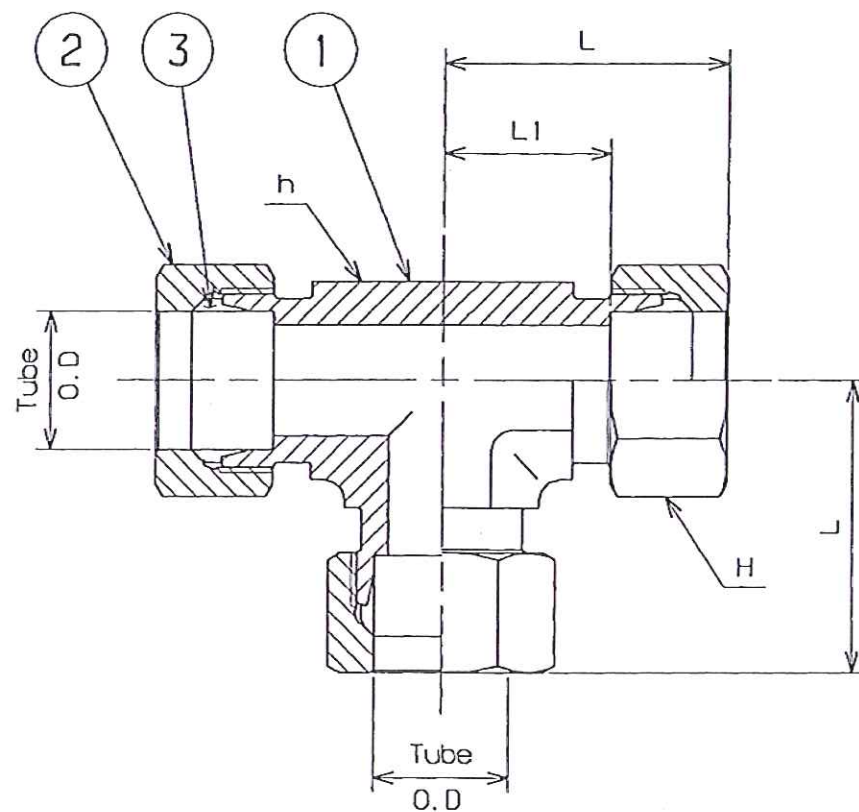


| GRADE No.         | N12 | N11 | N10  | N9  | N8  | N7  | N6  | N5  | N4  | N3  | N2   | N1    |
|-------------------|-----|-----|------|-----|-----|-----|-----|-----|-----|-----|------|-------|
| VALUE             | 50  | 25  | 12.5 | 6.3 | 3.2 | 1.6 | 0.8 | 0.4 | 0.2 | 0.1 | 0.05 | 0.025 |
| SYMBOL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



#### 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

| MACHINING DEVIATIONS<br>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  |           |       |        |          |           |                            |           |           |            |

| PART NO.  | TUBE O.D (mm) | WIDTH ACROSS FLAT |    | L  | L1   |
|-----------|---------------|-------------------|----|----|------|
|           |               | H                 | h  |    |      |
| 909-60192 | 18            | 32                | 24 | 40 | 23.5 |

**UNCONTROLLED COPY**

| 3                             | 3                               | 909-60710        | SLEEVE      |      | SUS316             |        |
|-------------------------------|---------------------------------|------------------|-------------|------|--------------------|--------|
| 2                             | 3                               |                  | NUT         |      | SUS316             |        |
| 1                             | 1                               |                  | BODY        |      | SUS316             |        |
| SL No.                        | QTY                             | DRG. / STOCK No. | DESCRIPTION | SIZE | COMPANY STD/IS STD | Wt.Kg. |
| DETAIL PARTS                  |                                 |                  |             |      |                    |        |
| PRODUCT DMRC 8 CAR            |                                 |                  |             |      |                    |        |
| SURFACE TREATMENT             |                                 |                  |             |      |                    |        |
| APPROVED <i>Ant. Rangaiah</i> |                                 |                  |             |      |                    |        |
| CHECKED <i>R. S. Rangaiah</i> |                                 |                  |             |      |                    |        |
| DRAWN <i>W. S. Rangaiah</i>   |                                 |                  |             |      |                    |        |
| REF DRG EE01831-401           |                                 |                  |             |      |                    |        |
| SCALE NTS                     |                                 |                  |             |      |                    |        |
| SHEET 1 of 1                  |                                 |                  |             |      |                    |        |
| Wt (Kg)                       |                                 |                  |             |      |                    |        |
| ALT                           | CHANGES / ECN No.               | DATE             | BY          | CHKD | APP                | QTY    |
| 1                             | ECN No.90900482<br>NOTE 3 ADDED | 07.08.2015       | SK          | SM   | MS                 |        |
| TITLE UNION TEE               |                                 |                  |             |      |                    |        |
| DRG No. 909-60193             |                                 |                  |             |      |                    |        |
| ALT 1                         |                                 |                  |             |      |                    |        |

**BEML LIMITED**  
R&D, BANGALORE COMPLEX  
BANGALORE 560 075