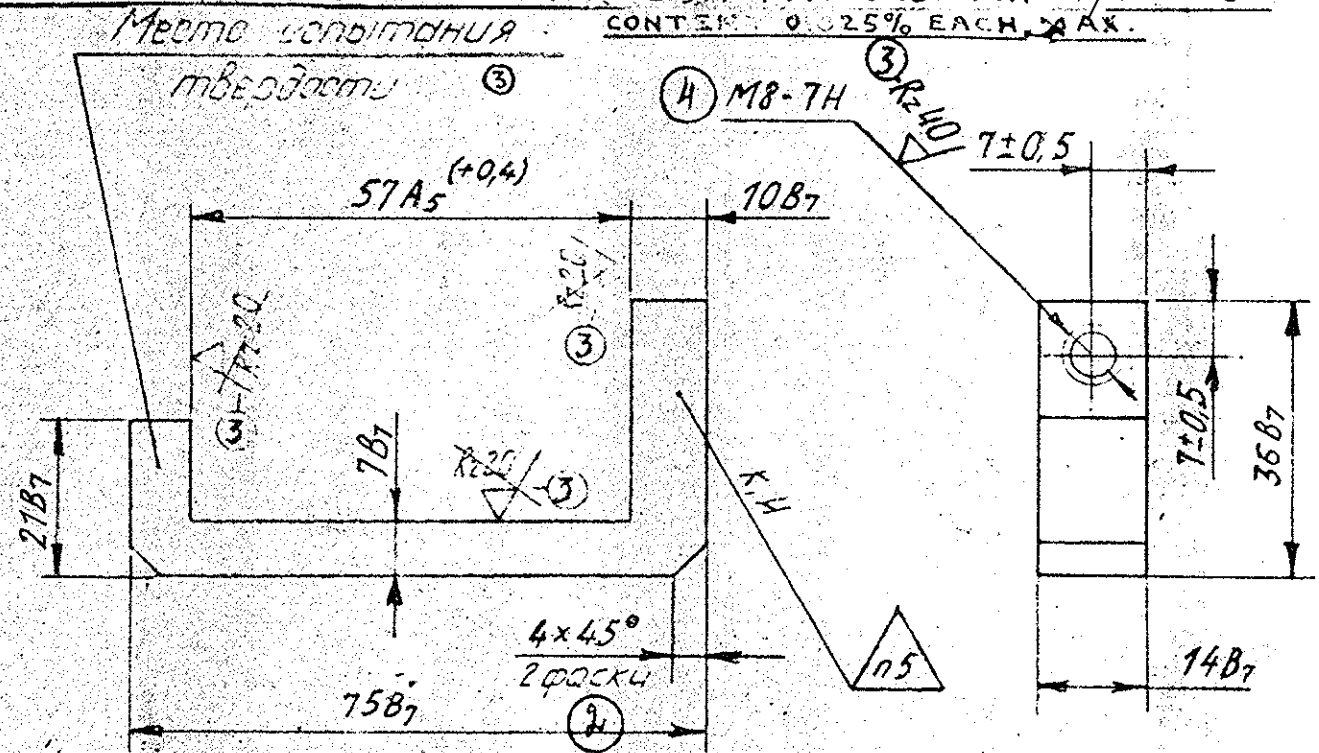


2A42.10.024

③ Rz 80

INDIGS. MATL: - BS: 970, PT. I, 530 M40 OR 700 M40. COMPONENTS TO BE HEAT TREATED TO 38.5-45.5 HRC. BS: 970, PT. I, 1983, GDE 517 M40, CONDITION 2, WITH S&P CONTENT: 0.025% EACH, MAX.



- * OR Phosphating (accelerated) with adhesive B-4, FOCT 12172-74 and nigrosine, grade A, FOCT 9307-78, applied in one layer.
- ① 1. HRC₂ 38.5 to 45.5.
- 2. Inner corners, R ≈ 0.4 mm.
- 3. Blunt sharp edges, R ≈ 0.6 mm.
- 4. Coating: accelerated electroless phosphating with chromate treatment/impregnation with adhesive B-4, FOCT 12172-74 and nigrosine, grade A, FOCT 9307-78, applied in one layer.
- 5. Stamp
- ② 4x45°
2 chamfers
- ③ Perform hardness test here
- ④ MB-7H

18412-W INDIGS. MATL AMENDED 8-12-97

18174-W PROV SEALING CANCELLED AND DRG SEALED. 22-9-95

17926-W INDIGS MATL AMENDED. 16-3-94

1781-W 4-12-93 INDIGS MATL AMENDED

16407-W DRG SEALED PROV. 20-2-86

INDIGS. MATL BS: 970 (PT. I) 700 M40 OR 530 M40 MATERIAL SHALL BE TESTED TO CONDITION 1 OF THE SPECN. COMPONENTS SHALL BE HEAT TREATED TO HARDNESS. 38.5-45.5 HRC.

33/D2236

APPROVED H VASU

CHECKED V. Behl...

CONTROLLERATE OF INSPECTION (ICV)

2A42.10.024

CLAMP

STEEL 40X, OCT 3-98-80

WEIGHT	SCALE
90g	1:1
SHT	SHTS
	8/8