



ALTERATIONS		REV. NO	DATE	BY	CHKD
IDENTIFICATION STICKER ADDED EDM: ER-DIN-0000108 NRB/VMG		23.05.07		A	
IN ITEM 4:- Ø2.8,26% PERFORATION ADDED AS ALTERNATE PERFORATION AND DIMENSION 170 IS TAKEN AS REFERENCE IN ASSEMBLY:- THE STITCH WELD BETWEEN ITEM 5 AND ITEM 8 DELETED STITCH WELD BETWEEN ITEM 2 AND ITEM 5 WAS CONTINUOUS WELD STITCH WELD BETWEEN ITEM 4 AND ITEM 5 WAS CONTINUOUS WELD ITEM 5:- BAFFLE THICKNESS 1.2 WAS 1.6 ITEM 2 & 4:- TUBE STEEL MATERIAL DELETED		08.07.07		B	
ER DIN:0000213 PJ/KH/MMN IN ITEM 4 & 5:- THICKNESS 1.2 MM WAS 1.6 MM. SERIAL NO 5 DELETED IN ASSEMBLY INSTRUCTION.		24.07.07		C	
ER DIN:0000374 PJ/KH/MMN MATERIAL SPEC UPDATED. SPECIAL INSTRUCTION NOTES UPDATED FOR SURFACE PROTECTION / WELDING. NOTES UPDATED.				D	
WELDING DETAILS ADDED IN ITEMS 02 & 04.		ER-DIN-9144 & 04.			
DIAMETER & LENGTH DIMENSIONS ADDED IN ASSEMBLY VIEWS.					
DIMENSION IN DETAIL B ADDED.					

ASSEMBLY INSTRUCTIONS	
1) MANUFACTURE ALL COMPONENTS INDIVIDUALLY	
2) PREPARE SUB-ASSEMBLY OF INLET PIPE (ITEM #1, #2, #3)	
3) PREPARE SUB-ASSEMBLY OF INLET PIPE, OUTLET PIPE, BAFFLE, (ITEM #4, #5, #9 & SUB-ASSY PREPARED IN STEP 2)	
4) INSERT SUB-ASSEMBLY PREPARED IN STEP 3 INTO THE JACKET (ITEM #8)	
5) CARRYOUT ASSEMBLY OF BAFFLE (ITEM #5 & #9) TO THE JACKET (ITEM #8)	
6) INSERT ENDCOVER-1 (ITEM #7) FROM INLET SIDE AND WELD IT TO THE JACKET (ITEM #8)	
7) WRAP THE SILENTEX - GLASS WOOL BAG ON THE PERFORATED TUBE IN THE FOURTH CHAMBER AND JOIN THE ENDS OF THE BAG BY PACKING TAPE (ENSURE TIGHT WRAPPING ON THE TUBE AND FLATTEN THE BAG BEFORE WRAPPING)	
8) INSERT ENDCOVER-2 (ITEM #6) FROM OUTLET SIDE AND WELD IT TO THE JACKET (ITEM #8)	
9) WELD THE OUTLET PIPE (ITEM #4) TO ENDCOVER 2 (ITEM #6)	
10) WELD THE INLET PIPE (ITEM #2) TO ENDCOVER (ITEM #7)	
11) PREPARE OUTER SURFACE FOR SURFACE PROTECTION PROCESS	
12) CARRYOUT ALUMINIUM HEAT RESISTANT PAINT PROCESS AS PER NOTE.	
13) PLUG INLET AND OUTLET PIPES WITH TEMPORARY PLUGS SO AS TO PROTECT FROM ANY FOREIGN PARTICLE ENTRY INSIDE THE MUFFLER	

REVISION		DATE	STATUS
9	9	16/5/2012	RELEASE
8	8	16/5/2012	RELEASE
7	7	16/5/2012	RELEASE
6	6	16/5/2012	RELEASE
5	5	16/5/2012	RELEASE
4	4	16/5/2012	RELEASE
3	3	16/5/2012	RELEASE
2	2	16/5/2012	RELEASE
1	1	16/5/2012	RELEASE

TOLERANCES	
REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION	
FABRICATED COMPONENTS TO BE DEGREASED, DESCALED, APPLY ZINC PHOSPHATE, APPLY EPOXY PRIMER AND APPLY ENAMEL TO MEET 300 HRS OF SALT SPRAY LIFE WHEN TESTED AS PER ASTM B117 (UNDER PELLICULAR CORROSION -- 2mm. NO BLISTERING IS ALLOWED.)	
MACHINED SURFACE TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS1114	
METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4216	
SHARP EDGES TO BE REMOVED	
DIMENSIONS ARE IN MM	
DO NOT SCALE DRAWING	

SPECIAL INSTRUCTIONS/NOTE:	
WELDING SPECIFICATION: WELDING AS PER ALS 276.02	
SURFACE PROTECTION: TO MEET REQUIREMENTS OF IS13183 GRADE 1	

BILL OF MATERIALS			
APPEARANCE	ITEM	ER-DIN	DATE
YES	NO	ER-DIN-9144	20.02.2012
FINISHED WEIGHT (APPROX)		REF. PT. NO.	
18 Kgs		S/A.PT. NO.	
SCALE		SUPERSEDES	
1:1		SPEC. NO.	

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED				
DRWN/ DATE	CHEKED/ DATE	MD APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
ASHWIN M	ANIL KHOT		SIRIRAM B	
20.02.2012	20.02.2012		20.02.2012	
MATERIAL REFER BOM				
HEAT TREATMENT				
REMARKS				
MUFFLER FOR H6 160/180HP APPLN. (BS2/3)				
DESCRIPTION				
49L OBLONG MUFFLER - HYBRID				
PART NO.	B 5 1 2 8 5 0 2 D			
SHEET NO	1	OF	1	AO