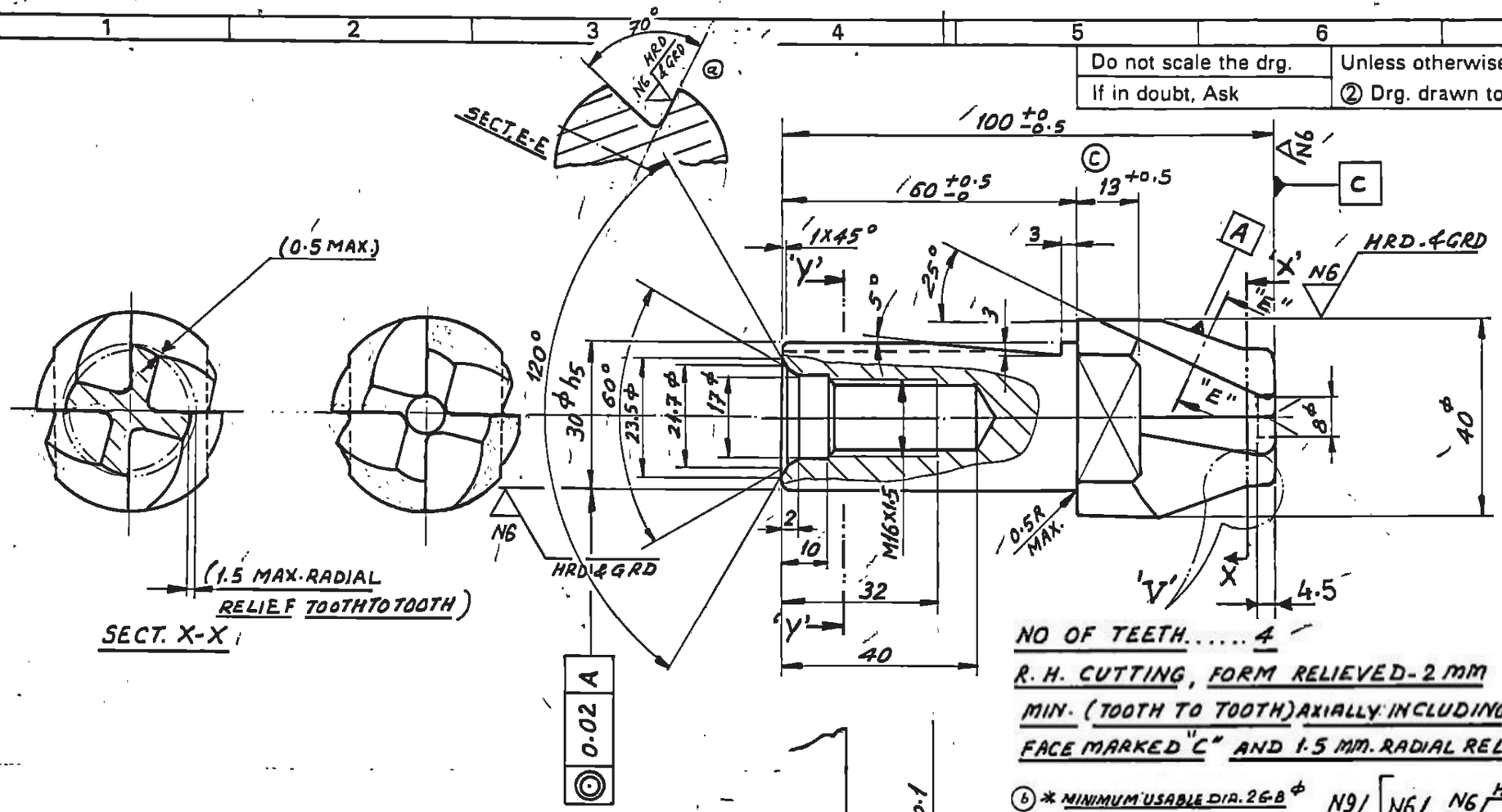
Do not scale the drg.	Unless otherwise stated ① All dimns. in mm.
If in doubt, Ask	② Drg. drawn to first angle projection.

