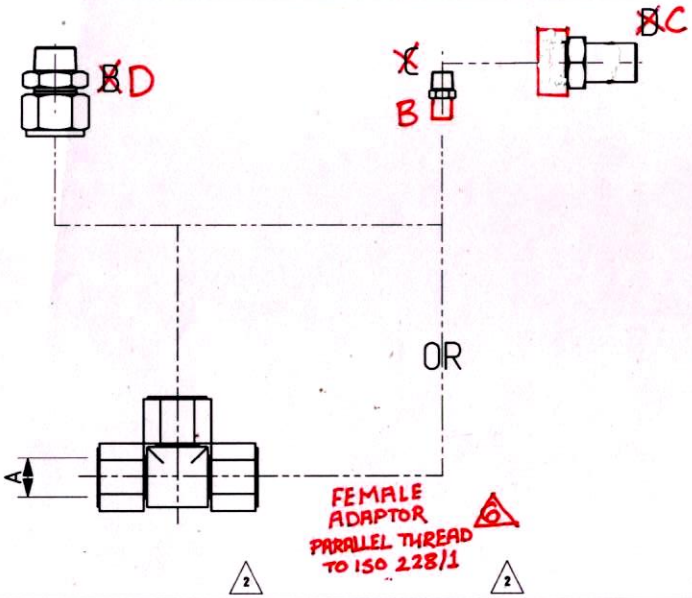
ALT. NO.	AUTHY	DESCRIPTION	DATED INITIAL
6	DY.CEE/ D-III	DESCRIPTION OF COLUMN 'C' CHANGED FROM 'PLUG' TO 'FEMALE ADAPTOR'. FOR SL. NO. 1, 3,5 PROPER SIZE OF 'FEMALE ADAPTOR' ADDED. FOR SL. NO. 3, MALE CONNECTOR TAPER THREAD SIZE CHANGED FROM 3/8" TO 1/2". NOTE 4 DELETED.	



NOTE:-

1. EACH ASSY. SHALL CONTAIN SUITABLE NOS. OF ITEM B/C/D.
2. MATERIAL:- (a) STEEL BODY & BACK NUT ARE MADE OF CARBON STEEL (ASTM A 108)
   (b) FERRULE IS MADE OF ST. STEEL Gr. 316.
3. REMOVE ALL BURRS AND SHARP EDGES.
4. ~~X~~ DRILL & TAP PLUG TO SUIT 1/2 " BSPT.
5. (1) BODY & BACK NUT ARE TO BE ZINC PLATED ION/PASSIVATED.
6. (1) EACH ASSEMBLY (UNION TEE SPECIAL) CONSISTS OF THREE FRONT FERRULES AND THREE BACK FERRULES.
7. (2) ISO 7/1 & ISO 228/1 FOR TAPER AND PARALLEL THREAD RESPECTIVELY.
8. UNION TEES 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 MAX.
10. ALL THE PARTS OF THE FITTING SHOULD BE CONCENTRIC AND CAPABLE OF SELF ALIGNMENT WHENASSEMBLED WHEN ASSEMBLED WITH PROPER SIZE TUBING.
11. NUTS & FERRULES OF PARTICULAR SIZE SHALL BE INTERCHANGEABLE FOR EACH TYPE.

USED FOR LOCO WAG-9, WAP-7 & WAP-5 (3)

