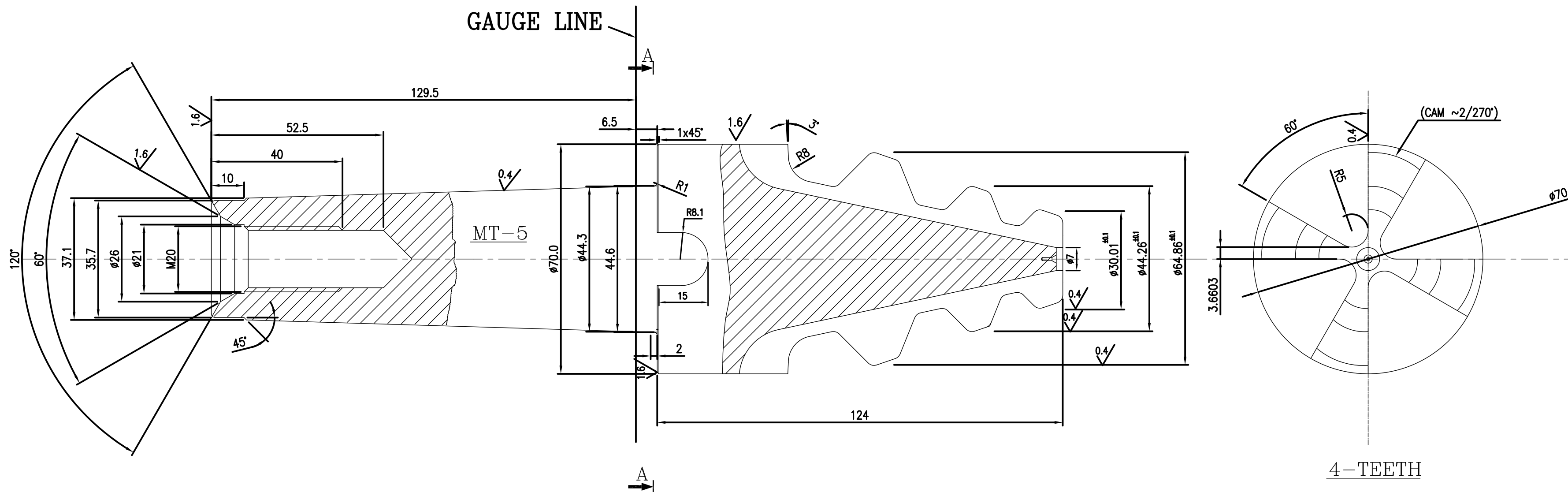

3

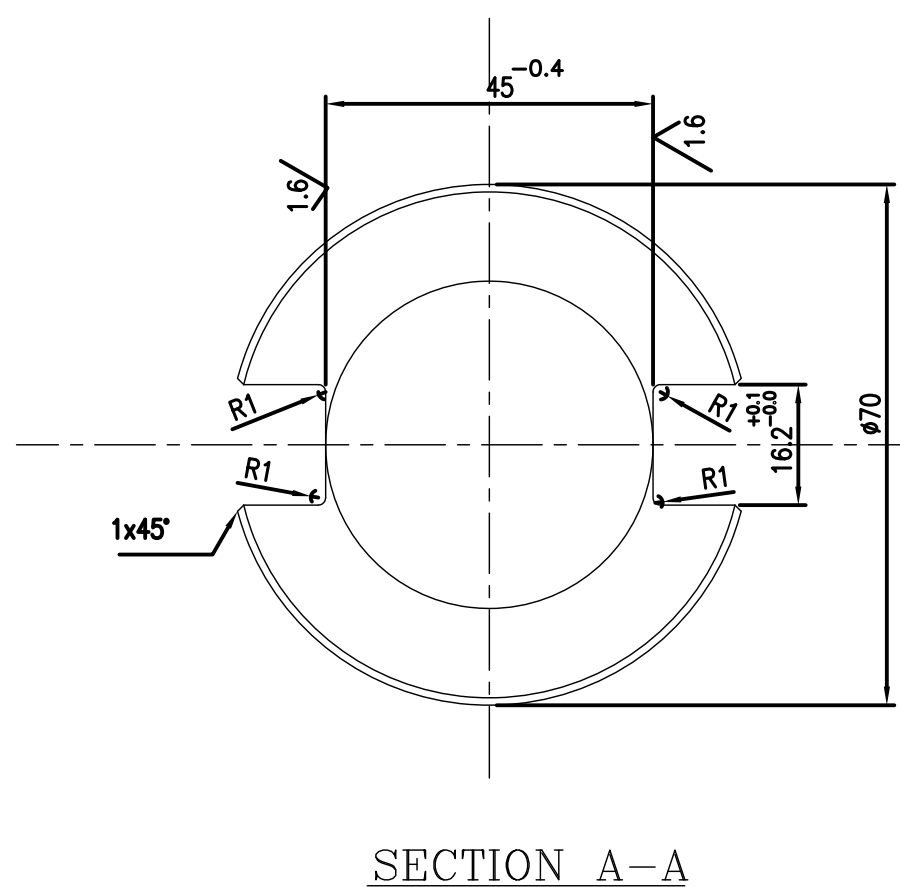
3.2 0.8 0.4



MARK : 10-31-11025 (FORM- 17 A) FINISHER.

NOTE:—

MATERIAL : ASP 60
CUTTING PORTION TO BE HARDENED & TEMPERED
TO 65–67 HRC.
SHANK HARDNESS 40–45 HRC.
DIAMETER RUNOUT OF CUTTER : 0.02
SIDE FACE RUNOUT : 0.005
PROFILE TO BE CHECKED AGAINST 10:1 MAGNIFICATION
DRG. No. TRG: 1004
CUTTING PORTION TO BE ALTiN/TiAlN–COATED.
ALL UNDIMENSIONED RADIUS ARE 2.5±0.1mm.



		2-71-281-0115	00		ASP:60	5.1	5.6
						1	
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED...

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				10-31-11025			6/14	
 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD				NAME		SIGN.	DATE	NO.OF VAR. NA
				DRN.	AB		20.6.2014	
				CHD.	MRC		20.6.2014	
				APPD.	MRC		20.6.2014	
DEPT.	TRD		SCALE	WEIGHT(Kg)	REF. TO ASSY DRG. PROFILE DRG. NO. 2-TR-0575		ITEM NO.	NO.OF ITEMS
CODE	207D		NTS	NA			NA	NA
TITLE <u>FIR-TREE FORM CUTTER</u> FINISHER (FORM- 17 A) ROTOR					DRAWING NO. 2-71-281-0115			REV. 00
					SHEET NO. 01		NO OF SHEETS 02	

REV.	DATE	ALTERED	
		CHECKED	APPD.
ZONE			