

INVENTORY NO. SIGN & DATE REF. DRG. NO. COMPUTER NO. 4TR0532 THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

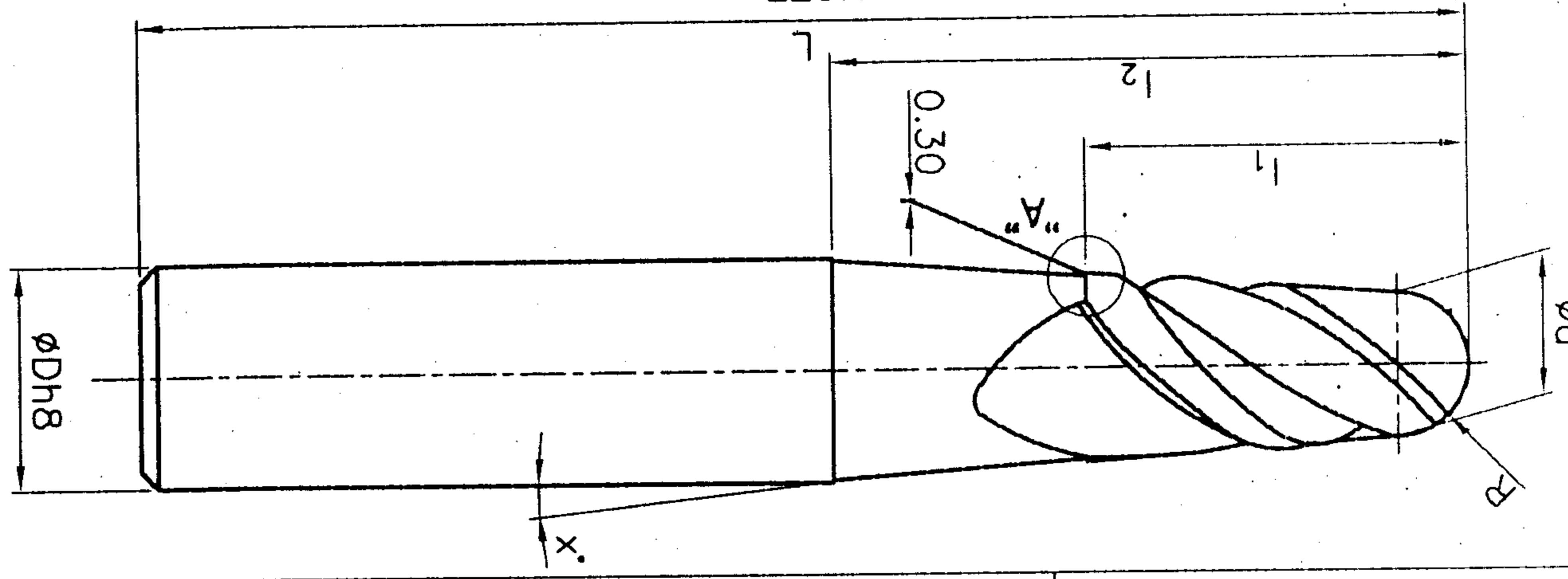
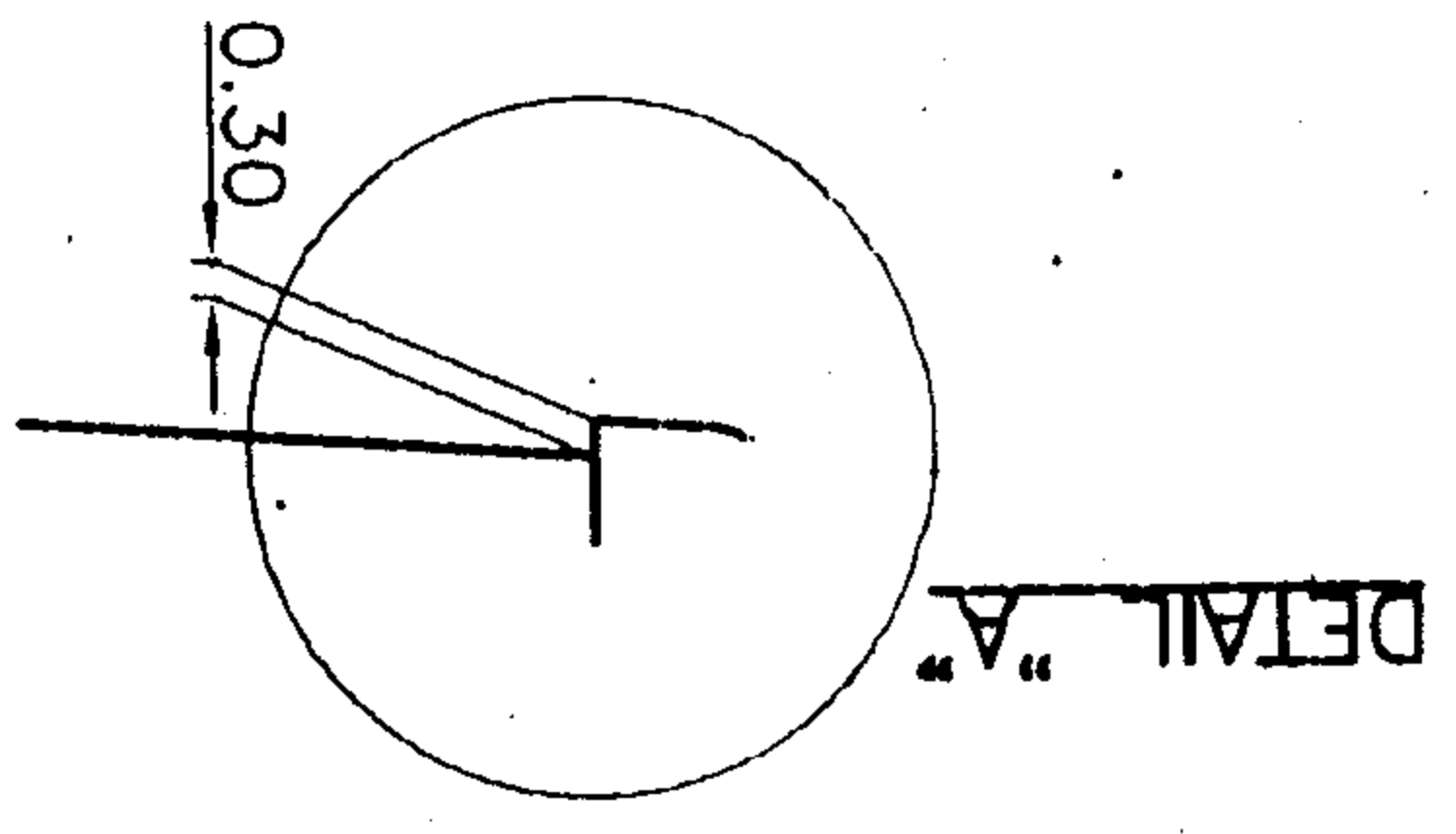
REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.

