

2

00. AIR SI W/ MO
71 1387 000 0017001

ALL DIMENSIONS ARE IN MM

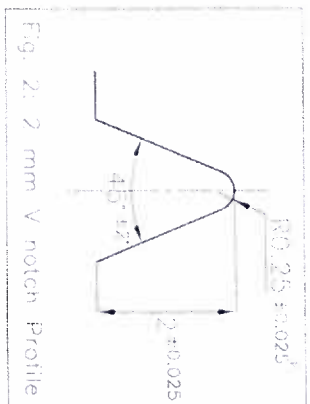
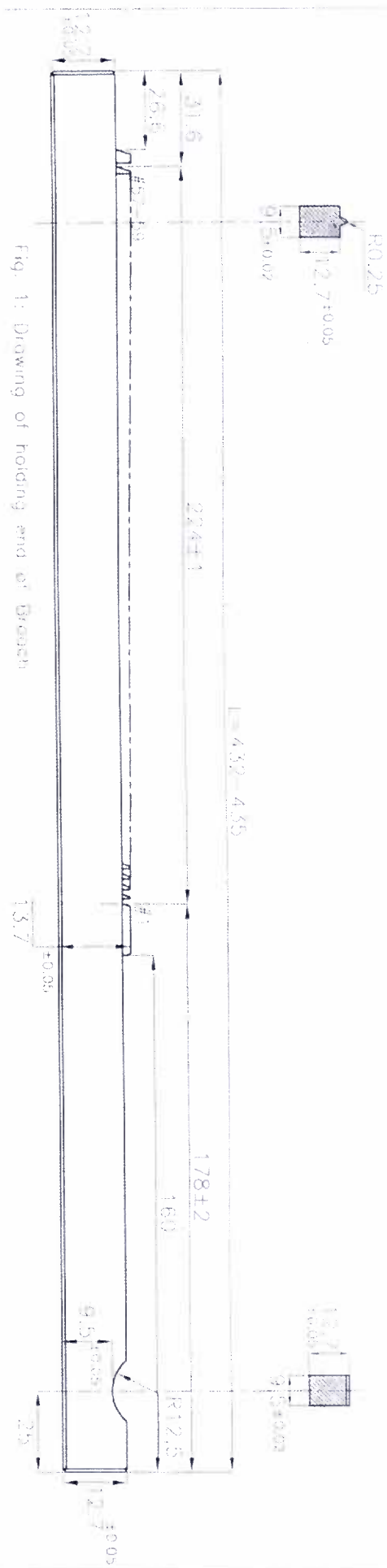


Fig. 1: Drawing of holding end of Broach

- NOTE:-
1. THIS MATERIAL MUST BE SUPPLIED IN DRG. DIMENSIONS WITHIN TOLERANCES AS MENTIONED.
 2. TOOTH HARDNESS - HRC 62-67
 3. SHANK HARDNESS - HRC 45-55
 4. FIG. 2 SHOWN V NOTCH PROFILE.
 5. REFERENCE STANDARD IS 1757.
 6. ALL DIMENSIONS IN MM AND ALL ANGLES IN DEGREE

DETAIL OF TEETH NOTCH

4
15°

REV	DATE	ALTERED	CHECKED
TITLE			
DRAWING FOR BROACH			
MATERIAL - H.S.S. (M2)			
PROJECT/MACHINE TYPE			
M/C - VERTICAL PULL TYPE			
BROACHING MACHINE			
DRAWING NO.			
CML/ML-15 REV 00			
SHEET NO.			
NO. OF SHEETS			
DEPT - QUALITY MGMT			
SCALE			
WEIGHT IN KG			
NAME			
SIGN			
DATE			
DRN			
WKO			
CHD			
APPD			
M. BIRUA			
S. HEMBROW			
V. K. AGRAWAL			
03.04.17			
03.04.17			

BIHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT
RANPUR HARDWAR

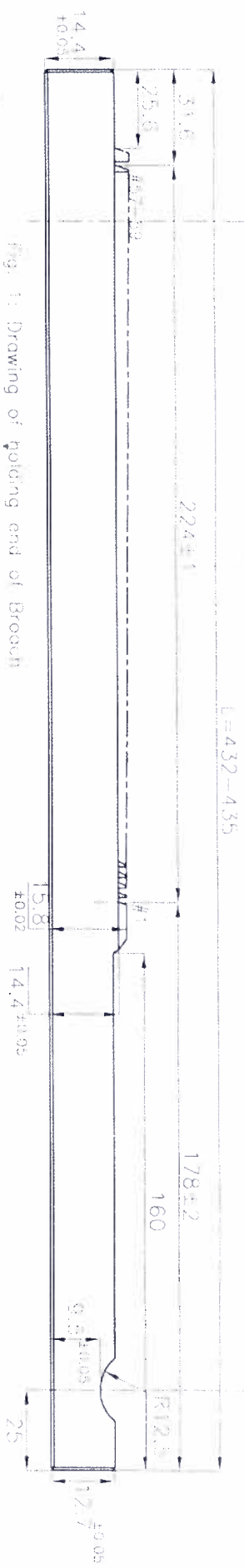


Fig. 1: Drawing of holding end of Broach

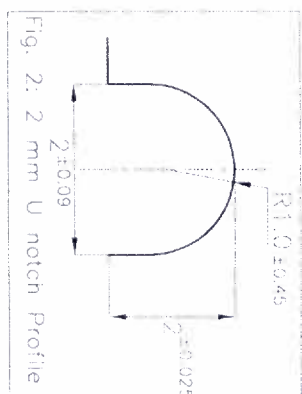


Fig. 2: 2 mm U notch Profile

DETAIL OF TEETH PITCH



- NOTE:-
1. THIS MATERIAL MUST BE SUPPLIED IN DRG. DIMENSIONS WITHIN TOLERANCES AS MENTIONED.
 2. TOOTH HARDNESS - HRC 62-67
 3. SHANK HARDNESS - HRC 45-55
 4. FIG. 2 SHOWN U NOTCH PROFILE
 5. REFERENCE STANDARD IS 1499
 6. ALL DIMENSIONS IN MM AND ALL ANGLES IN DEGREE

REV	DATE	ALTERED	CHECKED

EX-111 BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANPUR HAWAR		PROJECT/WORKING TYPE DRAWING FOR BROACH MATERIAL - H.S.S. (M2)	
DEPT - QUALITY MGMT SCALE WEIGHT IN KG		DRAWING NO. CML/ML-16 REV 00	
DRN WKO CHKD APPRO		NAME SIGN DATE	
M/C - VERTICAL PULL TYPE BROACHING MACHINE		NO OF SHEETS	

3.04.11
19.05.11