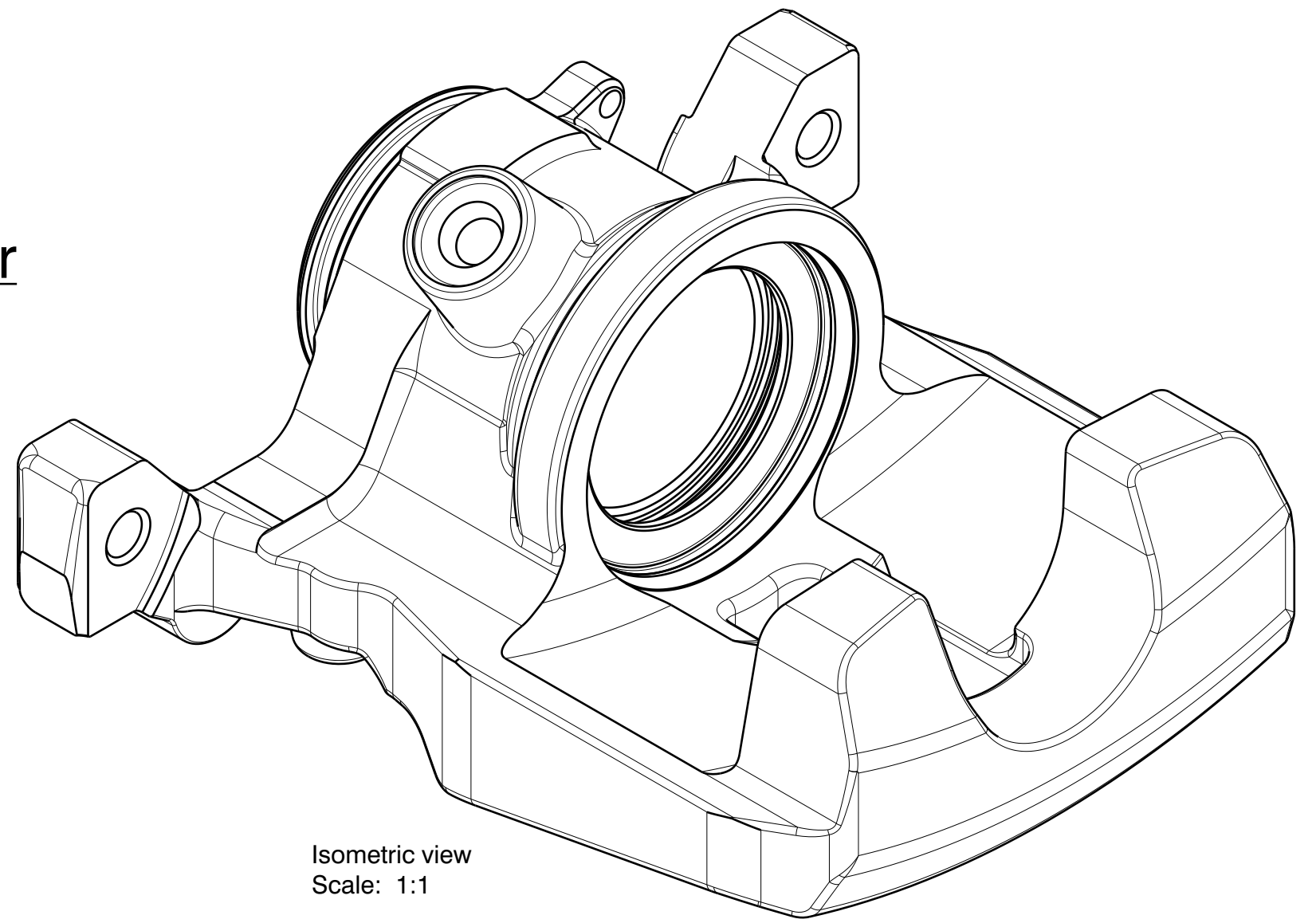
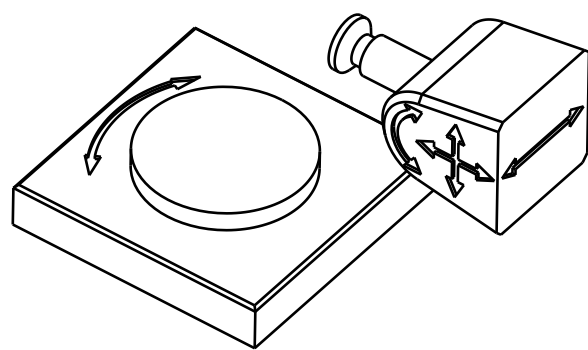






