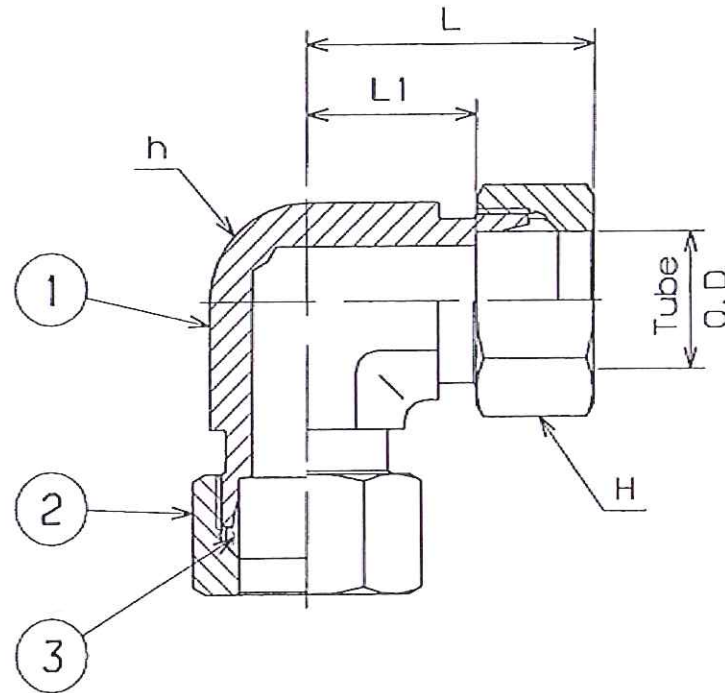


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.						PROTO / PILOT / PRODUCTION			
QUALITY OF WELD JOINTS REF, RD-230 MEDIUM									



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

3. END FITTING SHALL BE OF FLARELESS DOUBLE COMPRESSION TYPE
& CONFIRM TO SPECIFICATION: DIN2353 (ISO8434-1)

3	2	909-60710	SLEEVE		SUS316	
2	2		NUT		SUS316	
1	1		BODY		SUS316	
SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD	Wt.Kg.
			DETAIL PARTS	MATERIAL		
			PRODUCT DMRC 8 CAR			
					SURFACE TREATMENT	
					APPROVED	Start Changes
					CHECKED	S. S. Suresh
					DRAWN	S. S. Suresh
1	ECN No.90900481 NOTE 3 ADDED	07.08.2015	SK <i>SK</i>	SM <i>SM</i>	MS <i>MS</i>	REF DRG EE01830-401
ALT	CHANGES / ECN No.	DATE	BY	CKD	APP	QTY
						NEXT ASSY
						MODEL
			TITLE			DRG No.
			UNION ELBOW			909-60189
						ALT
						1

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