

MACHINE:

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STD. TOOLS & GAUGES

SPECIAL TOOLS & GAUGES

NOTE :- & TECHNICAL REQUIREMENTS OF FORGINGS

- ①. NORMALIZE THE FORGING TO 170 & 255 BHN. ($d' = 4.6$ to 3.8)
- ②. UN SPECIFIED ROUNDING OFF RADII WILL BE R 2.5 MM.
UN SPECIFIED DRAFT WILL BE 5 TO 7°.
- ③. CAMBER SHOULD NOT EXCEED 0.6 MM.
- ④. BURR IS NOT ALLOWED ON THE SURFACE 'A' TO A LENGTH OF 17.5 MM.
- ⑤. BURR ALONG PERIMETERS OF CUT SHOULD NOT EXCEED 0.9 MM / SIDE,
STRETCH SHOULD NOT EXCEED 3 MM
- ⑥. MIS MATCH OF DIE SHOULD NOT EXCEED 0.9 MM.
- ⑦. MIS MATCH SHOULD NOT EXCEED 0.9 MM.
- ⑧. NOT FILLED CORNERS SHOULD BE WITHIN THE LIMIT
OF 0.5 MM OF ACTUAL ALLOWANCE.
- ⑨. CLEAN FROM SCALE.
- ⑩. DENTS FROM SCALE, NICKS AND THE SIMILAR SURFACE
DEFECTS TO A DEPTH NOT MORE THAN 0.5 MM OF
ACTUAL ALLOWANCE ARE ALLOWED.

SM		
PRED.	CHD.	APPD

⑪. PINCHES, HAIR CRACKS & SIMILAR DEFECTS EXCEPT CRACKS
TO A DEPTH NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE
BY DETERMINING THE DEPTH OF DEFECT BY ACROSS THE LOCAL
RECESS, SELECTIVELY BY 0.5% FROM A BATCH ARE ALLOWED.

