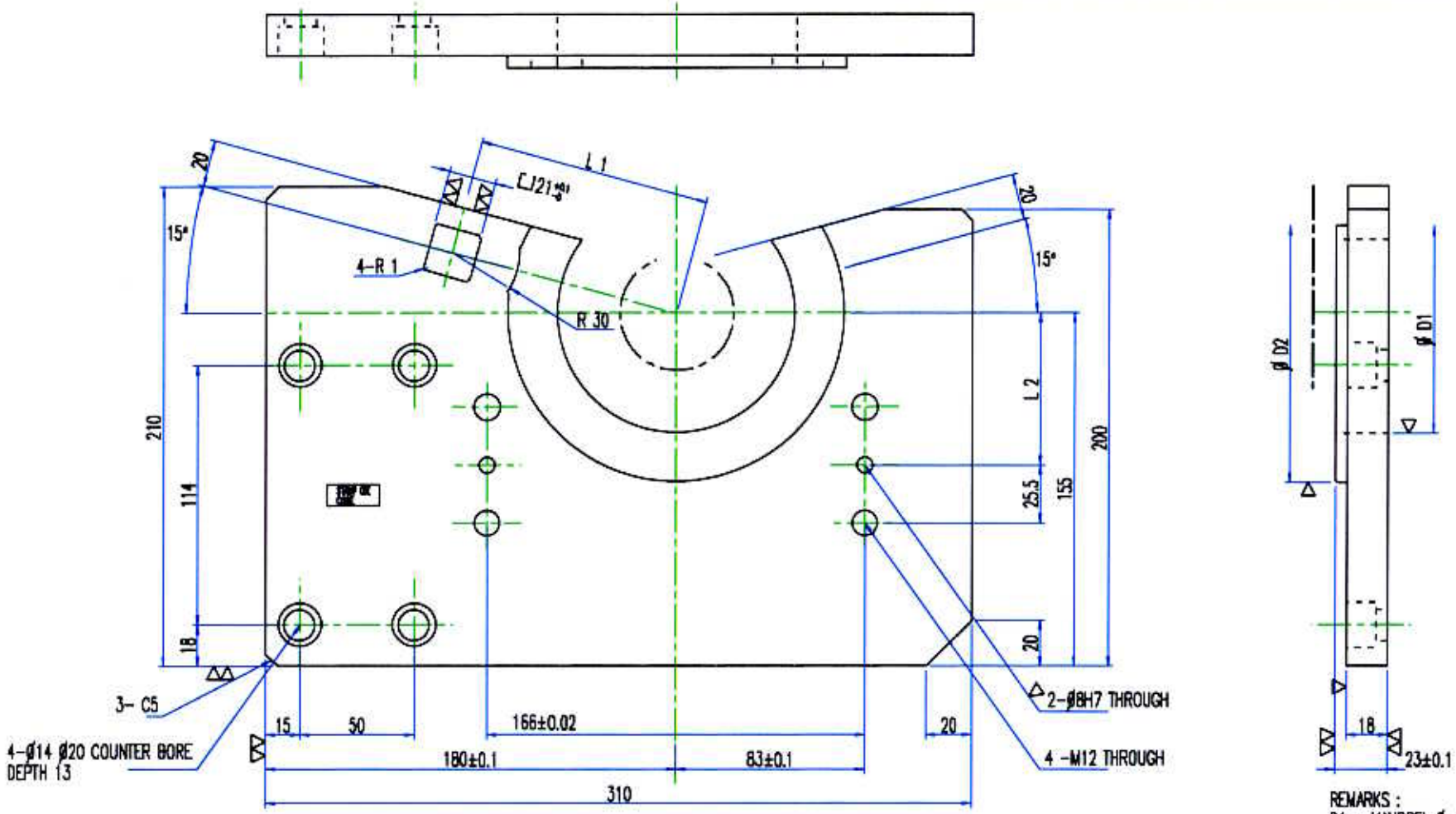
3RD ANGLE	NOT TO SCALE	DIMENSION IN MM	SURFACE ROUGHNESS ▽

MARK	REVISION	DATE	CHECK
1			
2			



REMARKS :
D1 = MANDREL ø + 3 ~ 4 MM
D2 = MANDREL ø + WIRE DIAMETER X 2
L1 = (MANDREL ø + WIRE ø X 2) /2 + 27
L2 = (MANDREL / 2) +15 + 1~ 1.2MM

NO	DIE CODE	ø D1	ø D2	L 1	L 2
6	SP 95	95	125	87.0	74
5	SP 90	90	120	84.5	69
4	SP 85	85	115	82.0	64
3	SP 80	80	110	79.5	59
2	SP 75	75	105	77.0	54
1	SP 70	70	100	74.5	49

NO	DIE CODE	ø D1	ø D2	L 1	L 2
12	SP 125	125	155	102.0	104
11	SP 120	120	150	99.5	99
10	SP 115	115	145	97.0	94
9	SP 110	110	140	94.5	89
8	SP 105	105	135	92.0	84
7	SP 100	100	130	89.5	79

NO	DIE CODE	ø D1	ø D2	L 1	L 2
18	SP 155	155	185	117.0	134
17	SP 150	150	180	114.5	129
16	SP 145	145	175	112.0	124
15	SP 140	140	170	109.5	119
14	SP 135	135	165	107.0	114
13	SP 130	130	160	104.5	109

S. HARDNESS	HRC 50~55	DRAWN	WCT
HEAT TREATMENT	INDUCTION HARDENING		
MATERIAL	S45 C	DESIGNED	WCT
MACHINE NAME	MORITA COILING		
DRAWING NO	P&E/T/006	APPROVED	JEFF
TITLE	STRIPPER PLATE		

PT APM ARMADA SUSPENSION