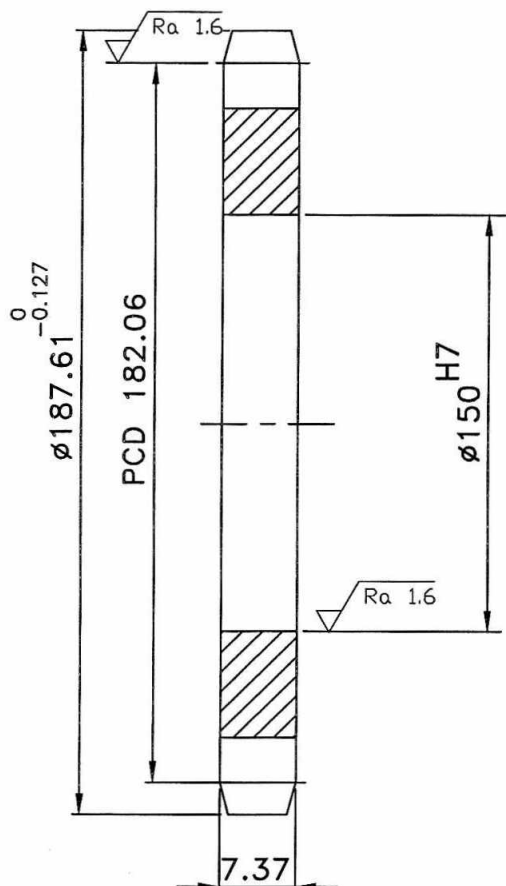


ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

 $\sqrt{Ra\ 6.3}$ ($\sqrt{Ra\ 1.6}$)

H7	+0.040
ø150	0

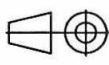


NOTES:

PROFILE : DIN 8187 / ISO R606
 TO SUIT 08B-1 ROLLER CHAIN
 NO OF TEETH : 45
 PITCH : 12.7
 DIA OF ROLLER : 8.51
 TOOTH TO BE INDUCTION HARDENING TO HRC 45 ±2

SHARP EDGES REMOVED BY 1x45°

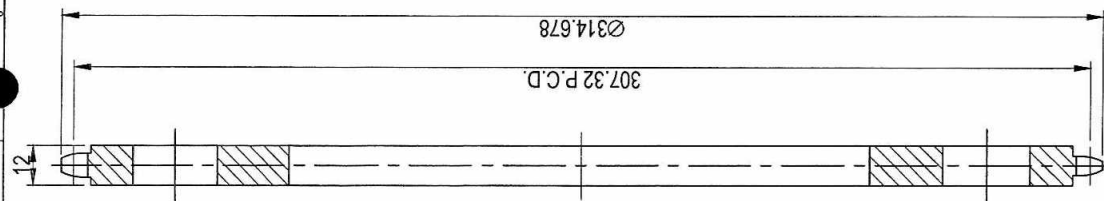
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ITEM NO	DESCRIPTION	DRAWING NO	45C8 IS:5517	MATL CODE	UNIT WT
				MATL SPEC	QTY
EQPT: MANIPULATOR					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME SSN.KUMAR	SIGNATURE <i>S.S.V. Kumar</i>	DATE 20.05.13
		CHD	G.LOGANATHAN	<i>G. Loganathan</i>	20.05.13
		APPD	S.MOHAN	<i>S. Mohan</i>	20.05.13
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi/M/f$ IS: 2102	 NTS	13	REF TO OLD DWG NO	
TITLE			CARD CODE	DRAWING NO :	REV
MPL - SPROCKET Z=45, P=12.7 LIFTING CARRIAGE ARRANGEMENT			U 01	4-7-1124-00-10098	00

A4-SIZE

4208-64P2	
Next	

8 Nos. HOLES $\phi 20.1H7$ THRU"
AT PCD $\phi 245 \pm 0.10$ EQUISPACED



Sprocket Teeth Detail:-

Pitch 12.7 (Simplex)
No. of Teeth - 76
Pitch Dia. :- 307.32
Outside Dia. :- 314.678

Machine's plate:

01) Remove the sharp corner & edges with 1mm chamfered &

shall files to be 1mm, radius unless otherwise specified.

02) All dimension are in millimeter (mm.) unless otherwise specified.

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING

IS THE SOLE PROPERTY OF PPRM. ANY REPRODUCTION

IN PART OR AS A WHOLE WITHOUT THE PERMISSION OF

PPRM IS PROHIBITED.

NOTE :- 1: 2

All dimensions are in Millimolters unless otherwise stated. Do not

Scale. If in doubt, please ask.

