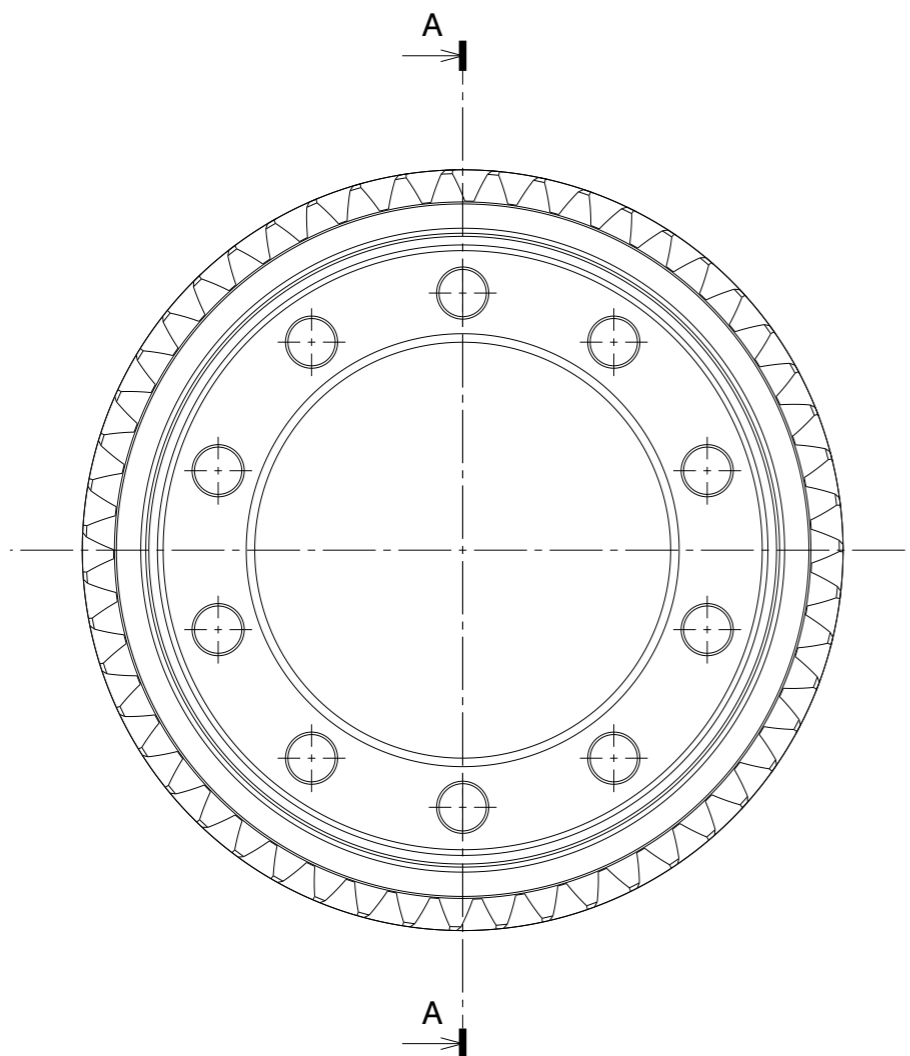
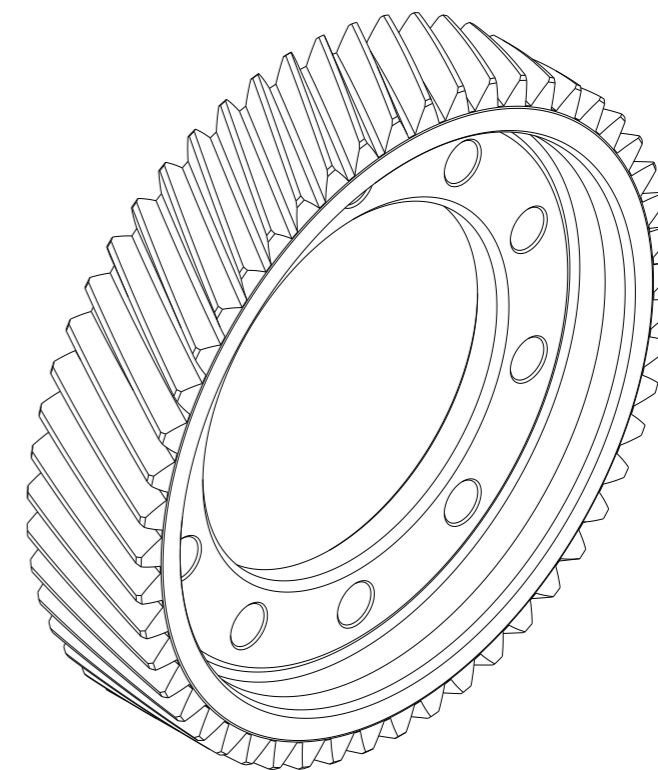


