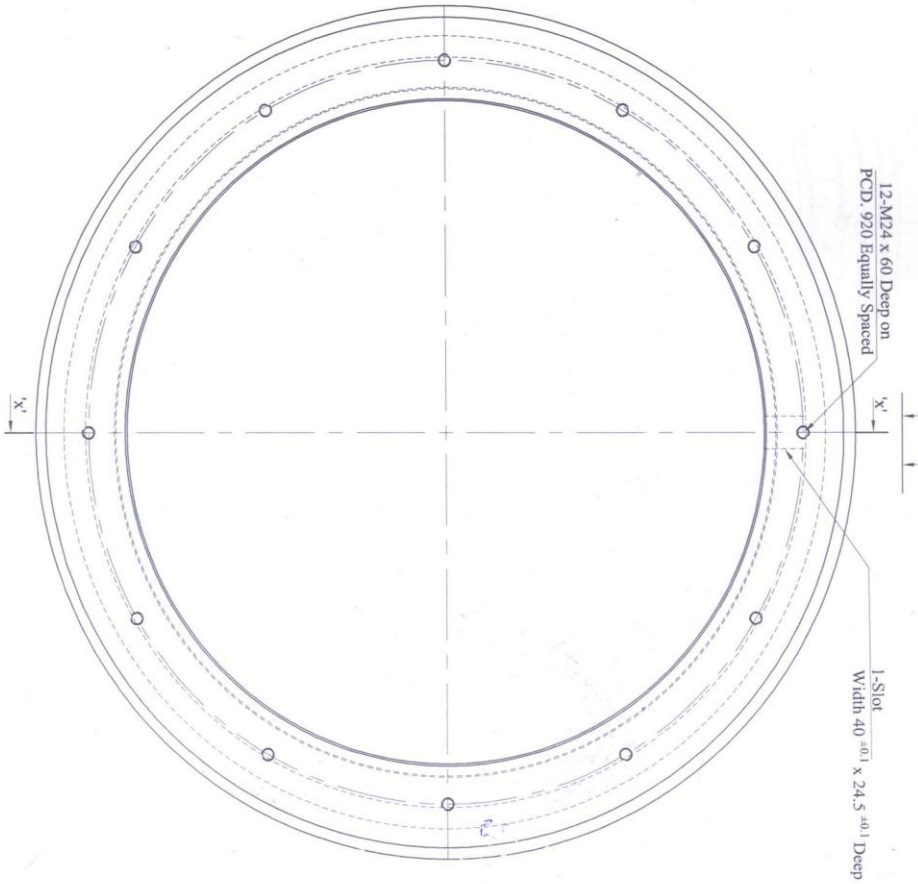
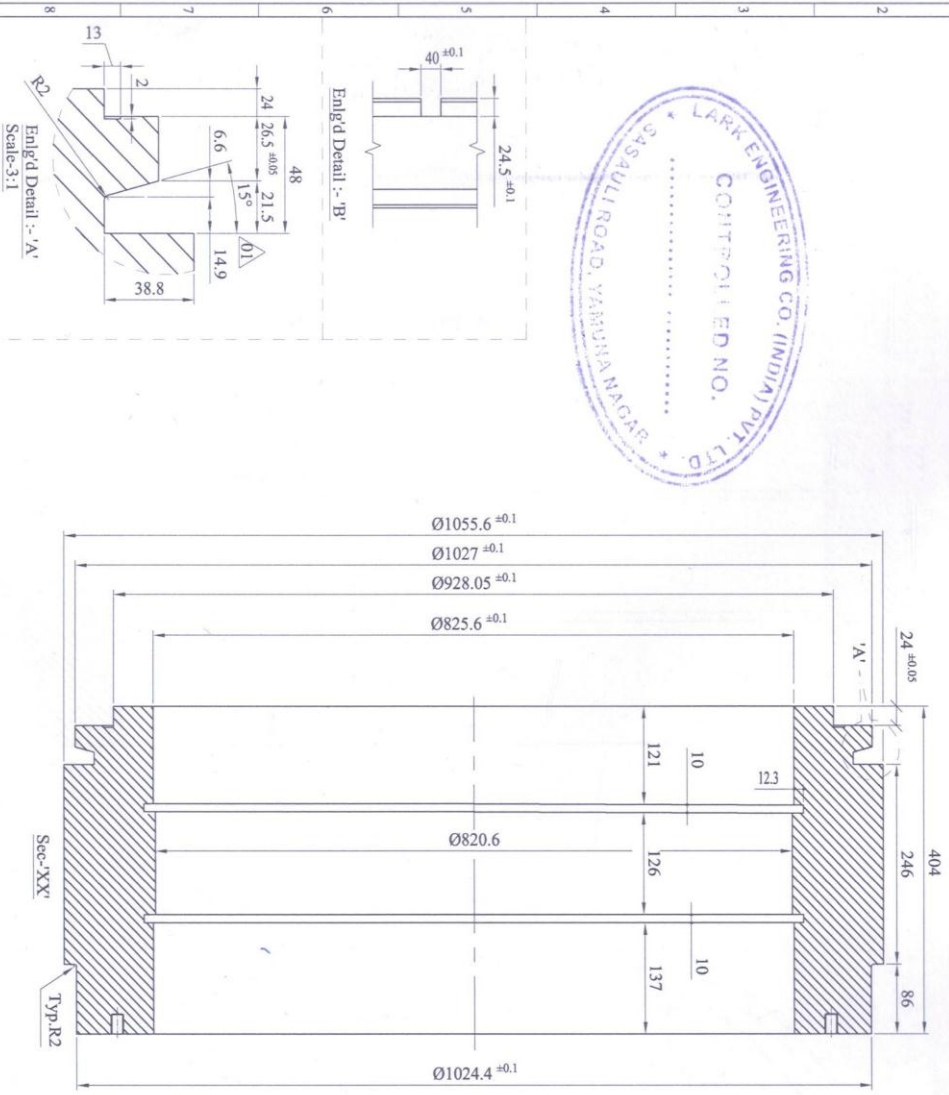


