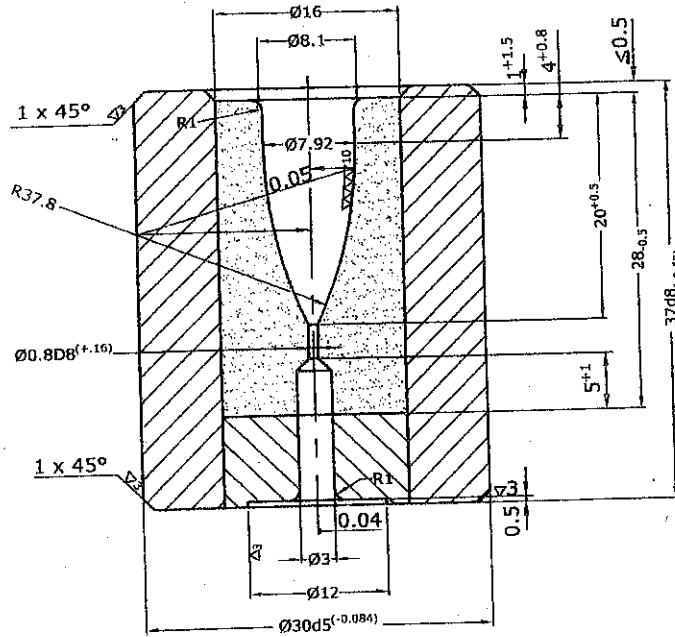


# CNC Internal Grinding Machine

5/101-26

UN STATED VV6



1. IT IS ALLOWED IF PLUG GAUGE L1TK 20-1 DOES NOT TOUCH THE RED LEAD AT A DISTANCE OF 2mm FROM THE GRADUATION LINE

PLUG GAUGE	7.92	L1TK20-3		PLUG GAUGE	Z	0.96	L1TK20-5
PLUG GAUGE	8.1	L1TK20-2		PLUG GAUGE	T	0.8	L1TK20-4
OGIVE PLUG GAUGE	R37.8	L1TK20-1					
NAME	SYMBOL	NOM. SIZE	CODE	NAME	SYMBOL	NOM. SIZE	CODE
	MARKING				MARKING		

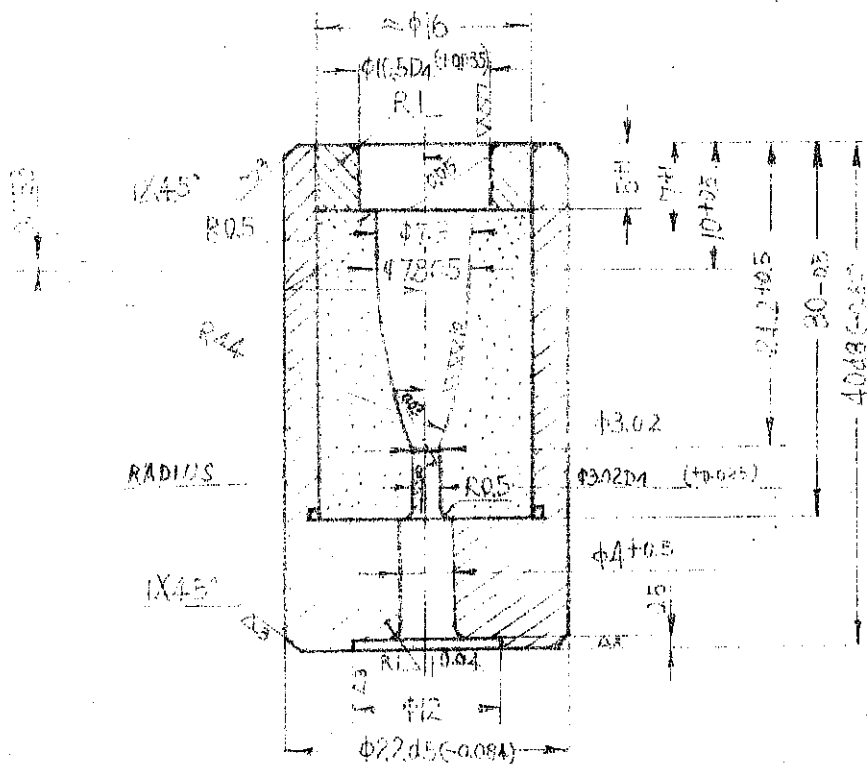
## GAUGE FOR INSPECTION

			TRACED BY	TAUHID
			CHECKED BY	
			RECHECKED BY	
			APPROVED BY	
			SCALE	2:1
			BASED ON	
DATE	AMMENDENTS	SIGN	MAT	
BULLET JACKET DIE BODY YG15, YB 104-60				GITK -20
2ND POINTING DIE DIE SLEEVE 45,GB699-65				
			NO OF SHTS-1	SHT NO-1

