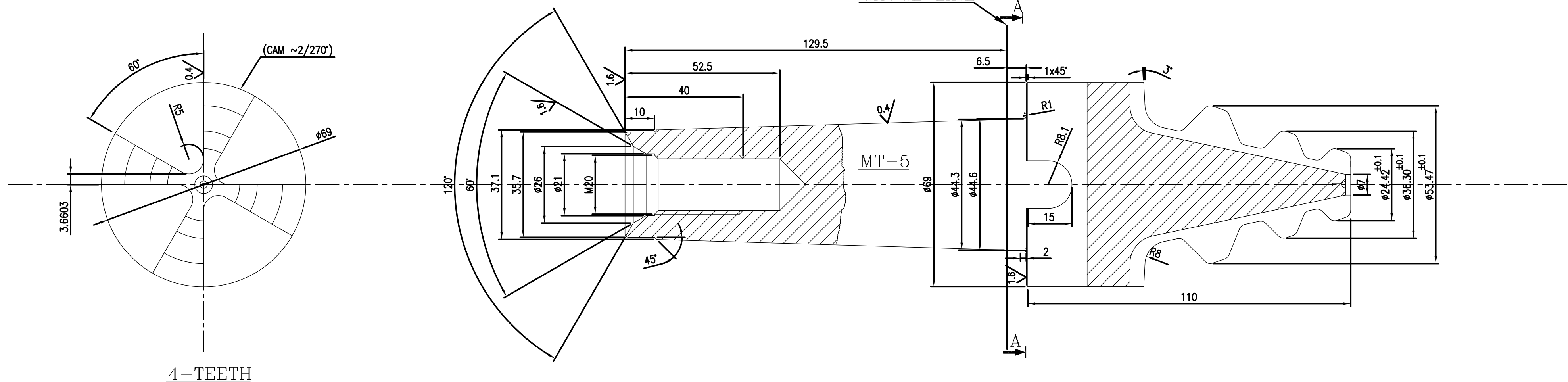
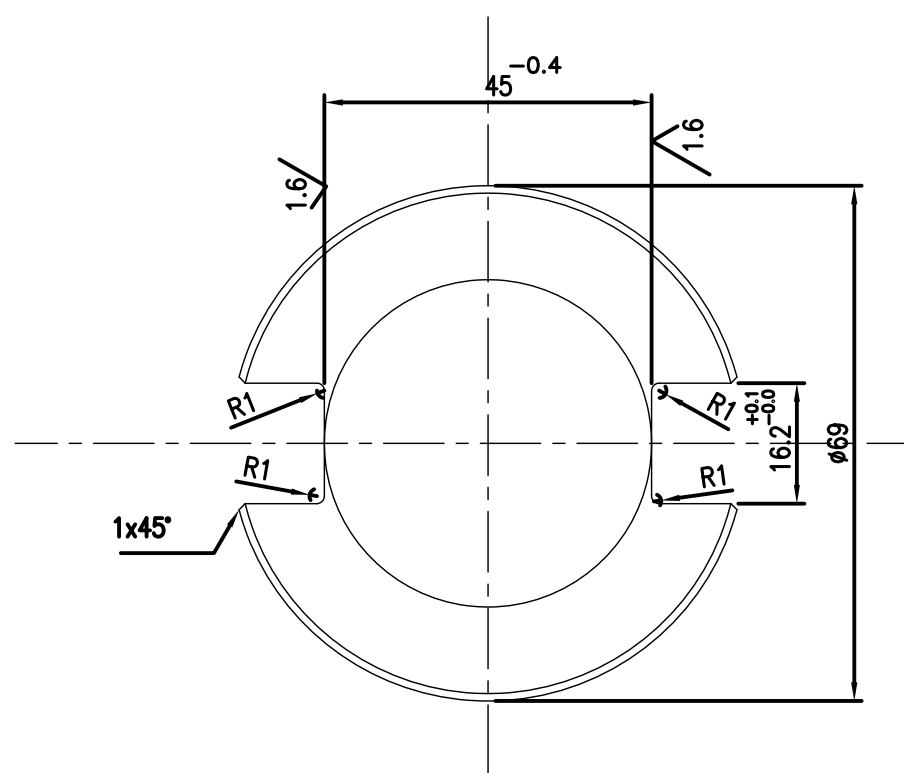


8

$$\sqrt[3]{3.2} \sqrt[3]{0.8} \sqrt[3]{0.4}$$


4-TEETH



SECTION A-A

MARK : 10-31-11021 (FORM- 11) ROUGHER.

NOTE:—

ALL UNDIMENSIONED RADII ARE 2.5 ± 0.1 mm.

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:1009

CUTTING PORTION TO BE ALTiN/TiAlN-COATED.

		2-71-281-0120	00	ø 70 X 250	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

10-31-11021

6/14

	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	NAME DRN. AB CHD. MRC APPD. MRC	SIGN. _____ _____ _____	DATE 20.6.14 20.6.14 20.6.14	NO.OF VAR. NA
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DEPT.	TRD		SCALE	WEIGHT(Kg)	REF. TO ASSY DRG. PROFILE DRG NO.	ITEM NO.	NO.OF ITEMS
CODE	207D		NTS	NA	2-TR-576	NA	NA

TITLE FIR-TREE FORM CUTTER
ROUGHER (FORM- 11) ROTOR

DRAWING NO.

2-71-281-0120

REV.
00

SHEET NO. 01

NO OF SHEETS 02

REV.	DATE	ALTERED	
		CHECKED	APPD.
ZONE			