D:\DESIGN-6\LSF-SPARE PART MANUFACTURER FILE DATA\BIOFUELL\SCF-06\_CPM (BIOFUEL)\M.JUMBO\USD-476B\_DETAIL.DWG  
 DO NOT SCALE. IF ANY DOUBT PLEASE ASK.  
 PLEASE DESTROY THE OLD REVISION OF THIS DRAWING.



UNAUTHORIZED USE OF THIS DRG. OR MAKING PRODUCT AS PER THIS DRG. WITHOUT OUR PERMISSION OR ANY OTHER MISUSE IS NOT PERMITTED.  
 ALL THE DIMENSIONS ARE IN MM OTHERWISE MENTIONED.  
 ALL THE SHARP EDGES MUST BE REMOVED.

Material:- X46Cr13  
 Hardness:- 18-22 HRC(In Blank)  
 All Sizes Are Before GunDrilling

UNSPECIFIED TOLERANCES in MM (ISO 2768-1)

|           |       |              |      |
|-----------|-------|--------------|------|
| 0 TO 06   | ±0.05 | 120 TO 400   | ±0.2 |
| 06 TO 30  | ±0.1  | 400 TO 1000  | ±0.3 |
| 30 TO 120 | +0.15 | 1000 TO 2000 | +0.5 |

SURFACE FINISH

|               |       |     |     |     |     |     |      |    |    |     |
|---------------|-------|-----|-----|-----|-----|-----|------|----|----|-----|
| IS: 3073-1967 | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |
| Re VALUE -um  | ✓     | ✓   | ✓   | ✓   | ✓   | ✓   | ✓    | ✓  | ✓  | ✓   |



LARK

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I.T.I. SASAULI ROAD YAMUNA NAGAR. PH.: 91-01732-254685, 259685  
 Find us at: www.larkengg.com, e-mail: info@larkengg.com

