FIRST ANGLE PROJECTION

DRG. NO. 2SP08007427

ALL DIMENSIONS ARE IN MM

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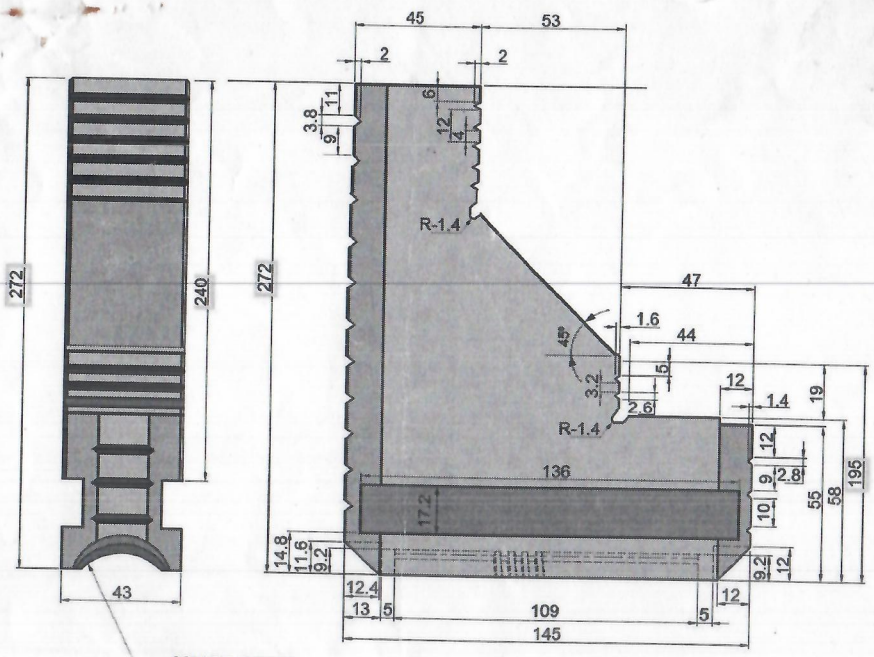
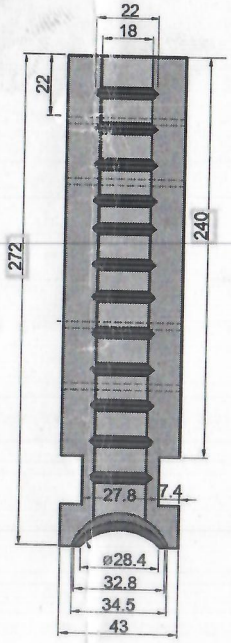
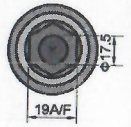
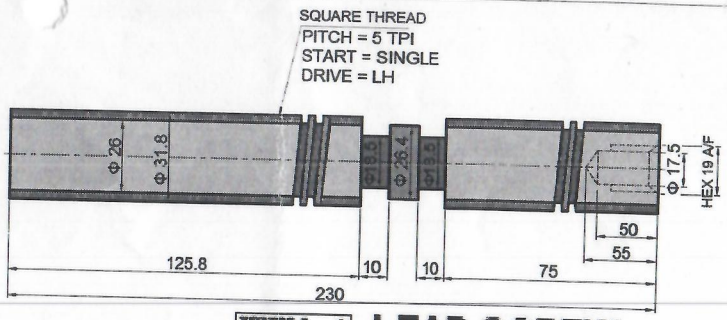
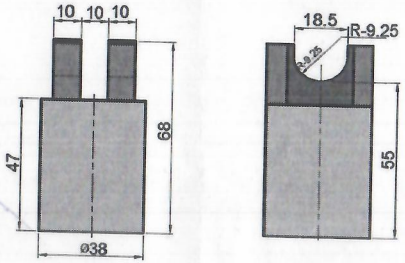


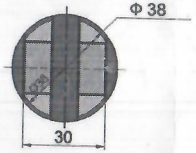




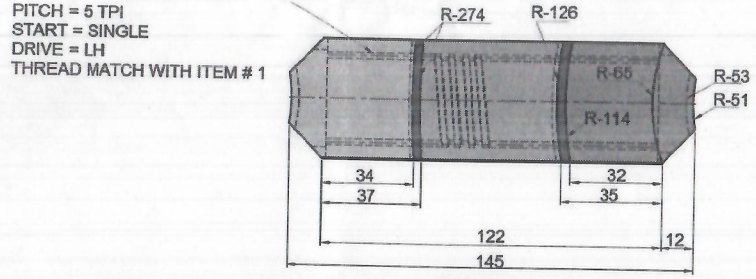


ITEM-1 LEAD SCREW





ITEM-2 GATTOO



ITEM-3 JAW

SIZE OF HEX KEY
Nominal Size: HEX 19 MM A/F
Engagement Length: 30 MM
Material : Chrome vanadium steel hardened to 52-56 HRc