MODEL IN SCALE 1:2

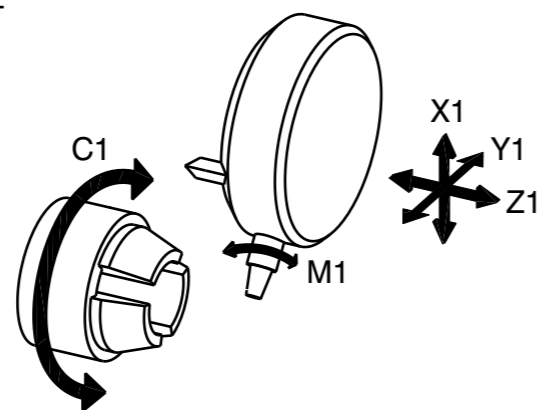


Section view A-A
Scale: 1:2



Isometric view
Scale: 1:2

MACHINE : CNC Turning Center
Turret : □25x25, PSC40

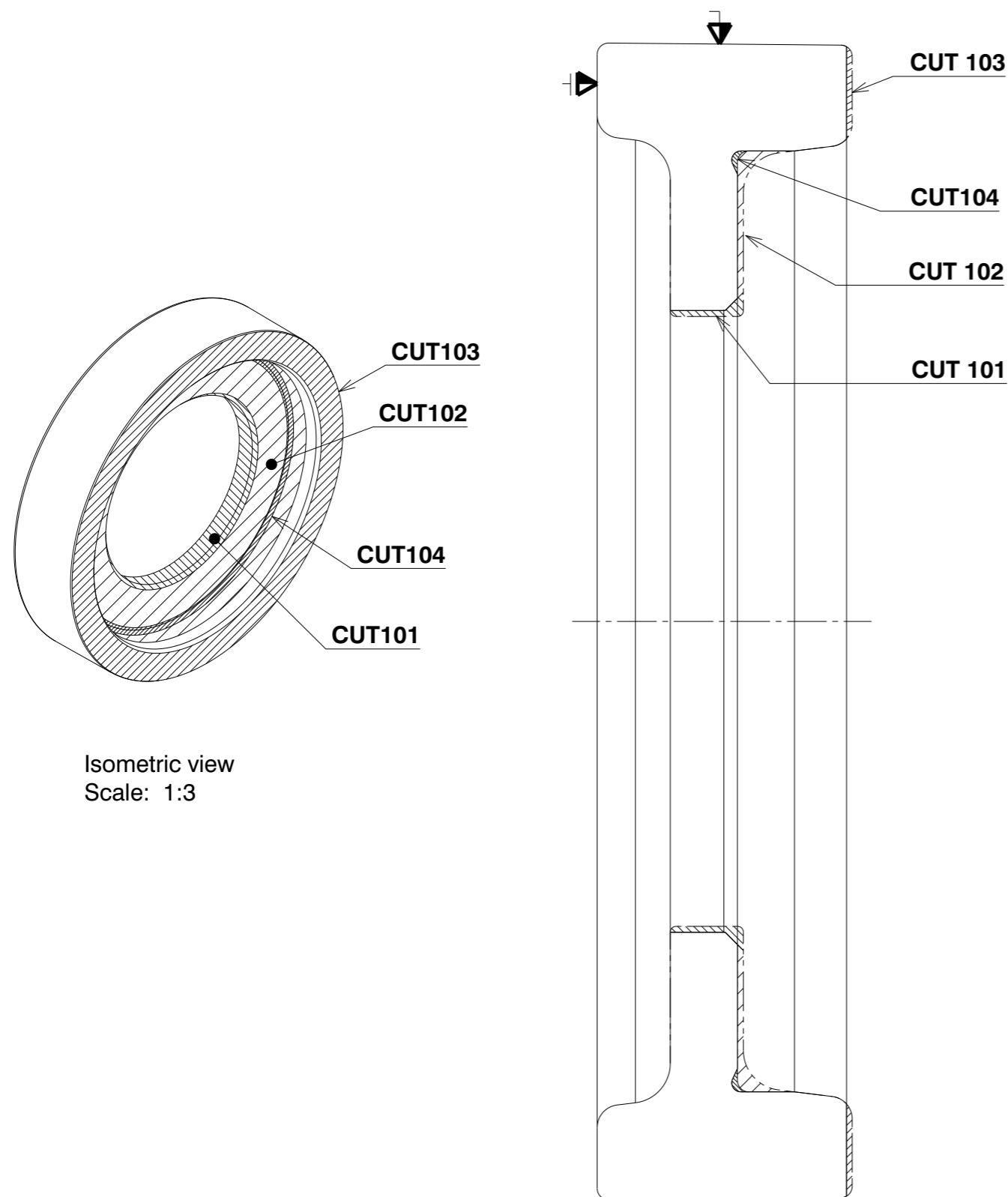


WORK : RING GEAR

WORKPIECE MATERIAL : Alloy Steel

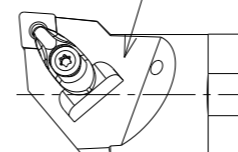
Unspecified Tolerances	Draw	-.	-.	Customer: TUNGALOY	Japan	
	Design			Designation:		
Dim.s:	Check			LAYOUT-RING GEAR-71874		Dwg.No. 32457155-HCL
	Appr.			Process	Layout.	Page 1 Of 1
Angles:	Scale	-.		Lead Drawing		Rev. No.
				-		Reg.No. 71874/1
	© 2023 Tungaloy Corporation Copyrights Notice			FL-40054489		A3L

