

SIGN & DATE

SUPERSEDES
INVENTORY No.

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SIGN & DATE

INVENTORY No.

C4-55



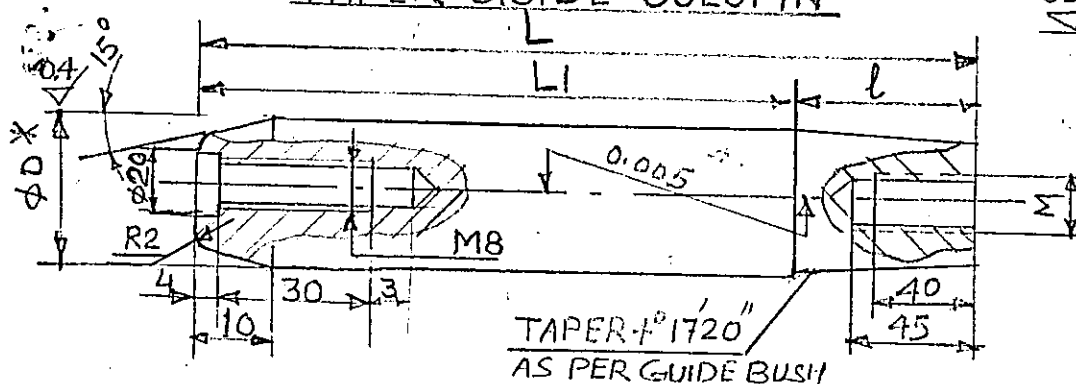
TOOL STANDARD JIG AND TOOL ENGINEERING

TL-10055

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TAPER GUIDE COLUMN

6.3 REST



SL. NO	CODE NO.	ϕD^*	L	L_1	l	M	WT. KG
1	01	30	107	70	37	M10	0.8
2	02	30	147	110	37	M10	1.5
3	03	40	195	140	55	M12	2.15
4	04	40	255	200	55	M12	2.75
5	05	50	245	180	65	M16	4.5
6	06	50	285	220	65	M16	5.5
7	07	50	315	250	65	M16	5.8
8	08	70	235	150	85	M16	8.15
9	09	70	285	200	85	M16	11.3
10	10	70	335	250	85	M16	9.8
11	11	100	310	240	120	M16	21.2
12	12	70	375	290	85	M16	11.3
13	13	40	215	160	55	M12	2.5
14	14	50	215	150	65	M16	3.5
15	15	50	265	200	65	M16	3.8
16	16	70	265	180	85	M16	9.5

1. MATERIAL:- OHNS-T90 Mn 6WCY2 AS PER AA 10821

HARDEN TO HRC 60÷63 FOR COLUMN $\phi D < 70$ AS PER INST. 0912-008OR HARDEN TO HRC 55÷58 FOR COLUMN $\phi D \geq 70$ AS PER INST. 0912-008

*2. TO ENSURE INTERFERENCE FIT OF 0.010 TO 0.025 BETWEEN GUIDE COLUMN BUSH AND BALL CAGE (IN CASE OF USING OF BALL CAGE)

3. TAPER CONTACT SURFACE WITH GUIDE BUSH TO BE ACHIEVED 80% BY LA

REVISION THIS TL. SUPERSEDES U/SAME

05 TL NO. CH. AD. NO. JTE/D/099/033

06 ICH. AD. NO. JTE/D/2002/018

WORKED BY

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APPROVED M. M. A.