

PLANNING SHEET - PDO / EFA FORM No: EFA/P-0

NOMENCLATURE
CAMSHAFT INLET (20.07.06A) & EXHAUST (20.07.15A)

DRAWING NO
20.07.06A
~~20.07.15A~~

ISSUE

OPN. NO
050

OPERATION
WHIRLING

MACHINE: WHIRLING M/C
GFM.

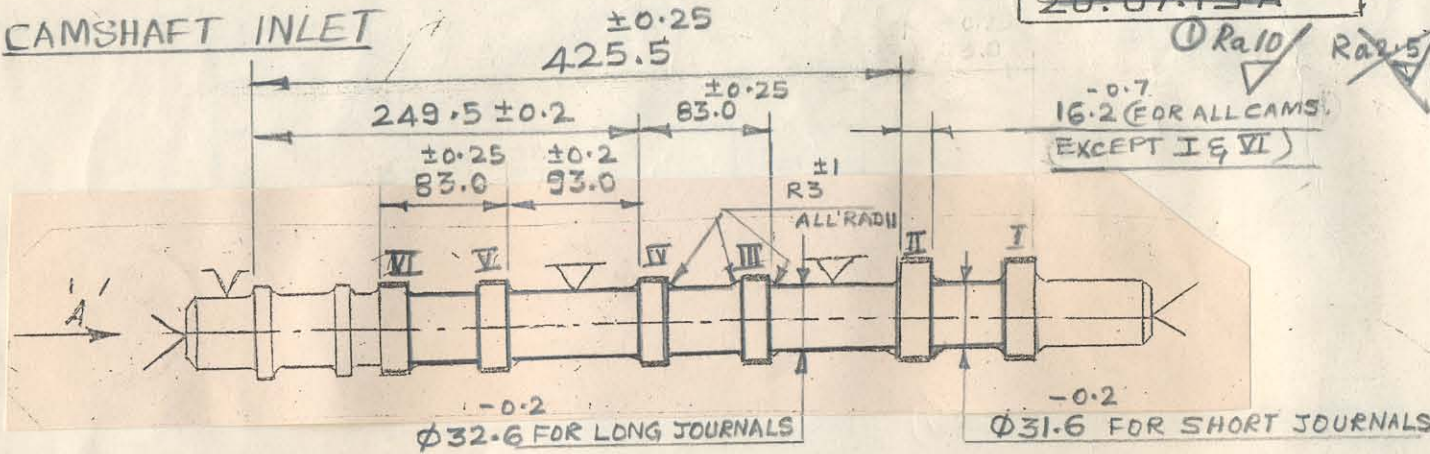
STD. TOOLS & GAUGES

- | | |
|---------------------|---------|
| 1. CUTTER - | MK ▽ 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-30-51-G47 - | 3 NO'S |
| 6. SPACER | |
| FKP-30-51-D81 - | 6 NO'S |

SPL. TOOLS & GAUGES

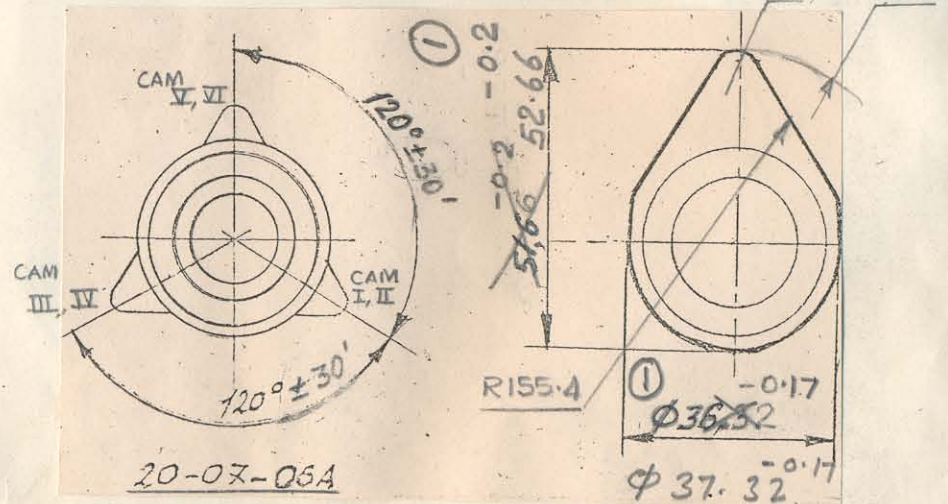
- | | |
|---------------------|--------|
| 7. PRECENTERING JAW | |
| FKP-30-51-G07 - | 1 NO |
| 8. PRECENTERING JAW | |
| FKP-30-51-G06 - | 1 NO |
| 9. CHUCK JAW | |
| FKP-30-51-G48 | 3 NO'S |
| 10. ALIGNING FLANGE | |
| FKP-30-51-F97 - | 1 NO |
| 11. INSERT | |
| FKP-30-51-G03 - | 2 NO'S |
| 12. INSERT | |
| FKP-30-51-G04 - | 2 NO'S |
| 13. INSERT | |
| FKP-30-51-F93 - | 2 NO'S |

CAMSHAFT INLET



TECH. REQTS:

1. RUN OUT OF LONG BEARINGS RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.15mm.
2. RUN OUT OF CAMHEEL RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.1mm.



3. ANGULAR DEVIATION BETWEEN AXES OF 2 CAMS AND ANY PAIR SHOULD NOT EXCEED ± 30'.
4. RUNOUT OF CAM HEEL SHOULD NOT EXCEED 0.10mm OVER ARC 150°.