MODEL IN SCALE 1:1, TOOLS IN SCALE 1:2



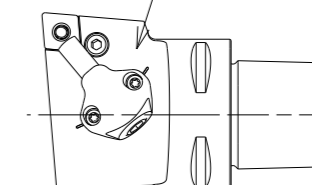
Isometric view
Scale: 1:3

CUT 101/102/103
ID turning, Face turning Finish
A32S-ACLNL0904-D400
CNMG090412E-ZM T9225



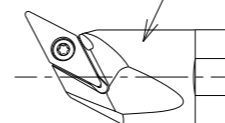
**ISO-EcoTurn
T9200**

CUT 101/102/103
ID turning, Face turning Finish
C4PCLNL27050-0904-CHP
CNMG090412E-ZM T9225



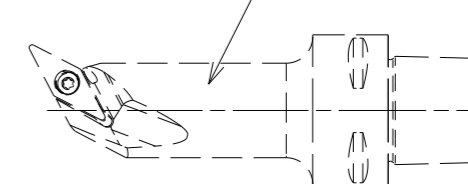
**TungCap
ISO-EcoTurn
T9200**

CUT 104
ID turning Finish
A25S-SVQBL16-D305
VBMT160408-PS T9215



**StreamJetBar
T9200**

CUT 104
ID turning Finish
C4SVQBR18095-16
VBMT160408-PS T9215



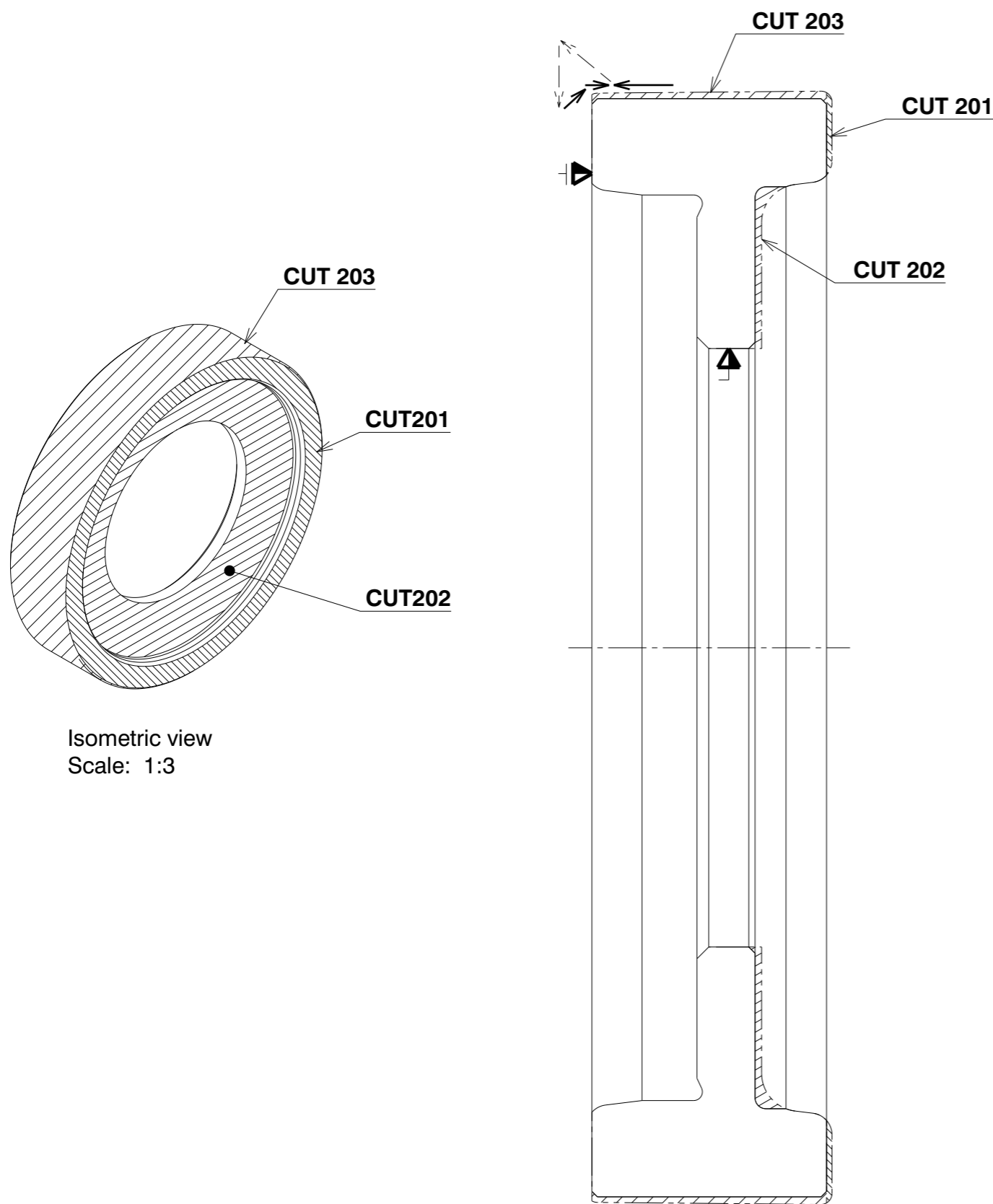
Back View

**TungCap
T9200**

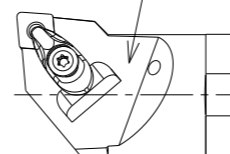
Lathe : I.D.turning, Face turning

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation:		
--	Check			LAYOUT-RING GEAR-71874		Page 1
Angles:	Appr.			Process	Layout.	Rev. No. 1
--	Scale	--		Concept		Reg.No. 71874/1
				--		A3L
				© 2023 Tungaloy Corporation Copyrights Notice	FL-40054489	

