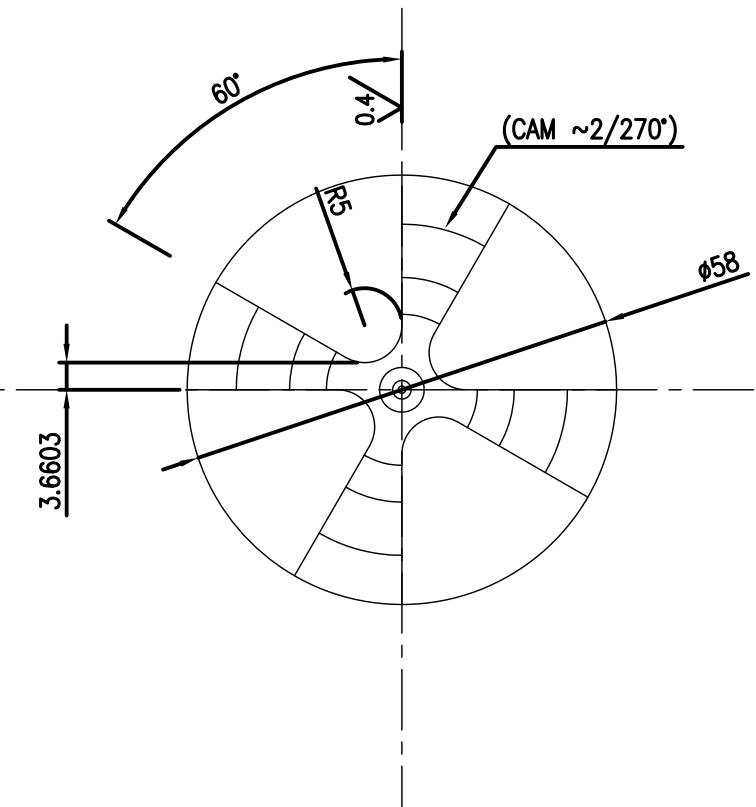
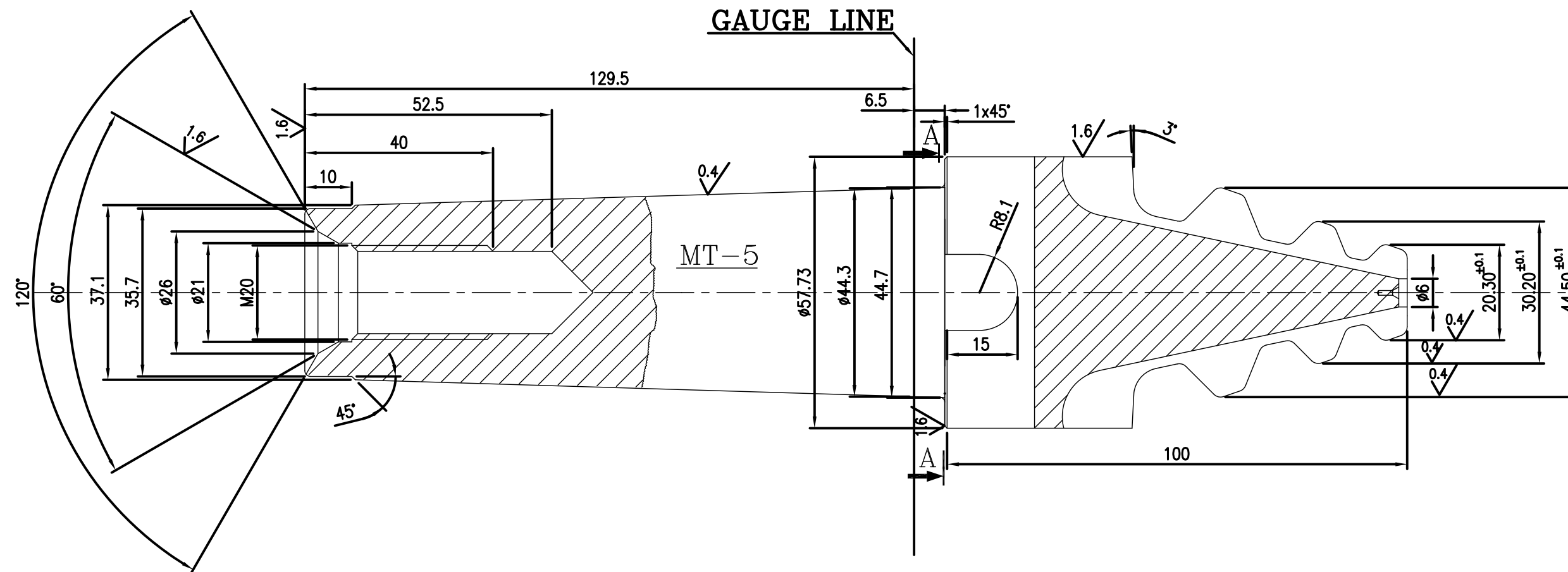


