

In Process Sketch / Szkic Operacyjny

Group: CHASSIS
Dywizja:

Plant: PRASZKA
Zaklad:

Op.-Description: _____
Op.-Opis: _____

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. glowna

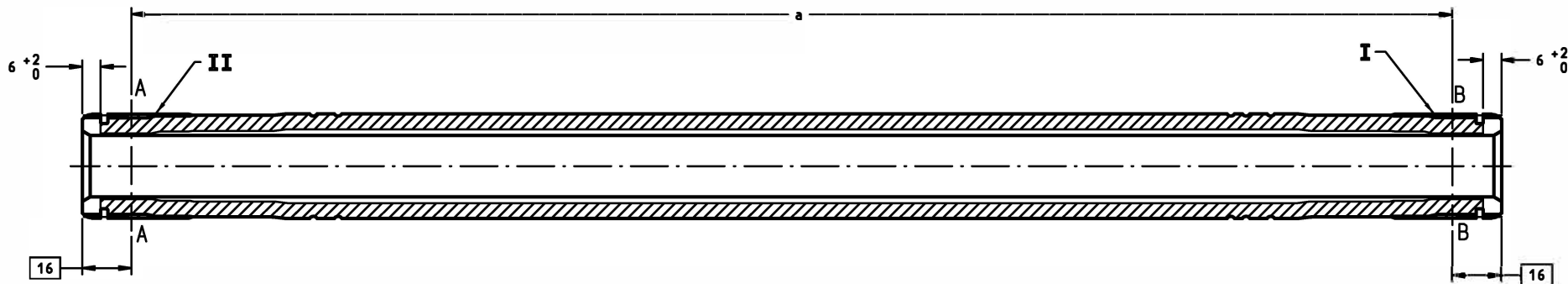
Part-Name: **WALEK**
Nazwa detalu:

Prototype
 Pre-Launch
 Production

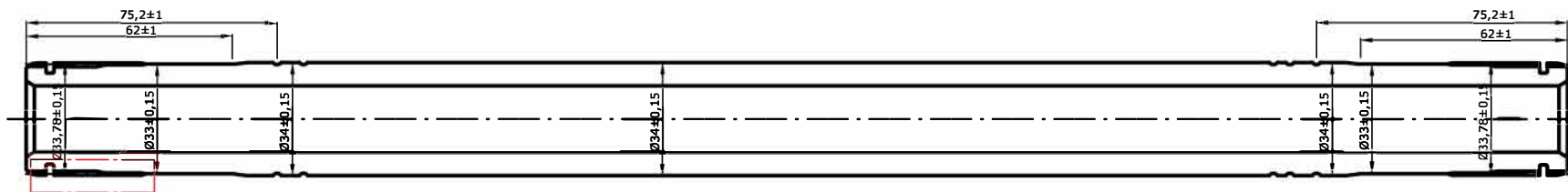
Control Item Yes No
Tak Nie

Part-No.: **E0007355.A**
Nr detalu:

Do not scale / Rys. nie w skali



HARDNESS PATTERN



HEAT TREATMENT:

AFTER MACHINING INDUCTION HARDENED AND TEMPERE
WITHIN 3 HOURS AFTER HARDENING

5

HARDNESS 520-630HV5:
- 5.0mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a",
MEASUREMENT IN SECTIONS A-A, B-B;

SURFACE HARDNESS: 50-55 HRC

Mash. Type:
Typ Maszyny:

BT:
Nr Tabl:

Proc.Engr.Group:
Zespol Inz:

Proc.Engr. :
Inz. Procesu:

Op.No.:
Op.Nr :