MODEL IN SCALE 1:1, TOOLS IN SCALE 1:2

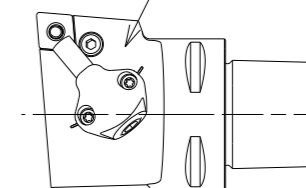


CUT 201/202
Face turning Finish
 A32S-ACLNL0904-D400
 CNMG090412E-ZM T9225



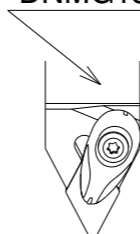
ISO-EcoTurn
T9200

CUT 201/202
Face turning Finish
 C4PCLNL27050-0904-CHP
 CNMG090412E-ZM T9225



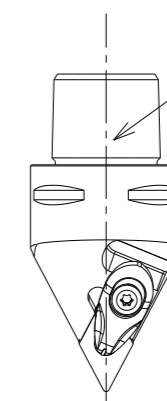
TungCap
ISO-EcoTurn
T9200

CUT 203
OD turning Finish
 ADPNN2525M15-A
 DNMG150412-TM T9215



Turnnig A
T9200

CUT 203
OD turning Finish
 C4ADNNN00060-15N (Special)
 DNMG150412-TM T9215

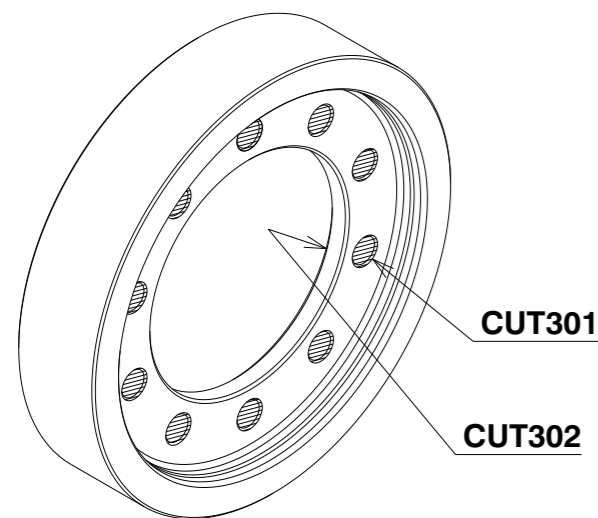


TungCap
T9200

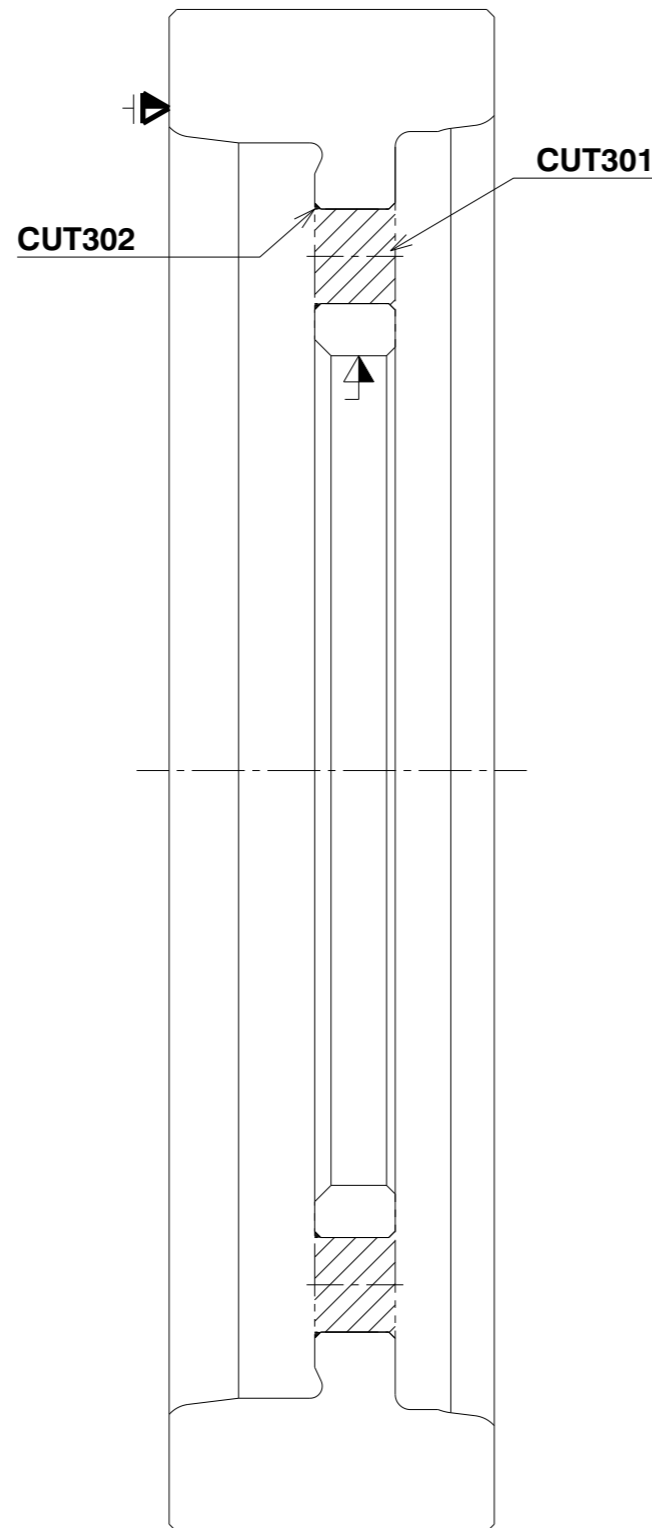
Lathe : Face turning, O.D turning

