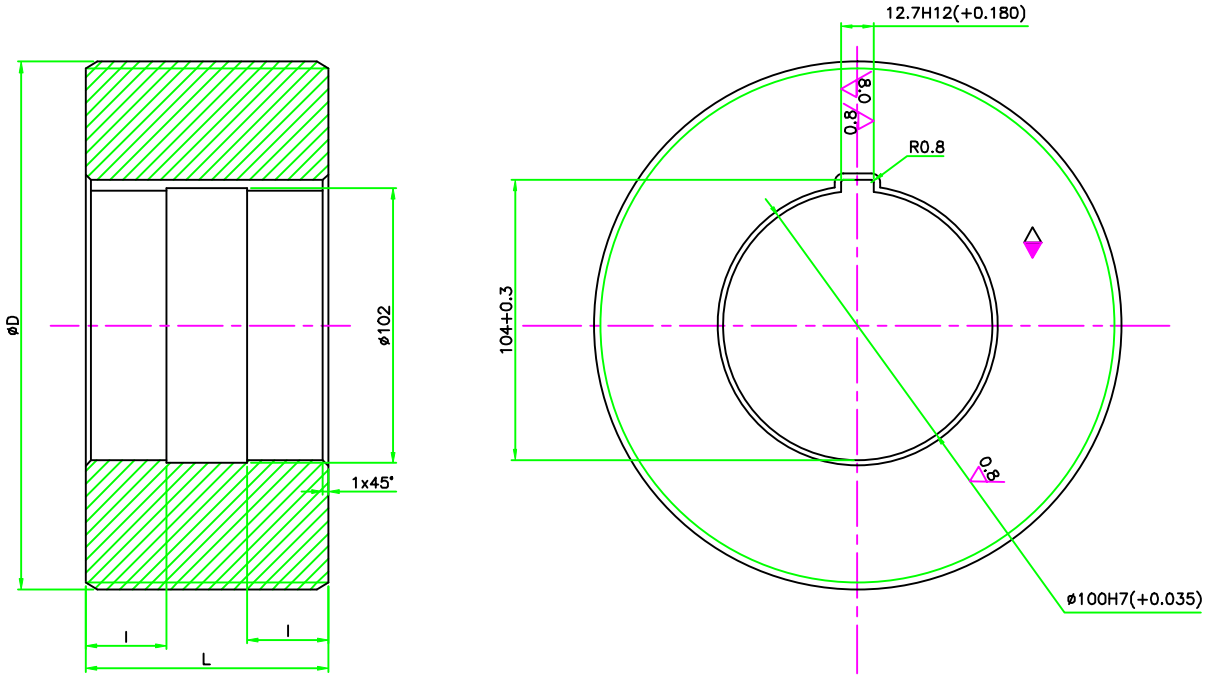
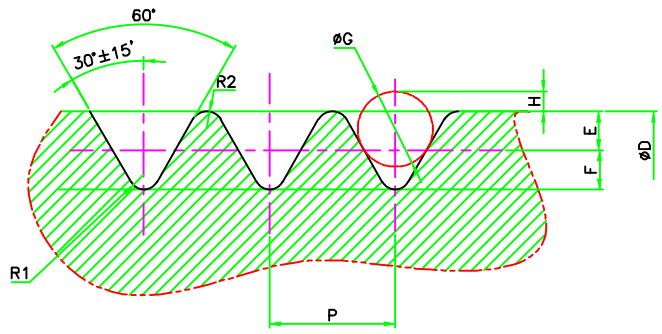
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R2684-0011

1.6 THE REST





MARK

DRAWING NUMBER
SIZE OF THREAD
MATERIAL OF DIE

S.NO.	SIZE	ØD±0.02	NO OF STARTS	HELIX ANGLE	HAND OF HELIX	l	L	E	F	ØG	H	R1±0.05	R2	VARIANT (01)	REMARKS (01)	QTY.	MATERIAL OF DIE ***
1.	M72X6P	208.2	3	1°37'	L.H.	50	150	$1.92^{+0.060}_{+0.030}$	$1.95^{\pm0.030}$	3.464	$0.658^{0.0}_{-0.020}$	0.7063	$0.668^{-0.040}_{-0.064}$	VAR–I	MATERIAL OF DIE SHOULD BE SUITABLE FOR COMPONENT MATERIAL – ALLOY 783	2 No (1 SET)	M2/HSS(6:5:2) OR BETTER
														VAR–II	MATERIAL OF DIE SHOULD BE SUITABLE FOR COMPONENT MATERIAL High Alloy Steel(X12CrMOWVNbN:10–1–1)	2 No (1 SET)	

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	VAR.	MATERIAL CODE *** / MATERIAL SPECN.	A C	UNIT	UNIT WEIGHT / QTY.	GS	ZONE

NOTES:–

1– ~~TWO NOS. OF ROLLERS (ONE SET) IS REQUIRED FOR EACH TYPES OF THREAD.~~
2– MATERIAL TEST CERTIFICATE TO BE PROVIDED BY NABL CERTIFIED LAB.
3– HARDENED TO HRc 60–65.
4–CONSERVATION TO BE DONE AS PER TL–30007.

GRADE OF UNTOL.DIM. :–
M/CG–E/M/F AA0230208
WELDING–A/B/C/D–AA0621104
GAS CUTTING–'T3'AA0621101

REV	DATE	ALTERED / CHECKED

REV	DATE	ALTERED / CHECKED
01	18.7.20	ALTERED SJTEGS, CHECKED SJTEVC — REMARKS & VAR ADDED AS PER W/O–TTX/––– AGAINST CAF–JTE–20–F...

GMS No./GR.SP.No.	STATUS OFDRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		800 MW	31132156042		HMT 0–4449/4492/4491
			DESIGN ORDER No. TTX/800/C/0078	MODEL No. ROLLING	

AGREED DEPT.	NAME	SIGN.	DATE
TTX	DILIP	Sd/–	28.11.19

BHARAT HEAVY ELECTRICALS LTD. HARDWAR

	NAME	SIGN.	DATE
DRN.	GHAN SHYAM	–Sd–	28.11.19
CHD	RAVI	–Sd–	28.11.19
APD	GAGAN	–Sd–	28.11.19

No. OF VAR.

DEPT. JTE | CODE 209 | SCALE NTS | WEIGHT(Kg.) | REF. TO ASSY. DRG. | ITEM No. | No. OF ITEM

TITLE THREAD ROLLING DIE (M72X6P)

DRAWING No. R2684–0011 | REV. 01

SHEET No. 01 | No. OF SHEET 01

SIZE A 2

REF. DRG. No. | SIGN. & DATE | INVENTORY No.

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