Date: 10.09.2024

Sht.: 1 of 1
Szkic: z 1

Group: CHASSIS
Dywizja: _____

Plant: PRASZKA
Zakład: _____

Op.-Description: _____
Op.-Opis: _____

OBRÓBKA CIEPŁA

Release-No.: See cover page
Zwolnienie Nr.: patrz str. główna

Part-Name: WALEK
Nazwa detalu: _____

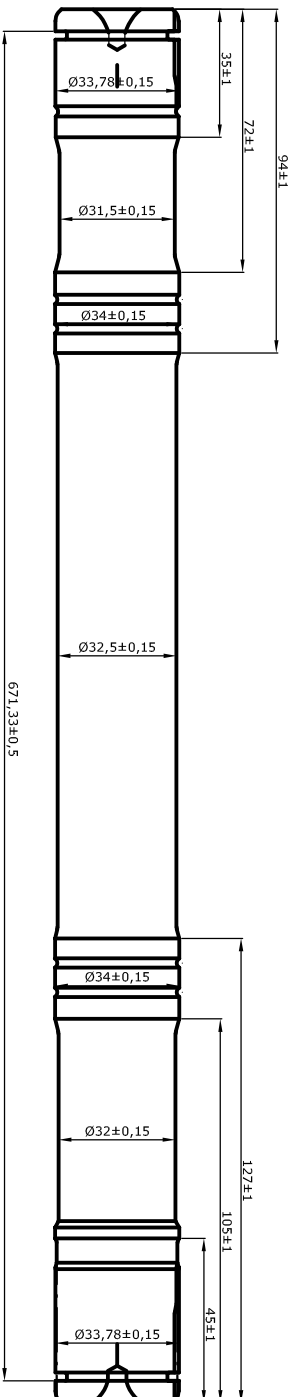
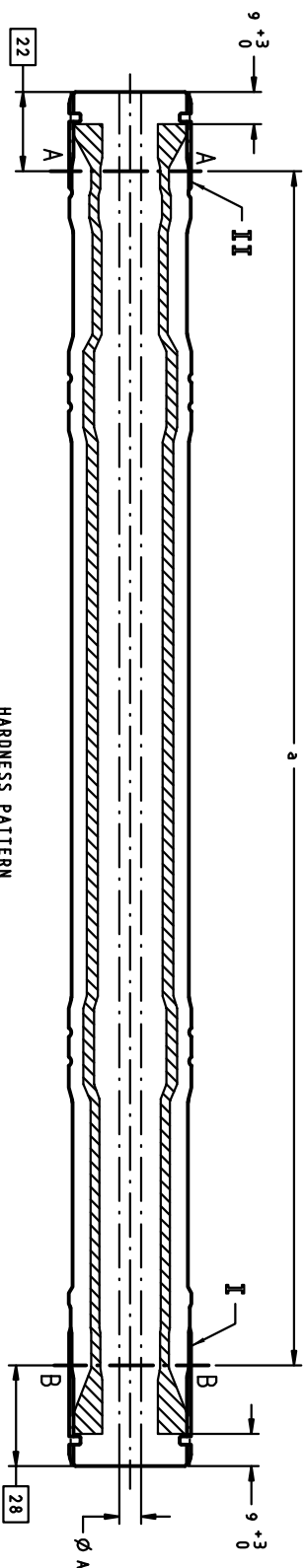
Prototype
 Pre-Launch
 Production

Control Item
 Yes
 No

Part-No.:
Nr detalu: _____

E0007430.A

Do not scale / Rys. nie w skali



MATERIAL:
STEEL 37MnB6 MOD. ACC. TO NEAPCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED

HARDNESS 500HV MUST FALL WITHIN CASE DEPTH:
- 5.0-7.5 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a"
MEASUREMENT IN SECTIONS A-A, B-B

CORE HARDNESS IN $\phi A=6$ TO BE 350HV MAX.

SURFACE HARDNESS: 55-60 HRC

5

Mash. Type: Typ Maszynowy	Op.No.:
BT:	Op.Nr.:
Nr. Tabli:	Date: 10.09.2024
Proc.Engr. Group:	Sht.: 1 of 1
Zespol Inz.:	Szkie: 1 z 1
Proc.Engr. Inz.:	
Inz. Procesu:	

Group: CHASSIS
Dywizja: patrz str. glowna

Plant: PRASZKA
Zaklad: 1019698 SHOT BLASTED

Op.-Description: Op.-Opis:

In Process Sketch / Szkic Operacyjny

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. glowna

Part-Name: WALEK
Nazwa detalu:

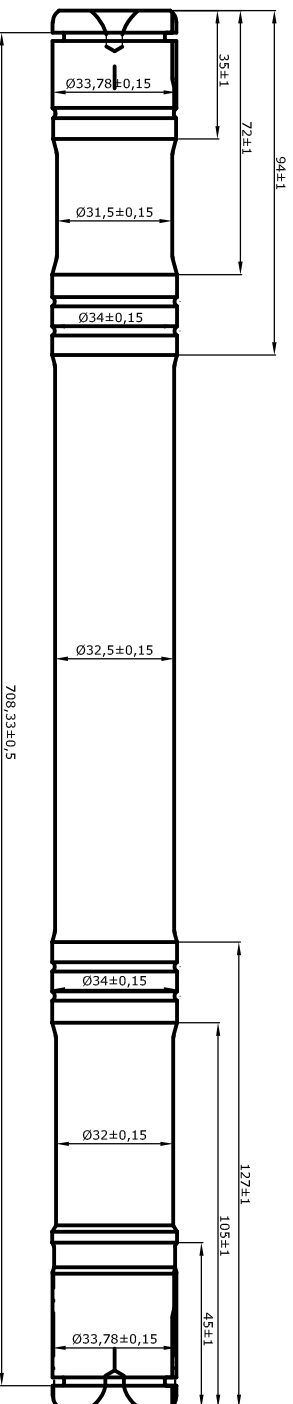
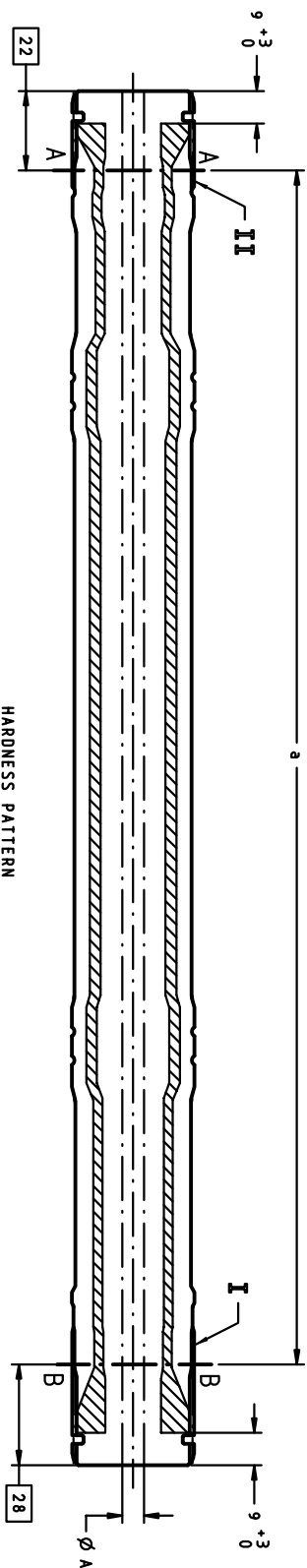
Prototype
 Pre-Launch
 Production

Control Item
 Yes
 No

Part-No.:
Nr detalu:

E0007432.A

Do not scale / Rys. nie w skali



MATERIAL:
STEEL 37MnB4 MOD. ACC. TO NEAPCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED

HARDNESS 500HV MUST FALL WITHIN CASE DEPTH:
- 5.0-7.5 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a"
MEASUREMENT IN SECTIONS A-A, B-B

CORE HARDNESS IN ØA=6 TO BE 350HV MAX.

SURFACE HARDNESS: 55-60 HRC

5

Mosh. Type: Typ Maszynowy:	Op.No.:
BT:	Op.Nr.:
Nr. Tabl.:	Date: 10.09.2024
Proc.Engr. Group:	Sht.: 1 of 1
Zespół Inz.:	Szkie: 1 z 1
Proc.Engr. Inz.:	
Inz. Procesu:	

