

NOMENCLATURE

CAM SHAFT INLET (307.06.4A) & EXHAUST (307.21.1A)

DRAWING NO

307.06.4A

ISSUE

1

OPN. NO

050

OPERATION

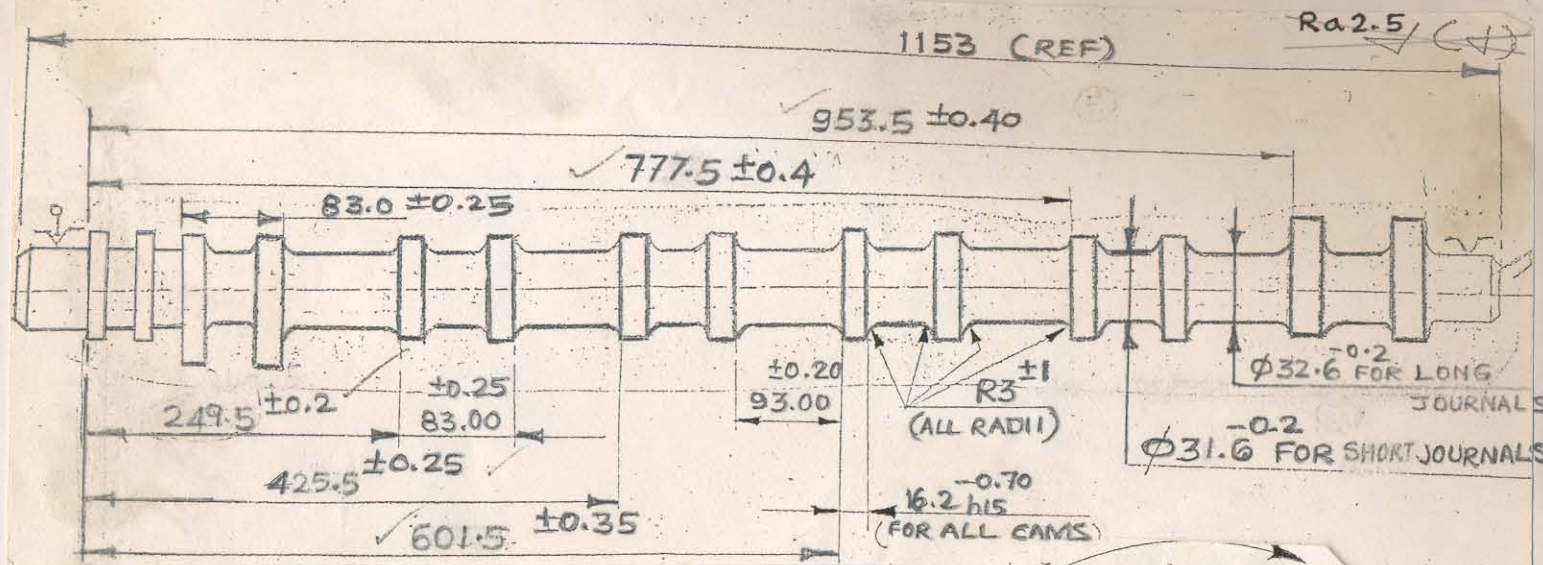
WHIRLING.

CAM SHAFT INLET

~~307.21.1A~~

Ratio ①

MACHINE: WHIRLING M/C GFM.

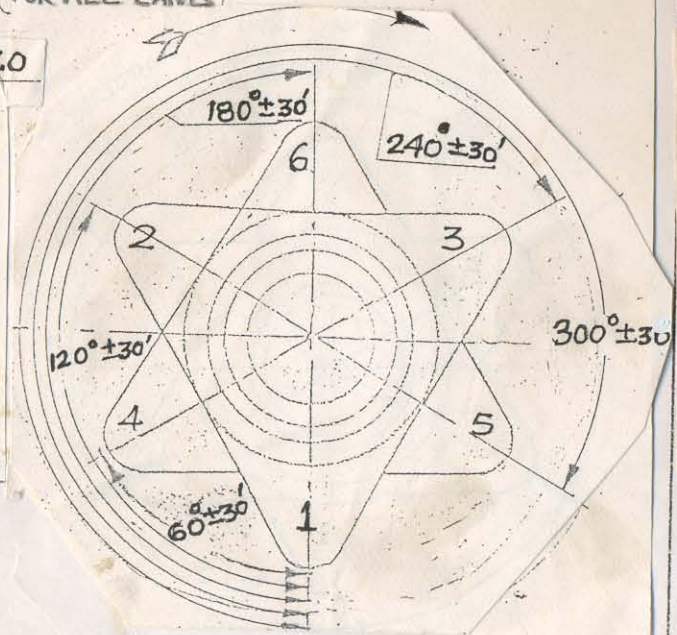
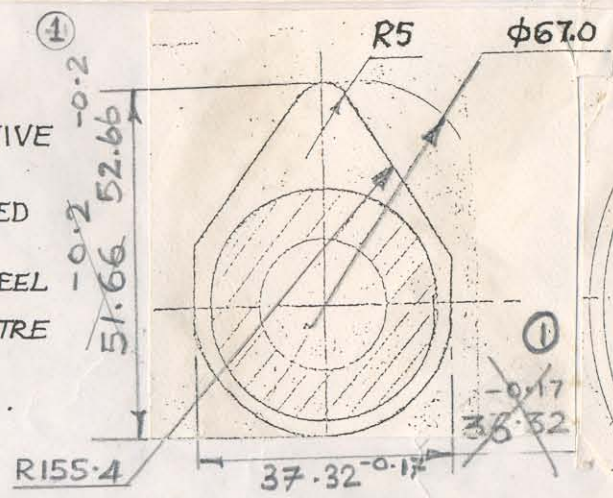