ITEM-4 CHUCK KEY

3.2

1- Machine all over
2- Lead screw, Gattoo & chuck key EN-24 Hardened & toughened to 40-45 HRc, Nitrided to depth 0.05-0.1 mm (Item 2,3 & 4)
3- Hard Jaws : Medium Carbon forged steel Case Hardened to 56-60 HRc to depth 0.8-1.2 mm. Threaded portion to be induction annealed to avoid jaw thread breakage and premature wearing of connected parts

ADDITIONAL INFORMATION	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
STATUS OF DRAWING	
DISTRIBUTION OF PRINTS	BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	R.BARASKAR		05.09.19	
CHD.	R.MEHRA		06.09.19	
APPD				00

DEPT.	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
WEX CODE 375						

TITLE: CHUCK-JAW'S, FINGER & SCREW CHUCK OF GRINDING M/C #5/A/2109-21421

DRAWING NO. 2SP08007427 REV. 00

SHT. NO. 01 NO. OF SHT. 01

REV.	DATE	ALTERED / CHECKED / APPROVED	ZONE

INVENTORY NO. | SIGN. & DATE | REF. DRG. NO.

Thomas Parkey

Prmanshu

वरि. अभियंता (उत्पा.) / SUMIT
Executive Engineer (Prod.)
टी.एक्स.एम. विभाग / TXM Division
बी.एच.ई.एल. भोपाल / BHEL Bhopal

SIZE A2

FIRST ANGLE PROJECTION

DRG. NO. 2SP08002032

ALL DIMENSIONS ARE IN MM

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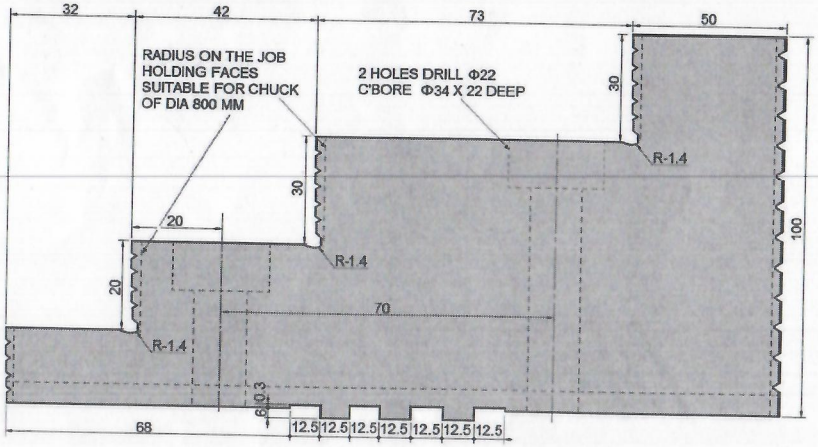
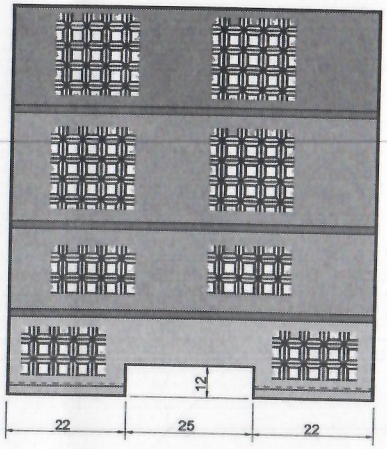
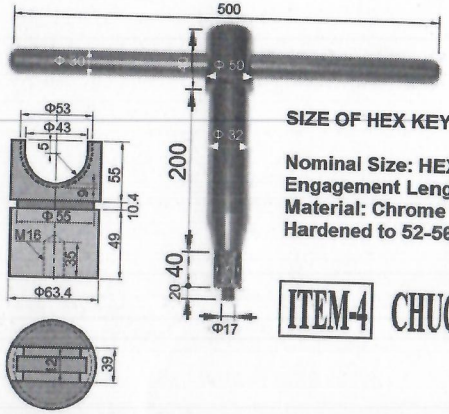


