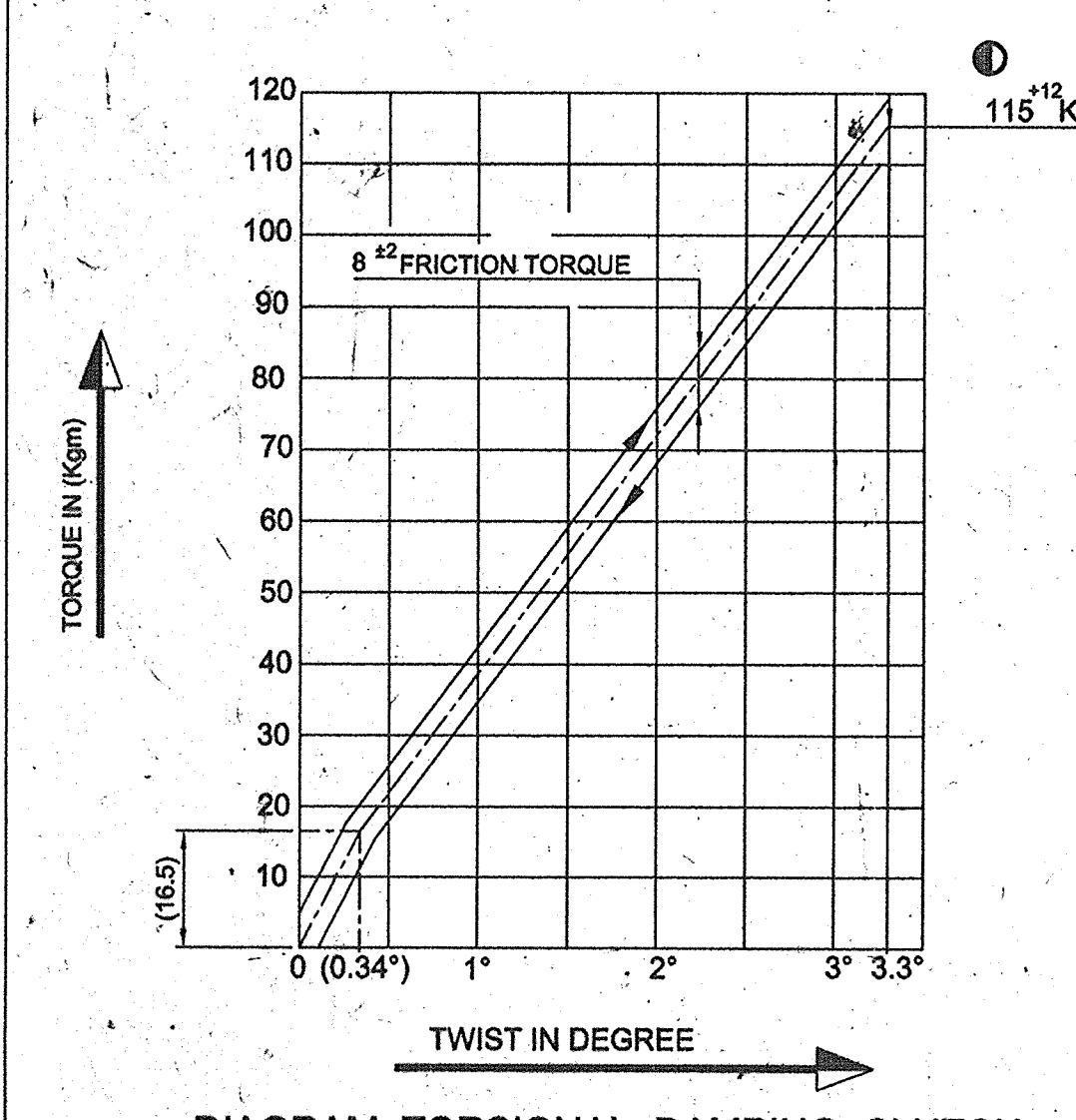