TITLE SOLID CARBIDE TAPER BALL NOSE END MILL		SHT. NO. 01		NO. OF SHT. 01	
DRAWING NO. 4-TR-0532		REV. 00			
DEPT. TRD		CODE 207/D		NTS	
SCALE		WEIGHT(K.G.)		REF. TO ASSY. DRG.	
NO. OF VAR.		DRN. ABR		CKD.	
DATE		SIGN		SNT	
NO. OF VAR. 270298		ITEM NO. 01		NO. OF ITEM 01	

NAME OF PRODUCT OR TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		DESCRIPTION & DRG. NO.		VAR. NO.	
MATERIAL CODE		RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.		MATERIAL SPECN.	
NET WT.		GROSS WT.		QTY.	
CARBIDE K20 GRADE		MICROFINE GRANED			

SL NO	∅ _d	R	L	∅Dh8	CODE
01	16.039	08	4	25	HY6288510017
02	16.039	08	4	25	HY6288510025
03	20.012	10	2	25	HY6288510084
04	20.012	10	2	25	HY6288510092
05	20.012	10	2	25	HY6288510106

NOTE :-
 - NO OF TEETH = 3
 - ANGLE OF RH HELIX = 35.
 - ALL OTHER DETAILS ARE AS PER MANUFACTURERS STD PRACTICE.
 - CUTTING PORTION TO BE AITN COATED.
 - MD. NO. TRG:0899 / 1,2