NUMERICAL CONTROL

GEAR

DRAWING No.
20.12.26-1

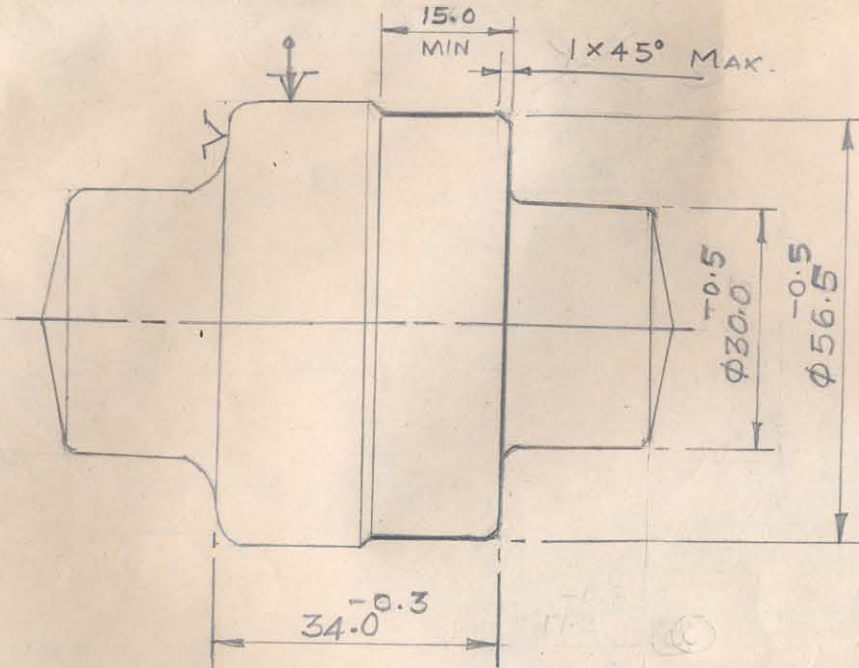
ISSUE

OPN. No.
005

OPERATION
TURNING

MACHINE: CNC - LATHE
HMT. GDM 65 2A

Ra 5



NOTE : REMOVE SHARP CORNERS

STD. TOOLS&GAUGES

TURNING & FACING TOOL.	PCLNR 2525-12
INSERT CNMG	120 408

SPECIAL TOOLS&GAUGES

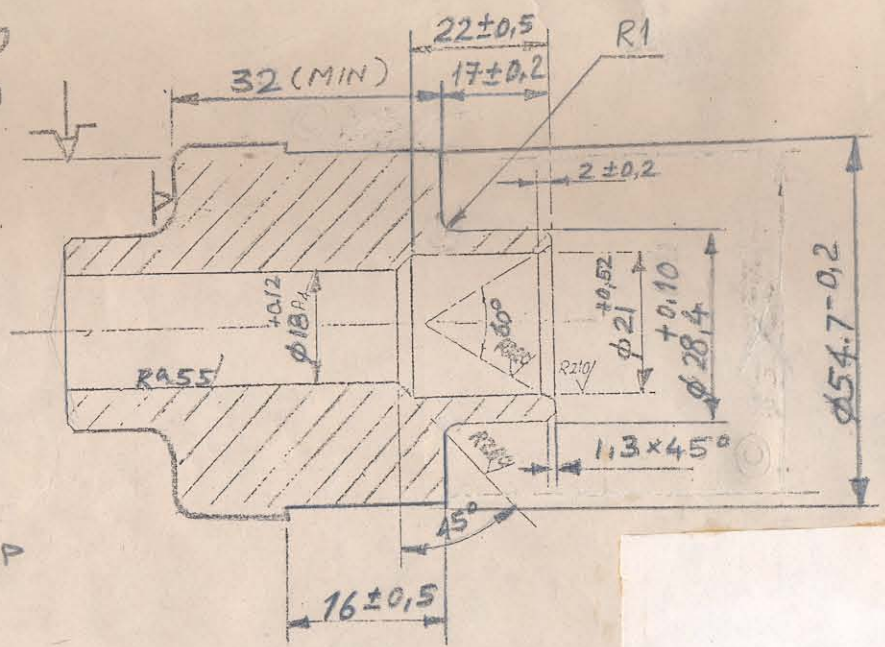
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PRED.	CHD.	APPD			

NOMENCLATURE GEAR	DRAWING No. 20-12-26-1	ISSUE -	OPN. No. 010	OPERATION TURNING
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$R_{z10} = Ra 2,5$
 $R_{z40} = Ra 10$
 $R_{z80} = Ra 20$

RA 5 / (✓)

MACHINE:
CNC LATHE
(GDM 65/2A)



NOTE: REMOVE SHARP CORNERS

STD. TOOLS & GAUGES	
DRILL $\phi 17,5$	
BORING TOOL	S12 K STFCR-11
INSERT	TCMM 110303
GRADE	7G
CENTRE DRILL	
REAMER $\phi 18,10$	
TURN & FACING TOOL	PC LNR 2525M12
INSERT	CNMG
GRADE	TK 35 120408
SPECIAL TOOLS & GAUGES	
PLUG GAUGE FOR $\phi 18,0 \pm 0,12$	020/06/28
CARBIDE CHUCKING REAMER $\phi 18,03 \pm 0,02$	202271
GAP GAUGE FOR $\phi 54,7 \pm 0,2$	025/04/125
V/CUT TOOL FOR C/LATHE	202049
SNAP GAUGE FOR $\phi 28,4 \pm 0,1$	025/03/110

SM		
PRED.	CHD.	APPD

NUMERATURE

GEAR

DRAWING No.

20-12-26-1

ISSUE

OPN. No.

020

OPERATION

TURNING

R_Z40 = R_A10. NOTE: REMOVE SHARP CORNERS.
 R_Z80 = R_A20.

RA 5

MACHINE:

CNC LATHE
(GDM 65/2A)

STD. TOOLS & GAUGES

BORING TOOL S12 K
STFCR11
INSERT TCMM
110308
GRADE - TG.

