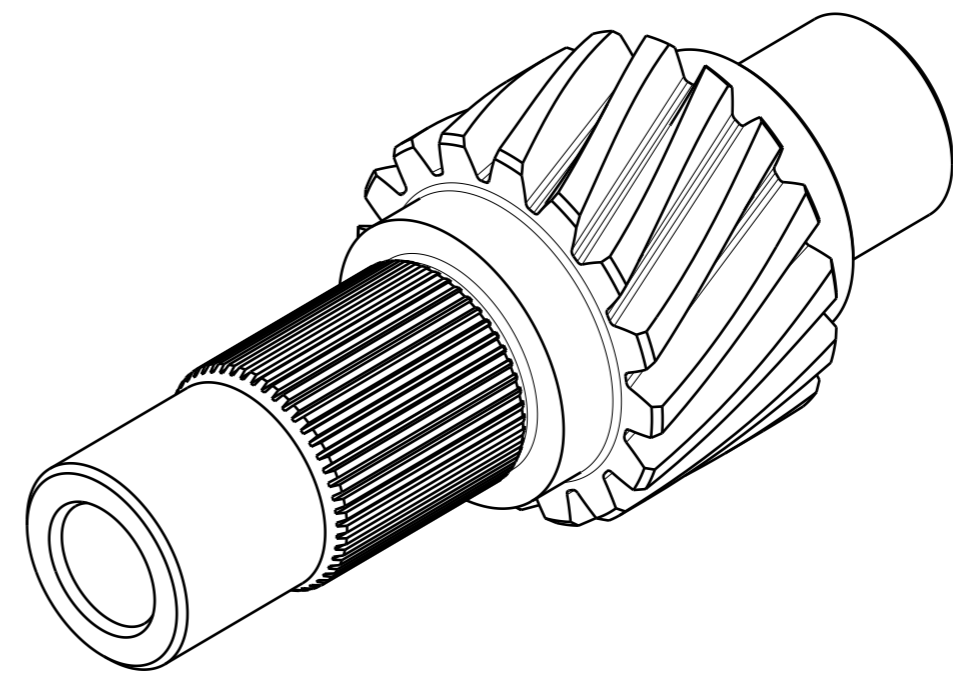
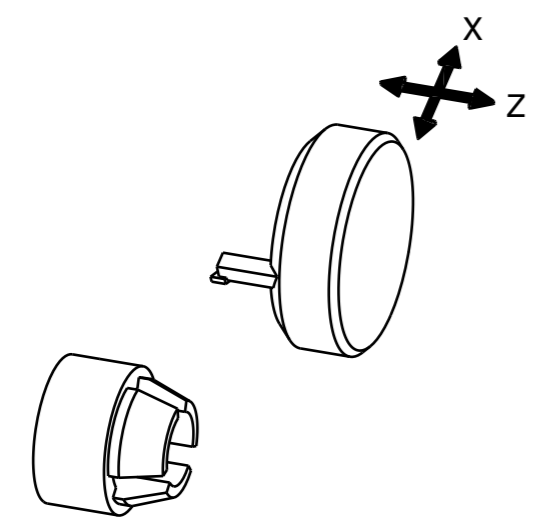
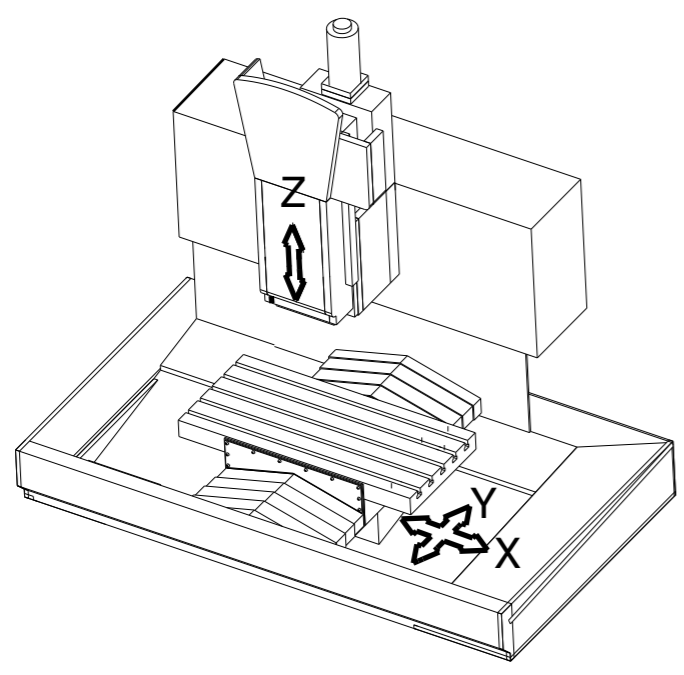


