

Attachment table 3

Type of mechanical press	Components of the clutch	Heat treatment	Surface hardness( Rockwell C scale)
pin clutch mechanical press	clutch slide- pin	quenching , tempering	over 52 below 56
	clutch driving cam	quenching and tempering being applied to the contact portion for carbon tool steel;  quenching and tempering after carburization for chromium molybdenum steel	over 52 below 56
	stopper of clutch slide- pin	quenching and tempering for alloy tool steel; quenching and tempering after carburization for chromium molybdenum steel	over 54 below 58
key clutch mechanical press	clutch ring in inner	quenching and tempering	over 22 below 25
	clutch ring in middle	quenching and tempering after carburization	over 52 below 56
	clutch ring in outside	quenching and tempering	over 22 below 25
	rolling- key	quenching and tempering	over 54 below 58
	clutch driving cam	quenching and tempering	over 42 below 45
	portion in the metal fittings for clutch engaging or separating that contacting with the clutch driving cam	quenching and tempering	over 42 below 45