Nominal dims.	Tolerances in μm
31 e 8	-50 / -89
30 ϕ h5	0 / -9



NO OF TEETH..... 4

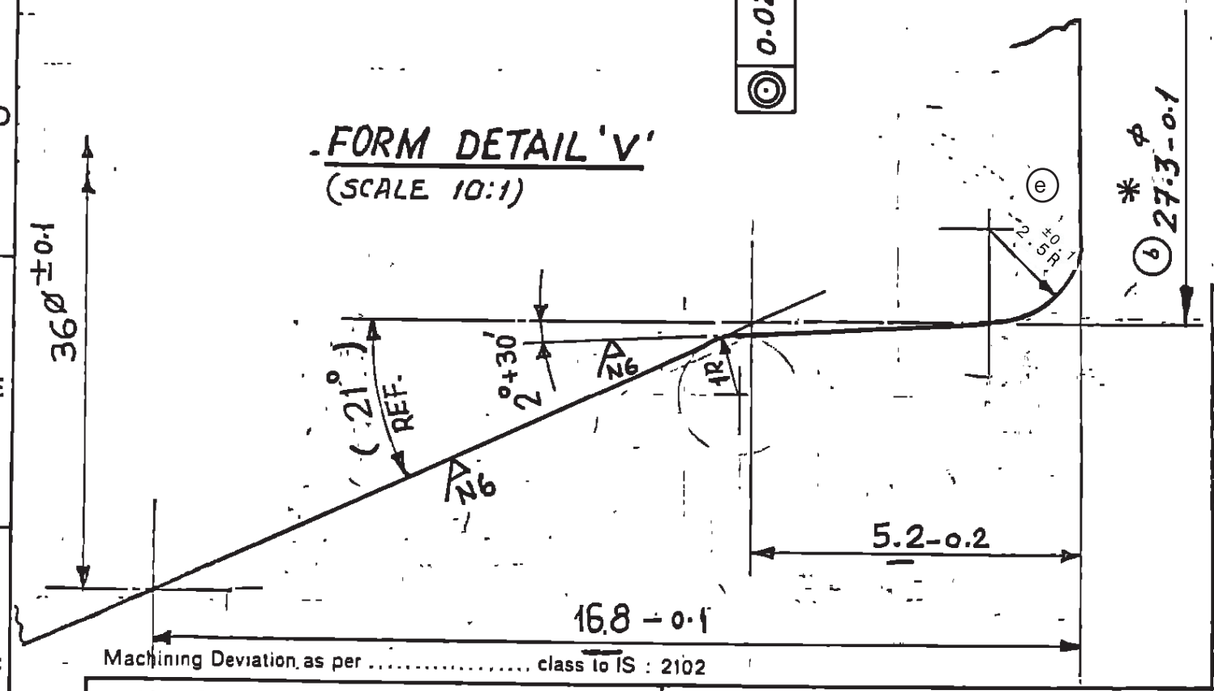
R. H. CUTTING, FORM RELIEVED-2 mm MIN. (TOOTH TO TOOTH) AXIALLY INCLUDING FACE MARKED "C" AND 1.5 MM. RADIAL RELIEF (REF. SECT "X-X")

ⓑ * MINIMUM USABLE DIA. 26.8 ϕ

N9 [N6 N6 HRD&GRD]

ⓓ HRD. & GRD TO HRc 63 TO 65

MARK DRG. NO



Machining Deviation as per ..... class to IS : 2102

M/cg Deviation for open Dimns. (Med to IS · 2102)									
Dim	Over	–	6	30	120	315	1000	2000	>4000
	Upto & Inc.	6	30	120	315	1000	2000	4000	
Tolerance		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3

Surface Roughness Symbols								
New	N12	N11	N8	N6	N3	N6 GRD	N6 HRD & GRD
Old	~	▽	▽▽	▽▽▽	▽▽▽▽	Ω	Ω

For other Roughness Symbols & Values See IS: 3073 (TS: 11507)

03/04 2018	ⓔ			RADIUS 2.5R ±0.1 WAS 1.5R ±0.1 MODIFIED AS PER SHOP FEEDBACK	ABP	RSS
27.11.04	ⓓ			MISSING HARDNESS VALUE HRc 63 TO 65 ADDED		
11.4.03	ⓒ			DIMN. 13 +0.5 WAS 13 MOD. AS PER TIC REPORT		
19.7.92	ⓑ		E-4	DIMN. 27.3-0.1 WAS 27-0.1 modified as per EMA Inductor size Ref. APL Letter	AVM	
17.12.90	ⓐ			RACK & 8° DELETED (modified as per 8800.470.850.00) mod ⓐ		
Date	Mod No	S.No	Zone	Modification	D.O.	STDZ

Material Description Size, Spec. Std. No.: H.S.S. with 5% CO 45 ϕ × 105

Tolerances as per Std.

Measurements to be specially checked.

This drg. is the sole property of Telco. It should not be copied or communicated to any person without the written approval of the proprietors.

1990	SIGN	DATE
DRN.	AVM	30-9
CHD.		5.11
APPD		

~~L-352 0514601-58(A2)~~ 3126 165 11001-(A1) 036-45/201

Scale 1:1 & (10:1)

Product/Group No. CAM-SHAFT FOR 692 ϕ D.I. ENGINE WITH 94 AIR COMP.

Drg./Part Designation: FORM-CUTTER

Gross Wt. in kg.

Surface protection as per Std.

Replaces Drg.

Reference Drg. No. 8800.470.330.00

~~Gen. Hand Drg.~~ / Pt. No. 2523 0510 7915N

Drg./Part No. 8800.470.349.00

Sheet No. 1 of 1 Sheets.

C.T.D

TATA ENGINEERING & LOCOMOTIVE CO. LTD. PUNE