Machine : Horizontal Machining Center  
Turret : BT50

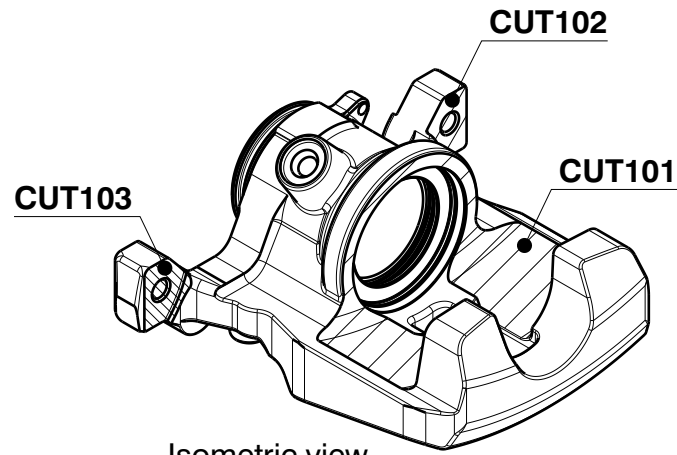


Isometric view  
 Scale: 1:1

**WORK : BRAKE CALIPER**

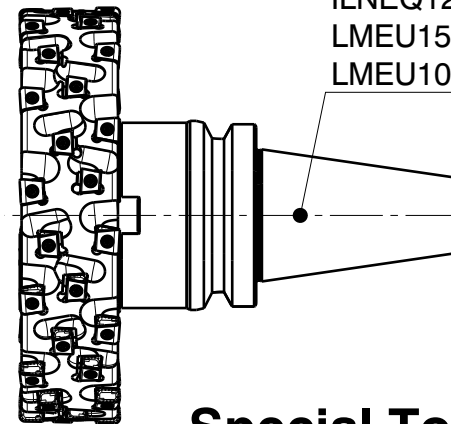
**WORKPIECE MATERIAL - Cast iron**

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	 Dwg. No. 32448715-HCL
	Design			Designation: LAYOUT-BRAKE CALIPER-62306		
Dim.s:	Check			Process	Layout.	Page 1
--	Appr.			Lead Drawing		Of 1
Angles:	Scale	--				Rev. No. 
--						0
	© 2019 Tungaloy Corporation Copyrights Notice			Reg. No.		
				FL-40032187		62306/1
						A3L

