



DETAIL OF ANNULAR THREAD

(SCALE 50:1)

THIS DRG. SUPERCEDED TO MCC 444C.

JMN / MCC

*[Signature]*

BASED ON DRG. NO - CCT-007/216 B: ORDNANCE FACTORY, AMBAJHARI.

NOTE :- 1) EACH ANNULAR THREAD OF CUTTER MUST BE COMPLETE PROFILE.

2) PITCH DEVIATIONS ± 0.010 mm AT 16 mm LENGTH.

3) PROTECTIVE TYPE CENTRE HOLE Bxφ/6 TO IS:2473. AT BOTH THE ENDS.

4) TO BE SUB-ZERO TREATED.

5) GRADUAL HARDNESS VARIATION FROM 65 HRC TO 40 HRC. FROM FACE TO TAPER END OF HOB.

MATL: - XT90 W6 Co No 5 Cr 4 V2. IS:7291-81.



ITEM NO	DESCRIPTION AND FINAL DIMENSION	NO. OF	MATERIAL	HARDNESS	REMARKS
	DESCRIPTION OF AMENDMENTS				
	DESCRIPTION: -				
	THREAD MILLING HOB.				
	13.33 X 18 TPI, CLASS 2.				
	COMP: - CART CASE - 30 mm BMP II AMMN.				
	FOR: - METAL & STEEL FACTORY, BHARUPE.				
	SCALE				
	2:1				
	DRAWN				
	CHECKED				
	APPROVED				
	DATE				
	NAMES				
	DRG NO. NCC/1444-D				
	SHEET 1/1				