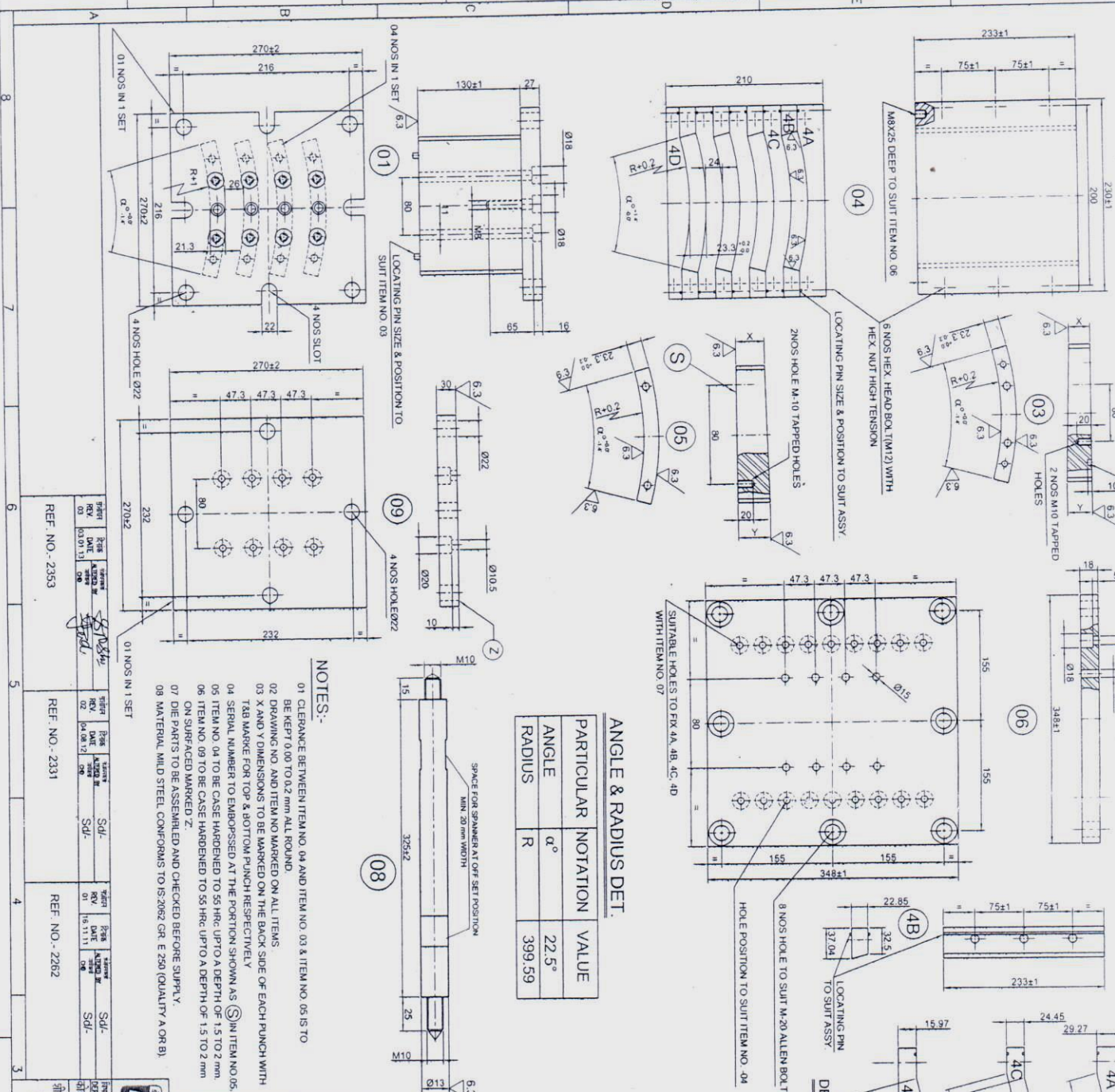


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समाधिकार एवं गैरसह
 इन प्रश्नों में ही मैं बहस करता हूँ। इनके समाधान विविध हैं। इसका प्रत्यक्ष या
 अप्रत्यक्ष रूप में किसी भी तरह प्रयोग नहीं किया जाए जो कम्पनी के हित में हानिकार हो।

