK SIDES SHOULD NOT EXCEED 0.05mm.
4. RINGS SHALL BE CHECKED FOR SCRATCHES AND MATALLURGICAL DEFECTS AS PER CLAUSE 2.8 OF DIN 70908 AND CRACKS ARE NOT PERMITTED.
5. RINGS SHALL BE DEMAGNETIZED BEFORE BEING CHROME PLATED.
6. RUNNING FACE SHALL BE CHR. PLATED AS SHOWN IN VIEW 'X' THICKNESS OF CHR. LAYER AFTER HONING TO A FINISH AS PERED DRAWING SPECIFICATION SHALL BE 0.1...0.16mm. THE HARDNESS OF CHR. LAYER SHALL BE MIN 800HV. 0.1
7. SPALLING OF CHROMIUM IS NOT PERMITTED.
8. RING SHALL BE COATED WITH TIN FOR CORROSSION RESISTANT. TIN PLATE LAYER THICKNESS PER SIDE 0.002...0.003mm & PERMISSIBLE INCRESE AFTER TIN PLATING IS MAX. 0.006mm.
9. QUALITY OF THE GROUND FACES i.e. TAPER FLANK SIDES SHALL BE CHECKED IN CLOSED CONDITION TO NOM.DIA. BY "BLUE TEST" BETWEEN TWO TAPER (RING ANGLE) PLATES. THE Wt. OF THE UPPER PLATE SHALL BE 2.5Kgs. COLOUR MUST COVER ENTIRE SURFACE IN THE FORM OF A CONTINUOUS BELT OF 1.5mm WIDTH THROUGH THE RING SURFACE.
10. BUCKLING OF THE RING SHOULD BE CHECKED AFTER FINISHING BY PASSING IT THROUGH THE SLIT FIXTURE. THE RING SHOULD FREELY PASS THROUGH THE SLIT IN TO FIXTURE BY ITS OWN WEIGHT. THE DIMENSION OF SLIT IS $3^{-0.010}$ mm.
11. RING FREE GAP WILL BE AS PER STANDARD AND WITH 100% LIGHT TIGHTNESS ON RING PERIPHERY i.e. WHEN THE RING IS FITTED IN D1±0.015 DIA CONTROL RING.
12. TANGENTIAL TENSION OF THE RING SHALL BE WITHIN 2200...3000gr (WITH RING COMPRESSED TO CYLINDER BORE Dia. WITH SPECIFIED GAP OF 0.90...1.20mm. BY MEANS OF FLEXIBLE STEEL TAP)
13. THREE LAST DIGITS OF COPONENT NUMBER (CQAHV Drg.No. 3304-06-9 WITH SIZE MARK) SHOULD BE MARKED BY SAND JET/SCREEN PRINT ALONG WITH MANUFACTURER STAMP MARK OF "YY"
14. VARIATION IN RADIAL THICKNESS IN A RING SHOULD NOT EXCEED 0.18mm.
15. PILOT SAMPLE SHOULD BE APPROVED, BEFORE BULK PRODUCTION.

SI	DRAWING No.	Size	Size Mark	Colour	D1	D2
3	3304-06-09 R2	R2	R2	-	150.2	140.0
2	3304-06-09 R1	R1	R1	-	150.1	139.9
1	3304-06-09	STD	STD	-	150.0	139.8

MATERIAL : KS3(X90CrMoV18)

ITEM	DESCRIPTION	QTY	MATERIAL	SPECN	SIZE	REMARKS
GEN.TOL.	COMPONENT NO.		OPN.NO.	M / C . NO.		SIGN. / DATE
0 - 6 ± 0.1 6 - 30 ± 0.2 30 - 120 ± 0.3 120 - 400 ± 0.5 400 - 1000 ± 0.8 1000 - 2000 ± 1.2 2000 - 4000 ± 2	SB 3304-01-8 V46-6 ENGINE		ASSEMBLY		DRN.BY 13/12/17 CKD.BY 13/12/17 APPD.BY 13/12/17 AUTHD.BY	
SCALE:- NTS	TITLE:- CHROMIUM PLATED TRAPEZOIDAL RING -TYPE GK170CSn 150 /139.8 X 2.94				DRG.No. 3304-06-9	
	ENGINE FACTORY, AVADI.				SHEET 1 OF 1 SHEETS ISSUE	

Drawing prepared based on CQA(HV) letter No. 83300/Tech Gen/TE/V46-6, Dated 04th Aug'1995