



Technical Requirement

1. The cranks/raft blank should go through normalizing, then hardening and tempering to 207HBS ~ 302HBS, shotblasting or blast sanding after quenching and tempering;

2.induction:high frequency;+temper;flat keyway:depth 0.8~1.8, Hardness 500HV500g~600HV500g@0.05;others:depth 1~3,Hardness 500HV500g~600HV500g@0.05;then tempering;:Polished transverse section of sample should be measured using a microhardness tester with a 500 gram load,the effective case depth is the distance from the surface to the depth at which hardness of 400HV500g;

3.130290255-T020 Other dimension and technical requirements Re:130300019-T020

技术要求

1. 毛坯经正火处理后进行调质处理,其调质硬度 207HBS~302HBS,调质后应做喷丸或喷砂等处理;

2. 热处理: 双点划线处高频淬火, 平键槽: 淬硬层深 $0.8 \sim 1.8$,

硬度 500HV500g~600HV500g; 其余硬化层深度 1~3,

硬度500HV500g~600HV500g; 高频淬火后应进行去应力回火;

取径向切割试样,抛光后用载荷为500g的显微硬度计测量;

表面硬度在距表面0.05处测量,有效硬化层深度是指表面到硬度

400HV500g处的距离;

3.130290255-T020其它尺寸和技术要求按130300019-T020执行。

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