DIMENSIONS TO BE CONTROLLED
WITHIN LIMITS AS SHOWN
MACHINING TOLERANCE ± 0.25 mm
UNLESS OTHERWISE SHOWN

सामान संख्या/INVENTORY NO.	पत्रांक और दिनांक/SIGN & DATE	संदर्भित अभिलेख संख्या/REFERENCE ORG.NO
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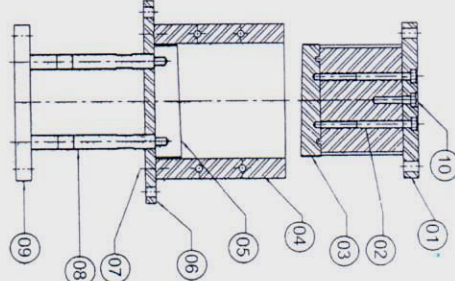
ANGLE & RADIUS DET

PARTICULAR	NOTATION	VALUE
ANGLE	α°	22.5°
RADIUS	R	399.59

PUNCH DETAILS

SERIAL NO.	ITEM NO.	DIM.		QTY.
		X	Y	
H1	03	30	30	04
H2	03	30	30.5	04
H3	03	30	30.75	04
H4	03	30	31	04
H5	03	30	31.25	04
H6	03	30	31.5	04
H7	03	30	31.75	04
H8	03	30	32	04
H9	03	30	32.5	04
H10	03	30	32.75	04
H11	03	30	33	04
H12	03	30	33.5	04
H13	03	30	34	04
H14	03	30	34.25	04
H15	03	30	34.75	04
H16	03	30	35	04
H17	03	30	35.5	04
H18	03	30	36	04

ASSEMBLY



SERIAL	ITEM	DIM.	DIM.	QTY
NO.	NO.	X	Y	
H19	05	40	40	04
H20	05	40	4.5	04
H21	05	40	40.75	04
H22	06	40	41	04
H23	05	40	41.25	04
H24	05	40	41.5	04
H25	06	40	41.75	04
H26	05	40	42	04
H27	05	40	42.5	04
H28	05	40	42.75	04
H29	05	40	43	04
H30	05	40	43.5	04
H31	05	40	44	04
H32	06	40	44.25	04
H33	05	40	44.75	04
H34	05	40	45	04
H35	05	40	45.5	04
H36	05	40	46	04

NOTES:-

01. CLEARANCE BETWEEN ITEM NO. 04 AND ITEM NO. 03 & ITEM NO. 05 IS TO BE KEPT 0.00 TO 0.2 mm ALL ROUND.
02. DRAWING NO. AND ITEM NO. MARKED ON ALL ITEMS.
03. X & Y DIMENSIONS TO BE MARKED ON THE BACK SIDE OF EACH PUNCH WITH TAB MARKER FOR TOP & BOTTOM PUNCH RESPECTIVELY.
04. SERIAL NUMBER TO BE EMPLOYED AT THE PORTION SHOWN AS  IN ITEM NO. 06.
05. ITEM NO. 04 IS TO BE CASE HARDENED TO 55 HRC. UPTO A DEPTH OF 1.5 TO 2 mm.
06. ITEM NO. 09 IS TO BE CASE HARDENED TO 55 HRC. UPTO A DEPTH OF 1.5 TO 2 mm.
- ON SURFACE MARKED 'Z'.
07. DIE PARTS TO BE ASSEMBLED AND CHECKED BEFORE SUPPLY.
08. MATERIAL, MILD STEEL CONFORMS TO IS: 2062, E. 250 (QUALITY A OR B).
- IN 1 SET

ITEM NO.	DESCRIPTION	MATERIAL	QTY
10	CAP SCREW (M8 TO SUIT ASSY)	HIGH TENSION STEEL	01
09	BOTTOM LIFTING PUNCH PLATE	MILD STEEL	01
08	EJECTING ROD	HIGH TENSION STEEL	08
07	CAP SCREW (ALLEN BOLT M8x25)	HIGH TENSION STEEL	18
06	BASE PLATE	MILD STEEL	01
05	BOTTOM PUNCH	MILD STEEL	01
04	DIE BODY	MILD STEEL	01
03	TOP PUNCH	MILD STEEL	01
02	ALLEN BOLT (M10 TO SUIT ASSY WITH 08mm HIGH TENSION STEEL	HIGH TENSION STEEL	06
01	TOP PUNCH HOLDER	MILD STEEL	01

MILD STEEL	
MILD STEEL	07
MILD TENSION STEEL	08
MILD STEEL	09

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
BHARAT HEAVY ELECTRICALS LIMITED
JAGDISHPUR, SULTANPUR

Ref/Name	Ref/Name	Ref/Name
C.S.JOSHI	Sd/=	24.10.1
S. YADAV	Sd/=	24.10.1
N. A. SAJI	Sd/=	24.10.1

FOUR CAVITY DIE (I.D.-686)

कॉर्ड कार्ड
CARD
CODE