MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315–1000	1000–2000	2000–4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3

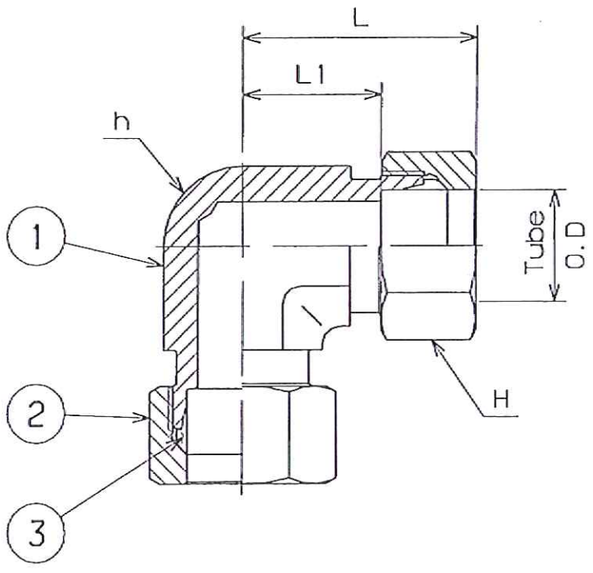
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD–227

UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT–1) (MEDIUM)

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

QUALITY OF WELD JOINTS REF, RD–230 MEDIUM

PROTO / ~~PILOT~~ / ~~PRODUCTION~~



PART NO.	TUBE O.D (mm)	WIDTH ACROSS FLAT		L	L1
		H	h		
909–60190	22	36	27	44	27.5

RESEARCH & DEVELOPMENT

CONTROLLED DOCUMENT

COPY No. 3 **CUSTODIAN** **M/s. Techsol Engineers,Bengaluru**

PO No. **BR01/RRD/ 4660001959/0** **Date: 09.03.2017**

NOTE

THE STRENGTH AND NO AIR LEAKAGE SHALL BE GUARANTEED UNDER THE CONDITION OF NO. 1 AND 2.

1. TEMPERATURE RANGE : –40 – +80°C
2. OPERATING PRESSURE : MAX. 80 BAR
3. END FITTING SHALL BE OF FLARELESS DOUBLE COMPRESSION TYPE & CONFIRM TO SPECIFICATION: DIN2353 (ISO8434–1)

– SHALL BE APPLIED FOR DIMENSIONS NOT SPECIFIED AT DRAWING

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg.
		DETAIL PARTS			MATERIAL	
3	2	909–60711	SLEEVE		SUS316	
2	2		NUT		SUS316	
1	1		BODY		SUS316	

ALT	CHANGES / ECN No.	DATE	BY	CKD	APP
1	ECN No.90900481 NOTE 3 ADDED	07.08.2015	SK	SM	MS

PRODUCT DMRC 8 CAR

SURFACE TREATMENT

APPROVED

CHECKED

DRAWN

REF DRG EE01830–402

QTY	NEXT ASSY	MODEL

SCALE NTS | SHEET 1 of 1 | Wt (Kg)

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE
UNION ELBOW

DRG No.
909–60190

ALT 1

A3

GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												

SURFACE ROUGHNESS