

SIGN. & DATE

SUPERSEDES
INVENTORY NO.

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SIGN. & DATE

INVENTORY NO.

JT-05



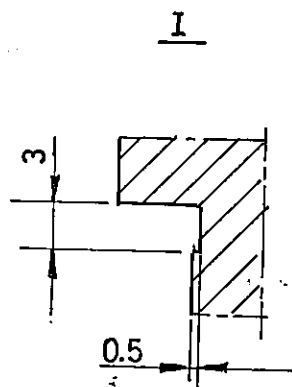
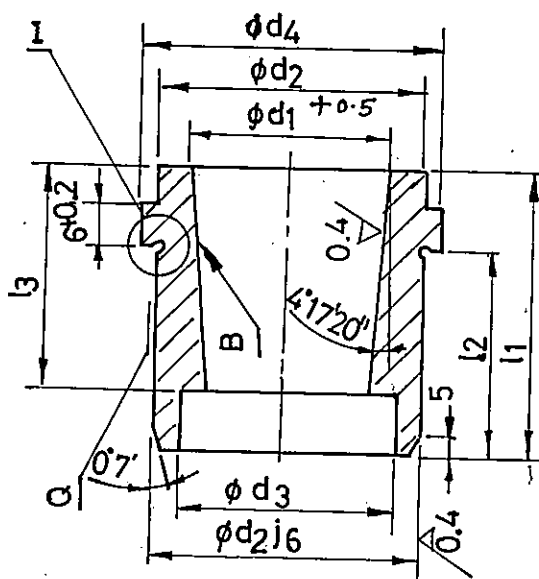
TOOL STANDARD JIG AND TOOL ENGINEERING

TL 10131

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TAPER BUSH

63 / THE REST



SL NO	CODE NO	$d_1^{+0.5}$	$d_2 \pm 0.012$ -0.007	d_3	d_4	l_1	l_2	l_3	WT.KG.
1	01	$30^{+0.5}$	$58^{+0.012}$ -0.007	35	68	55	44	37.5	0.75
2	02	$40^{+0.5}$	$70^{+0.012}$ -0.007	45	80	75	53	55.5	1.1
3	03	$50^{+0.5}$	$82^{+0.013}$ -0.009	55	92	86	53	65.5	2.0
4	04	$70^{+0.5}$	$104^{+0.013}$ -0.009	75	114	106	76	86	3.6
5	05	$100^{+0.5}$	$140^{+0.014}$ -0.011	105	150	136	100	121	5.1

1. MATERIAL 40Cr1 HW10571 / En 24 AA 10501 HARDEN TO HRC 40÷45 AS PER INST.0912.008

2. TAPER CONTACT SURFACE 'B' WITH GUIDE COLUMN TO BE
ACHIEVED 80% BY LAPPING.

3. SURFACE 'Q' TO BE GROUND IN ASSLY GUIDE COLUMN.

REVISION

(04)

THIS TL. SUPERSEDES U/SAME
TL. No. CHAD. No. JTE/D/99/027

WORKED BY

IP SINGH

-sd-

CHECKED BY

N SINGH

-sd-

APPROVED BY

MMA

sd/-

RETRACED FROM ORIGINAL

TRACED BEDD

CHD Singh 26.3.99