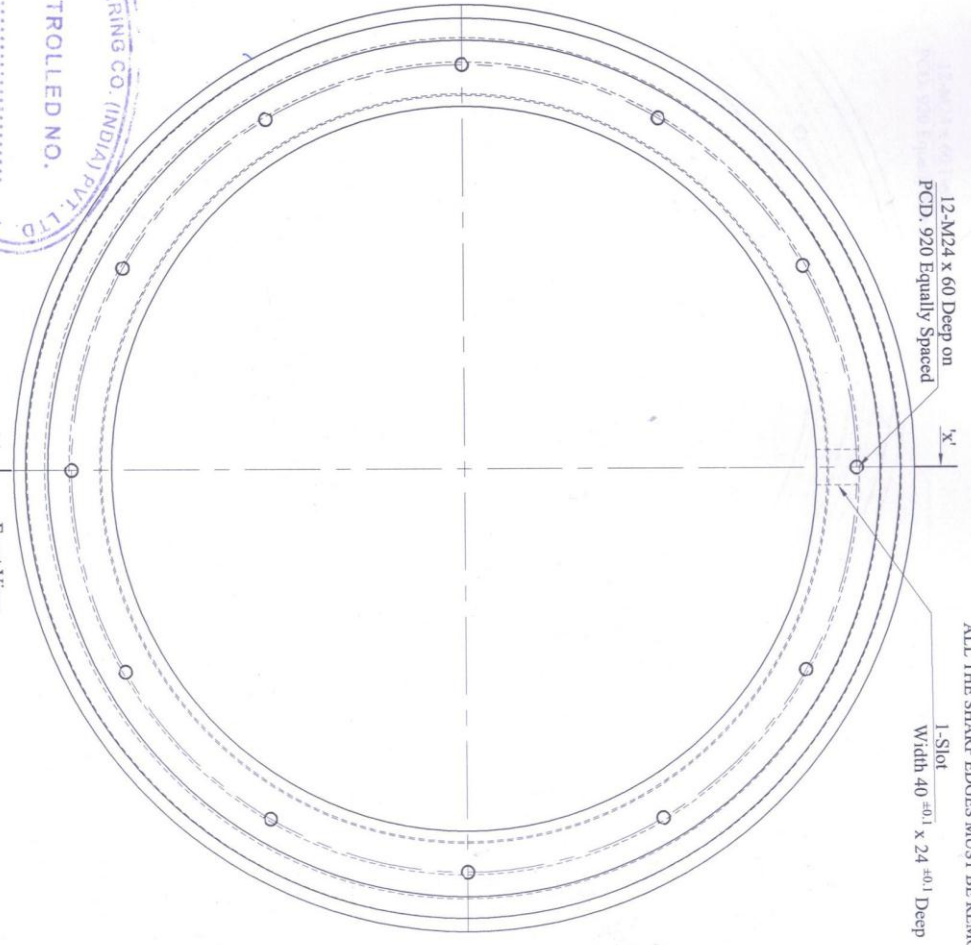
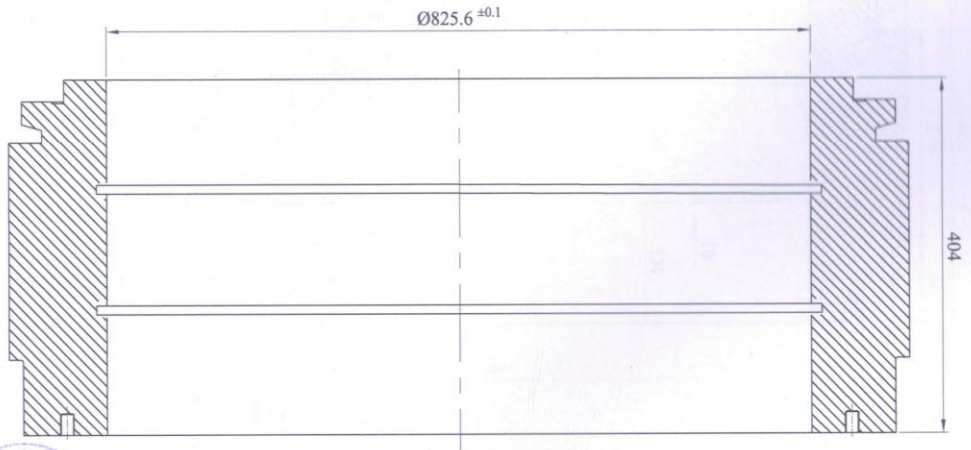
ITEM: MAKE CPM  
 DATE: 29-12-20

REFERENCE DRG NO.: LSD - 476 B  
 DRG. NO. LSD - 476

DRN. BY: KARAN  
 CKD. BY:  
 APPD. BY:  
 Job. REV. NO. 01  
 SHEET NO. A4

|               |                               |          |         |          |          |
|---------------|-------------------------------|----------|---------|----------|----------|
| REV. NO./ZONE | REVISION DETAIL               | DATE     | DRN. BY | CHKD. BY | APPD. BY |
| 01            | INTERNAL PAD HAS BEEN REVISED | 15.01.21 | KARAN   |          |          |

D:\DESIGN-6L SF-SPARE PART MANUFACTURER FILE DATA\BIOFUEL\SCF-06\_CPM (BIOFUEL)\M.JUMBOLSD-476B\_DETAIL DRG (FORMERLY THK-115) (REV. 01) (27/01/2019) PVT. LTD.  
 DO NOT SCALE, IF ANY DOUBT PLEASE ASK.  
 PLEASE DESTROY THE OLD REVISION OF THIS DRAWING.