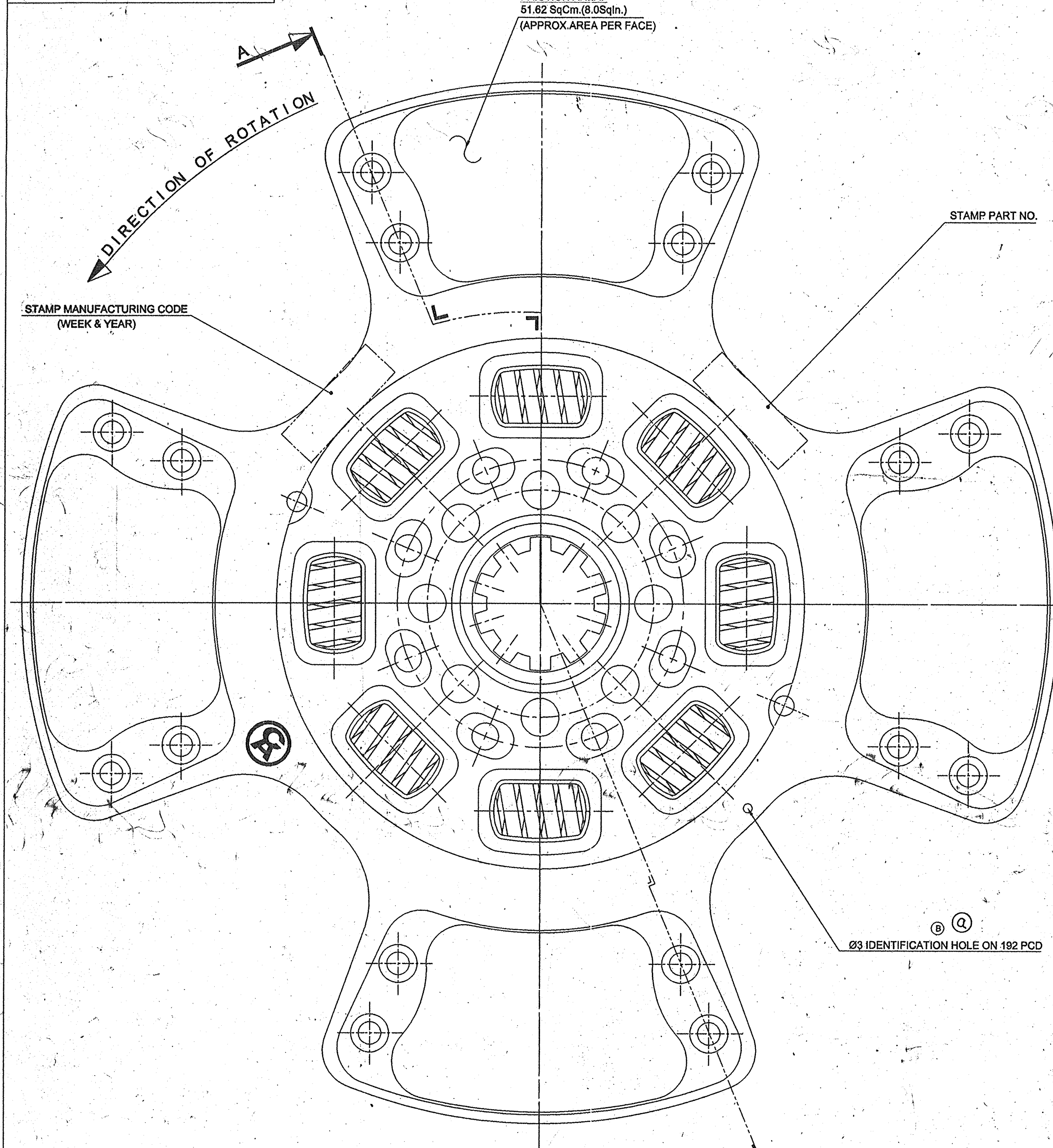
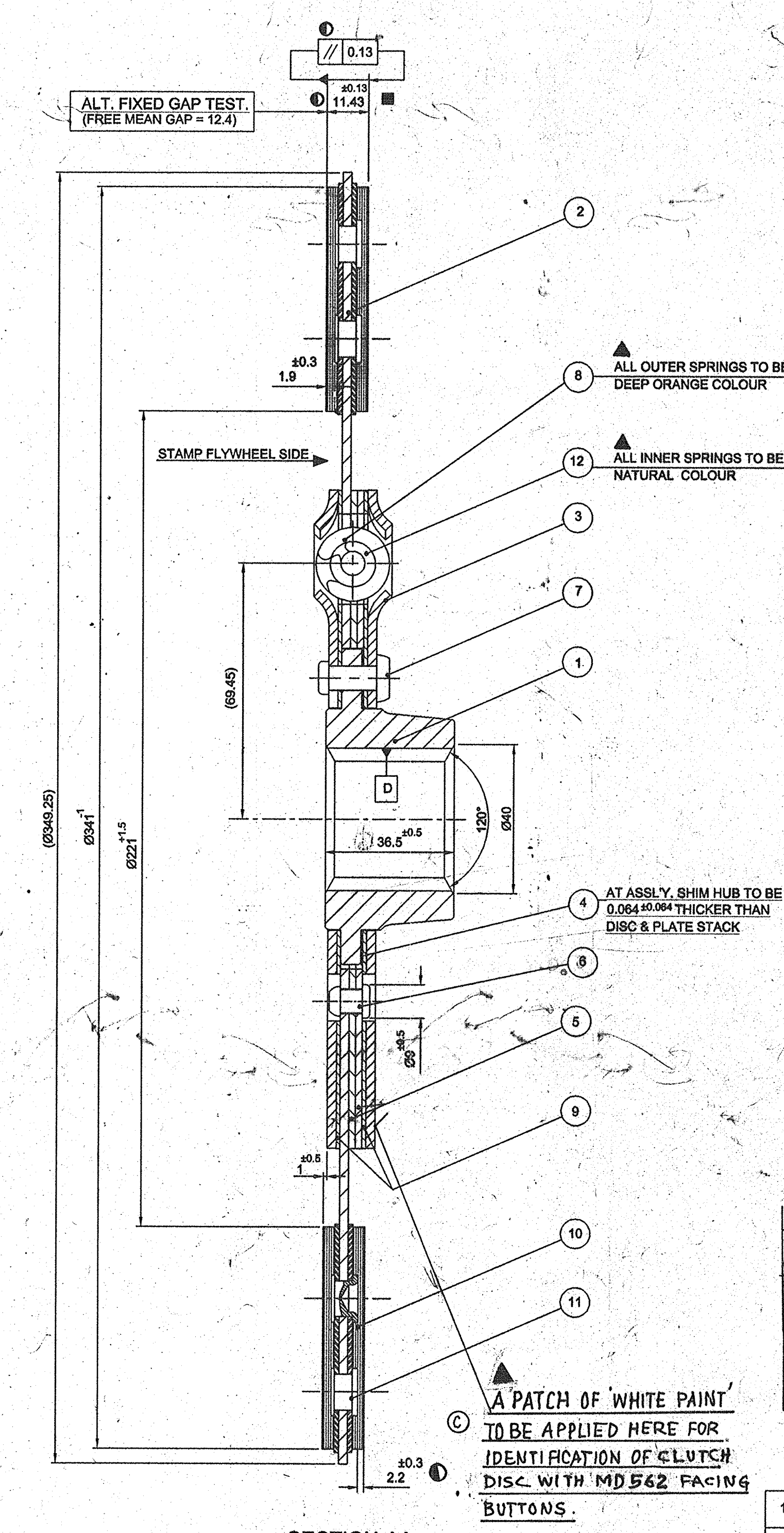