STD. TOOLS & GAUGES

1. CUTTER MK IV B
2. SEGMENT
 - 31.704 - 12 No's
 - 31.705 - 12 No's
3. INSERT (24 No's) 402150
4. - Do - (24 No's) 402156
5. CHUCK JAW
 - FKP-30-SI-G47 - 3 No's
6. SPACER
 - FKP-30-SI-D81 - 6 No's
7. PRECENTERING SAW
 - FKP-30-SI-G07 - 1 No.
8. PRECENTERING JAW
 - FKP-30-SI-G06 - 1 No.
9. CHUCK JAW
 - FKP-30-SI-G48 - 3 No's
10. ALIGNING FLANGE
 - FKP-30-SI-F97 - 1 No.
11. INSERT
 - FKP-30-SI-G03 - 2 No's
12. INSERT
 - FKP-30-SI-G04 - 2 No's
13. INSERT
 - FKP-30-SI-F93 - 2 No's
14. CENTRE
 - FKP-30-SI-C11 - 1 No.

TECH. REQTS:

1. RUN OUT OF LONG BEARINGS RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.15 mm.
2. RUN OUT OF CAMHEEL RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.1 mm.
3. ANGULAR DEVIATION BETWEEN AXES OF 2 CAMS AND ANY PAIR SHOULD NOT EXCEED $\pm 30'$.



4. RUNOUT OF CAMHEEL SHOULD NOT EXCEED 0.10 mm OVER ARC 150°.

QSV	AW	G	070	1	24.12.98
PRED.	CHD.	APPD.	PETE REF	ISSUE	DATE

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DRAWING. I

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ISSUE

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OPN. NO.