Machine : Horizontal Lathe  
Turret : □25X25,PSC40




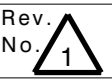

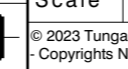
Isometric view  
 Scale: 1:1

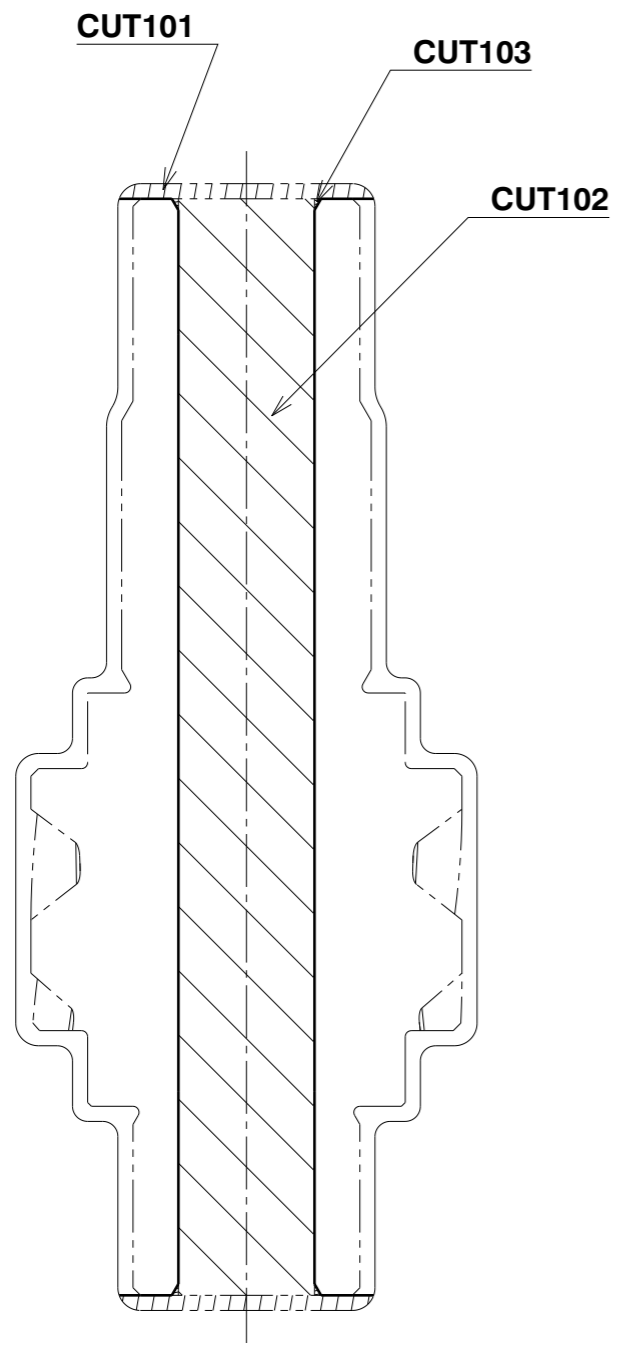
Machine : Vertical Machining Center  
Turret : BT30