(2) SL. NO.	"A" TUBE O.D.	B MALE ADAPTER TAPER THREAD TO ISO 7/1 (2)	C ~~PLUG~~	D MALE CONNECTOR TAPER THREAD TO ISO 7/1 (2)	MATERIAL	
1	1 1/2" x 1 1/2" x 1 1/2"	1 1/2T x 1 1/4"	~~YES~~	NO - SEE NOTE	STL / ST.STL	1 1/2" PIPE x 1/2" 6
2	1 1/2" x 1 1/2" x 1 1/2"	1 1/2T x 1 1/4"	NO	NO	STL / ST.STL	
3	1 1/2" x 1 1/2" x 1 1/2"	NO	~~YES~~	(4) 10 x ~~3/8"~~ 1/2" 6	STL / ST.STL	1 1/2" PIPE x 1/2" 6
(1) 4	1 1/2" x 1 1/2" x 1 1/2"	1 1/2T x 1"	NO	NO	STL / ST.STL	
		1 1/2T x 1 1/4"	NO	NO		
5	1" x 1" x 1"	NO	~~YES~~	1/2"T x 1/2"	STL / ST.STL	1" PIPE x 1/2" 6
(1) 6	1 1/2" x 1 1/2" x 1 1/2"	1 1/2T x 1 1/4"	NO	NO	STL / ST.STL	
		1 1/2T x 1 1/4"	NO	NO		

ORIGINAL SUPPLIER:- WAGELOK / USA

REF. NO.	C&D NO.	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN	WT. EACH IN K.G.
6	/		UNION TEE SPECIAL		SEE NOTE		
5	/		UNION TEE SPECIAL		SEE NOTE		
4	/		UNION TEE SPECIAL		SEE NOTE		
3	/		UNION TEE SPECIAL		SEE NOTE		
2	/		UNION TEE SPECIAL		SEE NOTE		
1	/		UNION TEE SPECIAL		SEE NOTE		

निर्देश संख्या / लागत एवं वितरण संख्या / अंग आरेखण संख्या / वर्णन / मात्रा / पदार्थ / विशिष्टि / प्रति भार कि. ग्रा.

अभिकल्पित DGN			
जाँचा च.अ.अ. CHD SSE	SUBHANKAR KUMBHAKAR		
समीक्षित च.रि.अ. / व.रि.अ. REVIEWED AEE / SEE	Pradeep Khatana		
अनुमोदित उ.मु.रि.अ. APPROVED DYEE	SYAMA PRASAD PATRA		
दिनांक DATE	22-09-20		
पैमाना अनुपात SCALE	1:5		
संदर्भ / REF.	182-00516	ALT:-	

चित्तरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

पदार्थ MATL	प्रति भार कि. ग्रा. WT. EACH IN KG
विशिष्टि SPECN	ASTM A108
वर्णन DESCRIPTION	UNION TEE SPECIAL
आरेखण संख्या DRAWING NO.	1209-18.306-031
परिवर्तन संख्या ALTERATION NO.	~~5~~ 6
पूर्ण SHEET	1 OF 1
	A3

परिवर्तन संख्या ALT. NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित आद्याक्षर DATED INITIAL
5		REDRAWN IN NX WITH 3RD ANGLE PROJECTION.	15-07-20
4		SL. NO. 3 M/C Ø 10 WAS 3/8"	14-02-12
3	AMD/D&D	WAP-5 AND CLASS OF LOCO ADDED	15-01-03
2	AMD/D&D	NOTES 7 TO 11 ADDED. THREAD DESIGNATIONS OF MALE ADAPTER 'B' & MALE CONNECTOR 'D' WAS BSP, SL.NO. WAS REF.NO.	07-09-01
1	AMD/D&D	NOTES 5 & 6 ADDED. 1 1/2"Tx1"BSP ADDEDIN COLUMN 'B' FOR REF.4, 1 1/2"Tx1 1/4"BSP ADDED IN COLUMN 'B' FOR REF. NO.6	19-08-98

धातु–वेल्डन चिन्ह
भा. मा. : 813 / अ. मा. सं. :2553
WELDING SYMBOLS TO IS:813 / ISO:2553

सतह – रुक्षता का मान
भा. मा. 3073 / अ. मा. सं. 1302
SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302

अनिर्दिष्ट सह – सीमा भा. मा. : 2102 / अ. मा. सं. : 2768
UNSPECIFIED TOLEARANCE TO IS : 2102 / ISO : 2768

पदांक 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
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												

TOL. CLS.

REDRAWN BY TCS

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