Group: CHASSIS
Dywizja: _____

Plant: PRASZKA
Zakład: _____

Op.-Description: _____
Op.-Opis: _____

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. główna

Part-Name: WALEK
Nazwa detalu: _____

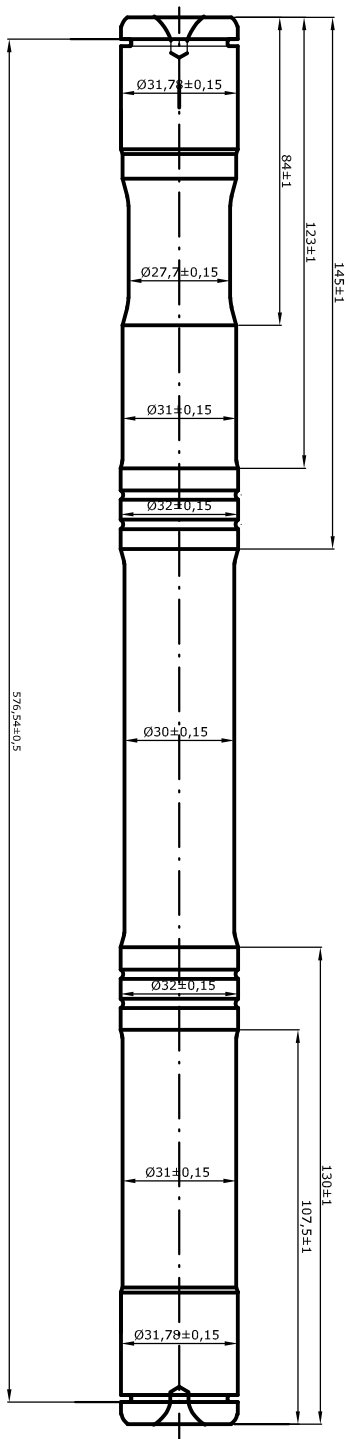
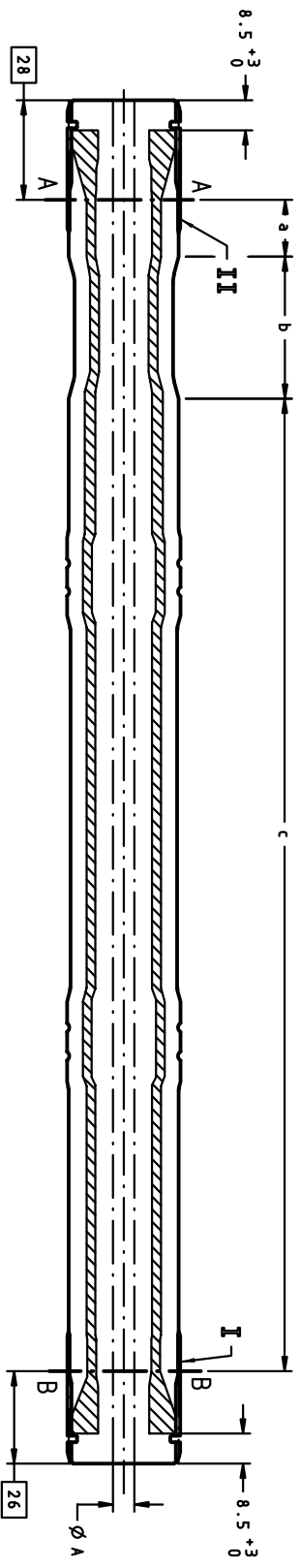
Prototype
Pre-Launch
Production

Control Item
Yes Tak No

Part-No.: _____
Nr detalu: _____

E0005103.A

Do not scale / Rys. nie w skali



MATERIAL:
STEEL 37MB4 MOD. ACC. TO NEAPCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED

HARDNESS 500HV MUST FALL WITHIN CASE DEPTH:
- 4.5-8.0 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a", "c"
MEASUREMENT IN SECTIONS A-A, B-B

- 6.0-8.0 mm FROM SHAFT OUTER DIAMETER IN AREA "b"

CORE HARDNESS IN ØA=6 TO BE 350HV MAX,
SURFACE HARDNESS: 55-60HRC

5

Mash. Type: Typ Maszynowy:	Op.No.:
BT:	Op.Nr.:
Nr. Tabli:	Date: 10.09.2024
Proc.Engr. Group:	Datal Inz.:
Zespol Inz.:	Sht.: 1 of 1
Proc.Engr. Inz.:	Szkic: 1 z 1

Group: CHASSIS
Dywizja:

Plant: PRASZKA
Zaklad:

In Process Sketch / Szkic Operacyjny

Op.-Description:
Op.-Opis:

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. glowna

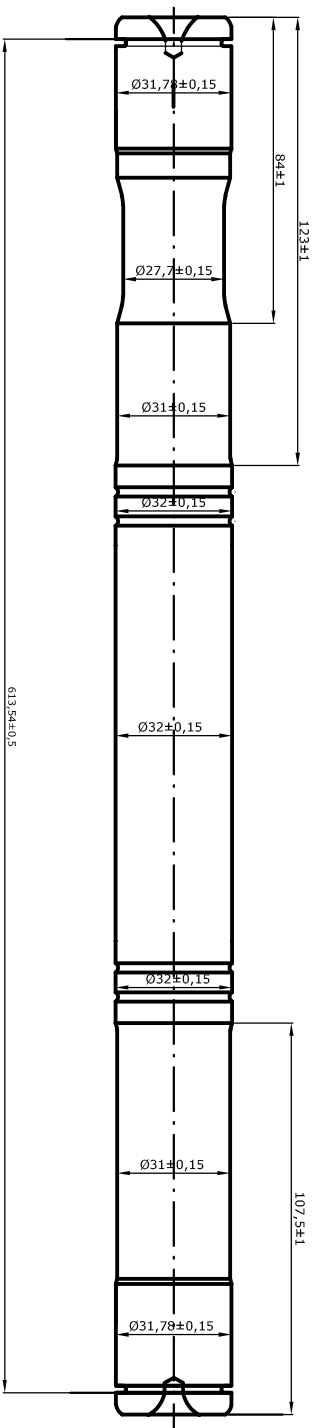
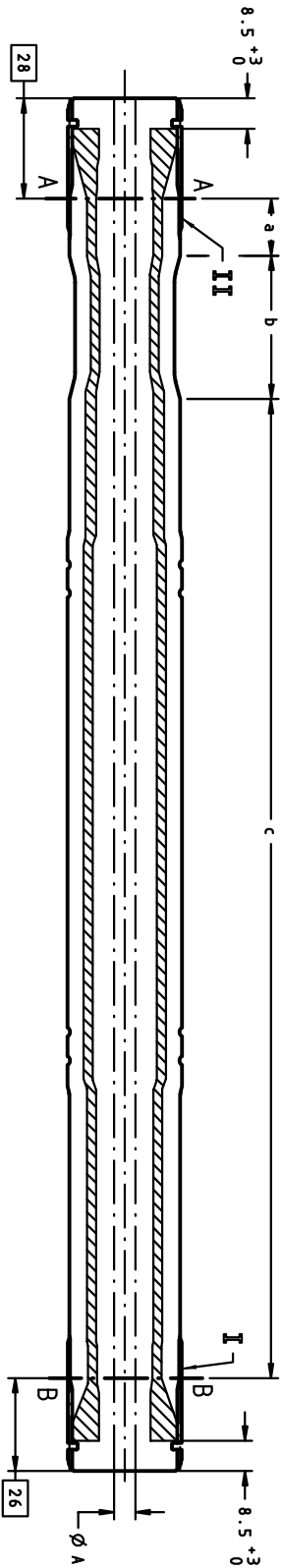
Part-Name: WALEK
Nazwa detalu:

Do not scale / Rys. nie w skali!

Prototype
 Pre-Launch
 Production
Control Item Yes No
Tak Nie

Part-No.:
Nr detalu:

E0005104.A



MATERIAL:
STEEL 37MB4 MOD. ACC. TO NEARCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED

HARDNESS SOOHV MUST FALL WITHIN CASE DEPTH:
- 4.5-8.0 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a", "c"
MEASUREMENT IN SECTIONS A-A, B-B

- 6.0-8.0 mm FROM SHAFT OUTER DIAMETER IN AREA "p"

CORE HARDNESS IN ØA=6 TO BE 350HV MAX,
SURFACE HARDNESS: 55-60HRC

5

Mash. Type: Typ Maszynowy:	Op. No.:
BT:	Op. Nr.:
Nr. Tabli:	Date: 10.09.2024
Proc. Engr. Group: Zespoł Inż.:	Sht. of 1
Proc. Engr. Inz.:	Szkiec: 1 z 1
Inz. Procesu:	

