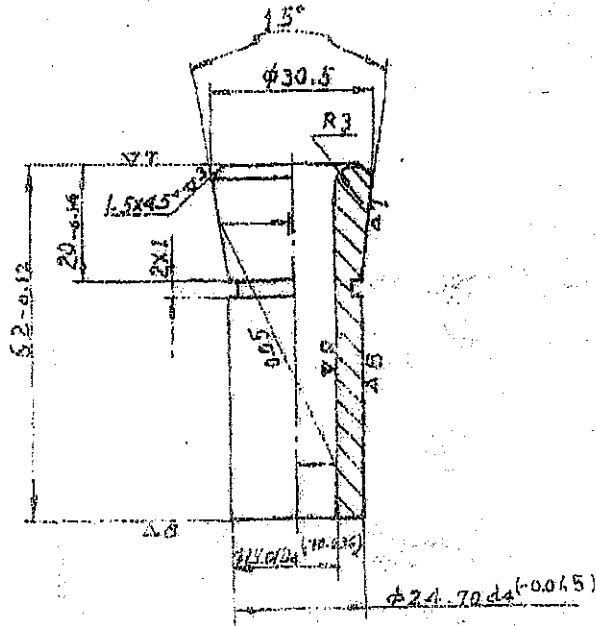


Internal grinding machine

OTHERWISE SPECIFIED

▽6



1. HARDEN TO HRC 58~62
2. NO NECK SHALL BE PERMITTED
3. ORIGINAL DIMENSION $\phi 24.590_4 (-0.045)$ WAS CHANGED TO $24.700_4 (-0.045)$ IN PENCIL HAND WRITING BY CHINESE EXPERT.

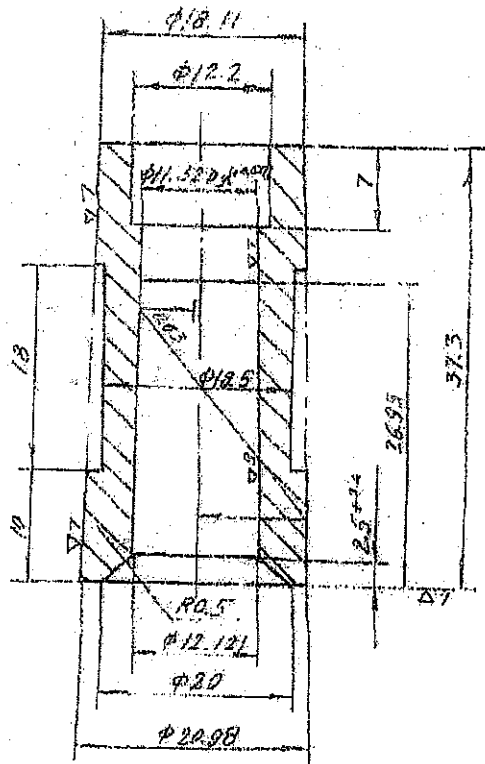
TAPER RING GAUGE	15° LOK 1-2	
PLUG GAUGE	T15.04 LOK 1-1	
PLUG GAUGE	Z15.045 LOK1-1	
NAME	MARKING	
GAUGE FOR INSPECTION		
CHECKED BY :- <i>7245</i>	PUNCH, BLANKING T10A YB5-59	
AMMENDED BY :-		
APPROVED BY :-		
		GOK1A
		SCALE
		1:1

12/100-11A S. BEGUM

Internal grinding machine

▽6

Unless otherwise specified



Harden to HRC 58~62

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

GAUGE FOR INSPECTION

SLEEVE TUBE	GOK63		
	PCS.	WEIGHT	SCALE
T10A YB5-59			2:1
	SHEETS		
	SHEET NO.		