E/ GITK-20

WV6

SURFACE FINISH  
EXCEPT WHERE STATED



DIE MOUTH TO BE QUENCHED TO HRC 59-63.

WHEN CHECKED WITH PLUG GAUGE R44 LITZ 9-1 IT IS ALLOWED  
IF THE GAUGE IS NOT ABLE TO GRIND RED LEAD AT A DISTANCE OF  
1.5 mm FROM THE TIP END AND 1-2 mm FROM THE GRADUATION LINE.

NAME	SYMBOL	NOM. SIZE	MARKINGS.	NAME	SYMBOL	NOM. SIZE	MARKINGS.
PLUG GAUGE	T	7.9	LITZ 3-4	PLUG GAUGE	TZ	3.02D <sub>1</sub>	
PLUG GAUGE	Z	10.539	LITZ 3-2	PLUG GAUGE	T	3.045	LITZ 3-7
PLUG GAUGE	T	10.5	LITZ 3-2	PLUG GAUGE	T	7.805	LITZ 9-2
OGIVE PLUG GAUGE		R44	LITZ 9-1	PLUG GAUGE			

INSPECTION GAUGES

NO. OF SET: SHEET NO.  
 TRACED:  
 CHECKED: *hick*  
 APPROVED:  
 SCALE: 2:1  
 BASED ON:  
 MAT. SPEC:

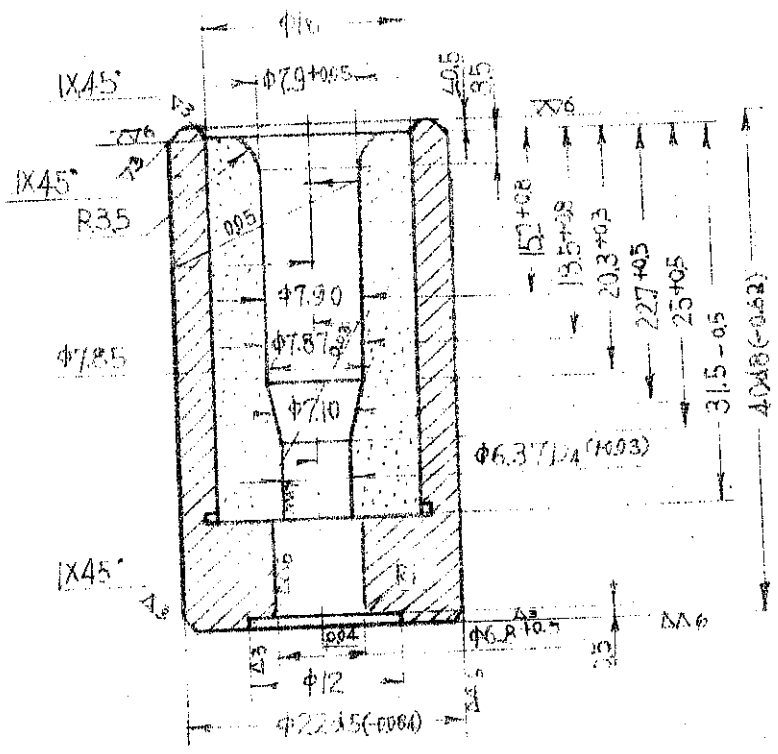
DATE: MOD. NO.  
 BULLET  
 BASE FORMING DIE

AMENDMENTS  
 DIE BODY Y&B YB104-60  
 DIE MOUTH T104, Y&B-57  
 DIE SHERVE. 45, (APL) 9-45

GITZ 9  
 DATE:

*21.1.01*

SURFACE FINISH TO  
EXCEPT WHERE STATED



NAME	SYMBOL	NOM. SIZE	CODE NO:	NAME	SYMBOL	NOM. SIZE	CODE NO.
PLUG GAUGE (18.5 - 19.3)	T	7.87	LITZ6-1	PLUG GAUGE (25 - 28.5)	Z	6.40	LITZ6-8
PLUG GAUGE (5.2 - 16)	T	7.90	LITZ6-2	PLUG GAUGE	T	6.37	LITZ6-7
PLUG GAUGE (18.6)	T	7.95	LITZ6-3	PLUG GAUGE	T	7.10	LITZ6-6
FULL FORM Plug Gauge.	T	2.5	LITZ6-1	PLUG GAUGE	T	7.85	LITZ6-5

INSPECTION GAUGES

NO. OF SET:      SET NO:

TRACKED:

CHECKED: *AK*

APPROVED:

SCALE: 2:1

BASED ON:

MAT. SPEC:

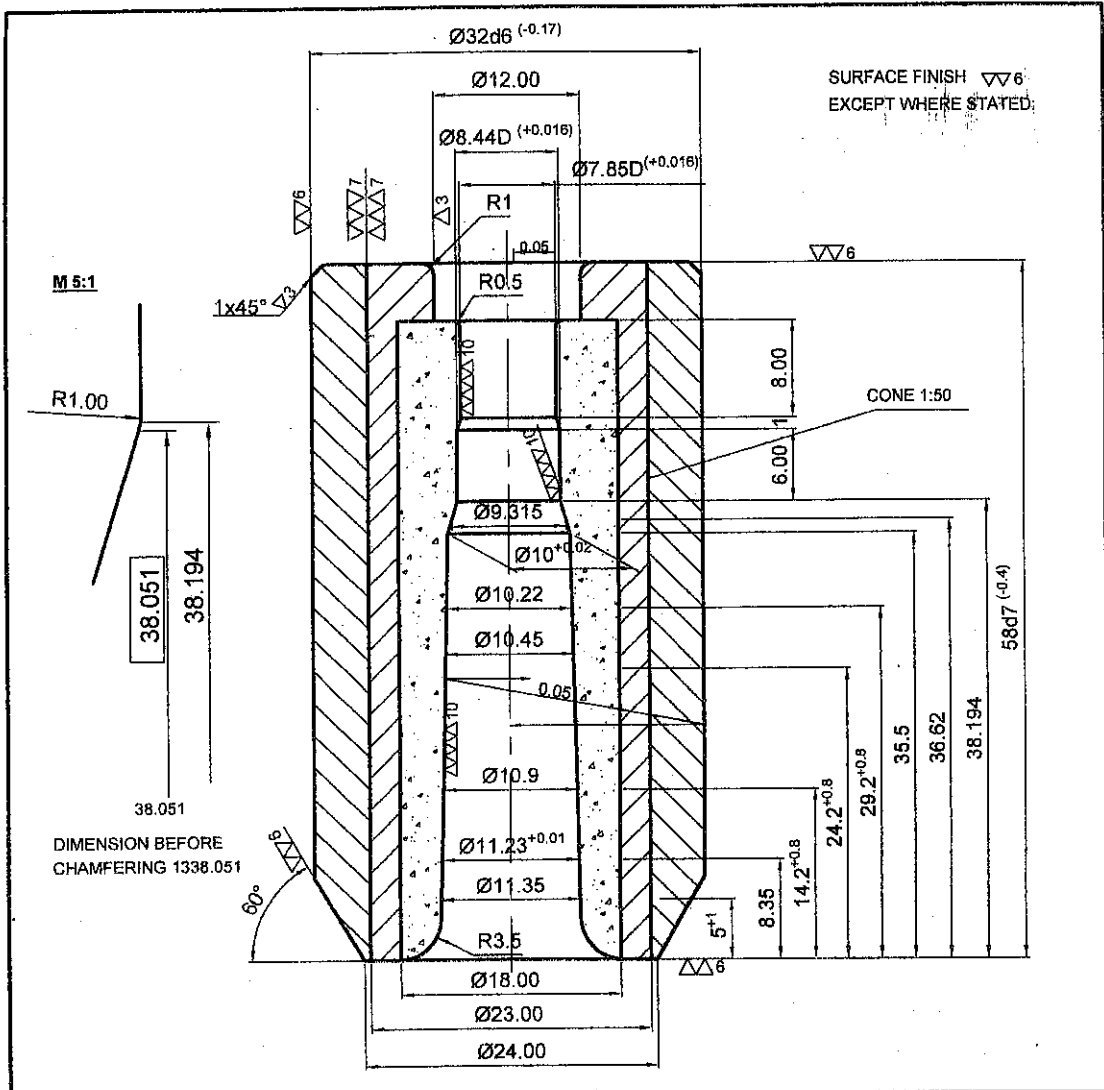
DATE      NOM. NO:      AMMENDMENTS

TITLE: BASE PRE-PRESSING DIE

MTL { DIE BODY ১৪৪ YB 104-6.1  
S.A.M. { DIE SLEEVE ৭৫ ৭৫ ৬৭৯-৬৫

GITZ 6

DATE:



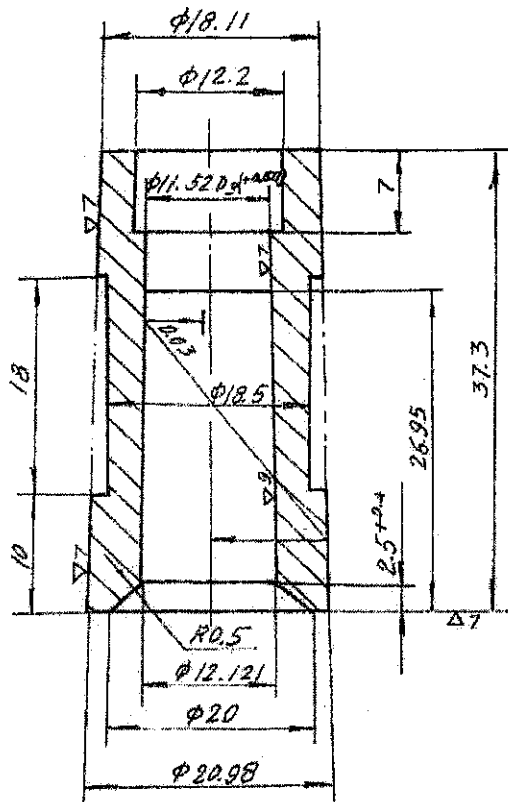
MARKING PLUG GAUGE (24.2-25)	T	10.45	LIK 49-6	FORM PLUG GAUGE		R1	LIK 49-11
MARKING PLUG GAUGE (29.2-30)	T	10.22	LIK49-5	FORM PLUG GAUGE			LIK49-10
MARKING PLUG GAUGE 35.5	T.Z	10 <sup>+0.02</sup>	LIK49-4	PLUG GAUGE	T.Z	8.44D	
MARKING PLUG GAUGE 36.62	T	9.315	LIK49-3	MARKING PLUG GAUGE 5-6	T	11.35	LIK49-9
MARKING PLUG GAUGE 38.194	Z	8.44D	LIK49-2	MARKING PLUG GAUGE 8.35	T.Z	11.23 <sup>+0.01</sup>	LIK49-8
MARKING PLUG GAUGE 2.984	Z	8.44D	LIK49-1	MARKING PLUG GAUGE (14.2-15)	T	10.9	LIK49-7
NAME	SYMBOL	NOM. SIZE	CODE. NO.	NAME	SYMBOL	NOM. SIZE	CODE. NO.
	MARKING				MARKING		

INSPECTION GAUGES				
			TRACED BY	SHAMIM
			CHECKED BY	<i>[Signature]</i>
			RECHECKED BY	<i>[Signature]</i>
			APPROVED BY	<i>[Signature]</i>
			SCALE	2:1
			BASED ON	
DATE	AMMENDENTS	SIGN	MAT	

MAT. SPEC:-		2ND TAPERING DIE FOR BLANK CASE	
DIE BODY :- YG 8,YB 10-60		GIK-49(a-b)	
DIE SLEEVE:- 45, GB 699-65		NO OF SHTS-1	
OUTER PART :- T10A, YB 5-59		SHT NO-1	

▽6

Unless otherwise specified



Harden to HRC58~62

Toper ring gouge	LOK63-4
Toper plug gouge	LOK63-3
Plug gouge	T11.52LOK63-2
Plug gouge	Z11.547LOK63-2
Plug gouge	12.121 LOK63-1
NAME	MARKING