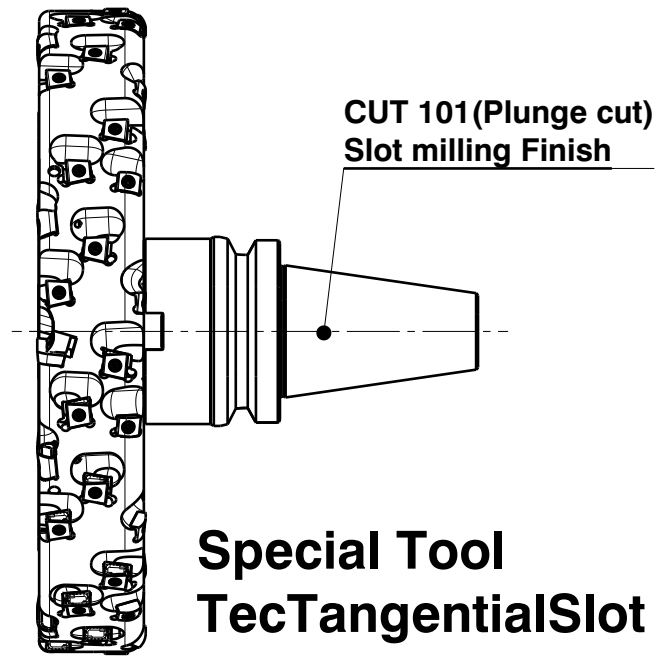


Isometric view  
Scale: 1:3

**CUT 101 (Copying cut)**  
**Slot milling Finish**  
 BT50SEM50.8X75V1  
 KS-220W57B50.8Z22 (SPECIAL)  
 ILNEQ121106D90-R100R04 (SPECIAL)  
 LMEU150955ZNEN-MJ AH120 (SPECIAL)  
 LMEU100808ZNEN-MJ AH120

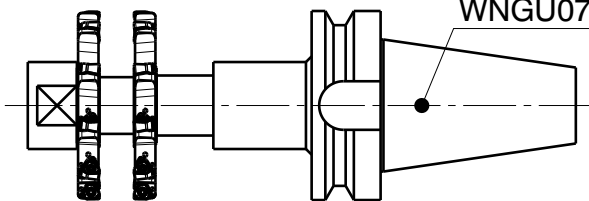


**Special Tool  
TecTangentialSlot**



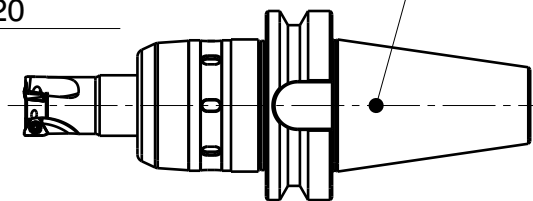
**CUT 101 (Plunge cut)**  
**Slot milling Finish**  
**Special Tool  
TecTangentialSlot**

**CUT 102/103**  
**Slot milling Finish**  
 KAA-B31.75L90BT50 (SPECIAL)  
 KS-100W12B31.75Z10-1 (SPECIAL)  
 KS-100W12B31.75Z10-2 (SPECIAL)  
 WNGU07T308TN-MJ AH120



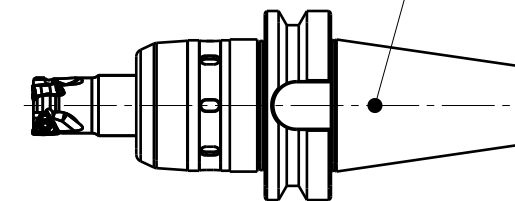
**Special Tool  
TungUniversalSlot**

**CUT 104/105**  
**Shoulder and Face milling Finish**  
 BT50MAXIN32X106  
 EPA10R032M32.0-03N  
 TOMT100408PDER-MJ AH120

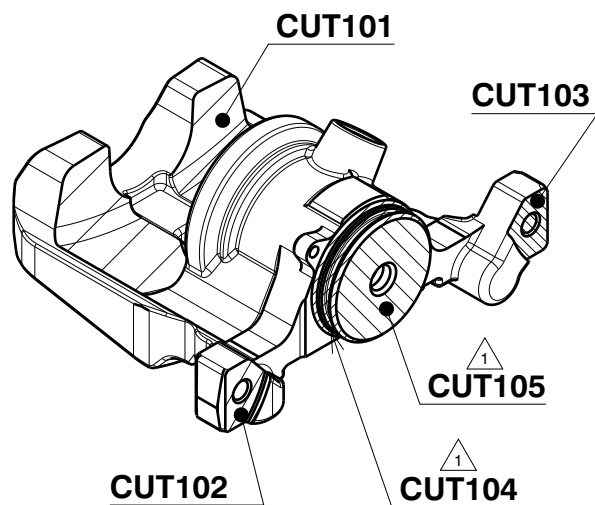


**TungTri**

**CUT 104/105**  
**Shoulder and Face milling Finish**  
 BT50MAXIN32X106  
 EPTN12M032C32.0R03N  
 TNGU120708PER-MJ AH120