Unspecified Tolerances	Draw	.-	.-	Customer: TUNGALOY	Japan	
	Design			Designation: LAYOUT-RING GEAR-71874		
Dim.s:	.-	Check		Process		Page 1
	.-	Appr.		Concept	Layout.	Rev. No. 1
Angles:	.-	Scale	.-	.-		Reg.No. 71874/1
				FL-40054489		A3L

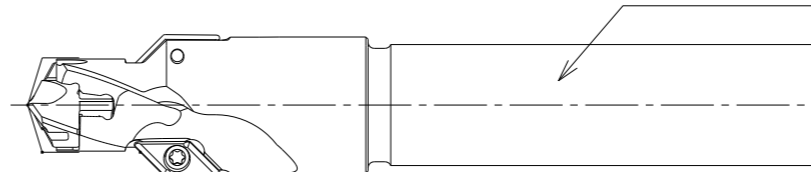
MODEL IN SCALE 1:1, TOOLS IN SCALE 1:1



Isometric view
Scale: 1:3

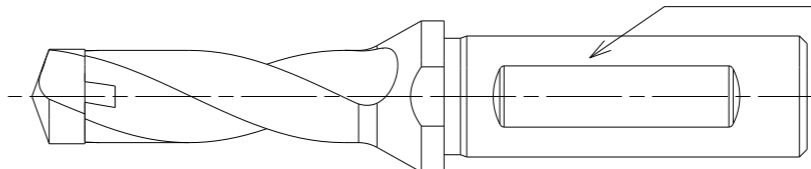


CUT 301
Hole making with chamfering
TID125L12L105R16 (Special)
DMP125 AH9130
AOMT060204-C45 GH730



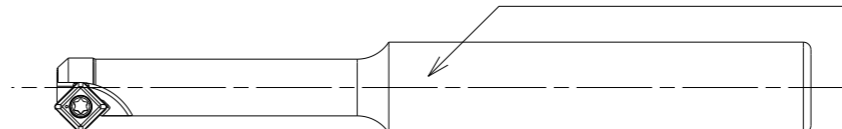
DrillMeister
AH9130

CUT 301
Hole making
TID125F16-3
DMP125 AH9130



DrillMeister
AH9130

CUT 302
Chamfering for back side (Contouring)
EASD05M006C12.0R01
SDMT050204PN-MJ AH725