SPL. TOOLS & GAUGES
GROOVING TOOL 202051
FOR 1.7 ±0.2 OR 402196
OR 402196

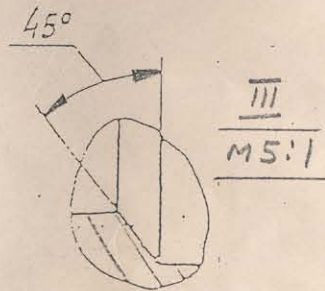
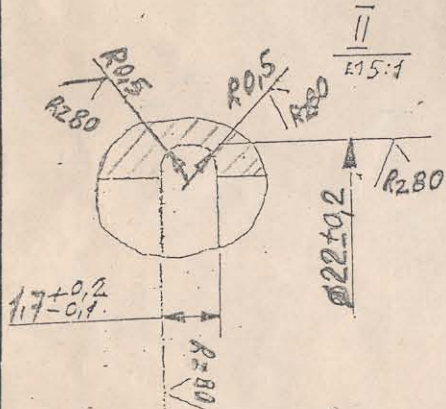
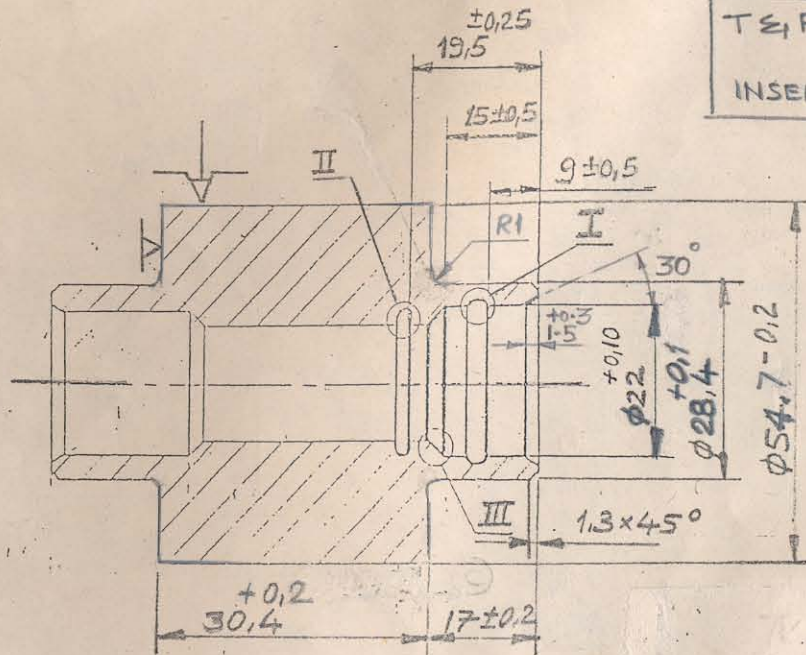
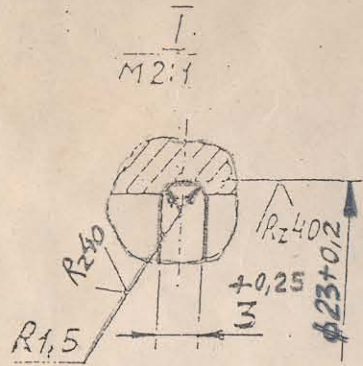
DIAL CALIPER
GAUGE φ22 ±0.2
φ23 ±0.2

SPECIAL TOOLS & GAUGES

PLUG GAUGE 020/07/23
FOR φ22 ±0.10
GAUGE FOR 19.5 ±0.25 203050

GROOVE WIDTH GAUGE 202047
3 ±0.25
SNAP GAUGE φ28.4 ±0.1 025/03/110
GAUGE FOR 30.4 ±0.17 025/03/36
φ54.7 ±0.2 025/04/125
GAUGE 9.0 ±0.5 203049

T&F TOOL PCLNR
252512
INSERT CNMG 120408



(GROOVE DIMNS) TO BE MAINTAINED BY TOOL

SM	<i>ABY</i>	<i>KR</i>	503	3-13
PRED.	CHD.	APPD	REL	ISSUE DA