ITEM-3 JAW



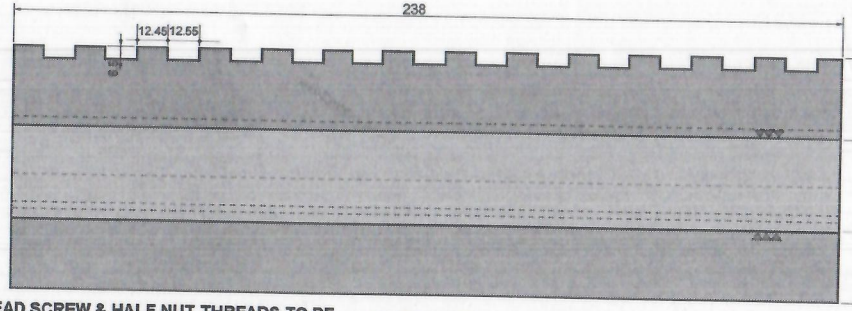


SIZE OF HEX KEY

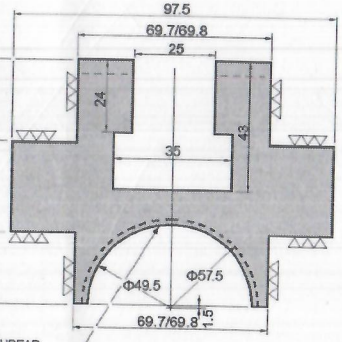
Nominal Size: HEX 25 mm A/F
Engagement Length: 30 mm
Material: Chrome Vanadium Steel
Hardened to 52-56 HRc

ITEM-4 CHUCK KEY

ITEM-2 GATTOO

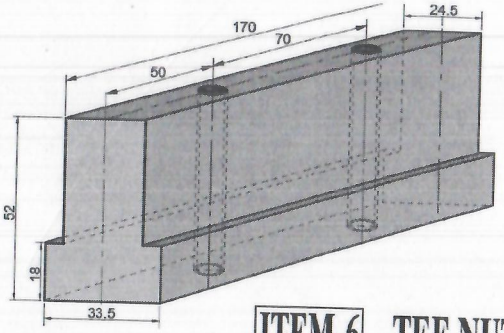


LEAD SCREW & HALF NUT THREADS TO BE MATCHED FOR USE INTERCHANGEABLY

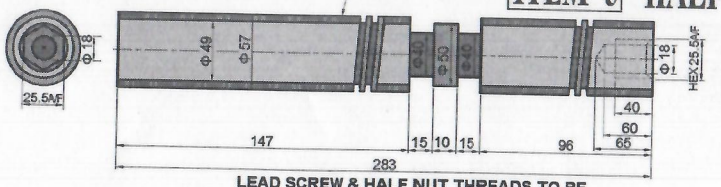


SQUARE THREAD
PITCH = 5 TPI
START = SINGLE
DRIVE = LH

ITEM-5 HALF NUT



ITEM-6 TEE NUT



SQUARE THREAD
PITCH = 5 TPI
START = SINGLE
DRIVE = LH

LEAD SCREW & HALF NUT THREADS TO BE MATCHED FOR USE INTERCHANGEABLY

ITEM-1 LEAD SCREW

3.2

1- Machine all over
2- Material EN-24 to be used for Lead screw, Gattoo, chuck key, Half nut and Tee nut (Items # 2,3,4,5 & 6), Hardened and Toughened to 40-45 HRc, Nitrided to depth 0.05-0.1 mm
3- Hard Jaws : Medium Carbon forged steel Case Hardened to 56-60 HRc to depth 0.8-1.2 mm. Threaded portion to be induction annealed to avoid jaw thread breakage and premature wearing of connected parts

ADDITIONAL INFORMATION	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT								
STATUS OF DRAWING									
DISTRIBUTION OF PRINTS	BHARAT HEAVY ELECTRICALS LTD. BHOPAL				NAME	SIGN	DATE	NO. OF VAR.	
				DRN.	R.K. JAISWAL		31.10.19		
				CHD.					
				APPD.				00	
REV	DATE	ALTERED / CHECKED / APPROVED	DEPT. WEX	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
ZONE			CODE 375						
			TITLE: SPARES FOR 800 MM CHUCK OF WARD LATHE 26/A/2032				DRAWING NO 2SP08002032		REV. 00
							SHT. NO. 01	NO. OF SHT. 01	

SIZE A2

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.

3