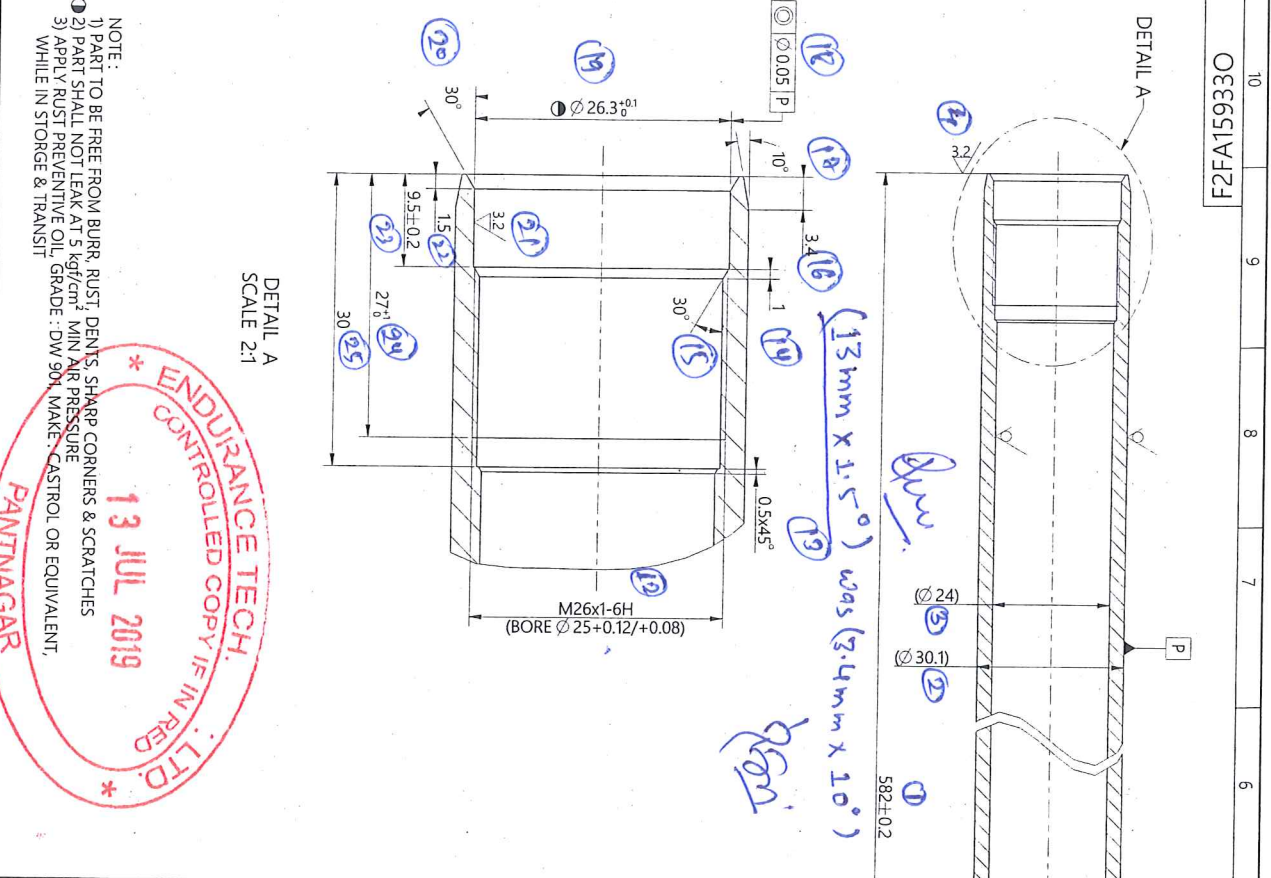


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ASK IF IN DOUBT ALL DIMENSIONS ARE IN mm (IF NOT SPECIFIED)