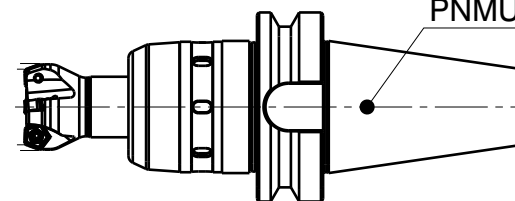


**DoForceTri**



Isometric view  
Scale: 1:3

**CUT 105**  
**Face milling Finish**  
 BT50MAXIN32X106  
 EEN09R040M32.0-04  
 PNMU0905GNEN-MJ AH120

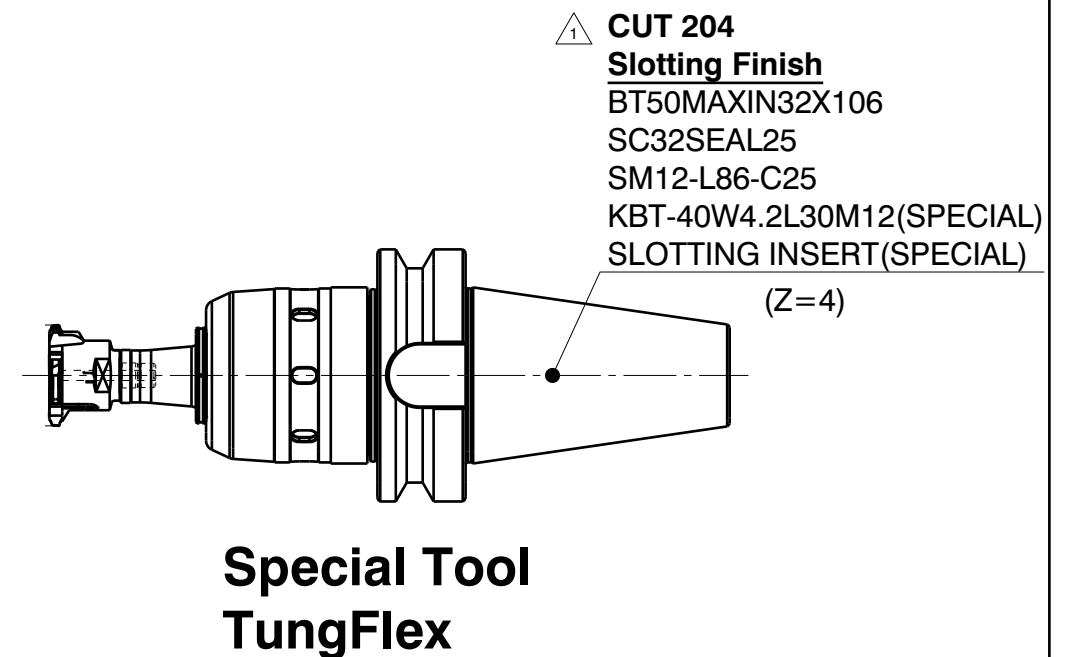
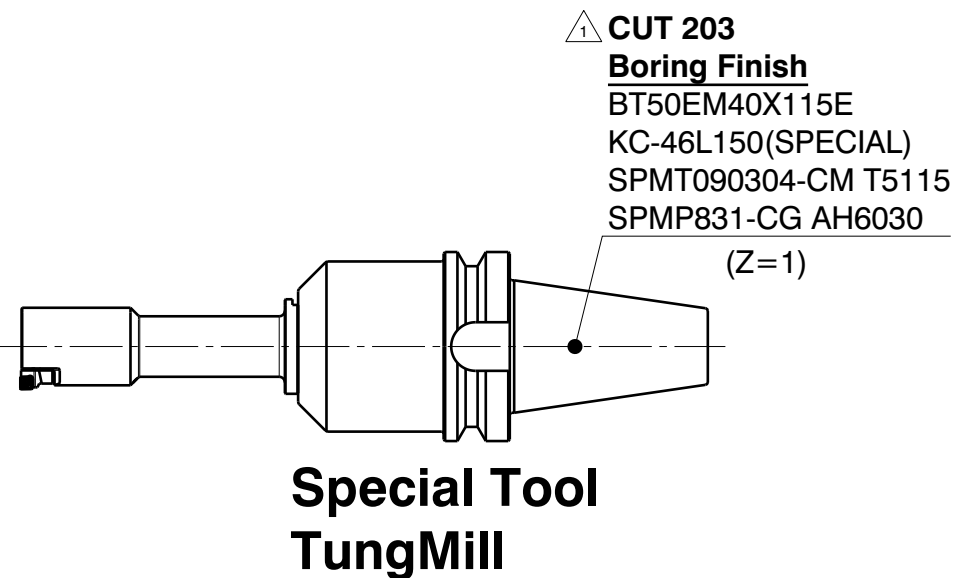
