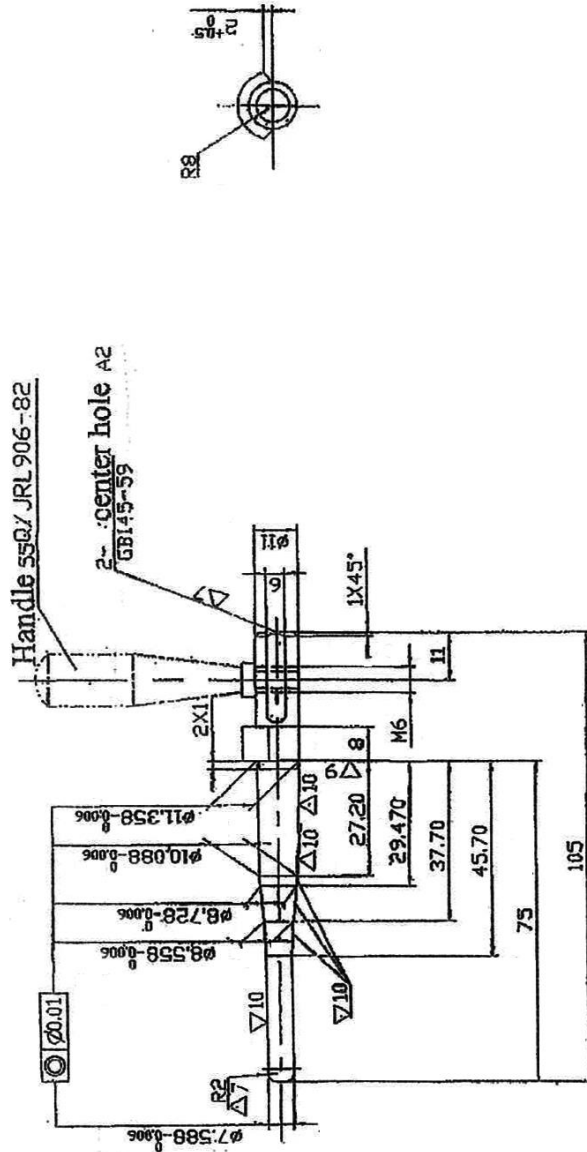


**ANNEXURE G TO  
TENDER NO. 23.27.0000.167.45.4112316.21.22  
DATED 19 JULY 2021**

CHAMBER DIA	CHAMBER UL. TOL	CHAMBER DIMINUTING DIA	CHAMBER UP. TOL
7.62<8.57>		7.588 <sup>+0.006</sup>	7.575
8.59<8.54>		8.558 <sup>+0.006</sup>	8.545
8.76<8.71>		8.728 <sup>+0.006</sup>	8.715
10.12<10.07>		10.088 <sup>+0.006</sup>	10.075
11.39<11.34>		11.358 <sup>+0.006</sup>	11.345