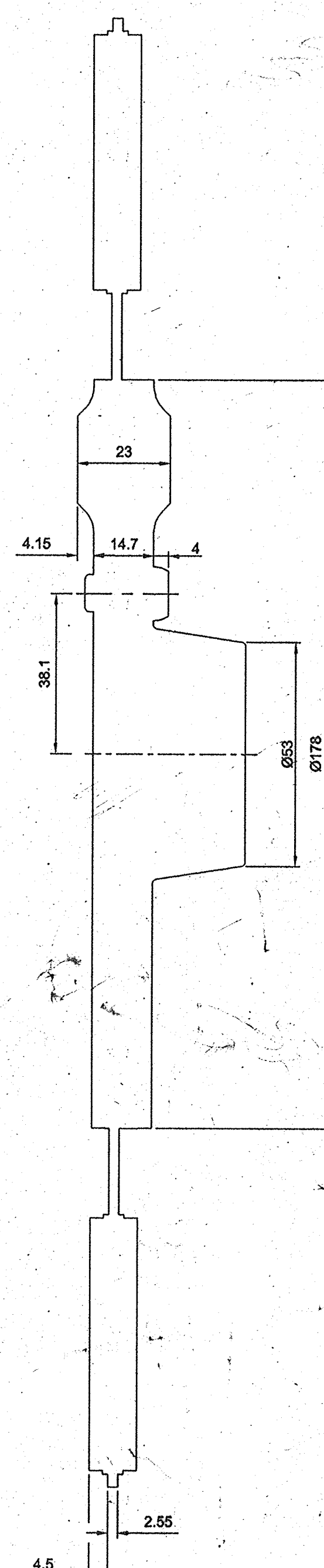