LARK ENGINEERING CO. (INDIA) PVT. LTD.  
 CONTROLLED NO.  
 SASOULI ROAD, YAMUNA NAGAR

Material:- X46Cr13  
 Hardness:- 18-22 HRC  
 All Sizes Are Before Gundrilling

UNSPECIFIED TOLERANCES in MM (ISO 2768-1)

|           |       |              |      |
|-----------|-------|--------------|------|
| 0 TO 06   | ±0.05 | 120 TO 400   | ±0.2 |
| 06 TO 30  | ±0.1  | 400 TO 1000  | ±0.3 |
| 30 TO 120 | +0.15 | 1000 TO 2000 | +0.5 |

|                |     |       |     |     |     |     |     |      |    |    |     |
|----------------|-----|-------|-----|-----|-----|-----|-----|------|----|----|-----|
| SURFACE FINISH | ▽▽▽ | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |
|                | ▽▽  | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |
| IS: 3073-1967  | ▽   | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |
| Ro VALUE       | -um | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |



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 Find us at: www.larkengco.com, e-mail: info@larkengco.com

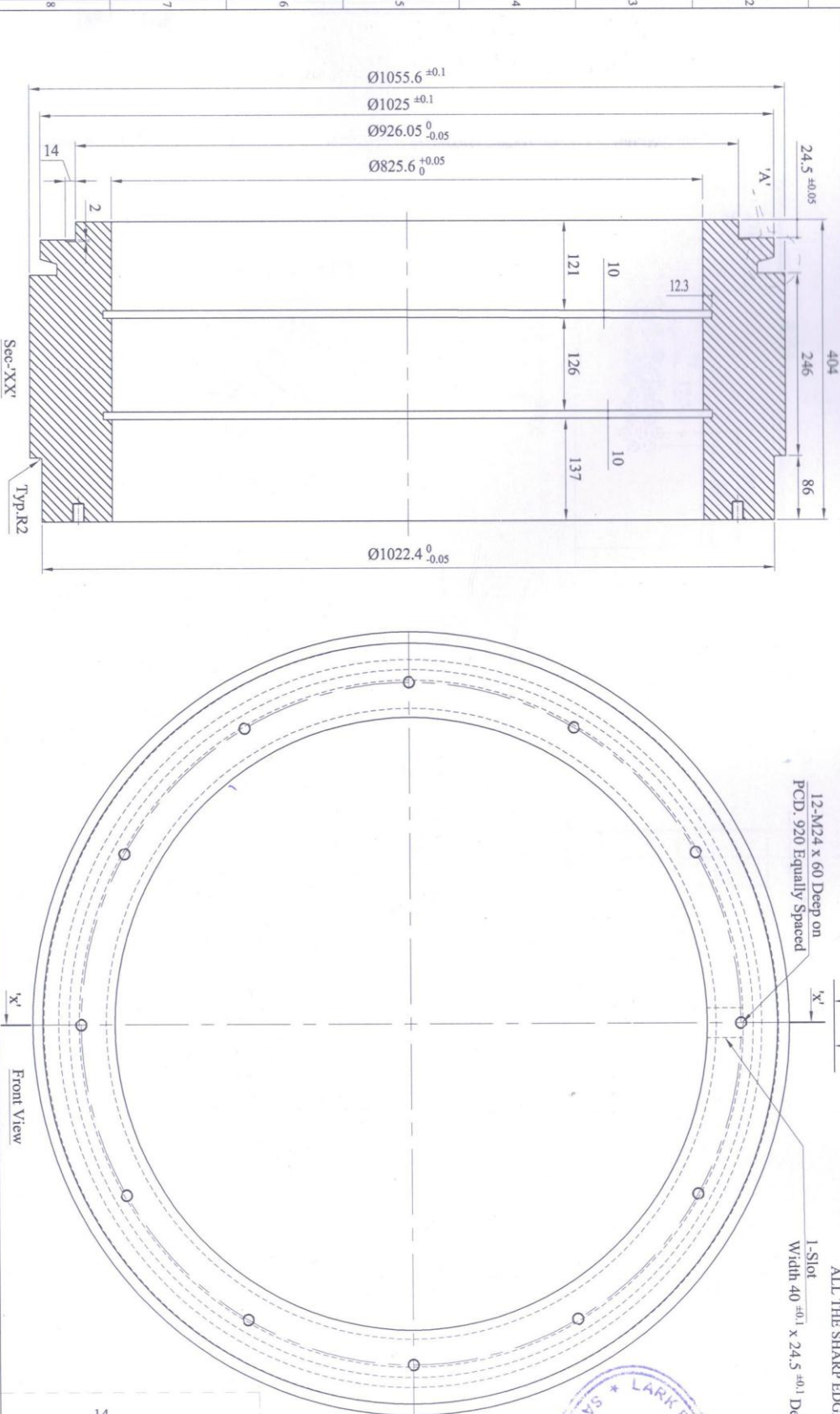
ITEM: DETAIL DRG OF DIE (THK-115)  
 REFERENCE DRG NO.: LSD - 476 B