GAUGE FOR INSPECTION

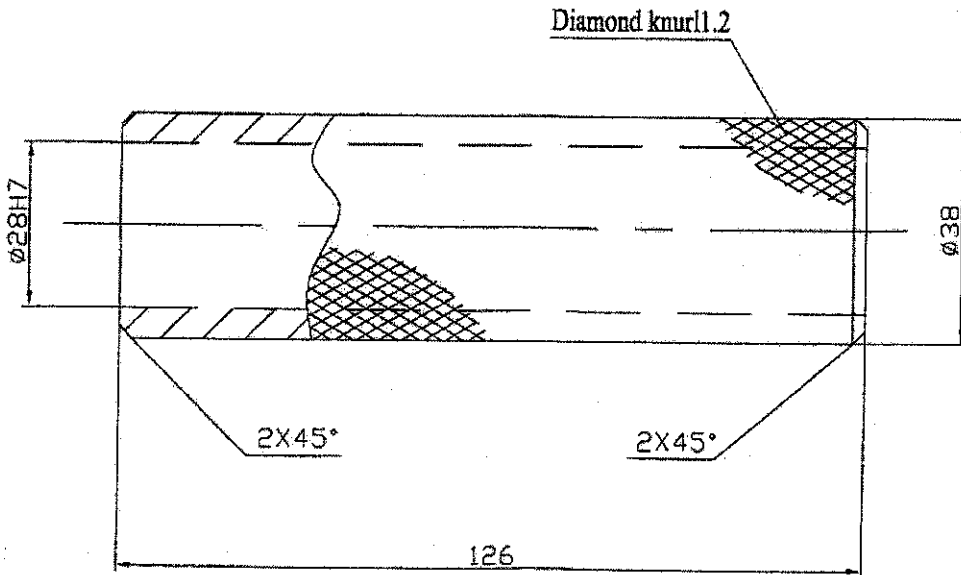
SLEEVE TUBE	GOK63		
	PCS.	WEIGHT	SCALE
T10A YB5-59			2:1
	SHEETS		
	SHEETNO.		

12/100-86

2/1/86 CK [Signature]

No. 57

UOS  $\nabla 6$

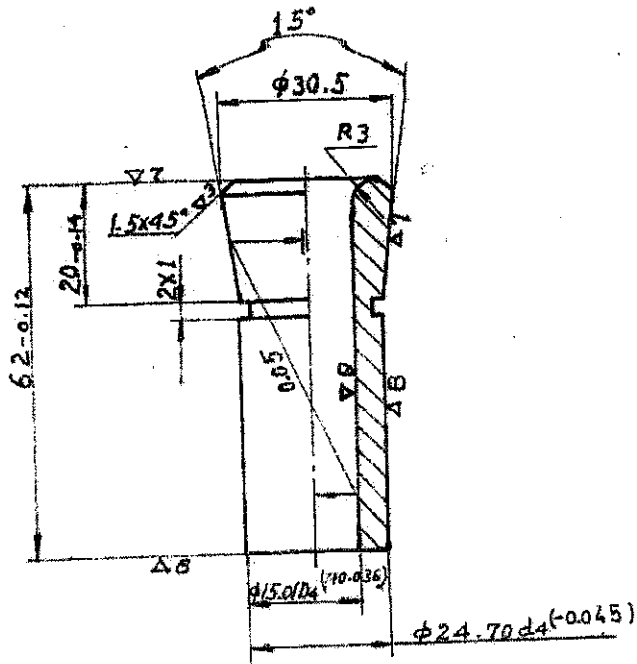


Part No.	1	Pieces	1	Q312-101-8-L61		
Material	45			Scale	Sheet	2
Heat Treatment	HRC35~40			1:1	of 3 Sheets	



UNLESS OTHERWISE SPECIFIED

▽6



1. HARDEN TO HRC 58~62
2. NO NECK SHALL BE PERMITTED
3. ORIGINAL DIMENSION  $\phi 24.59D_4 (-0.045)$  WAS CHANGED TO  $24.70D_4 (-0.045)$  IN PENCIL HAND WRITING BY CHINESE EXPERT.

TAPER RING GAUGE	15' LOK 1-2	
PLUG GAUGE	T15.01 LOK 1-1	
PLUG GAUGE	Z15.045 LOK1-1	
NAME	MARKING	
GAUGE FOR INSPECTION		
CHECKED BY :- <i>T245</i>	PUNCH, BLANKING  T10A YB5-59	GOK1A
AMENDED BY :-		SCALE 1:1
APPROVED BY :-		

12/100-11A S. BEGUM