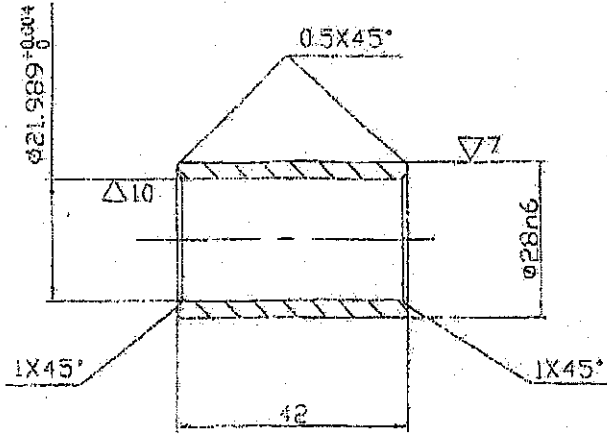
12/110-86

Bluh CR

Internal Grinding machine

00.57

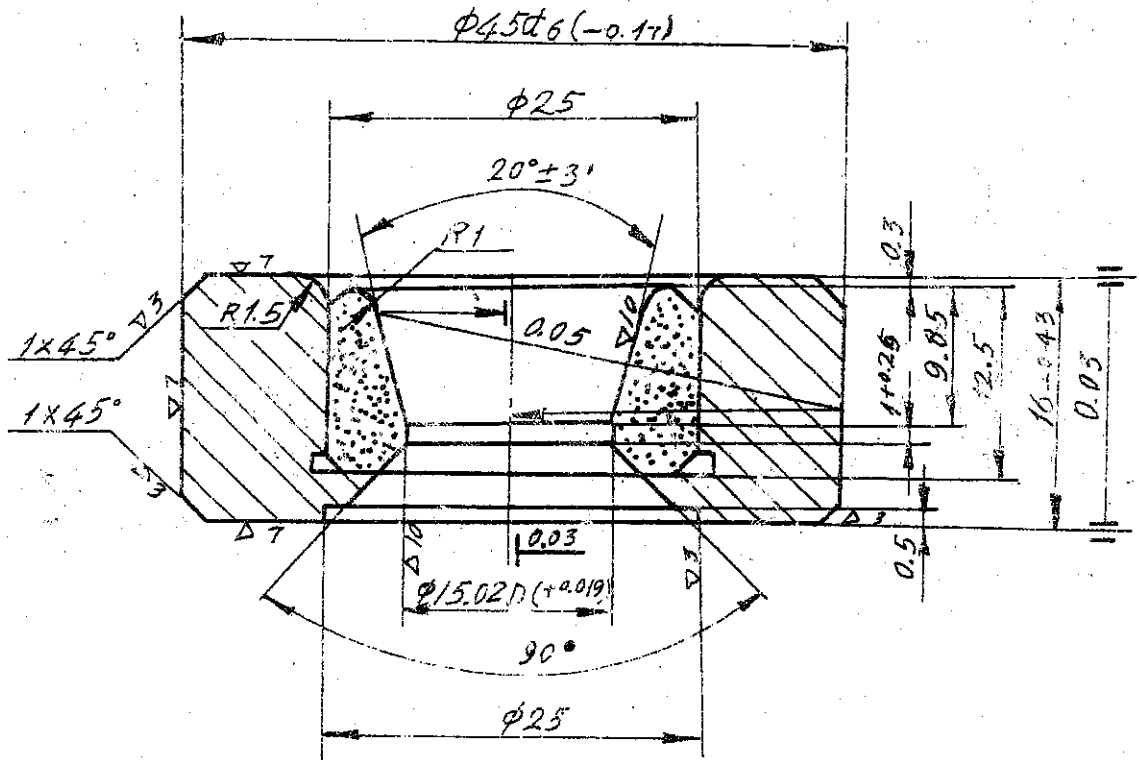
UOS▽6



Part No.	2	Pieces	3	0312-101-8-L61	
Material	T10A				
Heat Treatment	HRC58-65	Scale	Sheet	3	
		1:1	of	3	

Internal Grinding machine

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

		GOK9	
BOTTOM DIE. 1ST DRAWING			SCALE
			2:1
DIE BODY YGB			
DIE CREEVE TION YRS-57			

1953 TYPE
S.No. 15
12