QSV	ASV	Q	71	1	25/12/98
PRED.	CHD.	APPD.	PETE REF	ISSUE	DATE

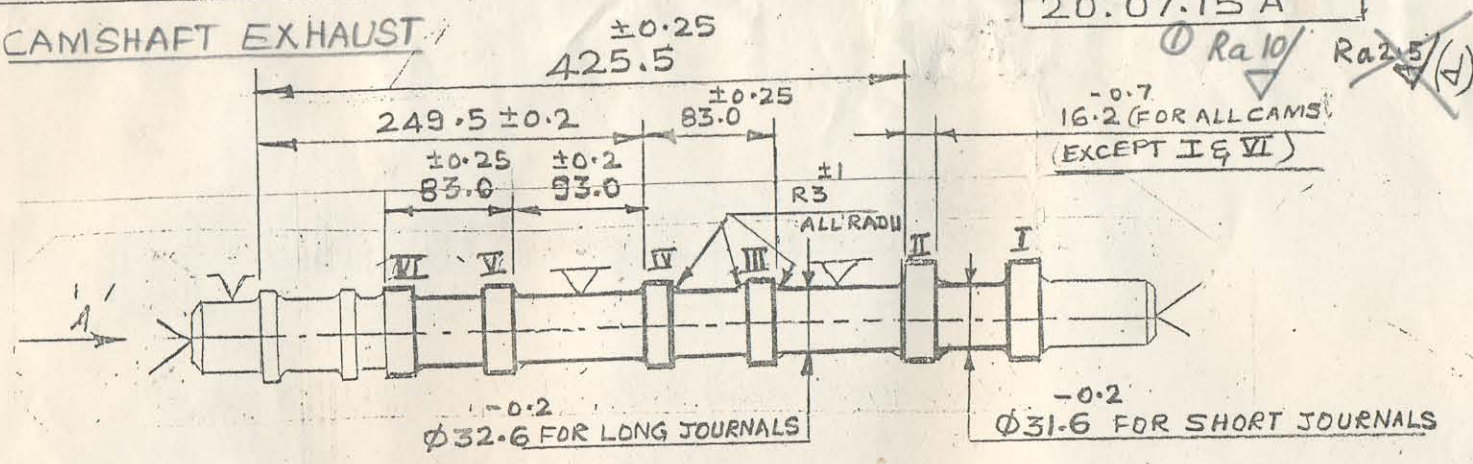
PLANNING SHEET - P/DO/EFA FORM No: EFA/P-0

NOMENCLATURE
CAMSHAFT INLET (20.07.06A) & EXHAUST (20.07.15A)

DRAWING NO
~~20.07.06A~~
20.07.15A

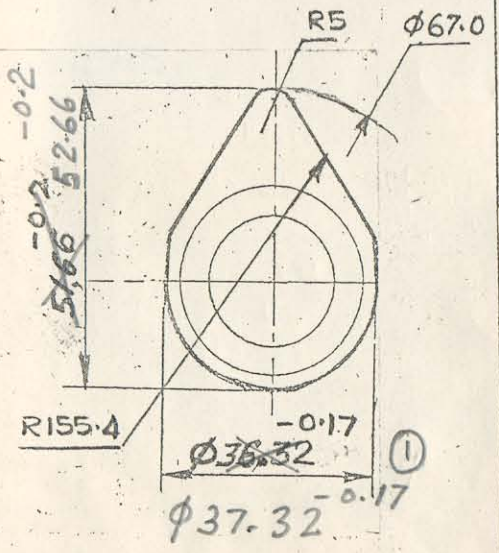
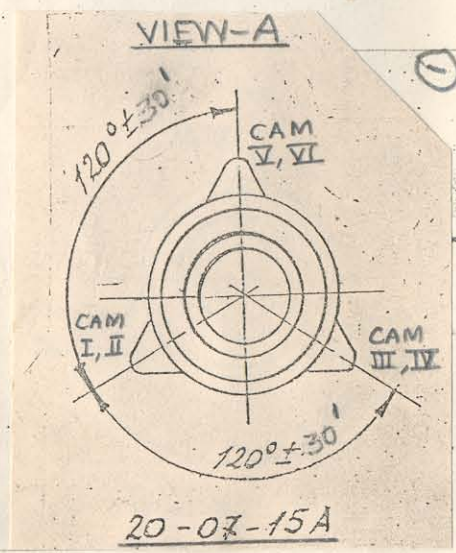
ISSUE
OPN. NO
050
OPERATION
WHIRLING
MACHINE: WHIRLING M/C
GFM.

CAMSHAFT EXHAUST



TECH. REQTS:

1. RUN OUT OF LONG BEARINGS RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.15mm.
2. RUN OUT OF CAM HEEL RELATIVE TO CENTRE AXIS SHOULD NOT EXCEED 0.1 mm.



3. ANGULAR DEVIATION BETWEEN AXES OF 2 CAMS AND ANY PAIR SHOULD NOT EXCEED ± 30'.
4. RUNOUT OF CAM HEEL SHOULD NOT EXCEED 0.10 mm OVER ARC 150°.

STD. TOOLS & GAUGES

14. CENTRE
FKP-30-51-C11 - 1 NO
15. CENTRE
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

SPL. TOOLS & GAUGES

19. JAW INSERT (NO: 1 & 3)
FKP-30-51-F95 - 2 NO'S

DESIGNED	APPROVED	DATE	7/	1	25/2/95
PRED.	CHD.	APPD.	PETE REF	ISSUE	DATE