

2

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A

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COMP. FILE NAME

REF.DRG.NO.

INVENTORY NO.

A

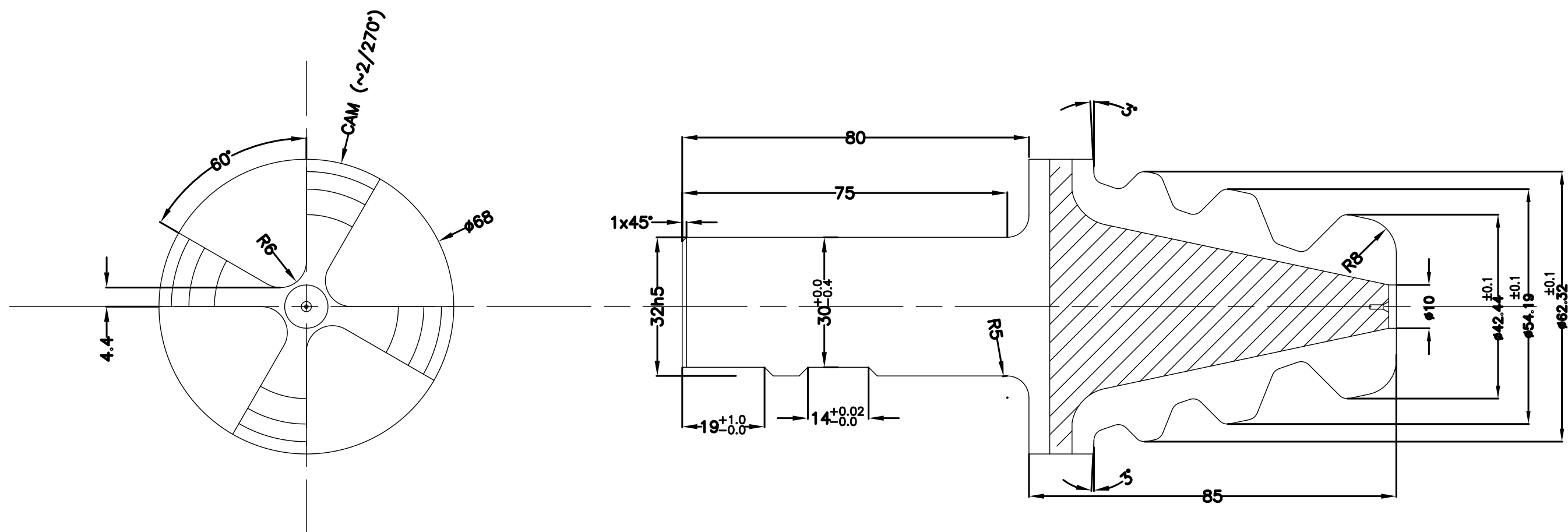
B

C

D

E

F



NOTE:-

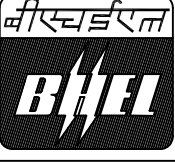
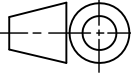
MATERIAL : ASP 60
CUTTING PORTION TO BE HARDENED & TEMPERED
TO 65-67 HRC.
SHANK HARDNESS 40-45 HRC.
DIAMETER RUNOUT OF CUTTER : 0.02
SIDE FACE RUNOUT : 0.005
PROFILE TO BE CHECKED AGAINST 10:1 MAGNIFICATION
DRG. No. TRG:1010
CUTTING PORTION TO BE ALTiN/TiAIN-COATED.
ALL UNDIMENSIONED RAIDUS ARE 2.5±0.1mm.

REV.	DATE	ALTERED	
		CHECKED	APPD.
ZONE			

		2-71-281-0121	00	ø 70 X 180	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				10-31-11007			6/14	
 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD					NAME	SIGN.	DATE	NO. OF VAR.
				DRN.	AB		20.6.14	
				CHD.	MRC		20.6.14	
				APPD.	MRC		20.6.14	
DEPT.	TRD		SCALE	WEIGHT(Kg)	REF. TO ASSY DRG. PROFILE DRG. NO. 2-TR-0576		ITEM NO.	NO. OF ITEMS
CODE	207D		NTS	NA	NA		NA	NA
TITLE <u>FIR-TREE FORM CUTTER</u> FINISHER (FORM- 11) BLADE					DRAWING NO. 2-71-281-0121			REV. 00
					SHEET NO. 01		NO OF SHEETS 02	