DATE	06/07/19	REV	1A	NEW RELEASE FOR DEVELOPMENT	ATTENTION	CO	1941	CR	A3	SIZE																								
NOTE: 1. UNSPECIFIED TOLERANCES AS PER IS-3028 (PART-II) MEDIUM (mm) 0 1 2 3 4 5 6 7 8 9 10 15 20 30 40 50 60																																		
<table border="1"> <tr> <td>MATERIAL</td> <td>REF. DRAWING</td> <td>WEIGHT</td> <td>1128.3</td> <td>DESCRIPTION</td> <td>FORK PIPE MACHINING (K19)</td> </tr> <tr> <td>REF. PART NO.</td> <td>F2FA159000</td> <td>VOLUME</td> <td>1</td> <td>DRG. NO./PART NO.</td> <td>F2FA159330</td> </tr> <tr> <td>DATE</td> <td>13 JUL 2019</td> <td>DRIVEN BY</td> <td>[Signature]</td> <td>CHECKED BY</td> <td>[Signature]</td> </tr> <tr> <td>SCALE</td> <td>1:1</td> <td>APPROVED BY</td> <td>[Signature]</td> <td>SHEET NO.</td> <td>1 OF 1</td> </tr> </table>											MATERIAL	REF. DRAWING	WEIGHT	1128.3	DESCRIPTION	FORK PIPE MACHINING (K19)	REF. PART NO.	F2FA159000	VOLUME	1	DRG. NO./PART NO.	F2FA159330	DATE	13 JUL 2019	DRIVEN BY	[Signature]	CHECKED BY	[Signature]	SCALE	1:1	APPROVED BY	[Signature]	SHEET NO.	1 OF 1
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10 9 8 7 6 5 4 3 2 1

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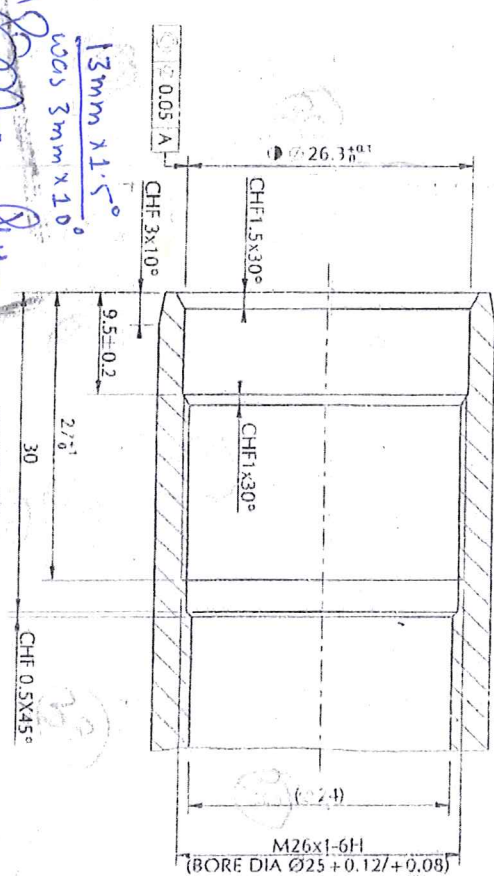
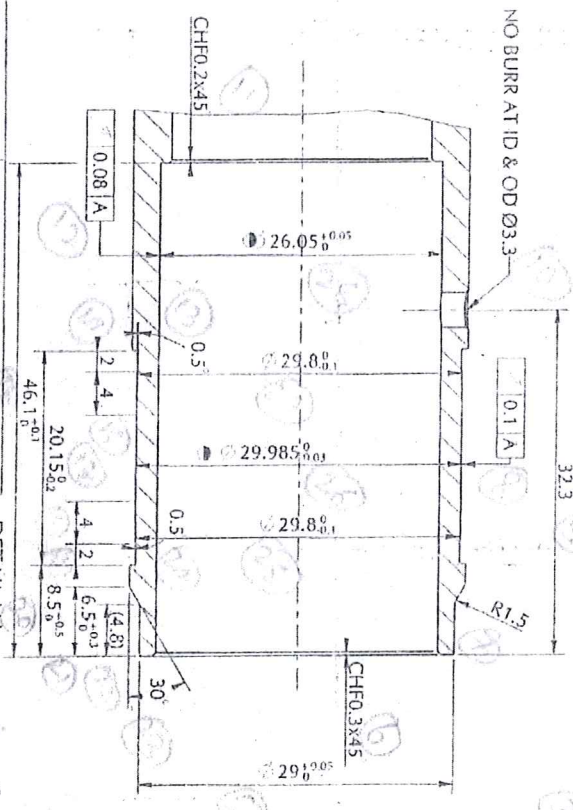
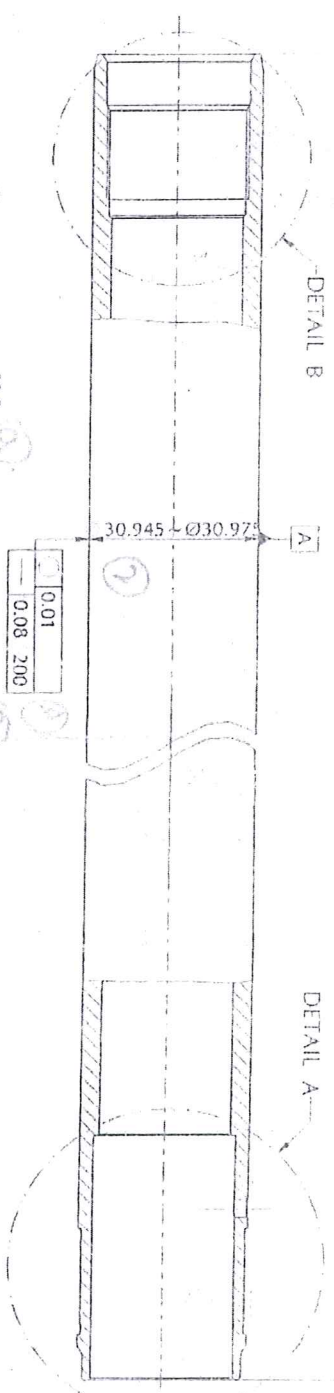