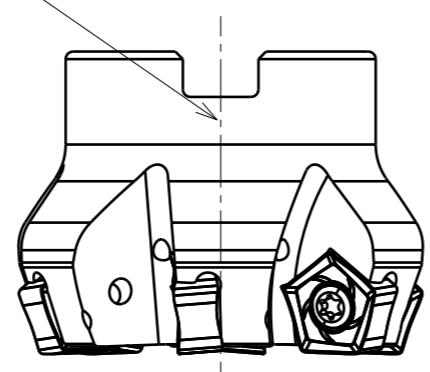
**WORK : DRIVE PINION**

**WORKPIECE MATERIAL : Chromium steel**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	 Dwg.No. 32457173-HCL
	Design		Designation: LAYOUT-DRIVE PINION-71876		
Dim.s:	Check		Process		Rev. No. 1
Angles:	Appr.		Layout.		 1
	Scale		Lead Drawing		
  © 2023 Tungaloy Corporation - Copyrights Notice			-		Reg.No.
			FL-40054535		71876/1
					A3L

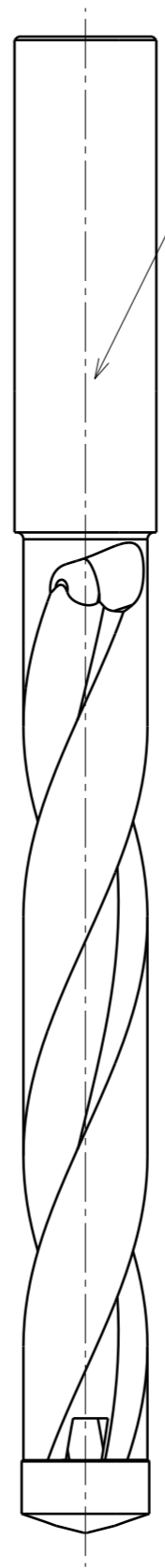


**CUT 101**  
**Face Milling Finish**  
 TEN09R050M22.0-06  
 PNMU0905GNEN-MJ AH3225



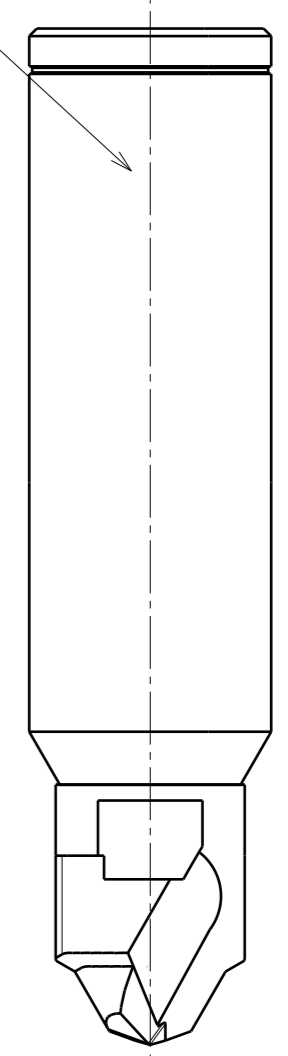
**DoPent**

**CUT 102**  
**Hole making Finish**  
 TID180R20-6  
 DMC180 AH9130



**DrillMeister**

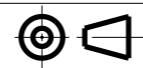
**CUT 103**  
**Hole making Finish**  
 VSSD32L100S15-S  
 VDP2000L10.0A60-02S15 (Special)



**TungMeister**

**M/C : Face Milling / Hole making**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
	Design		Designation: LAYOUT-DRIVE PINION-71876		
Dim.s:	Check		Process		Page 1
	Appr.		Layout.		Rev. No. 1
Angles:	Scale		Lead Drawing		Reg.No. 71876/1
			-		
			FL-40054535		A3L