Group: CHASSIS
Dywizja: _____

Plant: PRASZKA
Zakład: _____

In Process Sketch / Szkic Operacyjny

Op.-Description: _____
Op.-Opis: _____

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. glowna

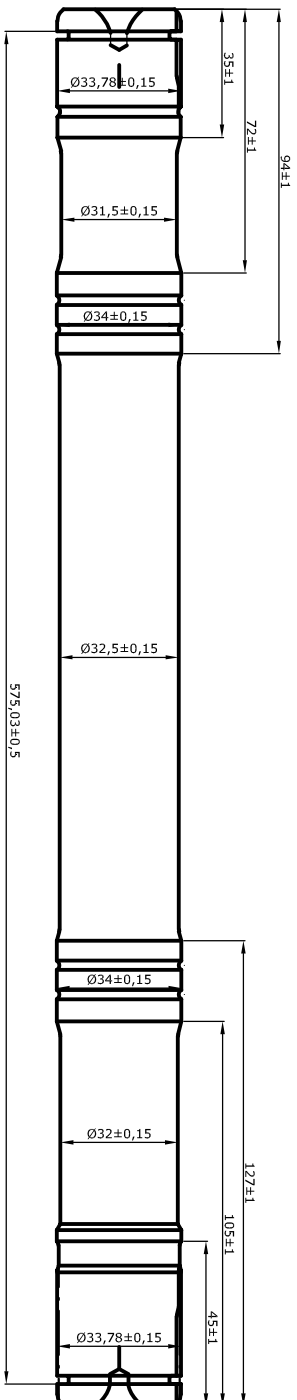
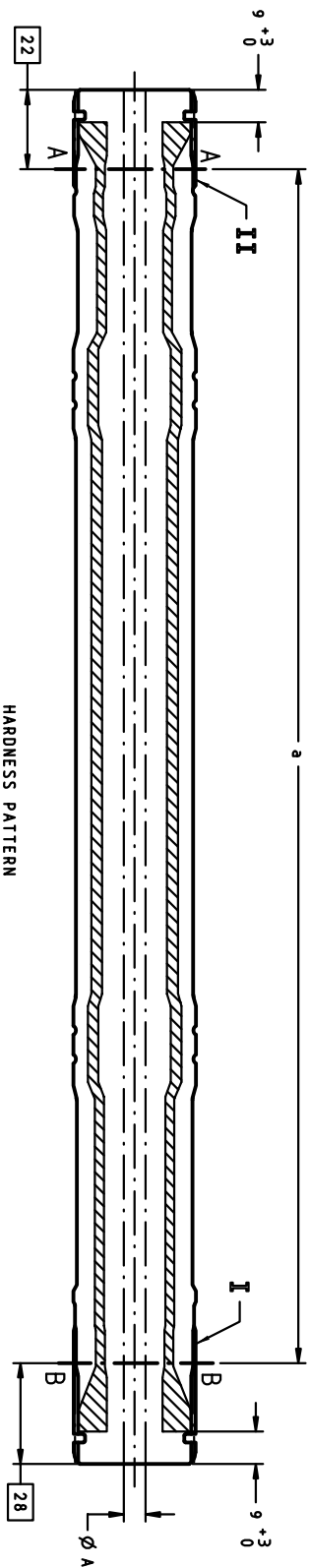
Part-Name: WALEK
Nazwa detalu: _____

Do not scale / Rys. nie w skali

Prototype
 Pre-Launch
 Production
Control Item Yes No
Tak Nie

Part-No.: _____
Nr detalu: _____

E0005105.A



MATERIAL:
STEEL 37MnB6 MOD. ACC. TO NEAPCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED

HARDNESS 500HV MUST FALL WITHIN CASE DEPTH:
- 5.0-7.5 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a"
MEASUREMENT IN SECTIONS A-A, B-B

CORE HARDNESS IN $\phi A=6$ TO BE 350HV MAX,
SURFACE HARDNESS: 55-60 HRC

5

Mash. Type: _____
Typ Maszyn: _____
Nr Tabl: _____
Proc.Engr.Group: _____
Zespól Inz: _____
Proc.Engr.: _____
Inz. Procesu: _____

Op.No.: _____
Op.Nr.: _____
Date: 10.09.2024
Sht.: 1 of 1
Szkic: 1 z 1

Group: CHASSIS
Dywiżja: patrz str. glowna

Plant: PRASZKA
Zakład:

Op.-Description:
Op.-Opis:

In Process Sketch / Szkic Operacyjny

OBRÓBKA CIEPLNA

Release-No.: see cover page
Zwolnienie Nr.: patrz str. glowna

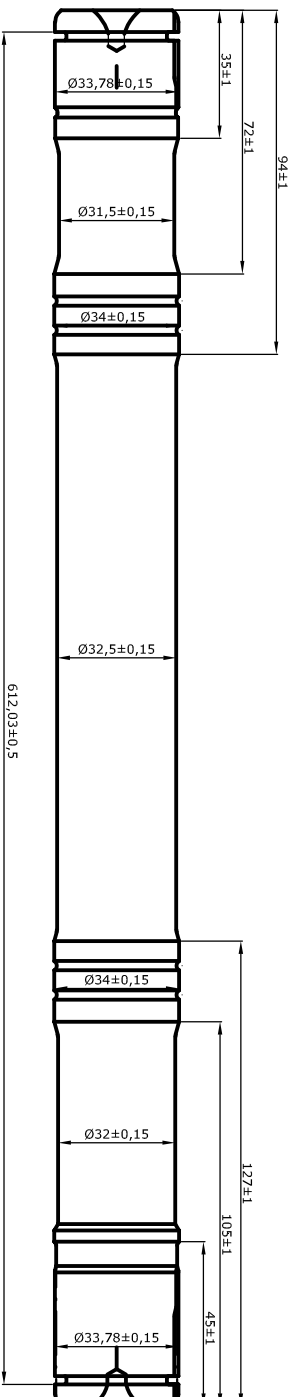
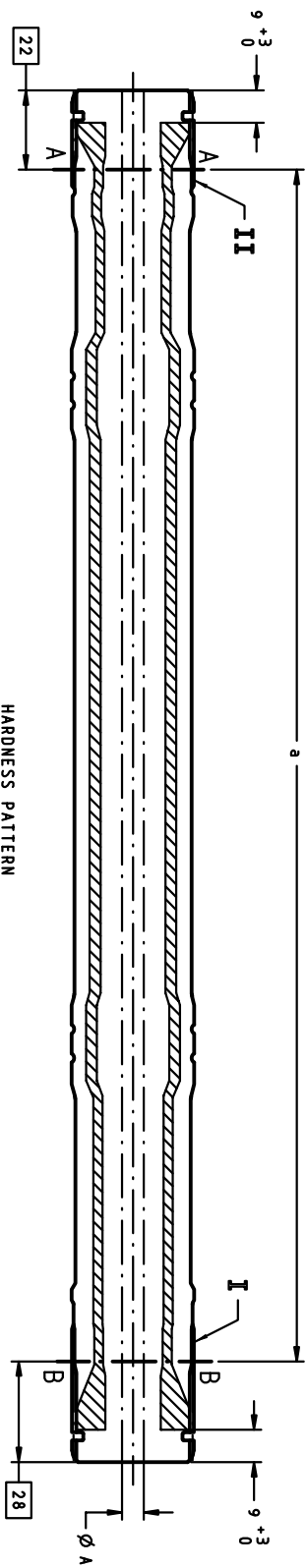
Part-Name: WALEK
Nazwa detalu:

Part-No.:
Nr detalu:

E0005106.A

Do not scale / Rys. nie w skali!

Prototype
 Pre-Launch
 Production
 Control Item
 Yes Tak
 No Nie



MATERIAL:
STEEL 37MnB4 MOD. ACC. TO NEARCO SPEC. 1019698 SHOT BLASTED

HEAT TREATMENT:
AFTER MACHINING INDUCTION HARDENED
HARDNESS 500HV MUST FALL WITHIN CASE DEPTH:
- 5.0-7.5 mm FROM SPLINE MINOR DIAMETER AND
SHAFT OUTER DIAMETER IN AREA "a"
MEASUREMENT IN SECTIONS A-A, B-B

CORE HARDNESS IN Øa=6 TO BE 350HV MAX.
SURFACE HARDNESS: 55-60 HRC

5

Mash. Type: Typ Maszynowy:	Op.No.:
BT:	Op.Nr.:
Nr. Tabl.:	
Proc.Engr.Group:	Date: 10.09.2024
Zespół Inz.:	Sht.: 1 of 1
Proc.Engr.:	Szkic: 1 z 1
Inz. Procesu:	