TABLE-1

DESCRIPTION	SPECIFICATION
PRE GROUND	31.15 - 0.08, Ra 1.2 MAX
AFTER ROUGH GRINDING	31.02 - 31.06; Ra 1.2 MAX
AFTER FINISH GRINDING	30.907 - 30.917; Ra 0.2 MAX
AFTER PLATING	30.945 - 30.975; Ra 0.1 MAX

NOTES:-
 1) NI-HARD CHROME PLATING TO MEET SPECS:-
 A) 96 Hrs. CASS TEST AS PER IS : 5328
 B) NI+HARD CHROME PLATING: Fe/Ni: 12 D GR12 DUPLEX COATING WITH NI-12 MICRON MINIMUM & Cr 12 MICRON MINIMUM
 C) ACCEPTANCE CRITERIA - RATING No.9 MINIMUM ON SIGNIFICANT AREA AS PER IS : 6009
 D) SURFACE HARDNESS - 1000 HV.25 Cms MINIMUM
 E) CHROME COATING TYPE: MICRO CRACKED WITH 600 TO 1000 CRACKS/Cm
 2) NO LEAKAGE AT 5 Kg/cm² MIN AIR PRESSURE
 3) NO DENT SCRATCH MARKS AFTER PLATING
 4) FORK PIPE TO BE BUFFERED & REMOVE BURR FROM I.D.

13mm x 1.5°
 WAS 3mm x 10°
 12 AUG 2011
 ENDURANCE TECH
 12 AUG 2011

DATE	REV	DESCRIPTION	ATTENTION	DATE	REV	DESCRIPTION	ATTENTION
10.02.14	XA	NEW RELEASE FOR DEVELOPMENT					

NOTE: 1. UNDESIGNED TO BE USED FOR THE SPECIFIC PART IN MEDIUM
 2. DO NOT SCALE DRAWING

SCALE: A3

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DRAWN BY	CHECKED BY	APPROVED BY	SHEET NO.
			1 OF 1

MATERIAL	F2FA073000
REF. PART NO.	550FA13804 REV XA
DESCRIPTION	F2FA073050
REV	XA

SAFETY CHARACTERS: 0
 SIGNIFICANT CHARACTERS: 4

VOLUME: mm3
 SURFACE: mm2
 WEIGHT: gm

FORK PIPE PLATED
 (K1 UPGRADE)