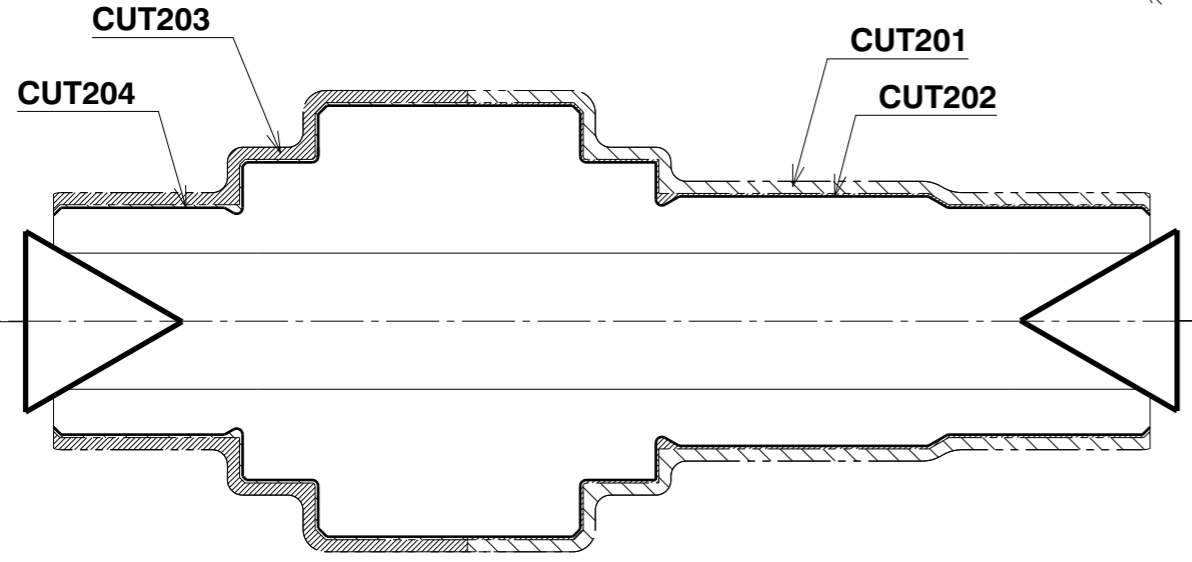
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MODEL IN SCALE 1:1 TOOLS IN SCALE 1:1

Back turning High feed  $\dashrightarrow$   
 Back turning  $\rightarrow$   
 Front turning  $\leftarrow$

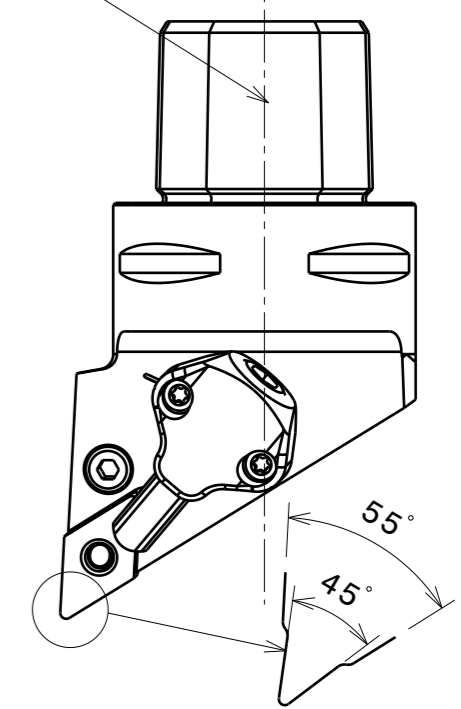
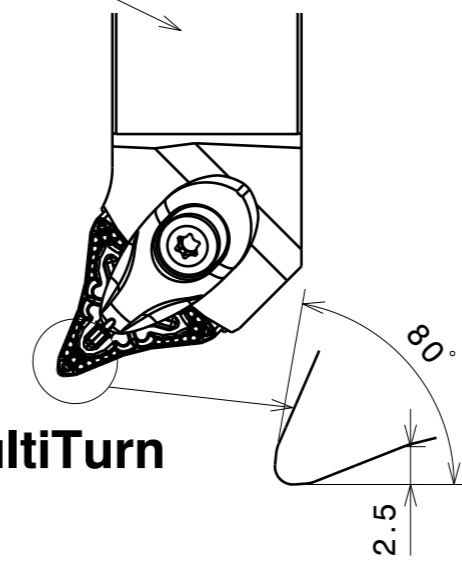
AddMultiTurn  
 ISO