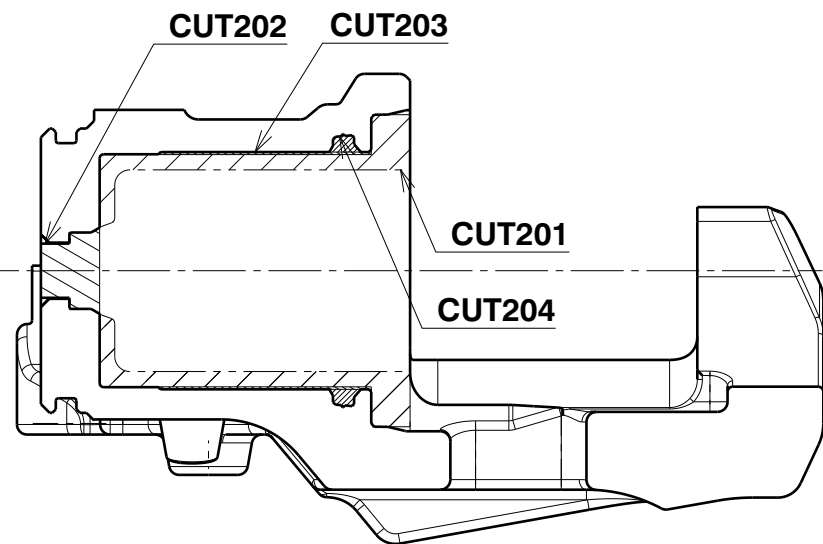
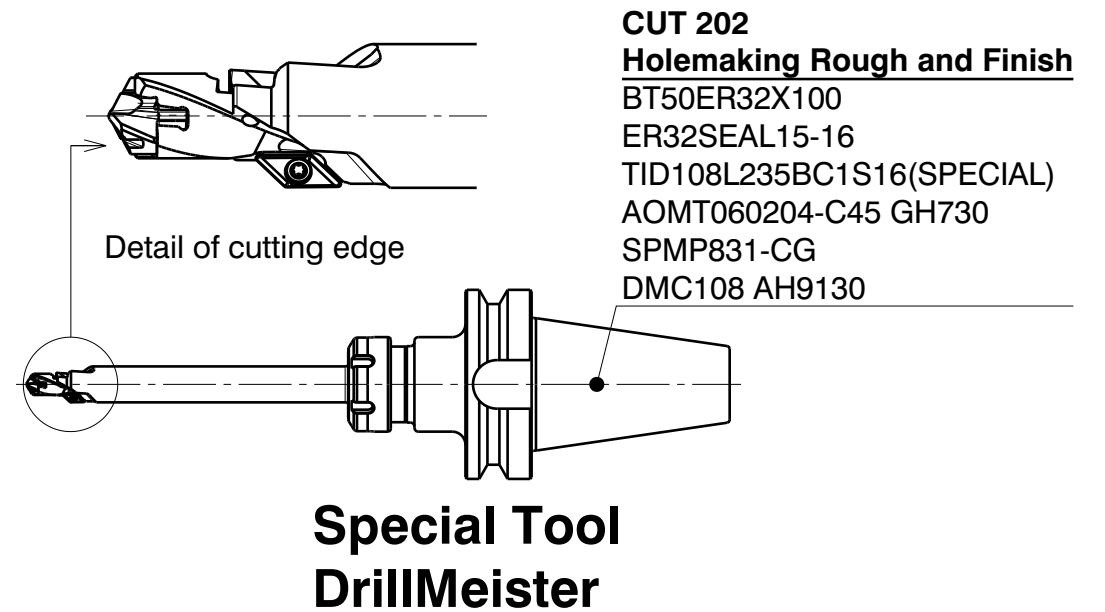
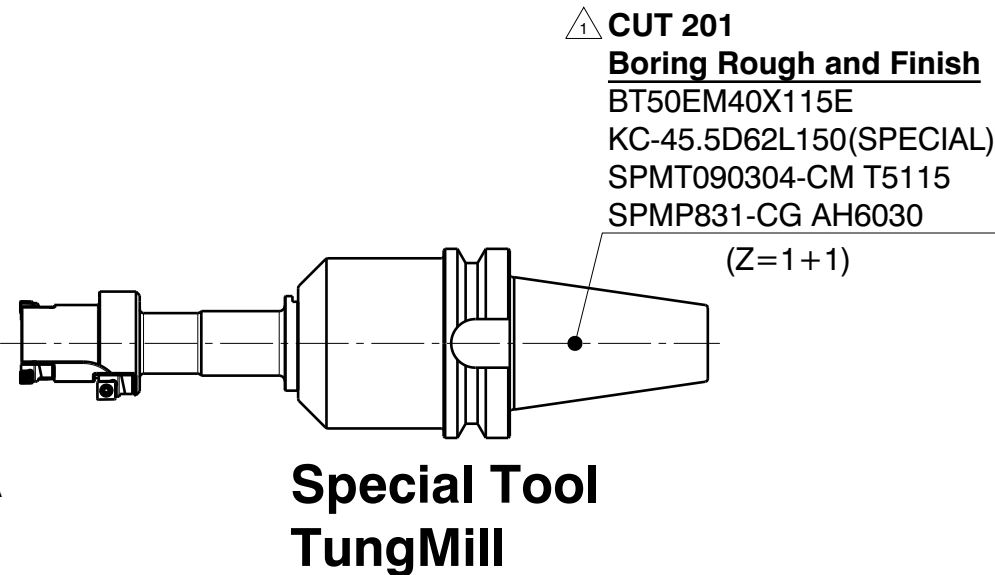
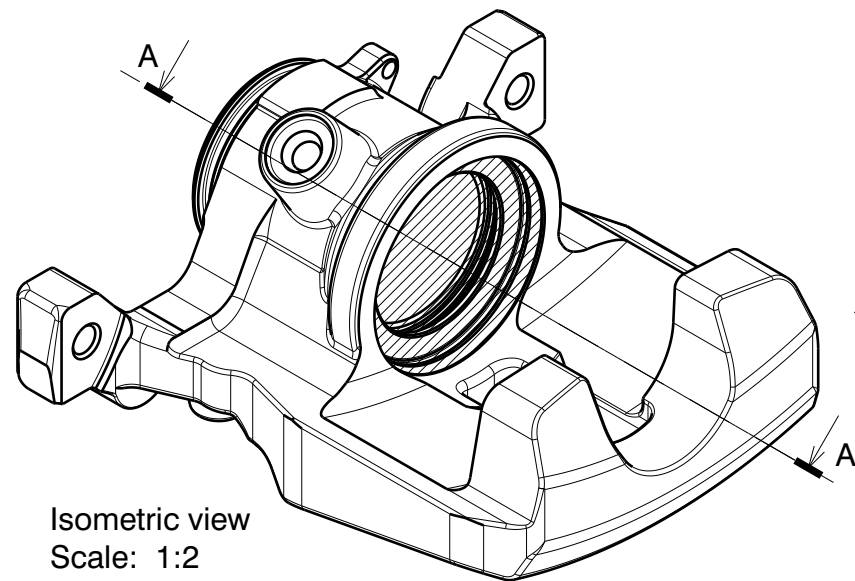