DRN. BY: KARAN  
 CKD. BY:  
 APPD. BY:  
 DATE: 29-12-20

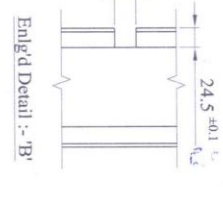
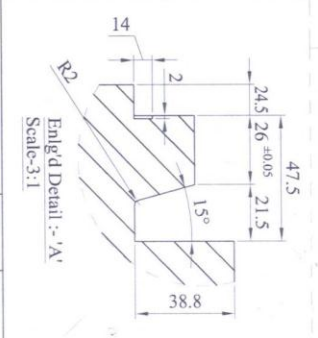
DRG. NO.: LSD - 476 A  
 Job: REV. NO. | SHIT: 01 | A4

|                 |                               |          |         |          |          |
|-----------------|-------------------------------|----------|---------|----------|----------|
| REV. NO.   ZONE | REVISION DETAIL               | DATE     | DRN. BY | CHKD. BY | APPD. BY |
| 01              | INTERNAL PAD HAS BEEN REVISED | 15.01.21 | KARAN   |          |          |

D:\DESIGN-6\LSF-SPARE PART\MANUFACTURER FILE DATA\BIOFUEL\LSCF-06\_CPM (BIOFUEL)\M.JUMBO\USD-476B\_DETAIL DRG (3:1) (4:1) (1:1) PVT.LTD.  
 DO NOT SCALE. IF ANY DOUBT PLEASE ASK.  
 PLEASE DESTROY THE OLD REVISION OF THIS DRAWING.



ALL THE DIMENSIONS ARE IN MM OTHERWISE MENTIONED.  
 ALL THE SHARP EDGES MUST BE REMOVED.  
 UNAUTHORISED USE OF THIS DRG. OR MAKING PRODUCT AS PER THIS  
 DRG. WITHOUT OUR PERMISSION OR ANY OTHER MISUSE IS NOT PERMITTED.



Material:- X46Cr13  
 Hardness:- 50-55 HRC  
 All Sizes Are After Grinding

UNSPECIFIED TOLERANCES in MM (ISO 2768-1)

|           |       |              |      |
|-----------|-------|--------------|------|
| 0 TO 06   | ±0.05 | 120 TO 400   | ±0.2 |
| 06 TO 30  | ±0.1  | 400 TO 1000  | ±0.3 |
| 30 TO 120 | +0.15 | 1000 TO 2000 | +0.5 |

|                |       |     |     |     |     |     |      |    |    |     |
|----------------|-------|-----|-----|-----|-----|-----|------|----|----|-----|
| SURFACE FINISH | 0.025 | 0.1 | 0.2 | 0.8 | 1.6 | 6.3 | 12.5 | 25 | 50 | 100 |
| IS: 3073-1987  | ✓     | ✓   | ✓   | ✓   | ✓   | ✓   | ✓    | ✓  | ✓  | ✓   |
| Re VALUE -µm   | ✓     | ✓   | ✓   | ✓   | ✓   | ✓   | ✓    | ✓  | ✓  | ✓   |

| REV. NO./ZONE | REVISION DETAIL               | DATE     | DRN. BY/CHKD. BY/APPD. BY |
|---------------|-------------------------------|----------|---------------------------|
| 01            | INTERNAL PAD HAS BEEN REVISED | 15.01.21 | KARAN                     |



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 Find us at : www.larkenggo.com , e-mail : info@larkenggo.com

TITLE : MAKE CPM  
 ITEM : DETAIL DRG OF DIE (THK-115)

REFERENCE DRG NO.: LSD -  
 DRG. NO. LSD - 476 B

DRN. BY: KARAN  
 CKD. BY:   
 APPD. BY:   
 DATE: 29-12-20

Job:   
 REV. NO.: 01  
 SHT: A4