



THREAD CONE SEAT & BORE MUST BE CONCENTRIC WITHIN 0.25MM OR .010" TOTAL INDICATOR READING. 45° CHAMFER TO THE ROOT OF THE THREADS AT THE ENDS. SMOOTH FINISH FREE FROM TOOL MARKS REQD AT CONE SEATS.

- \* TEMPORARY ALTERNATE DRILL SIZE 5/16" DIA
- \*\* TEMPORARY ALTERNATE DRILL SIZE 23/64" DIA

- SURFACE FINISH:-**
1. MACHINE ALL OVER TO  $\sqrt{3.2}$  EXCEPT HEXAGON.
  2. SURFACE PROTECTION: TO MEET REQUIREMENTS AS PER ALS 268.03 CLASS D
  3. LOCTITE 516 APPLICATION AT THREADED PORTION.
  4. PLASTIC CAPS FOR THREADED PORTION.

(C)-CRITICAL (S)-SAFETY (I)-IMPORTANT. THIS DRAWING CONTAINS SAFETY CHARACTERISTICS

UNLESS OTHERWISE SPECIFIED

TOLERANCES	REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION
SURFACE PROTECTION	FABRICATED COMPONENTS TO BE DEGREASED, DESCALED. APPLY ZINC PHOSPHATE, APPLY EPOXY PRIMER AND APPLY BLACK 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 IS:1154
METRIC THREADS	METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4218 CLASS 6g EXTERNAL OR 5H INTERNAL

SURFACE FINISH AS PER IS:3073(CLA VALUE)	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO
SHARP EDGES TO BE REMOVED	<input type="checkbox"/>
DIMENSIONS ARE IN MM DO NOT SCALE DRAWING	<input type="checkbox"/>

APPEARANCE ITEM	ER-DIN	DATE
FINISHED WEIGHT (APPROX):	REF PT NO:	
SUPERSEDES:	S/A PT NO:	
SCALE	SPEC NO:	

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
TEMPORARY DRILL SIZE NOTE ADDED MATERIAL EN3 WAS EN 1A	2.9.64	2	1
DIMENSIONS 32 WAS 28 17 WAS 67 AND 77 WAS 73	4.2.64	2	A
NOTE ADDED FOR ALTERNATIVE MATERIAL	2.6.81	1	B
DIMN 34 WAS 32 AND DIM 4 WAS 6 ALT PROFILE FOR UNDER CUT 'A' ADDED RHB/RGM EDM NO 6223	31.3.87	2	C
PARKERISING NOTE DELETED AND PLATING NOTE ADDED V.R EDM 7360	11.8.92	1	D
DRAWING E REVISION RELEASE FOR LEGACY CAD MODEL REGULARISATION RELEASE AAG/VK/RV	ER-DIN-10835 DATE-05.09.2012	1	E
DRAWING UPDATED WITH SURFACE FINISH AT CONE SEAT & NOTE 3 & 4. REDRAWN IN CATIA FROM PDF. AAG/VK/RV	ER-DIN-11720 DATE-08.09.2012	1	F

AL PLM VAULT

REVISION : F	DATE : 24/9/2012	STATUS : RELEASE
STAGE : III	ER-DIN NO : ER-DIN-0011720	DATE : 24/9/2012
ALTERED BY : amit.gaonkar	CHECKED BY : karthik.alh1	
MED APPROVAL : sivakumar.venu	APPROVED BY : vijayakumar.r2	

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL /DATE	APPROVED/ DATE	STDS APP/ DATE

MATERIAL STEEL STAMPING EN3 NORMALISED

HEAT TREATMENT —

REMARKS

DESCRIPTION	ELBOW
PART NO.	F 1 3 3 0 3 1 1 F
SHEET NO:	.....1..... OF... 1.....
	A3