FIRST ANGLE PROJECTION

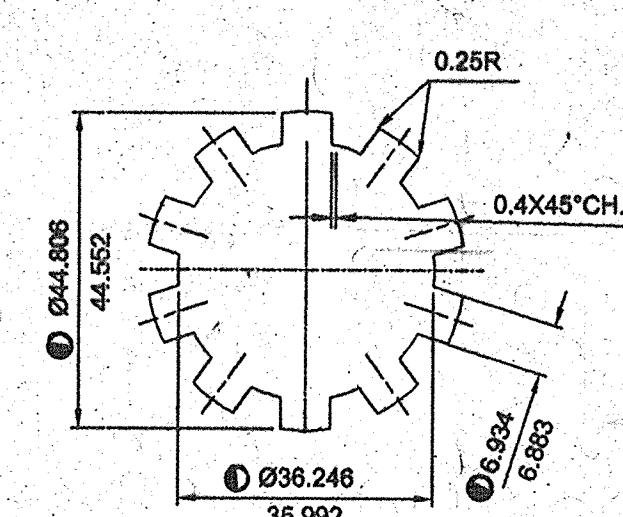


TEST PROCEDURES:- © (a)

TEST	REQUIREMENT
1) TORSIONAL TEST:- TEST CONDITION 10 X 10 ⁶ CYCLES WITH ONE CYCLE CONSISTING OF COMPRESSION FROM DRIVE TO COAST DIRECTION. TORQUE SETTING - DRIVE - 105 Mkg. OR STOPPER TORQUE, COAST-70 Mkg. MIN. FREQUENCY - 12 Hz MIN.	NO BREAKAGE OR CRACKING OF ANY STRUCTURAL COMPONENTS
2) FULL SIZE ENDURANCE TEST (CLUTCH DYNAMOMETER) TEST CONDITION CLUTCH SPEED - 1300 RPM INERTIA = 1.1 Kg-m. Sec ² NO. OF ENGAGEMENTS - 4 PER MINUTE NO. OF CYCLES - CUM. 70,000 CYCLES MIN.	DISC TORQUE OF 100 Mkg. MIN.
5) CONFIRMATORY VEHICLE TEST TEST CONDITION a) 50.00 Kms MIN. b) GRADABILITY CHECK ON VEHICLE LOADED TO RATED LOAD AS PER VEHICLE SPECIFICATIONS	NO FAILURE
6) BURST STRENGTH TEST (AMBIENT) MIN. BURST RPM TO BE 3 TIMES MAX. ENGINE RPM.	
7) CO-EFFICIENT OF FRICTION FOR LINING TEST CONDITION i) TEMPERATURE - 120°C MIN. ii) LINING CONDITION - PROPERLY BEDDED IN SAMPLE FOR ATLEAST 10,000 CYCLES ON DYNAMOMETER OR VEHICLE	CO-EFFICIENT OF FRICTION 0.35 MIN.