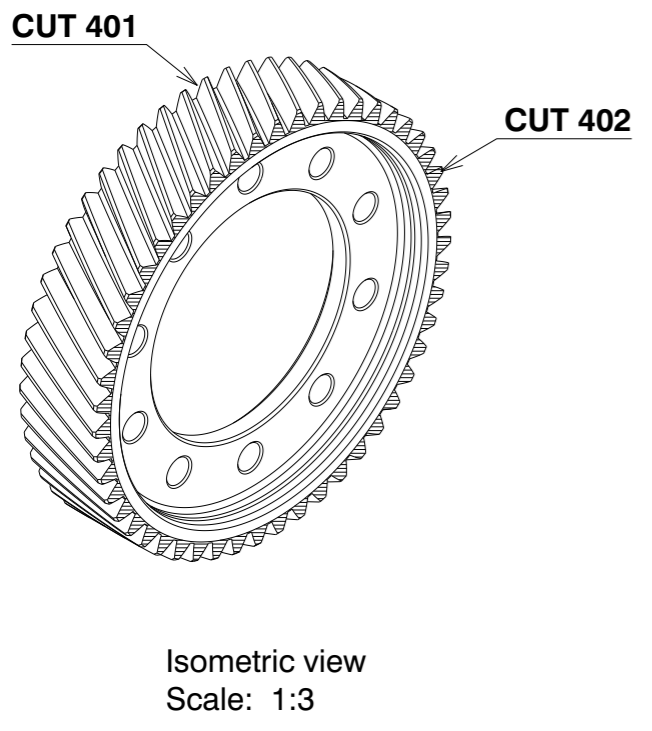
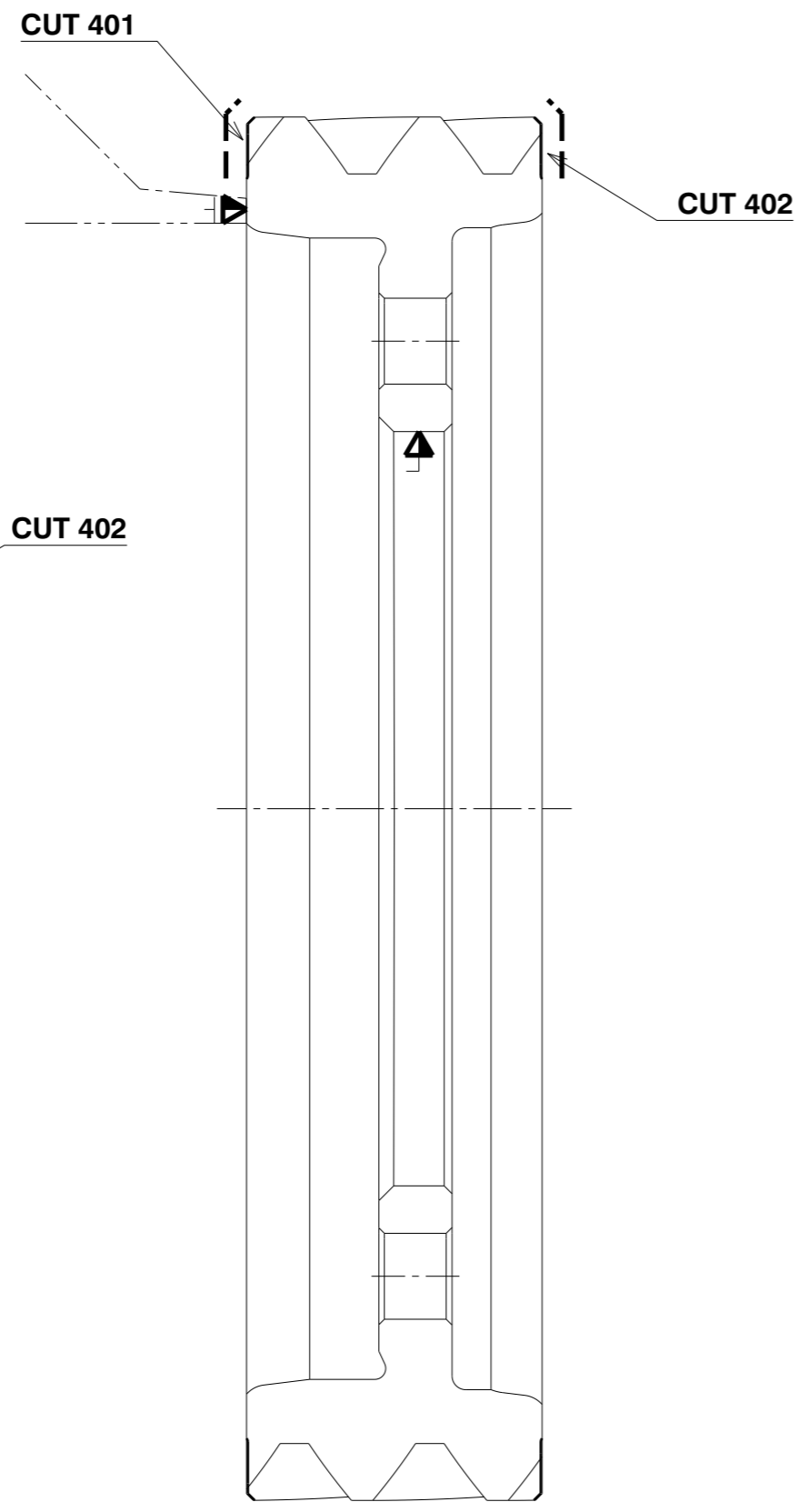
TungQuad
AH725