UDS  $\nabla 6$



Note: The width of grinding groove at each taper juncture  $\leq 0.5$

Designer	Collator	Checked for Process Signature Inspector	Approved

Material	Carburized depth	Quenching
10	0.7-1	HRC58-65

Scale	Sheet	of	Sheet
1:1	1	1	1

Q312-101-2-L300-1

Q312-1

366

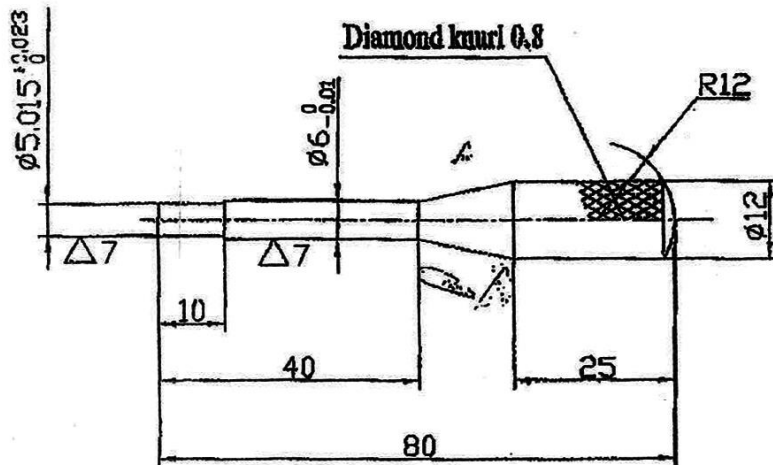
368

Designer

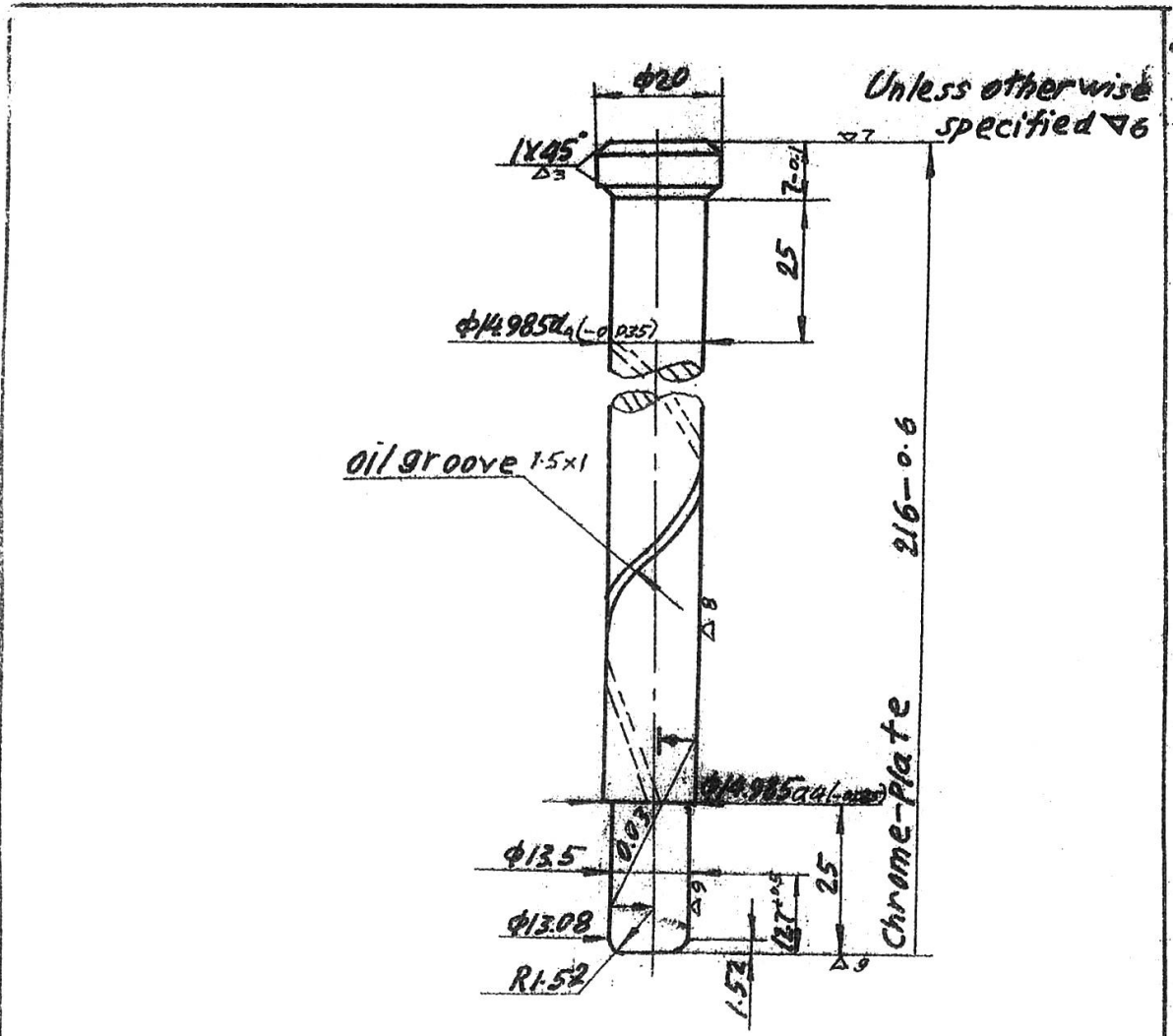
Collator

Inspector

Approver



Part No.	4	Pieces	1	Q312-101Z-L22	
Material	10			Scale	Sheet 5
Heat Treatment	Carburized depth 0.5~0.8 Quenching HRC58~65			1:1	of 5 Sheets



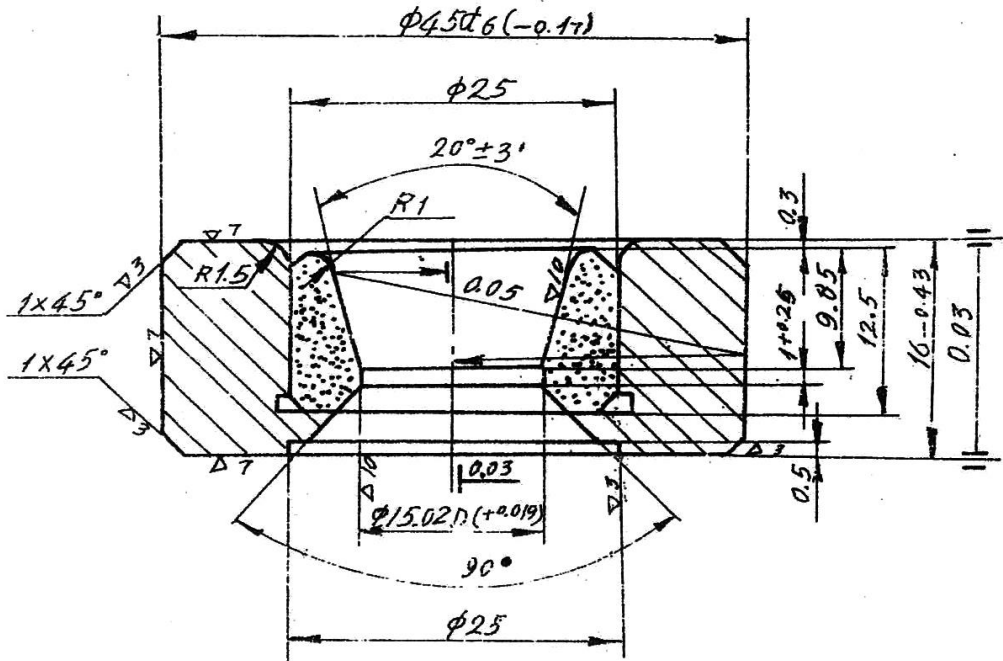
1. Harden to HRC58~62.
2. Chrome-plate 0.015 thick.

Taper templet	13.20L0K3-2
Templet for working end of punch	R1.52L0K3-1
NAME	MARKING

GAUGE FOR INSPECTION

PUNCH, CUPPING	GOK3		
			SCALE 1:1
T10A YB5-59			

Unless otherwise specified



1. Harden the sleeve to HRC 45~50
2. During inspection: LOK9-2 taper plug gauge is permitted to be 0.3 higher than the top surface of die.

Taper plug gauge	20° LOK9-2
plug gauge	T15.02 LOK9-1
Plug gauge	Z15.039 LOK9-1
Name	Marking

Gauge For Inspection

BOTTOM DIE: 1ST DRAWING	GOK9	
		SCALE
		2:1
DIE BODY YGB		
DIE CIEVE T10DYR5-57		

1953 TYPE  
 Ser. No. 15  
 No. 12