

NOTES:-

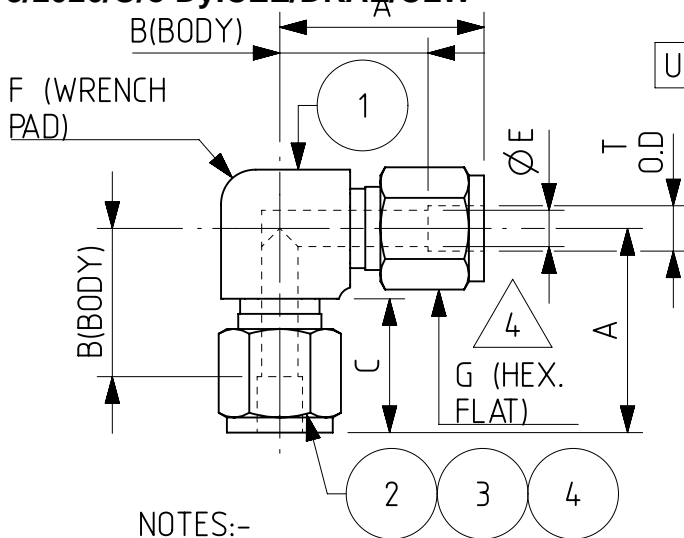
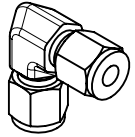
1. REMOVE ALL BURRS & SHARP EDGES.
2. BODY & BACKNUT ARE TO BE ZINC PLATED (10 μ)/PASSIVATED.
- 3.
4. ALL DIMENSIONS ARE IN mm EXCEPT OTHERWISE STATED.
5. DIMENSIONS A, Ax, C ARE TYPICAL FINGER TIGHT.
6. GENERAL TOLERANCES ON DIMENSIONS:
(a) BELOW 25 mm $^{+0.5}_{-0}$, (b) ABOVE 25 mm $^{+1.0}_{-0}$ EXCEPT 'T'
7. ISO 71 & ISO 228/1 FOR TAPER & PARALLEL THREADS RESPECTIVELY.
8. TEE'S ARE TO BE MACHINED FROM FORGED BLANK AND NOT TO BE CAST.
9. THIS FITTING IS TO BE SWAGED ON S.S TUBES (GR.304) OF HARDNESS 90 HRB MAXM..
10. ALL THE PARTS OF THE FITTING SHOULD BE CONCENTRIC AND BE CAPABLE OF SELF-ALIGNMENT WHEN ASSEMBLED WITH PROPER SIZE TUBING.
11. NUTS & FERRULES OF A PARTICULAR SIZE SHALL BE INTERCHANGABLE FOR EACH TYPE.

F	G	E	C	Hx	H	Ax	A	T	SL. No.
WRENCH PAD		MIM. OPENING						TUBE O.D.	
17	19	7.9	19.5	23.9	47.8	31.5	63	10	1
25	25	11.9	22	28.7	57.4	38.8	77.6	15	2
32.5	32	18.3	22	32.5	69.1	44.6	88.3	22	3

4		FERRULE (FRONT)	3	S.S.	GR.316	
3		FERRULE (BACK)	3	S.S.	GR.316	
2		BACK NUT	3	CARBON STEEL	ASTM A108	
1		BODY	1	CARBON STEEL	ASTM A108	
निर्देश संख्या	लागत एवं वितरण संख्या	अंग आरेखण संख्या	वर्णन	मात्रा	पदार्थ	विशिष्टि
REF. NO.	C&D NO.	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN

4	AME/D&D	VIEW MODIFIED, PREVIOUS TABLE NOTE 3 DELETED, NEW TABLE NOTE 4-11 ADDED	20-08-01	अधिकृत		
3	AME/D&D	NOTE 3 AND CLASS OF LOCO WAFS ADDED.	19-04-99	DGN		
2	AME/D&D	ITEM AT SL. NO. 3 ADDED.	12/4/1999	जॉचा व.अ.	SUBHAN KAR KUMBHA KAR	Digitally signed by Subhan Kar Kumbha Kar Date: 2021.01.15 13:08:12 +05'30'
1	AME/D&D	PASSIVATED ADDED.	19-08-98	CHD SSE		
परिवर्तन संख्या	प्राधिकार	वर्णन	दिनांकित बाधक	समीक्षित स.वि.अ. / व.वि.अ.	पदार्थ	प्रति भार कि. ग्रा.
ALT.NO.	AUTHY	DESCRIPTION	DATED INITIAL	REVIEWED AEE / SEE	MATL	WT. EACH IN KG
सतह - रूखाता का मान मा. मा. 3073 / अ. मा. सं. 1302	अतिरिक्त सद्य - सीमा मा. मा. : 2102 / अ. मा. सं. : 2768	TOL. CLS.	अनुमोदित स.यु.वि.अ.	SYAMA PRASAD PATRA	विशिष्टि	
SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302	धातु-वेल्डन चिन्ह मा. मा. : 813 / अ. मा. सं. : 2553	WELDING SYMBOLS TO IS:813 / ISO:2553	APPROVED DYCEE	Digitally signed by SYAMA PRASAD PATRA Date: 2021.09.15 13:39:56 +05'30'	SPECN	
पदांक	सं1	सं2	सं3	सं4	सं5	सं6
GRADE NO.	N1	N2	N3	N4	N5	N6
Rz	0.16-0.3	0.5-0.7	0.9-1.1	1.5-2.0	2.5-3.8	5.0-6.3
Ra μ m	0.025	0.05	0.1	0.2	0.4	0.8
चिन्ह						
SYMBOL						
दिनांक	05-10-20	वर्णन	DESCRIPTION	आरेखण संख्या	1209-18.406-014	
SCALE	N.T.S.	DRAWING NO.		परिवर्तन संख्या	4	पृष्ठ 1 OF 1
संदर्भ / REF.	182-00465	ALT. - 1		ALTERATION. NO.		A4

USED FOR LOCO.	WAG9, WAP5
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SL. NO.	T TUBE O.D.	A	B	C	E MIN. OPENING	G HEX. FLAT	F WRENCH PAD
1	6	27	19.6	17.7	4.8	14	1/2"
2	10	31.5	23.9	19.5	7.9	19	11/16"
3	15	38.8	27.9	22	11.9	25	15/16"
4	22	44.6	34.5	22	18.3	32	1 3/8"

1. REMOVE ALL BURRS & SHARP EDGES.

2. BODY & BACKNUTS ARE TO BE ZINC PLATED (10 μ)/PASSIVATED.

3.

4. ALL DIMENSIONS ARE IN mm EXCEPT OTHERWISE STATED.

5. GENERAL TOLERANCES:

(a) BELOW 25 mm: $\begin{matrix} +0.5 \\ -0 \end{matrix}$ (b) ABOVE 25 mm: $\begin{matrix} +1.0 \\ -0 \end{matrix}$ EXCEPT 'T'

6. DIMENSIONS A, C ARE TYPICAL FINGER TIGHT.

7. ELBOWS ARE TO BE MACHINED FROM FORGED BLANK AND NOT TO BE CAST.





8. ISO 7/1 & ISO 228/1 FOR TAPER & PARALLEL THREADS RESPECTIVELY.

9. THIS FITTING IS TO BE SWAGED ON S.S. TUBES (Gr.304) OF HARDNESS
90 HRB MAX.

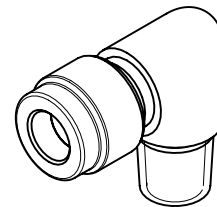
10. ALL THE PARTS OF THE FITTING SHALL BE CONCENTRIC AND BE CAPABLE OF SELF-ALIGNMENT WHEN ASSEMBLED WITH PROPER SIZE TUBING.