M/C : Hole making, Chamfering

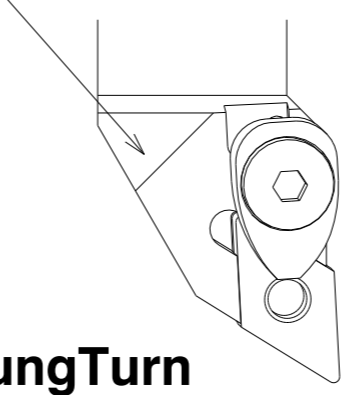
Unspecified Tolerances	Draw	-.	-.	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation:		
Angles:	Check			LAYOUT-RING GEAR-71874		Page 1 Of 1
	Appr.			Process	Layout.	Rev. No.
	Scale	-.		Concept		Reg.No.
						71874/1
						A3L



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

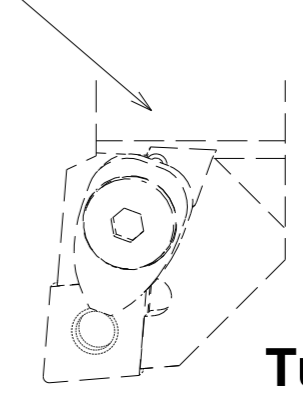


CUT 401
Face turning Finish
 DDJNR2525M15
 DNMG150408-TSF T9225



TungTurn
T9200

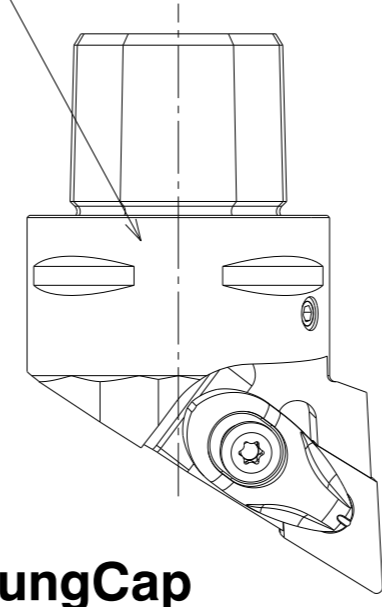
CUT 402
Face turning Finish
 DCLNR2525M12
 CNMG120408-TSF T9225