8

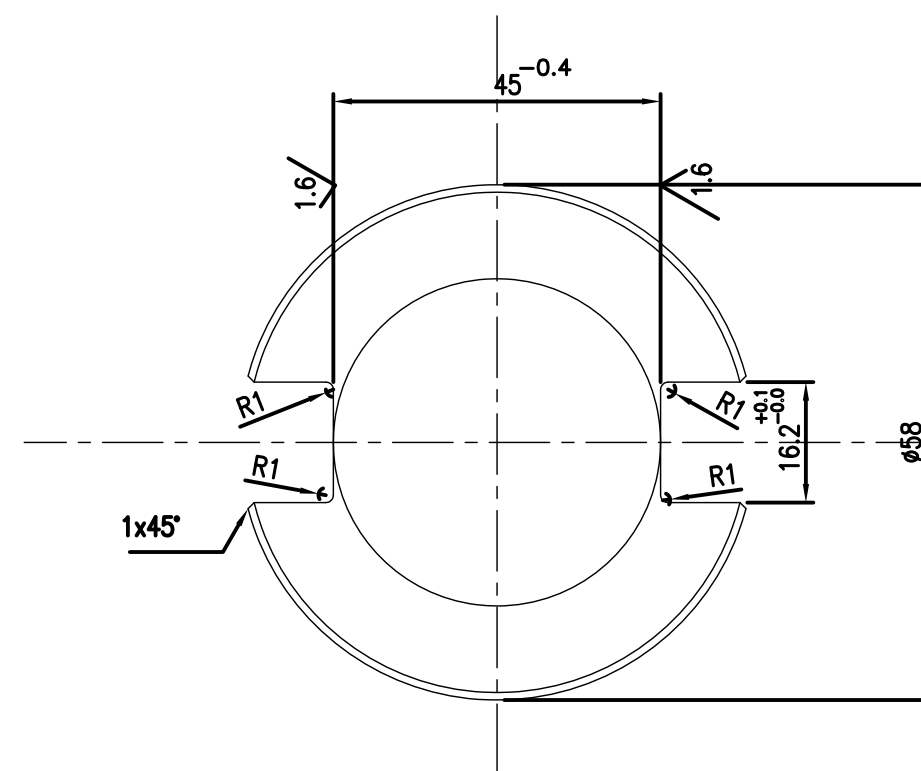
3.2//0.8//0.4



MARK : 10-31-11018 (FORM- 14) ROUGHER.

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:1013
CUTTING PORTION TO BE ALTiN/TiAIN-COATED.



SECTION A-A

		2-71-281-0124	00	Ø 60 X 250	ASP:60	5.1	5.56
						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 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.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	10-31-11018	6/14
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भारत भारती  BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			NAME		SIGN.	DATE	NO.OF VAR. NA	
			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-0577		ITEM NO.	NO.OF ITEMS
CODE	207D		NTS	NA	NA		NA	NA
TITLE					DRAWING NO.			REV.
FIR-TREE FORM CUTTER					2-71-281-0124			00
ROUGHER (FORM- 14) ROTOR					SHEET NO.		NO OF SHEETS	