11. NUTS & FERRULES OF A PARTICULAR SIZE SHALL BE INTERCHANGABLE FOR EACH TYPE

4			FERRULE (FRONT)	2	ST. ST.	GR. 316	
3			FERRULE (BACK)	2	ST. ST.	GR. 316	
2			BLACK NUT	2	CARBON STEEL	ASTM A108	
1			BODY	1	CARBON STEEL	ASTM A108	
निर्देश संख्या	लागत एवं वितरण संख्या	अंग आरेखण संख्या	वर्णन	मात्रा	पदार्थ	विशिष्टि	प्रति भार कि. ग्रा.
REF. NO.	C&D NO.	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN	WT. EACH IN K.G.

4	AME/D&D	PREVIOUS VIEW & TABLE NOTE 3 DELETED. NEW VIEW & TABLE NOTES 4 TO 11 ADDED	20-08-01		<div>चित्तरंजन रेलइंजन कारखाना</div> <div>CHITTARANJAN LOCOMOTIVE WORKS, INDIA</div>													
3	AME/D&D	NOTE 3 AND CLASS OF LOCO WAP5 ADDED.	19-04-99				<div>पदार्थ</div> <div>MATL</div> <div>प्रति भार कि. ग्रा.</div> <div>WT. EACH IN KG</div>											
2	AME/D&D	ITEM AT SL. NO 4 ADDED	12-04-99															
1	AME/D&D	PASSIVATED ADDED.	19-08-98															
परिवर्तन संख्या ALT.NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित बाह्यर DATED INITIAL	समीक्षित स.वि.अ. / व.वि.अ. REVIEWED AEE / SEE	पदार्थ MATL	प्रति भार कि. ग्रा. WT. EACH IN KG												
सतह - रूखाता का मान मा. मा. 3073 / अ. मा. सं. 1302 SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302	अनिर्दिष्ट सन्न - सीमा मा. मा. : 2102 / अ. मा. सं. : 2768 UNSPECIFIED TOLERANCE TO IS : 2102 / ISO : 2768		TOL. CLS.	अनुमोदित उमु.वि.अ. APPROVED DYCEE	विशिष्ट SPECN	वर्णन DESCRIPTION												
धातु-वेल्डन चिन्ह मा. मा. : 813 / अ. मा. सं. : 2553 WELDING SYMBOLS TO IS:813 / ISO:2553			दिनांक DATE	24-11-20														
			रेखिक अनुपात SCALE	1:1														
			संदर्भ / REF. 182-00461 ALT.-2															
पादांक GRADE NO.	सं1 N1	सं2 N2	सं3 N3	सं4 N4	सं5 N5	सं6 N6	सं7 N7	सं8 N8	सं9 N9	सं10 N10	सं11 N11	सं12 N12		परिवर्तन संख्या ALTERATION. NO.	4	पर्ण SHEET	1 OF 1	A4
Rz	0.16-0.3	0.5-0.7	0.9-1.1	1.5-2.0	2.5-3.8	5.0-6.3	9.0-12	16-25	30-40	50-63	75-100	160-250						
Ra μm	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50						
चिन्ह SYMBOL																		

Technical drawing of a 90° elbow fitting. The drawing shows a cross-section of the fitting with various dimensions labeled: A (total length), B (height to centerline), C (height to base), D (inner diameter), E (height to top of elbow), F (height to top of elbow), G (total height), HX (height to centerline), HY (height to base), P (thread specification: 1/4" NPT), and T (thread depth). Callouts 1, 2, 3, and 4 point to specific features: 1 points to the top of the elbow, 2 points to the inner diameter, 3 points to the outer diameter, and 4 points to the thread.



5. DIMENSIONS A,C,D ARE TYPICALLY FINGER TIGHT.
6. THIS FITTING IS TO BE SWAGED ON S.S. TUBES(Gr.304) OF HARDNESS 75 TO 80 HRB.
7. MALE ELBOWS ARE TO BE MACHINED FROM FORGED BLANKS AND NOT TO BE CAST.
8. ALL PARTS OF THE FITTING SHOULD BE CONCENTRIC & BE CAPABLE OF SELF ALIGNMENT, WHEN ASSEMBLED WITH PROPER SIZE OF TUBING.
9. NUTS & FERRULES OF PARTICULAR SIZE SHALL BE INTERCHANGEABLE FOR EACH TYPE.

[illegible]