

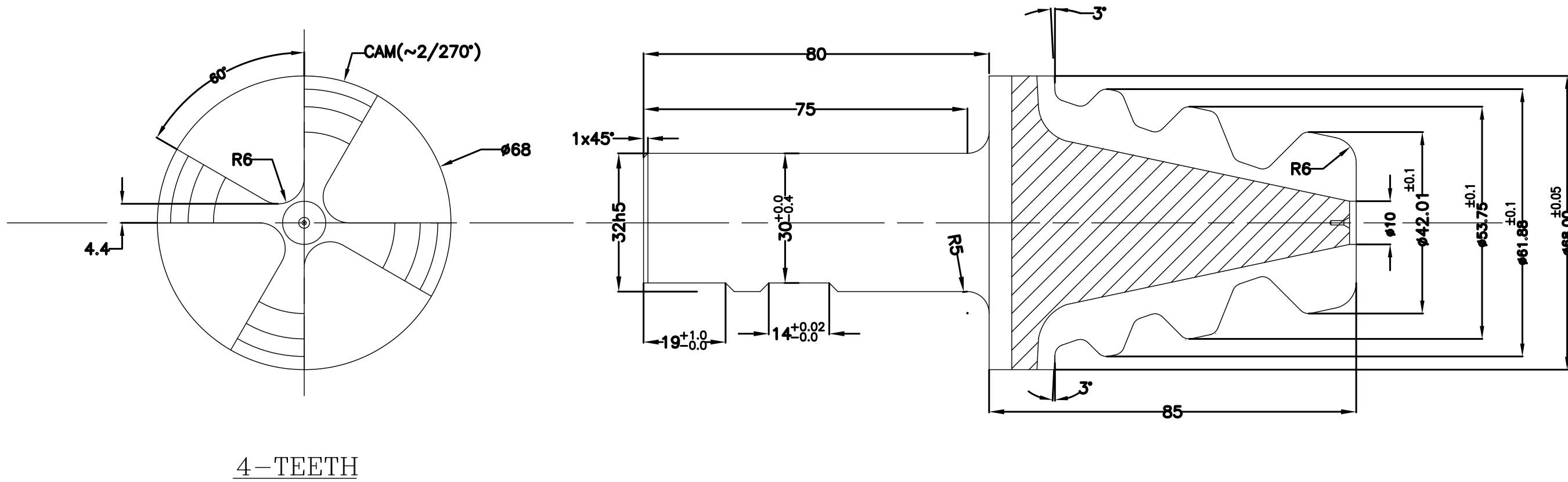
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INVENTORY NO. REF.DRG.NO. COMP. FILE NAME

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

2-71-281-0122 'ON'ORD



MARK : 10-31-11006 (FORM- 11) ROUGHER.

NOTE:-

ALL UNDIMENSIONED RADII ARE 2.5±0.1mm
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:1011
CUTTING PORTION TO BE ALTiN/TiAIN-COATED.
0.2mm UNDERSIDE WITH COMPARED TO FINISHER PROFILE.

REV.	DATE	ALTERED	
		CHECKED	APPD.
ZONE			

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	Ø 70 X 180 RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	ASP:60 MATERIAL CODE MATERIAL SPECN.	5.1 1 NET WT.	5.6 1 GROSS WT.
						QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				10-31-11006 6/14	
1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.				2. CHAMFER M/CD SHARP EDGE 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.				Bharat Heavy Electricals Ltd. Hyderabad				DEPT. TRD	
				CODE 207D				SCALE NTS	
				WEIGHT(Kg) NA				REF. TO ASSY DRG. PROFILE DRG NO. 2-TR-0576	
				DRAWING NO. 2-71-281-0122				REV. 00	
				TITLE FIR-TREE FORM CUTTER ROUGHER (FORM- 11) BLADE				SHEET NO. 01 NO OF SHEETS 02	