**Dopent**

**M/C: Slot, Face and Shoulder milling**

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation:		
Angles:	Check			LAYOUT-BRAKE CALIPER-62306		Page 1
	Appr.			Process	Layout.	Rev. No.
	Scale	--		Lead Drawing		Of 1
						Reg.No.
						62306/1
						A3L





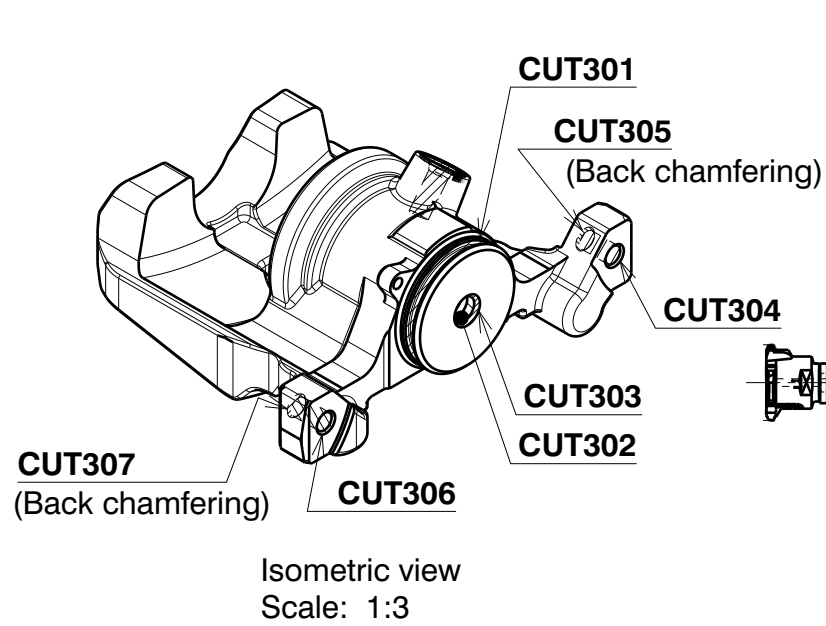
**M/C: Holemaking, Boring and Slotting**

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation:		
Angles:	Check			LAYOUT-BRAKE CALIPER-62306		Page 1 Of 1
	Appr.			Process	Layout.	Rev. No.
	Scale	--		Lead Drawing		1
						Reg.No. 62306/1
				FL-40032187		A3L

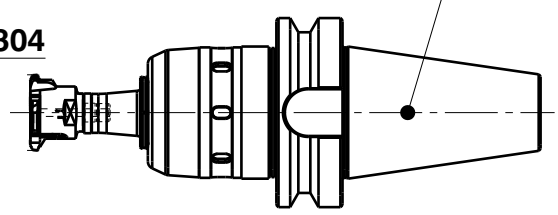


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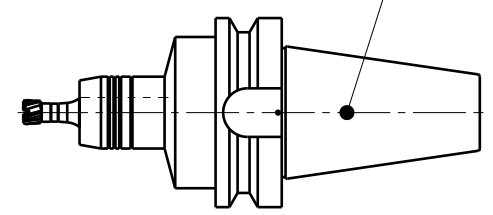


**CUT 301**  
**Slotting Finish**  
BT50MAXIN32X106  
SC32SEAL25  
SM12-L86-C25  
KBT-40W4.1L30M12(SPECIAL)  
SLOTING INSERT(SPECIAL)  
(Z=4)