SECTION-AA



PRODUCTION NOTES:-

S.NO.	DESCRIPTION	VALUE
1.	OIL GREASE OR PARAFIN MUST NOT BE ALLOWED UNDER ANY CIRCUMSTANCES TO BE BROUGHT IN CONTACT WITH FRICTION SURFACES.	
2.	SPLINES TO BE LIGHTLY WIPED WITH GREASE	3% MoS ₂ SS-6620-320, TS-25205 P1 OR BALMEROL MOLY XL
3.	DRAG TEST:- PLATE MUST ROTATE IN A FIXTURE REPRESENTING CLUTCH HAVING PLATE PRESSURE OF 1450 Kg. WITH 0.9 RELEASE MOVEMENT & DRAG TORQUE OF 0.07Kg-m.	

INFORMATION NOTES:-

S.NO.	DESCRIPTION	VALUE
1.	WEIGHT OF ASSLY	4.4 Kg. (APP.)
2.	MOMENT OF INERTIA	0.045 Kg-m ²
3.	NET TOTAL FRICTION AREA (BOTH SIDES)	413 cm ²
4.	MAX. UNBALANCE AMOUNT	15 gmm
5.	DIMENSIONS MARKED IN BRACKET () ARE FOR REFERENCE ONLY & NOT FOR INSPECTION.	
6.	SPECIAL CHARACTERISTICS	

APPROVAL TESTS:-

S.NO.	TEST	SCHEDULE	TEST PARAMETERS
1.	SPRING CENTER TEST	CALTP - 16	ENGINE TORQUE - 57Kg-m
2.	BURST TEST	CALTP - 11	MIN. BURST RPM 6000 AMBIENT TEMP. 200°C
3.	DYNAMOMETER FULL SCALE TEST	CALTP - 1	

SAMPLE TO BE APPROVED

TELCO PART NO. 2752 2520 01 03

DATE	MOD. NO.	S. NO.	ZONE	MODIFICATION	D. O.
16.4.05	97PM 240	C		BUTTON MATERIAL 'MD-562' WAS INTERFERED COPPER BASED. IDENTIFICATION NOTE ADDED.	
24.10.08	95PM 551	b		15.11.08 (PART-2) WAS 15.11.08 (PART-2) IN 50M. DAMPER SPRING MATERIAL 2D WAS 1D. NEW C SYMBOLS ADDED.	
13.8.10	94PM 302	a		PARTY'S DRG. REVISED AS PER THEIR REVISION TABLE REV. 'A' TO 'C'.	
13.8.10	95PM 551			NEW RELEASE	

TELCO RELEASE STATUS

S.NO.	DESCRIPTION	QTY.	MATERIAL	DRG. NO.
12.	DAMPER SPRING(INNER)	8	2D-IS:4454 (PART-10)-1975 ©	CPS-430
11.	BUTTON RIVET	16	AIN-15B25	SERIES 3-2.3
10.	BUTTON	8	MD-562 ©	44445
9.	SPACER PLATE	2	Gr.5,IS:2507-1975	CP-427
8.	DAMPER SPRING(OUTER)	8	2D-IS:4454 (PART-10)-1975 ©	CPS-246-S
7.	HUB RIVET	8	C10,IS:1570-1993	CP-252
6.	SPACER RIVET	8	C10,IS:1570-1993	CP-251
5.	SPACER PLATE	2	O-IS:513-1994	CP-247
4.	SPACER WASHER	AS REQD.	TIN PLATE	CP-250,CP-250A & CP-250B
3.	BACK PLATE	2	DD-IS:1079-1994	CP-248
2.	FRONT PLATE	1	O-IS:1079-1994	C349PFSF01DW
1.	HUB	1	EN9,BS:970-1955	C092HUR801DW

CLUTCH AUTO LIMITED FARIDABAD-INDIA

DESIGNATION	DRG. NO.
DISC ASSLY. CLUTCH	D352SNN504CC
QTY. PER SET - ONE	REF. - TC

POS. NO.	ECN NO.	CHANGES	DATE	NAME	APPD.	SCALE
C		TELCO TEST TABLE ADDED.	6.7.2000	B.ABHA		
B		MAX. UNBALANCE AMOUNT IDENTIFICATION ADDED.	10.5.00	B.ABHA		
A		FRONT PLATE PART NO. WAS C349PFSF01DR.	8.4.2000	B.ABHA		