



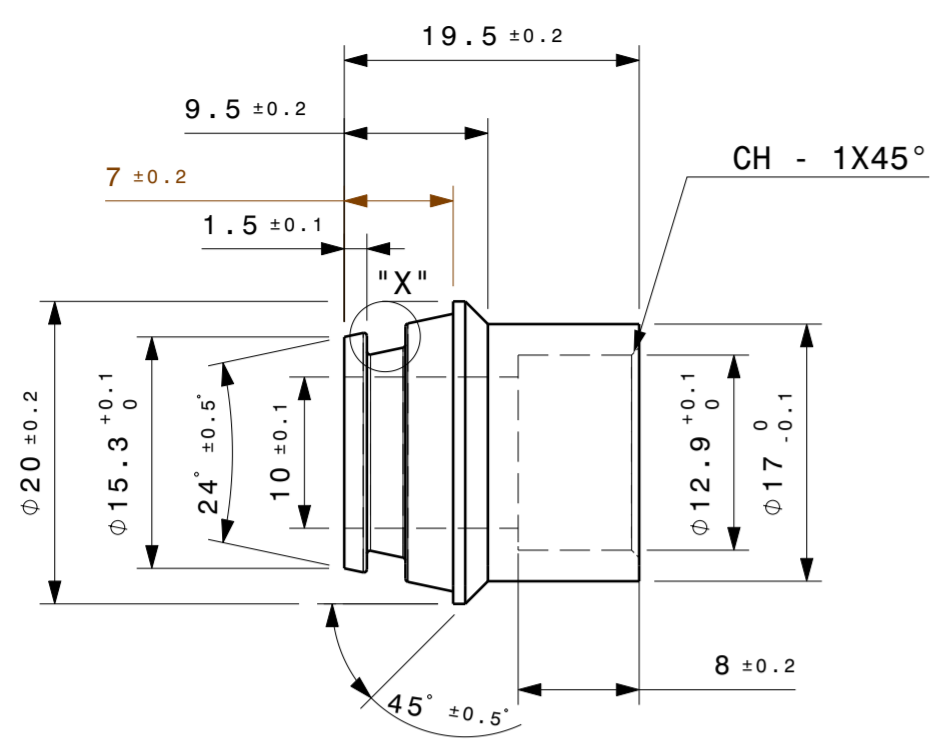
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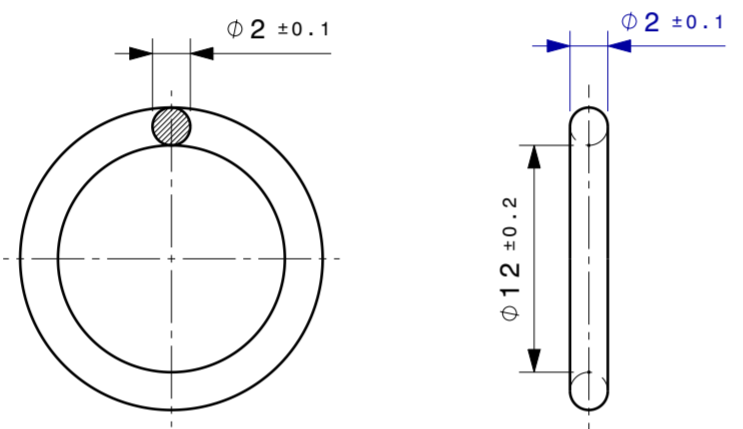
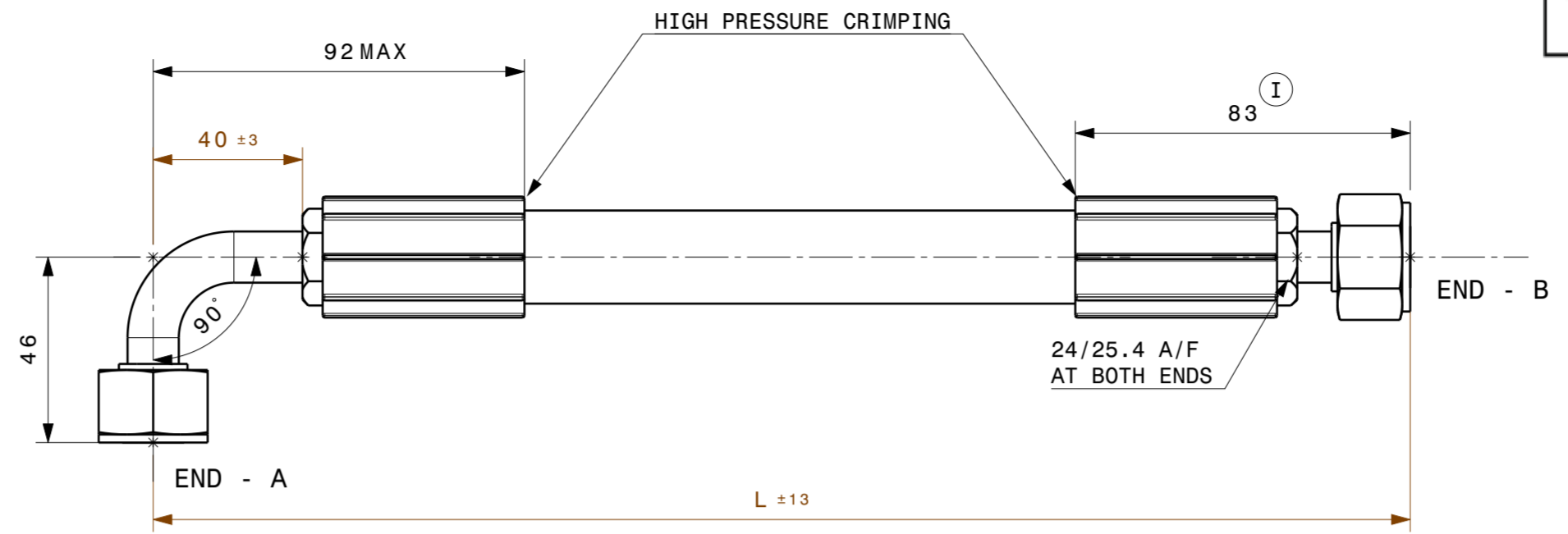
ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVOLCHAVADI



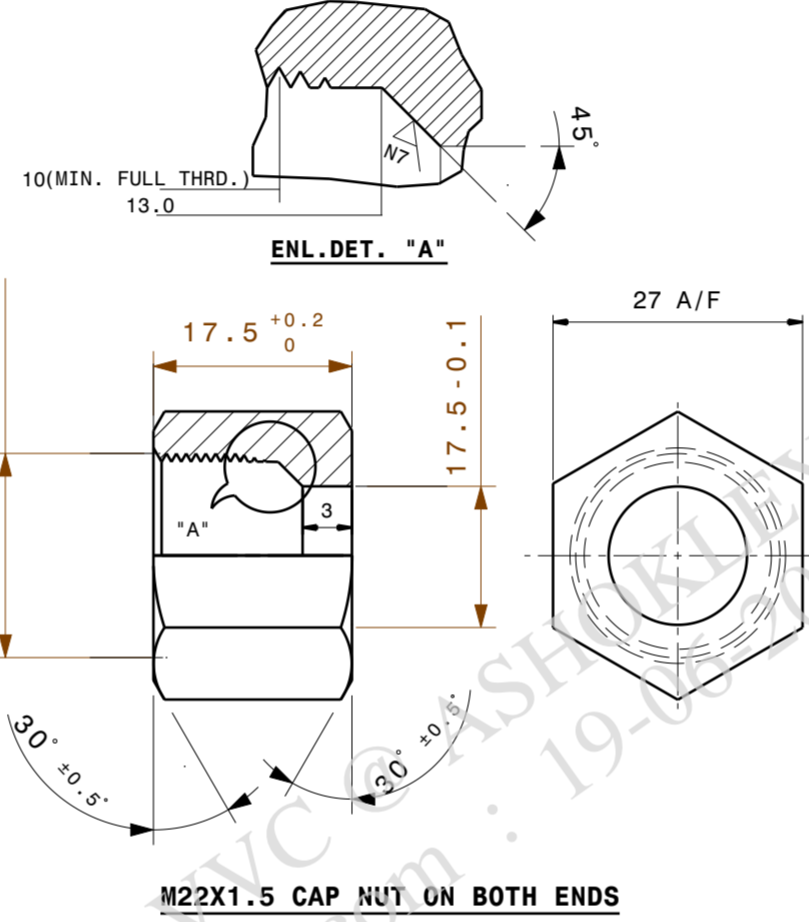
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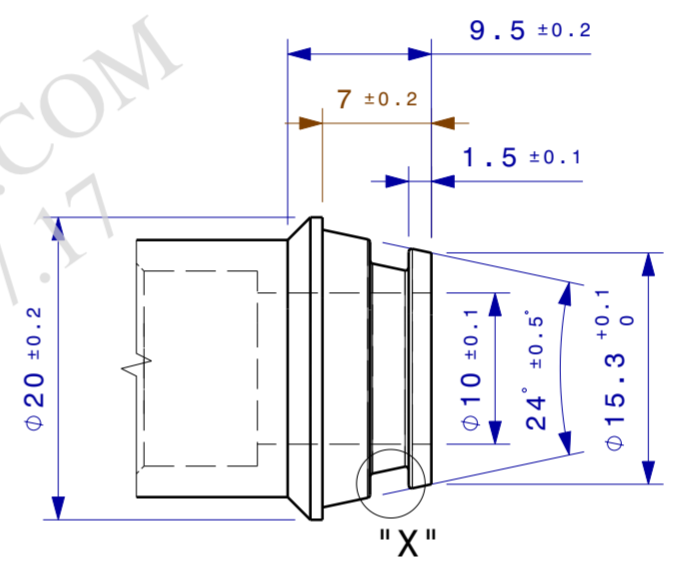
END - A NIPPLE PROFILE