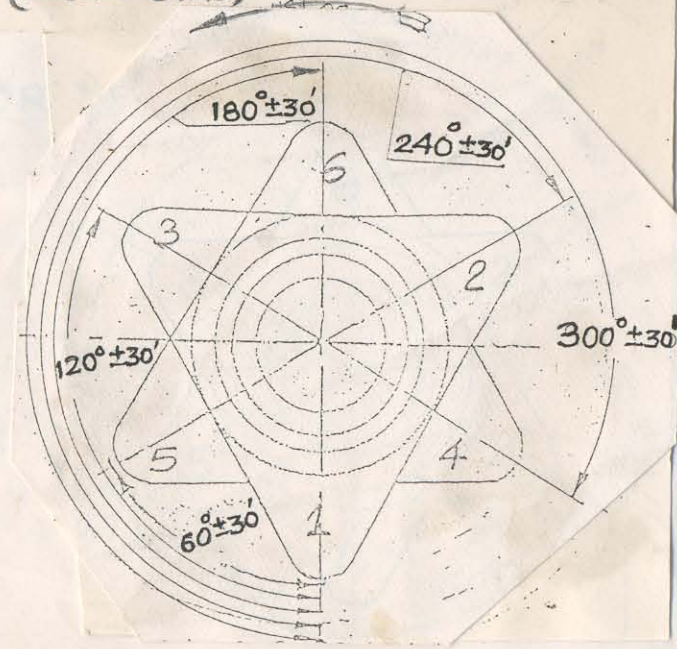
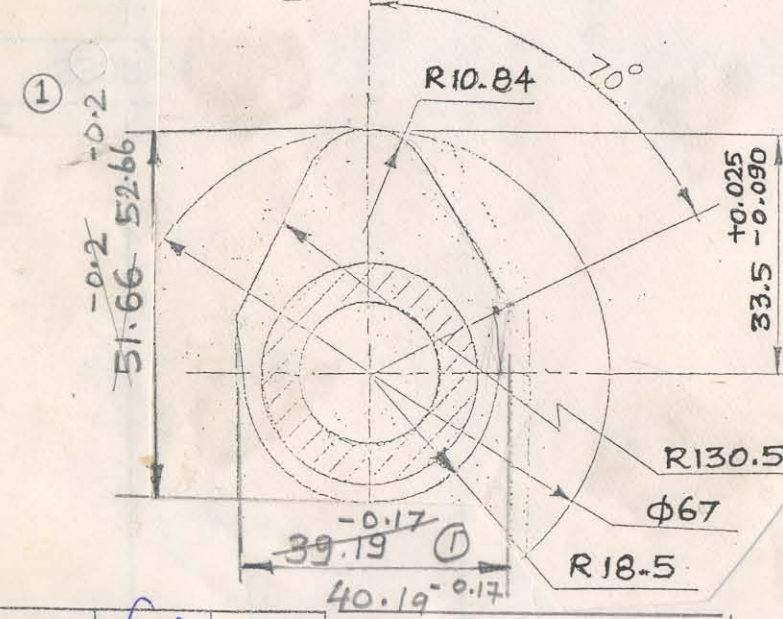
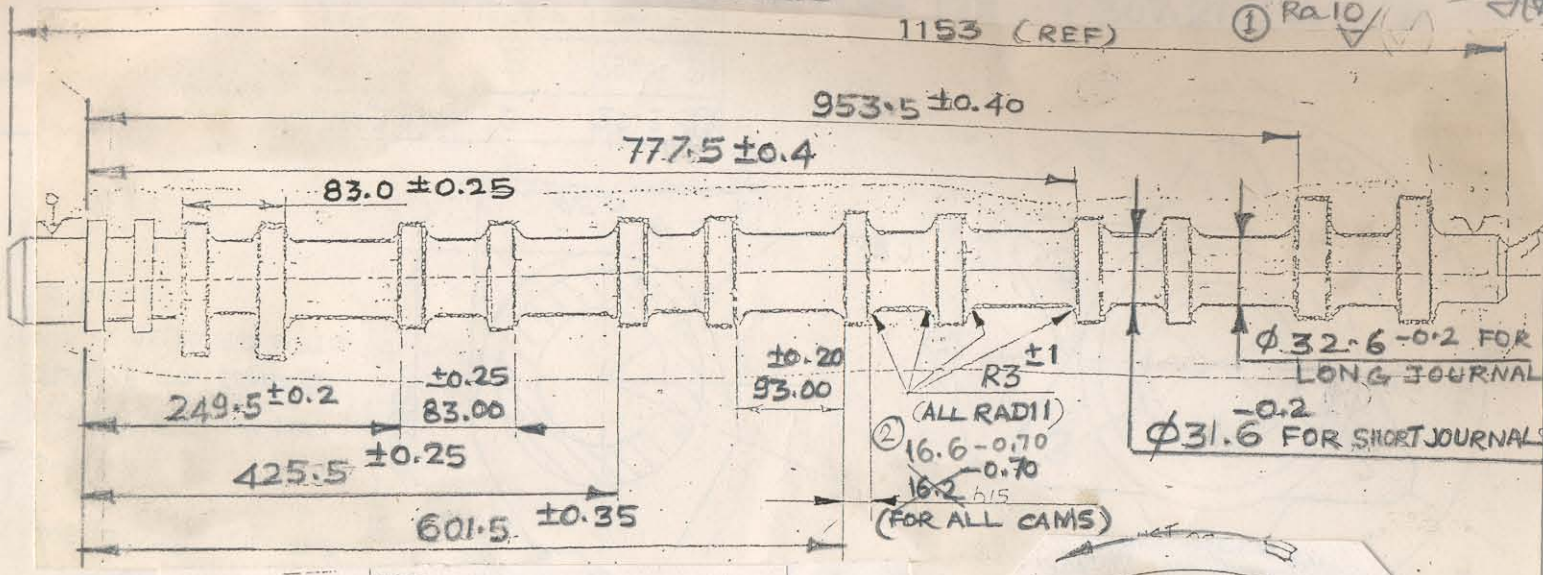
050

OPERATION

WHIRLING

CAM SHAFT EXHAUST

MACHINE: WHIRLING M/E
GFM.



STD. TOOLS & GAUGES

- 15. CENTER
FKP-30-51-D62 - 1 No.
- 16. STEADY JAW
FKP-30-51-F91 - 2 No's
- 17. SPACER
FKP-30-51-F92 - 4 No's
- 18. JAW INSERT (No 2 & 4)
FKP-30-51-F96 - 2 No's
- 19. JAW INSERT (No 1 & 3)
FKP-30-51-F95 - 2 No's

SPL. TOOLS & GAUGES

REFER SHT. NO. 014

TECH. REQTS: REFER SHT NO. 014

			173	2	4.3.05
			070	1	21.12.98
PRED.	CHD.	APPD.	PETE REF	ISSUE	DATE