SYMBOL	ϕ	$\sqrt{\frac{1}{2}}$	$\sqrt{\frac{1}{4}}$	$\sqrt{\frac{1}{8}}$	$\sqrt{\frac{1}{16}}$	$\sqrt{\frac{1}{32}}$	$\sqrt{\frac{1}{64}}$
Pa. #	25	12.5	6.3	3.2	1.6	0.8	0.4

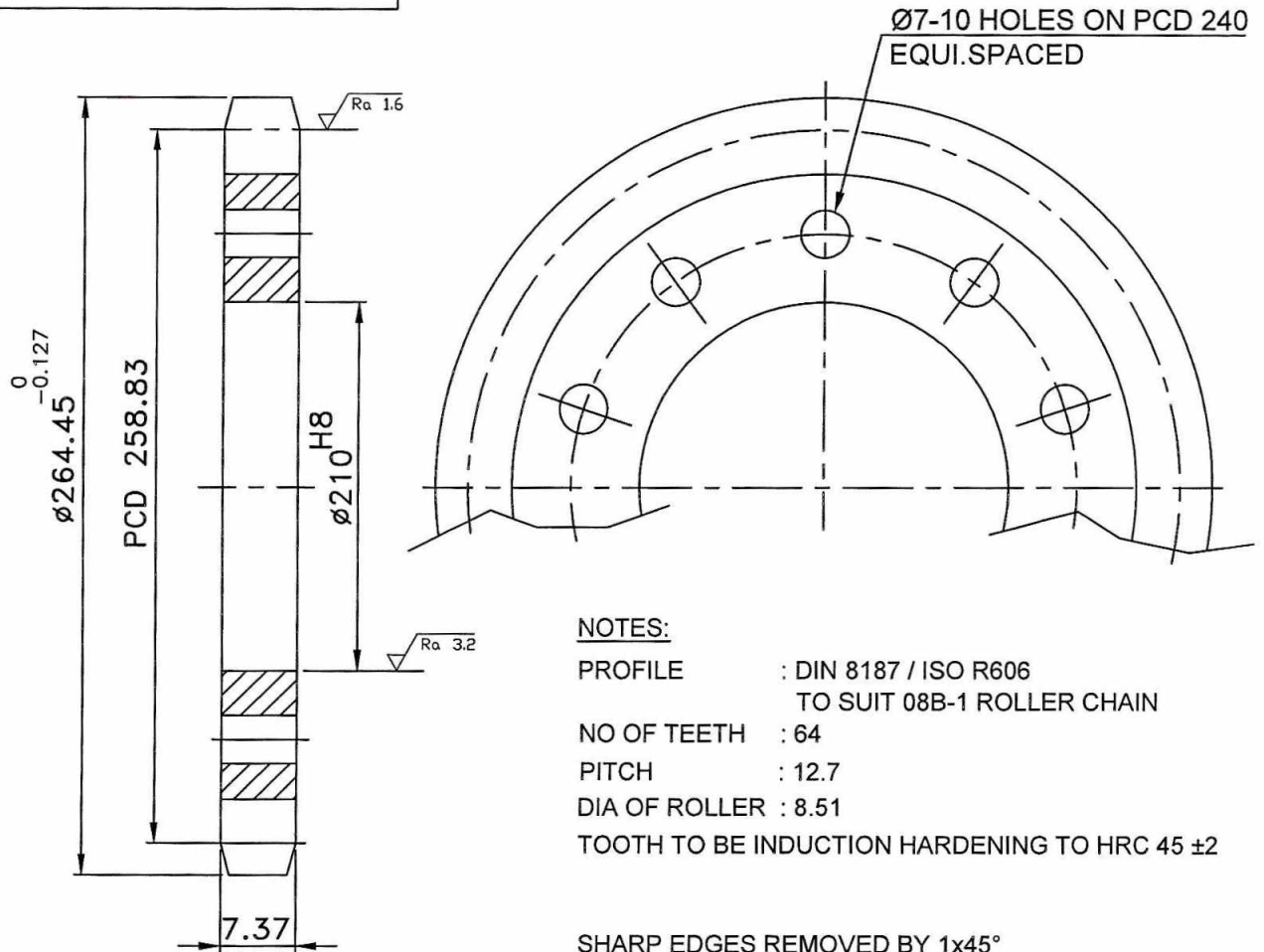
SURFACE FINISH

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

$\sqrt{Ra\ 6.3}$ ($\sqrt{Ra\ 1.6}$ $\sqrt{Ra\ 3.2}$)

$\varnothing 210$ H8	+0.072
	0



NOTES:

PROFILE : DIN 8187 / ISO R606
TO SUIT 08B-1 ROLLER CHAIN
NO OF TEETH : 64
PITCH : 12.7
DIA OF ROLLER : 8.51
TOOTH TO BE INDUCTION HARDENING TO HRC 45 $\pm$ 2

SHARP EDGES REMOVED BY 1x45°

CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ITEM NO	DESCRIPTION	DRAWING NO	45C8 IS:5517	MATL CODE	UNIT WT
				MATL SPEC	QTY
EQPT: MANIPULATOR					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME SSN.KUMAR	SIGNATURE <i>S.S.V. Kumar</i>	DATE 20.05.13
		CHD	G.LOGANATHAN	<i>S. Loganathan</i>	20.05.13
		APPD	S.MOHAN	<i>S. Mohan</i>	20.05.13
DEPT SSTP	GRADE OF UNTOL. DIM $\varnothing/M/F$ IS: 2102	SCALE NTS	WEIGHT (Kg) 1.05	REF TO ASSY DWG NO TA772.04.04.00.CC	ITEM
CODE 456				REF TO OLD DWG NO	
TITLE MPL - SPROCKET Z=64, P=12.7 MOVING CARRIAGE ARRANGEMENT			CARD CODE U 01	DRAWING NO : 4-7-1124-00-10097	REV 00

A4-SIZE