**CUT 201/203**  
**OD Turning Rough**  
 ATXOL2525M25-A  
 6C-TOMG250612M-TM T9215

**CUT 202/204**  
**OD Turning Finish**  
 C4PDJNL27055-1104-CHP  
 FNMG110408E-TSF T9215

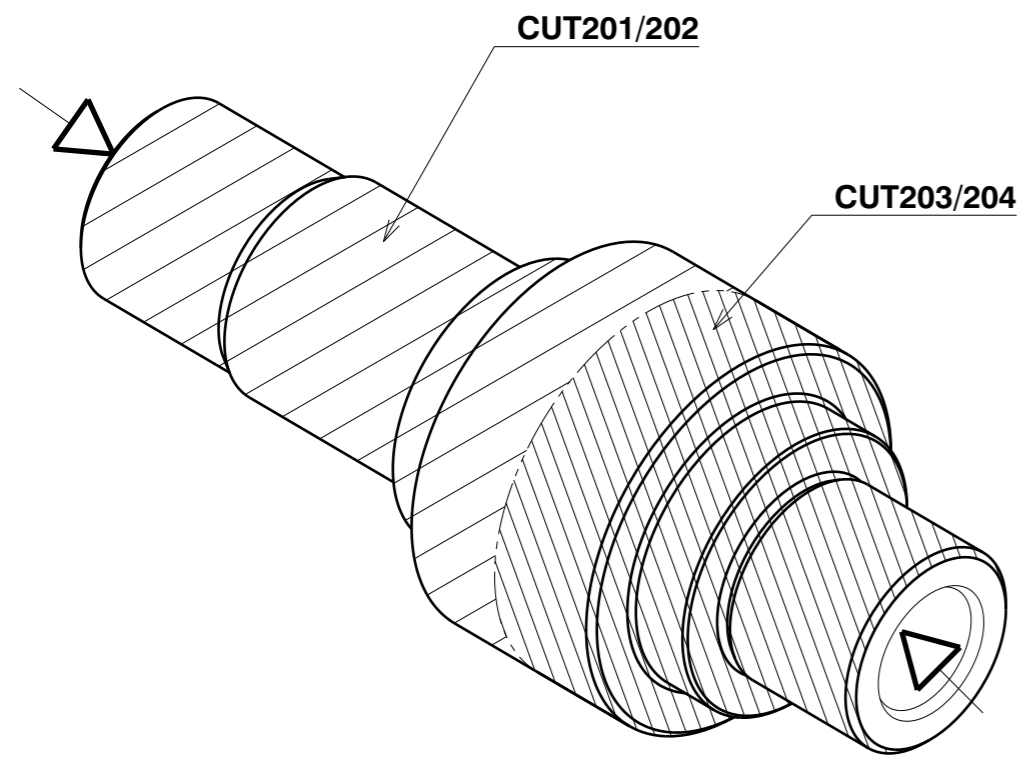
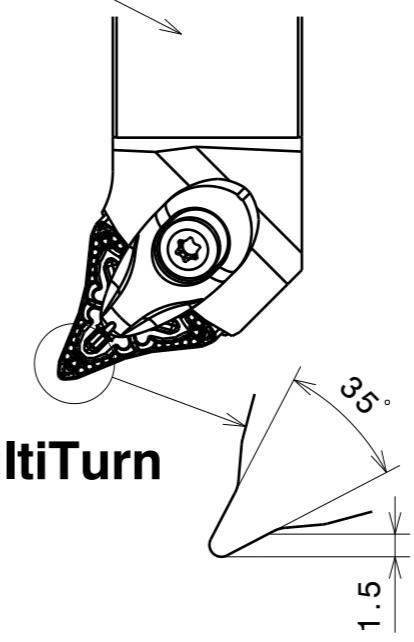
**AddMultiTurn**  
**T9200**