Back View

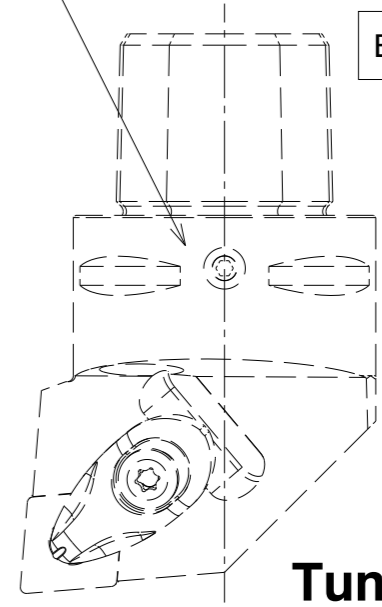
TungTurn
T9200

CUT 401
Face turning Finish
 C4ADJNR27050-15N
 DNMG150408-TSF T9225



TungCap
T9200

CUT 402
Face turning Finish
 C4ACLNR27050-12N
 CNMG120408-TSF T9225



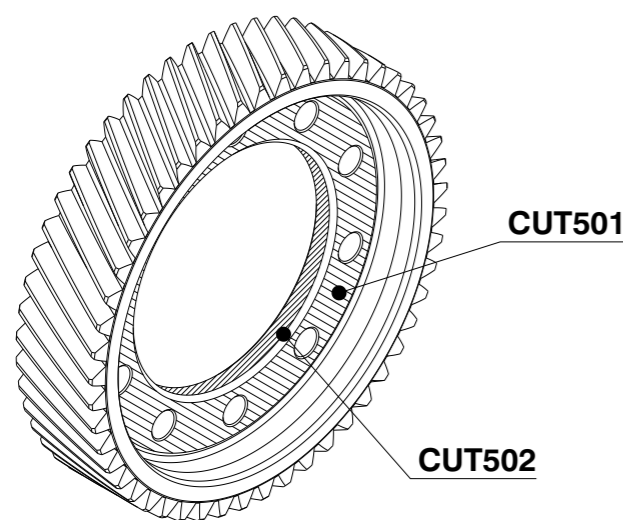
Back View

TungCap
T9200

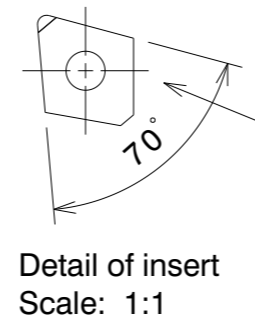
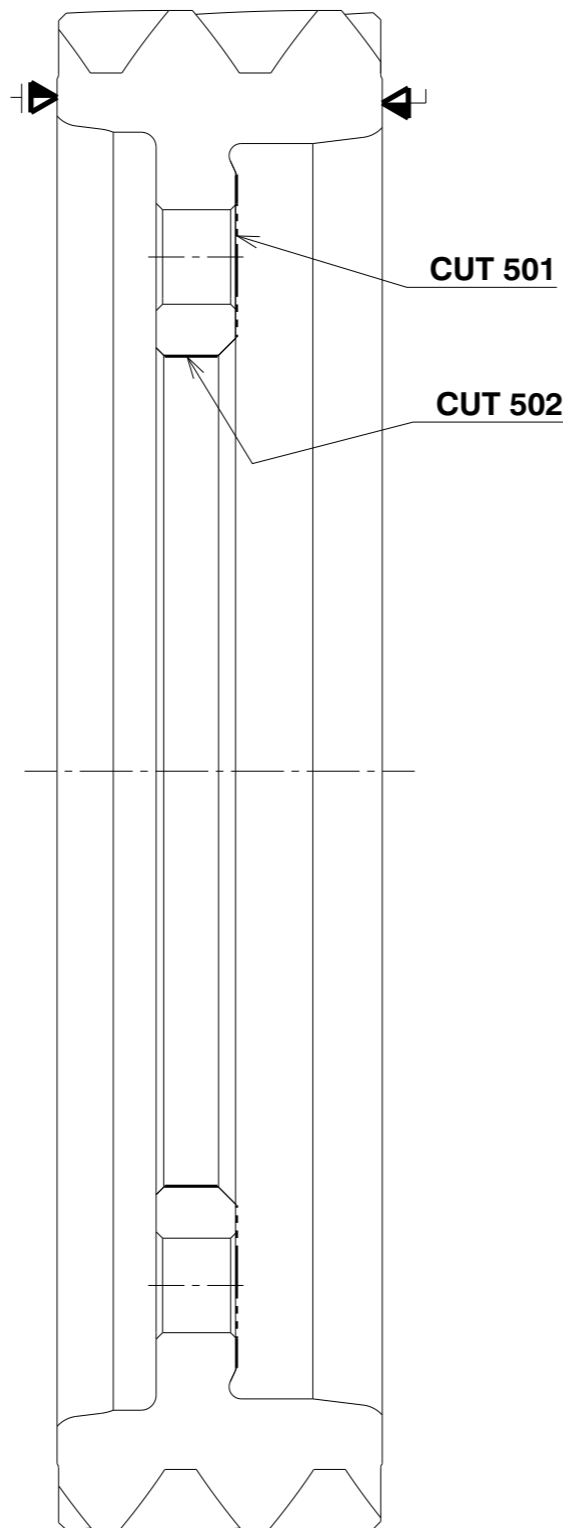
Lathe : Face turning (After gear milling)

Unspecified Tolerances	Draw	--	--	Customer: TUNGALOY	Japan	
	Design			Designation: LAYOUT-RING GEAR-71874		
Dim.s:	Check			Process		Page 1
	Appr.			Concept	Layout.	Rev. No. 1
Angles:	Scale	--	--	-		Reg. No. 71874/1
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MODEL IN SCALE 1:1, TOOLS IN SCALE 1:2



Isometric view
Scale: 1:3

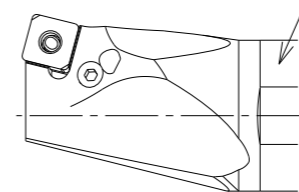


CUT 501
Face turning Finish
A40T-PCLNL12-D500
2QP-GNGA120412SR BR35F

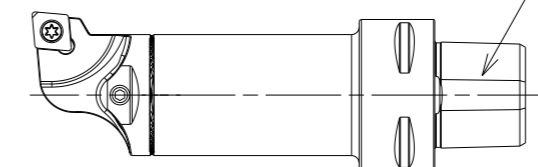
Insert option : 2QP-GNGG120412-HS BXA20
4QS-CNGA120412SR BR35F (Wavy joint)
4QS-CNGG120412-HS BR35F

StreamJetBar
BR35F

CUT 502
ID turning Finish
A40T-PSKNL12-D500
4QS-SNGA120412 BXA10



StreamJetBar
BXA10
WavyJoint



CUT 501
ID turning Finish
C4-SH-D32-2.5D-CHP
S32-SCLCL09-H
2QP-CCGW09T308SR BR35F

TungCap
BoreMeister
BR35F

Lathe : I.D turning, Face turning (After quenching)

Unspecified Tolerances	Draw	.-	.-	Customer: TUNGALOY	Japan	
Dim.s:	Design			Designation:		
Angles:	Check			LAYOUT-RING GEAR-71874		Page 1 Of 1
	Appr.			Process	Layout.	Rev. No.
	Scale	.-		Concept		1
						Reg.No.
						71874/1
						A3L



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