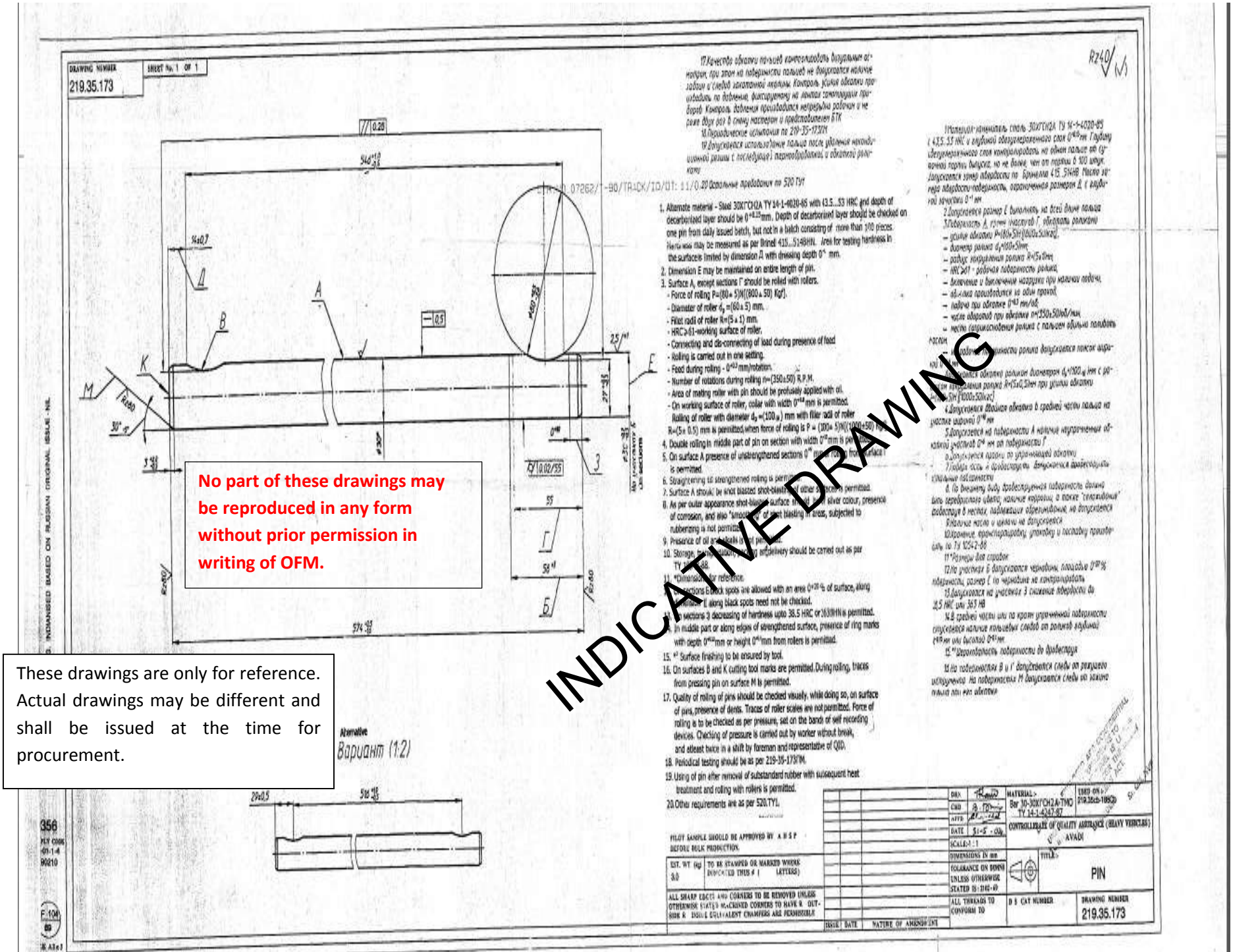

DRAWING NUMBER 219.35.173

SHEET No. 1 OF 1

R240

1. Alternate material - Steel 30ХГСН2А ТУ 14-1-4020-85 with 43.5...53 HRC and depth of decarbonized layer should be 0^{+0.35}mm. Depth of decarbonized layer should be checked on one pin from daily issued batch, but not in a batch consisting of more than 100 pieces. Hardness may be measured as per Brinell 415...514BHN. Area for testing hardness in the surface is limited by dimension Д with dressing depth 0^{1} mm.
2. Dimension E may be maintained on entire length of pin.
3. Surface A, except sections Г should be roiled with rollers.
- Force of rolling P=(80± 5)N((800± 50) Kgf).
- Diameter of roller d_p=(60± 5) mm.
- Fillet radii of roller R=(5± 1) mm.
- HRC>61-working surface of roller.
- Connecting and de-connecting of load during presence of feed
- Rolling is carried out in one setting.
- Feed during rolling - 0^{0.63} mm/rotation.
- Number of rotations during rolling n=(350±50) R.P.M.
- Area of mating roller with pin should be profusely applied with oil.
- On working surface of roller, collar with width 0^{+1.0} mm is permitted.
Rolling of roller with diameter d_p=(120±) mm with fillet radii of roller R=(5± 0.5) mm is permitted,when force of rolling is P = (100± 5)N((1020+50) ...
4. Double rolling in middle part of pin on section with width 0^{+5}mm is pe...
5. On surface A presence of unstrengthened sections 0^{+5} mm... from surface is permitted.
6. Straightening of strengthened rolling is perm...
7. Surface A should be shot blasted shot-blasting of other surfaces is permitted.
8. As per outer appearance shot-blasted surface should have silver colour, presence of corrosion, and also "smoothness" of shot blasting in areas, subjected to rubberizing is not permitted.
9. Presence of oil and lubricants on pin not permitted.
10. Storage, packing, marking and delivery should be carried out as per TY 24-8.
11. *Dimension for reference.