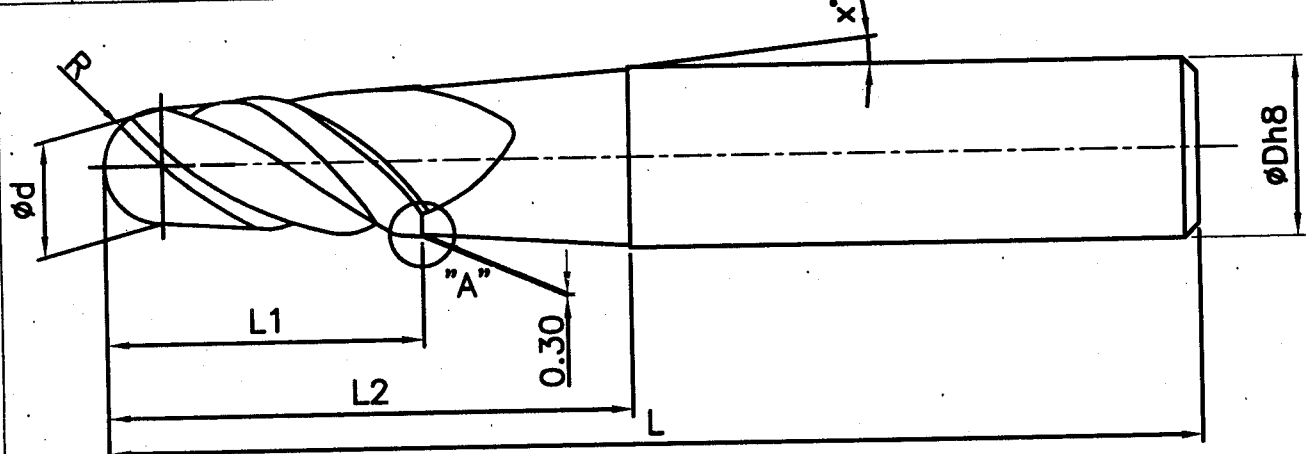


REV. DATE		ALTERED KTP		REV. DATE		ALTERED ABR	
01 040998		CHECKED SNT		02 090500		CHECKED SNT	
APPROVED KBK		APPROVED SNT		03 011005		APPROVED SNT	
CODE NO'S ADDED				AITN COATING ADDED.			
AS PER IOM DTD. 280905: SDCM TCGT-ST				1/ F.L. CHANGED FOR SLO3, 04 & 05 60 TO 40; 82 TO 40; 82 TO 40			

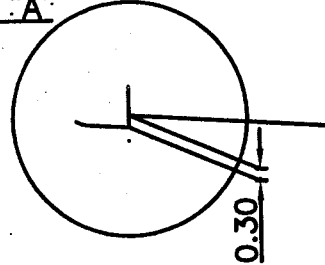
ALL DIMENSIONS ARE IN MM. FIRST ANGLE PROJECTION

REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED
01	250406				
	CHECKED		CHECKED		CHECKED
	APPROVED		APPROVED		APPROVED

For slno 01 & 02, L2 taper length 55 added as per req from Mr.Ajwani



DETAIL "A"



- NOTE :- SPECIFY IN QUOTATION
- NO OF TEETH = 3 (OR AS PER MANU. STD PRACTICE)
 - ANGLE OF RH HELIX = 35°
 - ALL OTHER DETAILS ARE AS PER MANUFACTURERS STD PRACTICE.
 - CUTTING PORTION TO BE AITIN COATED.
 - MD. NO. TRG:0946

SL NO	ϕd mm	R mm	α °	L mm	$\phi Dh8$ mm	L1 mm	L2 mm	CODE
01	4.0098	2.0	4	150	16	35	55	45-31-10001
02	5.0122	2.5	4	150	16	35	55	45-31-10002
03	10.0244	5.0	4	165	20	35	-	45-31-10003

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COMPUTER NO. 4TR0547
 REF. DRG. NO.
 SIGN. & DATE
 INVENTORY NO. 45-10011, 10012, 10013

		MICROFINE GRANED CARBIDE K20 GRADE		
DESCRIPTION & DRG.NO.	VAR NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATL. CODE	NET.WT. GROSS WT
			MATL. SPECN.	QTY.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT 02/06

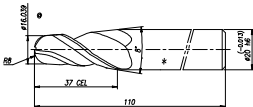
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	NAME	SIGN	DATE	NO.OF VAR.	
	DRN. ABR	<i>ABL</i>	170106		
	CKD.				
	APPD. SNT	<i>ALB</i>	250406		
DEPT. TRD	SCALE	WEIGHT(K.G.)	REF.TO ASSY.DRG.	ITEM NO.	NO.OF ITEM
CODE 207/D	NTS			01	01
TITLE SOLID CARBIDE TAPER BALL NOSE END MILL			DRAWING NO. 4-TR-0547	REV. 00	
			SHT.NO. 01	NO.OF SHT. 01	

DIMENSIONS IN MM UNLESS OTHERWISE SPECIFIED

REF.:

UNSPECIFIED TOLERANCES AS PER IS 2192 (MFD)

DESIGN VERIFICATION:

CUSTOMER REF.:
CUST. REF.: BLD00596
CUST: BMEL/HARDWAR

4 FLUTES EQUISPACED



NOTES:

R.H. CUTTING

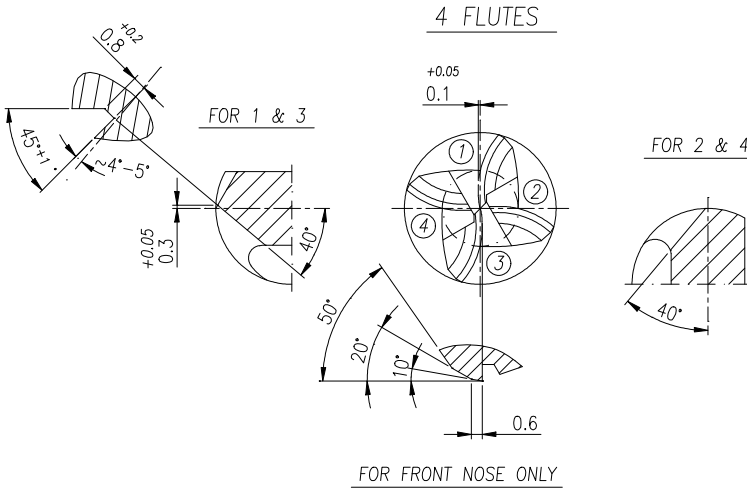
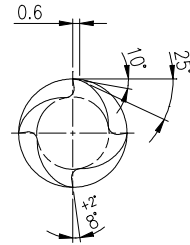
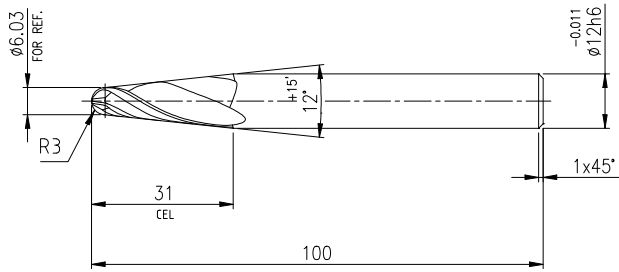
R.H. HELIX = $33^{\circ}49'$

TAIN COATED

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BANGALORE-73

PART NO.	DESCRIPTION	QUANTITY	STANDARD	CARBIDE	MATERIAL	HARDNESS	REMARKS
OLD SPEC. NO.			2003	DATE	NAME	MARK THIS	
DR	#16.039/110	02.04.03	DRN	28/74	HCS	T.M.W 62738054	
DR	CONCORD TO MANUFACTURE	17/7/04	DRN			#16.03 4' GRADE	
			STD. CHD	DATE	SCALE	NTS	REV. NO. 7/1
				TITLE			
				SC TAPER BALL NOSE END MILL			
ALPHABET				ALTERATION	DATE	NAME	
						DRAWING NO. W3 80 905	
						ALT. 01	

ONLY FOR QUOTATION



UNSPECIFIED TOLERANCE AS PER IS 2102-MED

R.H.CUTTING
R.H. HELIX = 30° 33'

MARK THUS: $\emptyset 6 \times R3 \times 6^\circ$
TLMW 62738003



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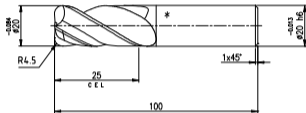
KENAMETAL INDIA LTD.
BANGALORE

SC TAPER BALLNOSE ENDMILL

Drawn	BSN	15/7/06	Scale N T S
Checked	BSN	15/7/06	
Approved			
Cust. Name#	B H E L (HEEP), HARDWAR		
Cust. Part#			
Cust. Dwg.#	BJ00601		
Cust. Tool#			
Subst. for			
Ref	W380906		
Type	REGRINDING		Sheet 1 of 1

PART NO.	CARBIDE BLANK	QTY.	STANDARD	9156	MATERIAL	HARDNESS	REMARKS
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DRAWING NUMBER	REV.	DWG SIZE
W580841	00	A3



4 FLUTES

UNSPECIFIED TOLERANCE AS PER IS 2103-MED

R.H.CUTTING

R.H. HELIX

Z = 4

TAIN COATED.

MARK THIS: $\phi 20 \times R4.5$
TLMW 62738100



MILLIMETERS

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BANGALORE



SC END MILL

Drawn	BSN	15/7/06	Scale
Checked	BSN	15/7/06	N T S
Approved			

Cont. Name# B H E L (HEEP), HARDWAR

Cont. Part#

Cont. Des.# BU00731

Cont. Tool#

Subst. for

Ref W380849

Type ASSEMBLY

DRAWING NUMBER

W580846

Sheet 1 of 1

REV.

00

REV. NO.

A3

PART NO.	DESCRIPTION	QTY.	STANDARD	CARBIDE MATERIAL	HARDNESS	REMARKS

