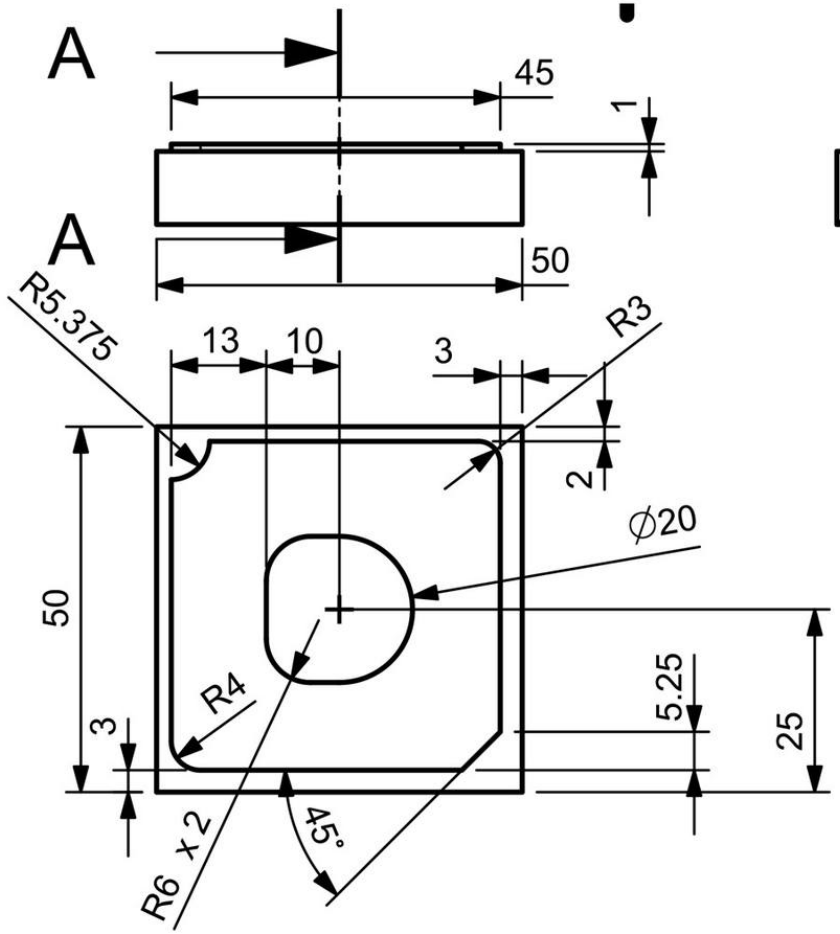
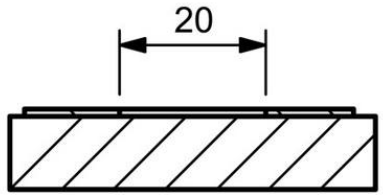
MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE

LENGTH OR DIA	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0

LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
±60'	±30'	±20'	±10'	8-25	1.6-8	0.025-1.6	<0.025





SECTION A-A

NOTE
DO NOT SCALE THE DRAWING .
ALL DIMENSIONS ARE IN MILLIMETERS .
REMOVE SHARP EDGES AND BURRS

http://www.facebook.com/afsalabba.in
http://www.youtube.com/c/afsalabbaabba

	TITLE :	
DRAWN BY :	TKMCE	
CHECKED BY :	MATERIAL : ALUMINUM	DRG.NO :
APPROVED BY:	SCALE : 1:1	QTY : 1

```
O12345
G28
T1 M06
G54 G40 G90 G21
M03 S1500
M08
G00 X-20 Y25
G00 Z10
G01 Z0 F100
M97 P10 L4
G00 Z10
G00 X25 Y25
G01 Z0 F100
M97 P20 L5
G00  Z10
G28
M09
M05
M30

N10
G91 G01 Z-0.25
G90 G01 G41 X2 Y25 F300 D01
G01  X2 Y42.625
G03  X7.375  Y48 R5.375
```

```
G01 X44 Y48
G02  X47 Y45 R3
G01 X47 Y8.25
G01 X41.75 Y3
G01 X6 Y3
G02  X2 Y7 R4
G01 X2 Y25
G01 G40 X-20 Y25
M99

N20
G91 G01 Z-0.2
G90 G01 G42 X15 Y25 F300 D01
G01 X15 Y29
G02 X21 Y35 R6
G01 X25 Y35
G02 X25 Y15 R10
G01 X21 Y15
G02 X15 Y21 R6
G01 X15 Y25
G01 G40 X25 Y25
M99
```