**CUT 202/204**  
**OD Turning Finish**  
 ATXOL2525M25-A  
 6V-TOMG250608F-TSF T9215

**Tungcap**  
**TungTurn-Jet**  
**ISO-EcoTurn**  
**T9200**

**AddMultiTurn**  
**T9200**



**Lathe : O.D.Turning**

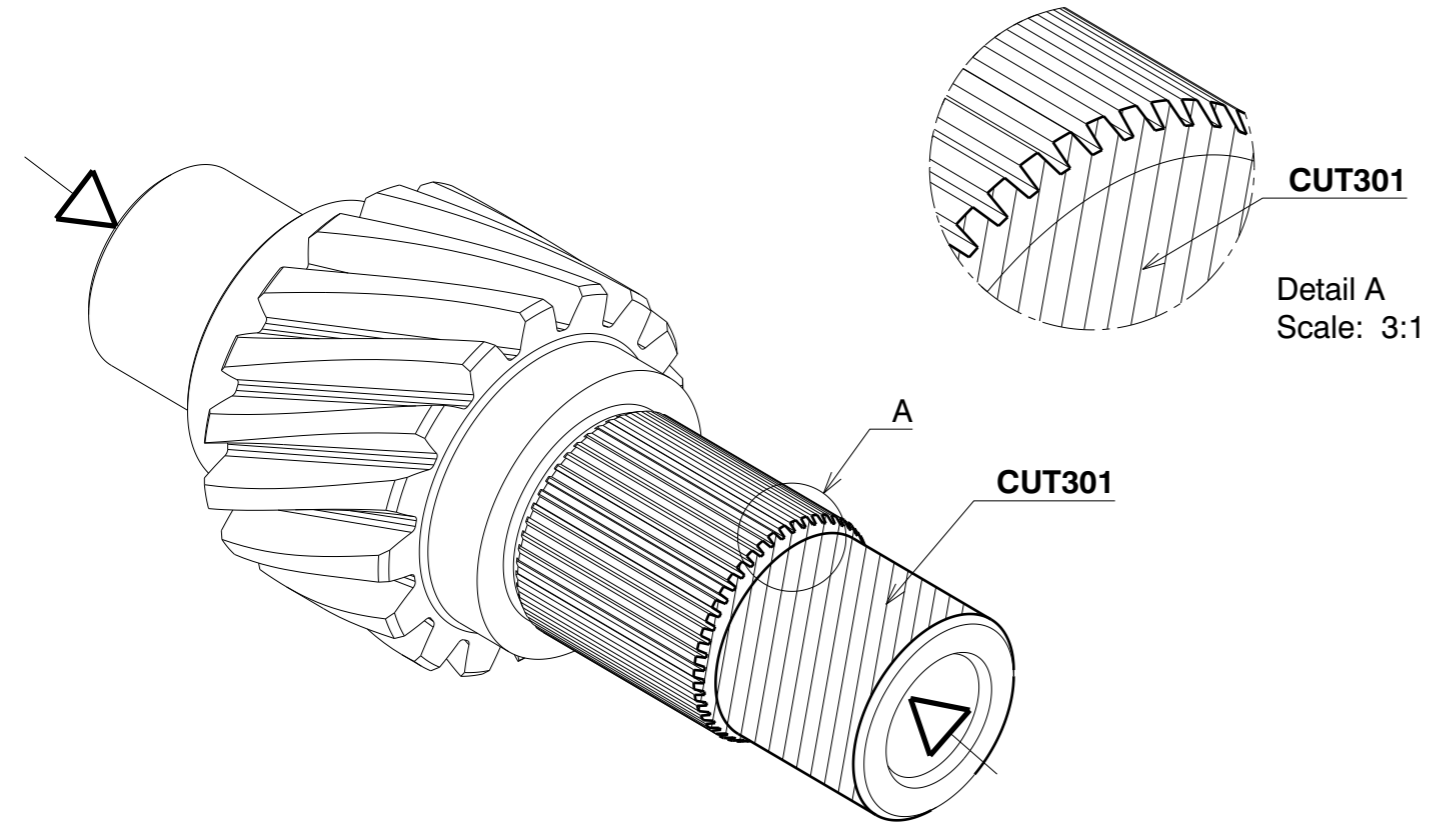
JAW	STOP	WORK REST	VACUUM CHUCK	TAILSTOCK CENTER	SPRING LOADED CENTER

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s:	Design		Designation: LAYOUT-DRIVE PINION-71876		
	Check		Process		Page 1 Rev. 1
Angles:	Appr.		Layout.		Of 1 No. 1
	Scale		Lead Drawing		Reg.No. 71876/1
			-		A3L
			FL-40054535		