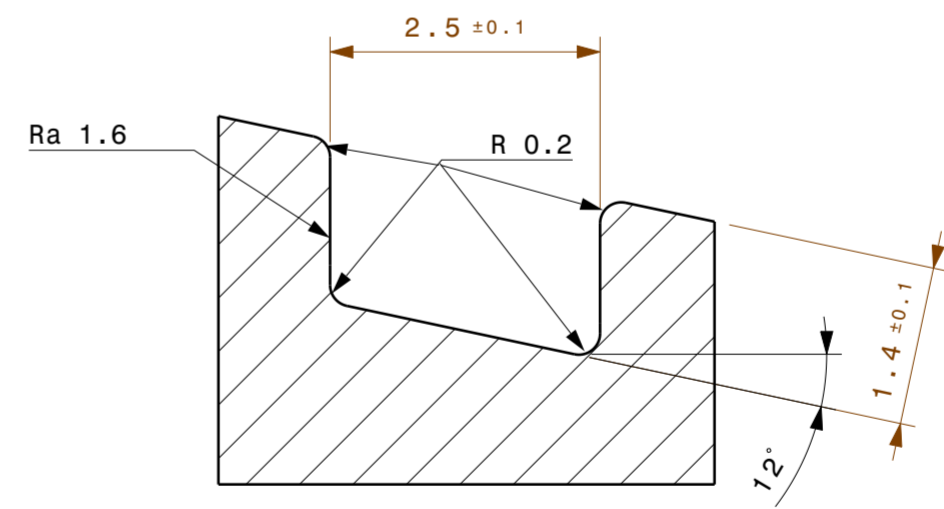
O-RING



M22X1.5 CAP NUT ON BOTH ENDS



END-B NIPPLE PROFILE



DETAILS OF O-RING GROOVE "X" ON BOTH NIPPLE ENDS

PART NO	LENGTH (L)	
	MM	INCHES
F7884500	622	24.5
F7884400	749	29.5
F7884300	1524	60.0
F7884200	1854	73.0
F7884100	1016	40.0
F7893000	400	15.75
F7853900	300	11.81
F8069800	1070	42.1
F8069900	1180	46.45
F8206900	483	19.0
F8225400	370	14.6
X3925500	500±5	19.64
F8001800	1175	45.25
F7886900	2400	94.48
F8214000	1180	46.45
X3908200	685±5	27.0
X3908200	838±5	33.0
X3919600	1143	45.0

NOTES:

- 12.7 mm OD, 1.6 THK. CDS-I TUBE IN ANNEALED CONDITION TO IS-3074.
- 1/2" ID HOSE CONSTRUCTION AS PER SAE J517 100R2, MAX. WORKING PRESSURE 245 BAR, WORKING TEMPERATURE RANGE FROM -40° C TO 130° C
- END FITTINGS, STEEL BAR BS 970 Gr:EN-1A (OR) 220M07 (OR) IS-4431 Gr:11C 10 S 25.
- BRAZING AS PER ALS.276.01.
- PROTECTIVE CAPS TO BE PROVIDED AT BOTH ENDS.
- STORAGE AND IDENTIFICATIONS AS PER ALS.000.04.
- SPRING GAURD TO COVER FULL LENGTH OF HOSE AND IT SHOULD NOT SLIDE FREELY.
- SPRING GAURD TO 24.5 MM ID, 1.5 MM WIRE DIA AS PER IS:4454 (PART I) GR SM.
- "O" RING MATERIAL TO BE HNBR TO SAE J200 M4 DH 716 A26 B36 E016 E036 F17. SHORE HARDNESS : A 70± 5. O-RING COLOUR TO BE BLACK.
- O-RING SEATING SURFACE ON NIPPLE TO BE FREE FROM BURR.
- HOSE ASSEMBLY TO BE LEAK PROOF WHEN TESTED AT 245 BAR.

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
F7893000 ADDED. PMK	DIN 11374 19.08.92		A
F7853900 ADDED MAK/SS	-		B
F8069800 & F8069900 ADDED VVC/SSR	DIN 16620 28.08.99		C
PT. NO F8206900 ADDED RLK/KRI	DIN 16799 12.12.99		D
PT. NO. F8225400 ADDED KVS/GB	DIN 8587 27.07.01		E
SURFACE PROTECTION SPEC UPDATED TO LATEST STD. GSK/SD	ER-DIN-0006971 24.06.11		F
END FITTING DESIGN CHANGED. SPRING GAURD ADDED RJN/BALAJI.L	ER-DIN-0012012 04.10.12		G
"O" RING MATERIAL ADDED HOSE WORKING TEMP MENTIONED DIM 15.3 IN END B WAS 12.9 DIM 1.4 WAS 1.5 RJN/BALAJI.L	ER-DIN-0014181 06.03.13		H
F7884600, F7885500, X7412400 AND X7445200 PART NUMBERS REMOVED. DIMENSION OF END-B IS CHANGED. NGR/LB/VV	ER-DIN-0025404 07.04.15		I

AL PLM VAULT				
REVISION : I	DATE : 9/4/2015	STATUS : RELEASE		
STAGE : III	ER-DIN NO : ER-DIN-0025404	DATE : 10/4/2015		
ALTERED BY : rajakumar.ug	CHECKED BY : LBALAJALMDCH			
MED APPROVAL : SUNILRAJS	APPROVED BY : vijaykumar.vlvc			

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED				
DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
RJN 08.03.2013	BALAJI.L 08.03.2013	SIVAKUMAR.GK 08.03.2013	VV 08.03.2013	----

MATERIAL REFER NOTE

HEAT TREATMENT

REMARKS

DESCRIPTION PRESSURE HOSE ASSEMBLY

PART NO. **F 7 8 8 4 1 0 0 I**

SHEET No1..... OF1..... **A2**

SURFACE PROTECTION CLASS D AS PER ALS.268.03

THIS DRG.CONTAINS (-) @ CRITICAL (-) S SAFETY (-) I IMPORTANT CHARACTERISTICS UNLESS OTHERWISE SPECIFIED

TOLERANCES REFER IS:2102; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION

SURFACE PROTECTION TO MEET THE REQUIREMENT OF ALS.268.03

SURFACE FINISH AS PER IS:3073(CLA VALUE) METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4218 CLASS 6g EXTERNAL OR 5H INTERNAL SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

BILL OF MATERIALS

APPEARANCE ITEM	ER-DIN	DATE
YES NO	ER-DIN-0014181	08.03.2013
FINISHED WEIGHT (APPROX)	REF PART NO:	----
0.60 Kgs	S/A PART NO:	----
SCALE	SUPERSEDES	----
NTS	SPEC NO:	----