12. Sections Б black spots are allowed with an area 0^{+20} % of surface, along which... along black spots need not be checked.
13. In sections Э decreasing of hardness upto 38.5 HRC or 363BHN is permitted.
14. In middle part or along edges of strengthened surface, presence of ring marks with depth 0^{+0.5}mm or height 0^{+0.5}mm from rollers is permitted.
15. ** Surface finishing to be ensured by tool.
16. On surfaces B and K cutting tool marks are permitted.During rolling, traces from pressing pin on surface M is permitted.
17. Quality of rolling of pins should be checked visually, while doing so, on surface of pins, presence of dents. Traces of roller scales are not permitted. Force of rolling is to be checked as per pressure, set on the bands of self recording devices. Checking of pressure is carried out by worker without break, and atleast twice in a shift by foreman and representative of QD.
18. Periodical testing should be as per 219-35-173PM.
19. Using of pin after removal of substandard rubber with subsequent heat treatment and rolling with rollers is permitted.
20. Other requirements are as per 520.TYL.

PILOT SAMPLE SHOULD BE APPROVED BY A B S P BEFORE BULK PRODUCTION.

EST. WT (kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
8.0	

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

ISSUE	DATE	NATURE OF AMENDMENT

DES. Rajan
CHD. A. Tiwari
APP. [illegible]
DATE 31-5-04
SCALE-2 : 1
DIMENSIONS IN mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69
ALL THREADS TO CONFORM TO

MATERIAL: Bar 30-30ХГСН2А-ТУМО ТУ 14-1-4247-87

USED ON: 219.35cb-1992

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE: PIN

D S CAT NUMBER

DRAWING NUMBER 219.35.173

Alternative Вариант (1:2)

No part of these drawings may be reproduced in any form without prior permission in writing of OFM.

These drawings are only for reference. Actual drawings may be different and shall be issued at the time for procurement.

INDICATIVE DRAWING