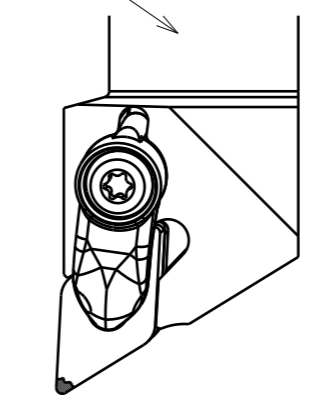
MODEL IN SCALE 1:1 TOOLS IN SCALE 1:1

Rev.No.: 1 Alteration: Change specifications

Date: 22/06/23 Name: sugana\_y

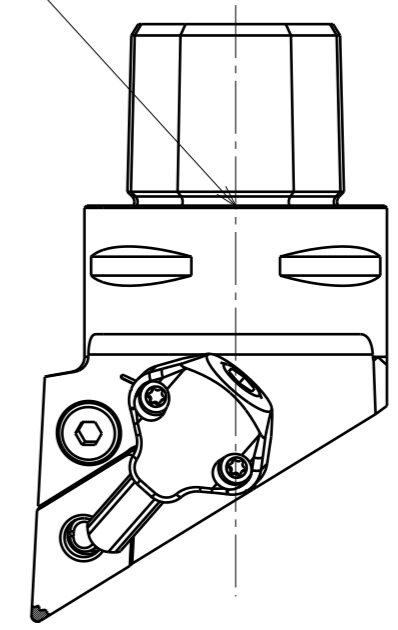


**CUT 301**  
**OD Turning Finish**  
 ADJNL2525X-15-CHP-MC  
 4QS-DNGG150408-HS BR35F

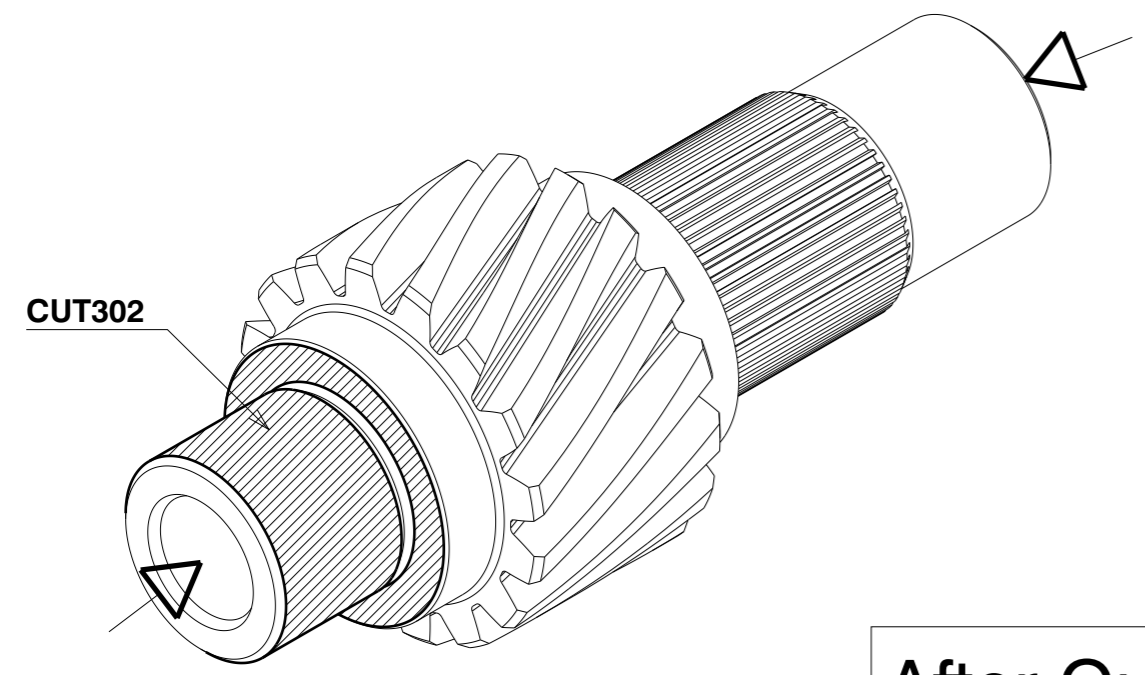


**TungTurn-Jet**  
**WavyJoint**  
**BR35F**

**CUT 301**  
**OD Turning Finish**  
 C4PDJNL27055-15-CHP  
 4QS-DNGG150408-HS BR35F

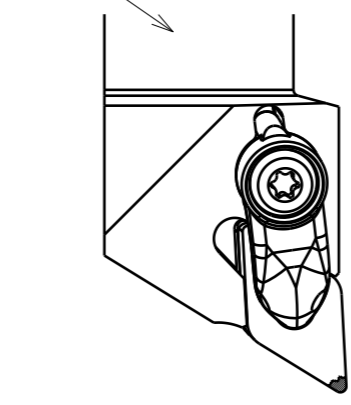


**Tungcap**  
**TungTurn-Jet**  
**WavyJoint**  
**BR35F**



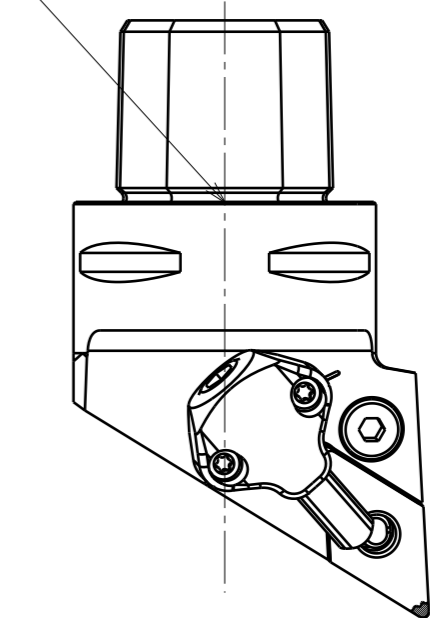
After Quenching

**CUT 302**  
**OD Turning Finish**  
 ADJNR2525X-15-CHP-MC  
 4QS-DNGG150408-HS BXA10



**TungTurn-Jet**  
**WavyJoint**  
**BXA10**

**CUT 302**  
**OD Turning Finish**  
 C4PDJNR27055-15-CHP  
 4QS-DNGG150408-HS BXA10



**Tungcap**  
**TungTurn-Jet**  
**WavyJoint**  
**BXA10**

**Lathe : O.D.Turning**

JAW	STOP	WORK REST	VACUUM CHUCK	TAILSTOCK CENTER	SPRING LOADED CENTER

Unspecified Tolerances	Draw	Customer: TUNGALOY	Japan	
Dim.s:	Design	Designation: LAYOUT-DRIVE PINION-71876		
Angles:	Check	Process		Page 1
	Appr.	Layout.		Rev. No. 1
	Scale	Lead Drawing		Reg.No. 71876/1
		-		A3L
		FL-40054535		