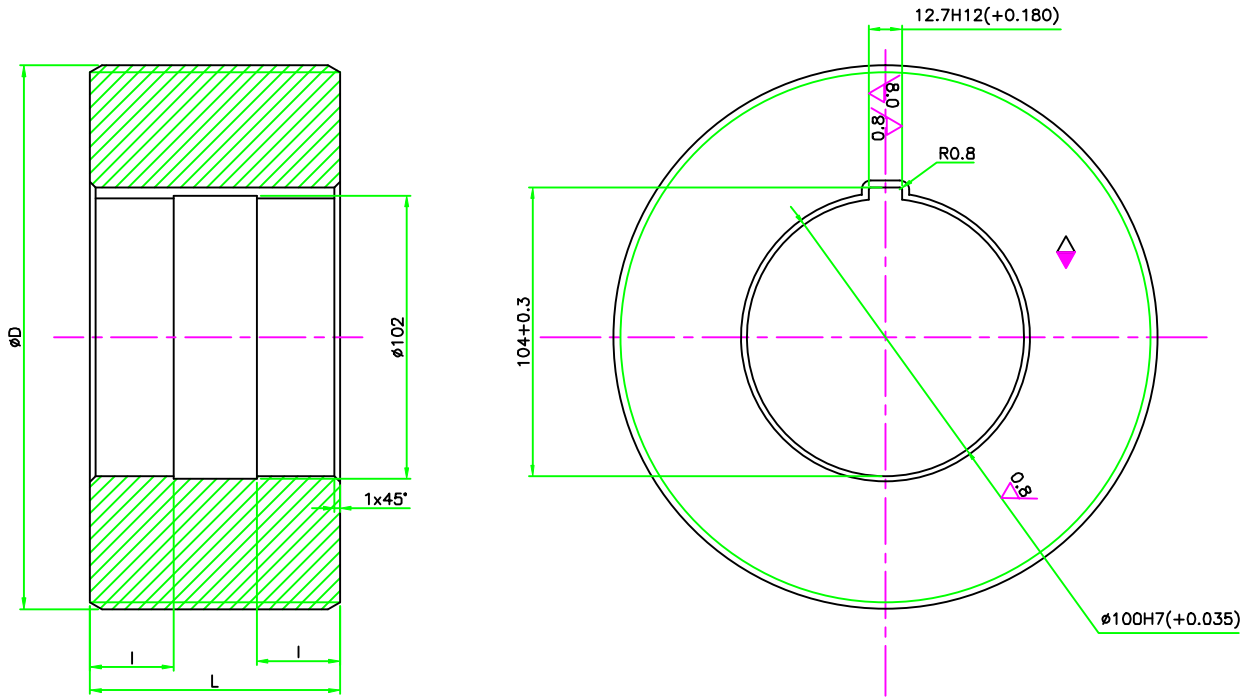
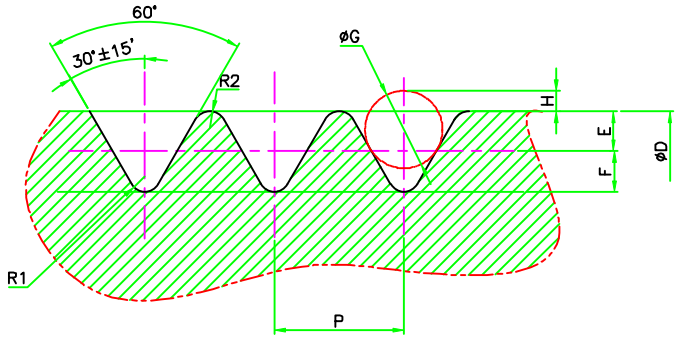
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R2684-0012

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.	M90X6P	176.1	2	1°16'	L.H.	30	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.
AGREED DEPT.	NAME	SIGN.	DATE
TTX	DILIP	Sd/–	28.11.19

TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
800 MW	31132131005		HMT
	DESIGN ORDER No. TTX/800/C/0077	MODEL No. ROLLING	0–4449/4492/4491

BHEL BHARAT HEAVY ELECTRICALS LTD. HARDWAR

	NAME	SIGN.	DATE	No. OF VAR.
DRN.	GHAN SHYAM	–Sd–	28.11.19	
CHD	RAVI	–Sd–	28.11.19	
APD	GAGAN	–Sd–	28.11.19	

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

TITLE THREAD ROLLING DIE (M90X6P)

DRAWING No. R2684–0012 REV. 01

SHEET No. 01 No. OF SHEET 01

SIZE A 2

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