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REF.DRG.NO.

9

Dec Thu 5 11:40 2013

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RELIEF

45°

A diagram showing a quarter-circle fillet with radius R and height A . The fillet is defined by a solid line, and the area between the solid line and the dashed line represents the fillet. The angle θ is indicated at the top left corner.

DETAIL-A

MARK : 10-31-9008/1

No. OF TEETH : 4

ANGLE OF R.H HELIX : 25°

PILOT SHOULD NOT HAVE CUTTING EDGES

ITEM No -1 TO BE HARDENED & TEMPERED AS PER CW:1004

INCINATION OF TOOL POST FOR RELIEVING 45°

PROFILE TO BE CHECKED AGAINST MAGNIFICATION DRG. TRG:0645

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED...

REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.

2. CHAMFER M/CD SHARP EDGES
1.2 TO 1.0 AT 45°:

3. INTERNAL M/CD CORNER RADII

1 TO 0.7.

4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

RECEIVED
BHEL
EDAS
BHEL ENGINEERING

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DEPT.	TRD		SCALE	WEIGHT (KG)
CODE	207D		NTS	NA

TITLE	ROUNDING OFF CUTTER

SHEET NO.	NO OF SHEETS
01	01

Engineering Digital Archive System (EQAS) A:

signatures are not essentially required.

3.2/0.4

[illegible]

SL.No.	MARK TOOL No.	D	d	R	∠°	LEAD OF HELIX	CAM HEIGHT
1	10-31-9008/1	20	^{-0.1} 15.45	1.5	1°	119	2
2	20-26-2085	23	^{-0.02} 13.98	3.0	3°	141.5	4.5
3	10-26-9108	22	^{-0.05} 15.20	2	1°	128	2.6
4	10-31-9009/1	22	^{-0.05} 15.95	1.5	1°	128	2.6
5	20-26-2085/A	22	^{-0.05} 14.75	3	3°	141.5	4.5
6	20-26-2190	23	^{-0.05} 11.75	3	3°	141.5	4.5

2	ø25x80				HY1060264129	0.115	0.310
					HY10664		
1	ø25x70				HY1080268120	0.15	0.27
					HY10868		
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	DRG. No.	2-14-1018	P.No.	31012
			10-31-9	

		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD				DRN.	NAME	SIGN.	DATE	NO. OF VAR.
				SCALE	WEIGHT (KG)	CHD.				
				NTS	NA	APPD.				
DEPT. TRD CODE 207D				REF. TO ASSY DRG.						
				NA						
				ITEM NO.						
				DRAWING NO.						
				3-71-287-0040						
				REV.						
				04						
				SHEET NO. 01						
				NO. OF SHEETS 01						

SHEET NO. 5