

इंटरनेट

मानक

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Mazdoor Kisan Shakti Sangathan

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Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6105 (1971): Feed Fingers [PGD 2: Machine Tool Elements and Holding Devices]



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Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Machine Tools, Machine Tool Elements and Wood-Working Machines Sectional Committee, EDC II [Ref: Doc: EDC II (1513)]

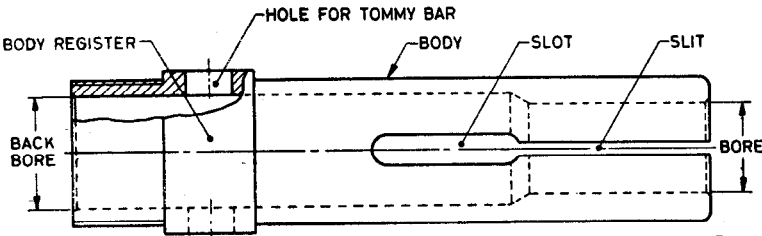


Indian Standard
SPECIFICATION FOR FEED FINGERS

1. Scope—Requirements for the following types of feed fingers:

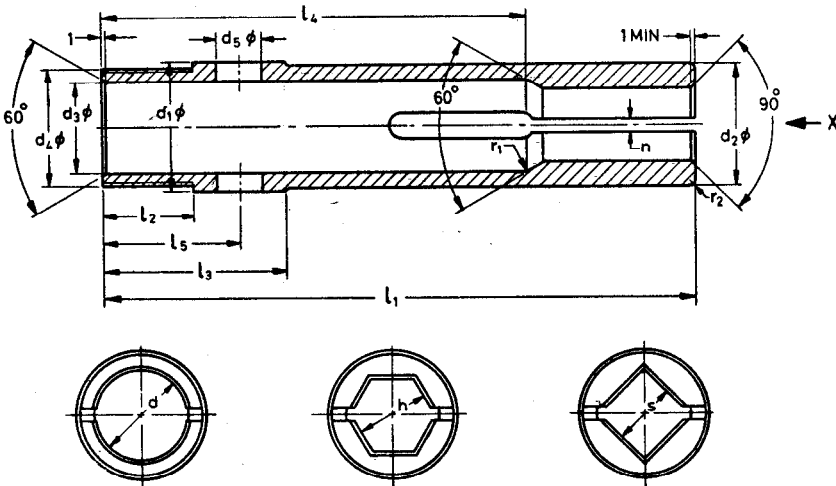
- Type A—Feed fingers of this type grip the rod within the spring collet. This arrangement permits the greatest possible utilization of rods, but does not permit the utilization of the total clamping capacity of the collets capable of being built into the automatic lathes.
- Type B—To permit the total clamping capacity of the spring collets to be used, certain sizes of automatic lathes are fitted with a complementary attachment for outside feed. The feed fingers required for this purpose are specified in this standard as Type B.

2. Terminology—The various terms of a typical type of feed finger are illustrated in figure below.



3. Dimensions

3.1 Feed Fingers for Inside Feed, Type A



VIEW X

All dimensions in millimetres.

d_1 h11	Capacity Max			d_2	d_3 H11	d_4	d_5	l_1	l_2	l_3	l_4	l_5	n	r_1	r_2
	d^* H11	h^* H11	s^* H11												
14	10	8	7	13.5	10.2	M 13 × 1 LH	5	64	10	20	46	15	1.6	3	0.5
18	12	10	8	16	12.5	M 16 × 1 LH	5	70	10	20	48	15	1.6	3	1
24	18	16	13	22	18.5	M 22 × 1 LH	5	85	10	26	56	18	2	3	1.5
30	24	20	17	29	24.5	M 28 × 1 LH	5	95	12	26	58	19	2	4	2
42	36	30	25	40.5	36.5	M 40 × 1 LH	6	116	12	30	70	21	2.5	4	2
60	52	45	36	58	53	M 58 × 1 LH	8	140	14	42	84	28	2.5	5	2

*The tolerance zones indicated are prior to slitting at n .

- Note 1 — Details of slots, etc, are left to the manufacturer who shall guarantee the performance with reasonable life.
- Note 2 — The figure is indicative of dimensions only and do not specify design features.
- Note 3 — Dimensional deviation for untoleranced dimensions—Medium grade according to IS:2102-1969
- * Allowable deviations for dimensions without specified tolerances (first revision) '.

Adopted 19 May 1971

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Revised Price

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NEW DELHI 1

Rs. 5-00

Gr 1

3.1.1 Designation—A feed finger for inside feed for round material having a shank diameter of 60 mm and bore diameter of 30 mm shall be designated as:

Feed Finger A 60 × 30 IS: 6105

Note — Symbols *d* for round, *h* for hexagon and *s* for square shall be used for designating the different form of bores.

3.1.2 Finish—Bore and head constituting the gripping area —60 ± 2 HRC. Back register, body and threaded portion —42 ± 3 HRC.

3.2 Feed Fingers for Outside Feed, Type B

