| 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 |

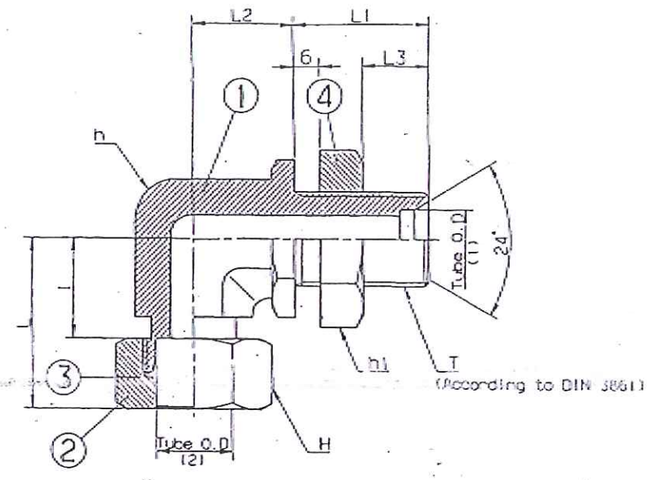
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD–227

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~~




UNCONTROLLED COPY

| PART NO. | Tube O.D (1) | Tube O.D (2) | H | h | h1 | L | I | L1 | L2 | L3 | T | WEIGHT(Kg) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 909–60727 | 15 | 18 | 32 | 24 | 30 | 40 | 23.5 | 38 | 23 | 25 | M22x1.5P | 0.26 |

SPECIFICATION

1. PRESSURE RANGES: O.D 8mm – O.D 15mm
   Max. 315 Bar (4.567 psi)
2. ALLOWABLE WORKING TEMPERATURES
   *FITTING MATERIAL: –60 °C UPTO +400 °C (DIN 17440)
   *SEAL MATERIAL: –35 °C UPTO +100 °C
3. UNIT: mm
4. END FITTING SHALL BE OF FLARELESS DOUBLE COMPRESSION TYPE

| SL No. | QTY | DRG. / STOCK No. | DESCRIPTION | SIZE | COMPANY.STD/IS.STD | Wt.Kg. |
|---|---|---|---|---|---|---|
| | | DETAIL PARTS | | | MATERIAL | |
| 4 | 1 | | LOCK NUT | | SUS316 | |
| 3 | 1 | 909–60710 | SLEEVE | | SUS316 | |
| 2 | 1 | | NUT | | SUS316 | |
| 1 | 1 | | BODY | | SUS316 | |

| ALT | CHANGES / ECN No. | DATE | BY | CKD | APP |
|---|---|---|---|---|---|
| 1 | ECN No.90900490 NOTE 4 ADDED | 07.08.2015 | SK | SM | MS |

| | | |
|---|---|---|
| PRODUCT | DMRC 8 CAR | |
| SURFACE TREATMENT | | |
| APPROVED | AB | |
| CHECKED | MS | |
| DRAWN | ALCH Rajkumar | |
| REF DRG | EF01225–401 | |
| SCALE | NTS | SHEET 1 of 1 |
| Wt (Kg) | | |
| QTY | NEXT ASSY | MODEL |

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: HOSE BULKHEAD ELBOW

DRG No. 909–60727

ALT 1

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

A3