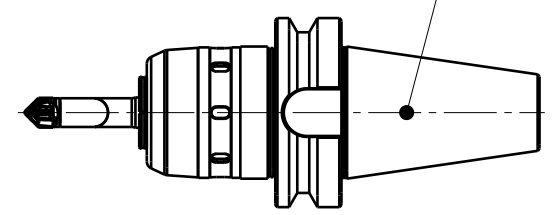
**Special Tool**  
**TungFlex**

**CUT 302**  
**Reaming Finish**  
BT50HYDRO16X110  
TRM-T5-R16-1.5  
HRM-12.700-BL-T5

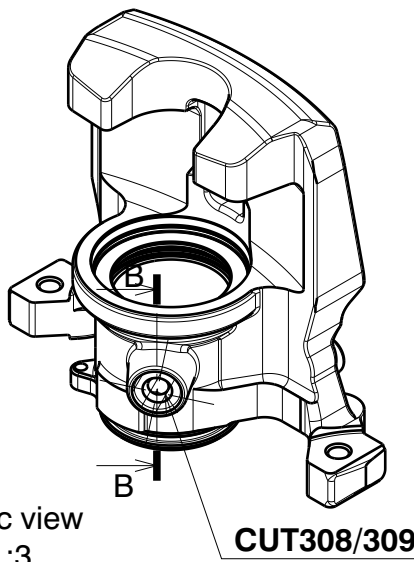


**ReamMeister**

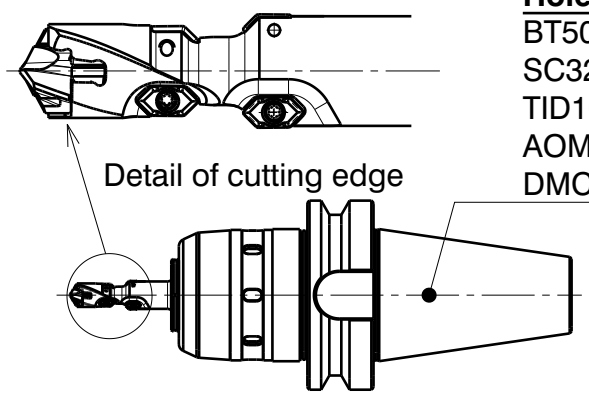
**CUT 303**  
**Chamfering Finish**  
BT50MAXIN32X106  
SC32SPR16  
VSSD16L090S10-C  
VCP160L15.0A45-02S10



**TungMeister**

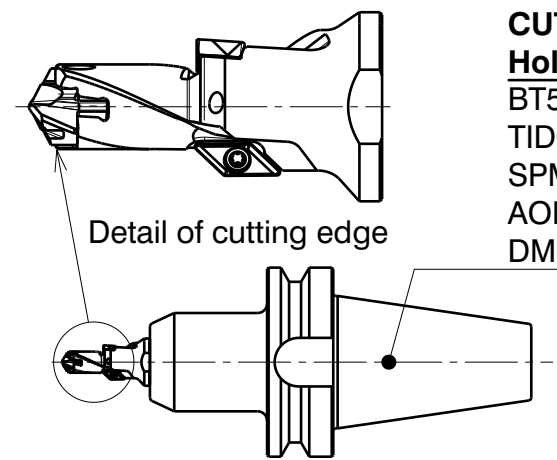


**CUT 304/305/306/307**  
**Holemaking and Backchamfering Finish**  
BT50MAXIN32X106  
SC32SEAL16  
TID100L18L50S16(SPECIAL)  
AOMT030204-N-45DT  
DMC100  
(Z=2)

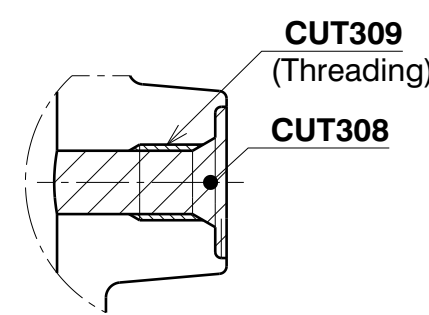


**Special Tool**  
**DrillMeister**

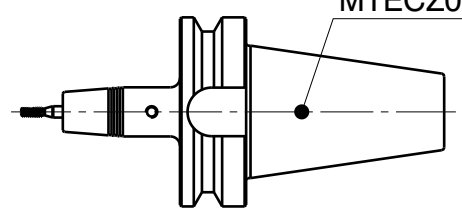
**CUT 308**  
**Holemaking Rough**  
BT50EM20X100  
TID080L23C1D20.0L45S20(SPECIAL)  
SPMP771-CG  
AOMT060204-C45  
DMC080  
(Z=1)



**Special Tool**  
**DrillMeister**  
**TungMill**



**CUT 309**  
**Threading Finish**  
BT50SRKIN6X100  
MTECZ06048C101.0ISO



**SolidThread**

**M/C: Reaming, Chamfering, Slotting**  
**Threading and Holemaking**

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation: LAYOUT-BRAKE CALIPER-62306		
Angles:	Check			Process	Layout.	Page 1 Of 1
	Appr.			Lead Drawing		Rev. No.
	Scale	--	--	-		Reg.No. 62306/1
				FL-40032187		A3L