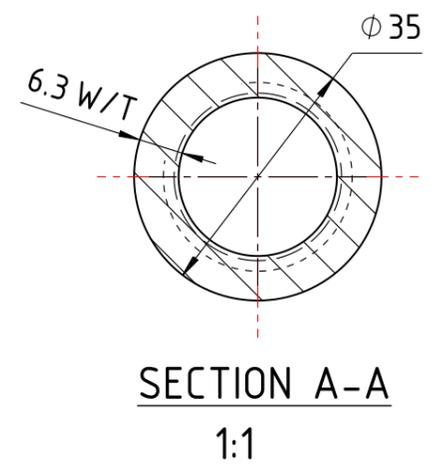
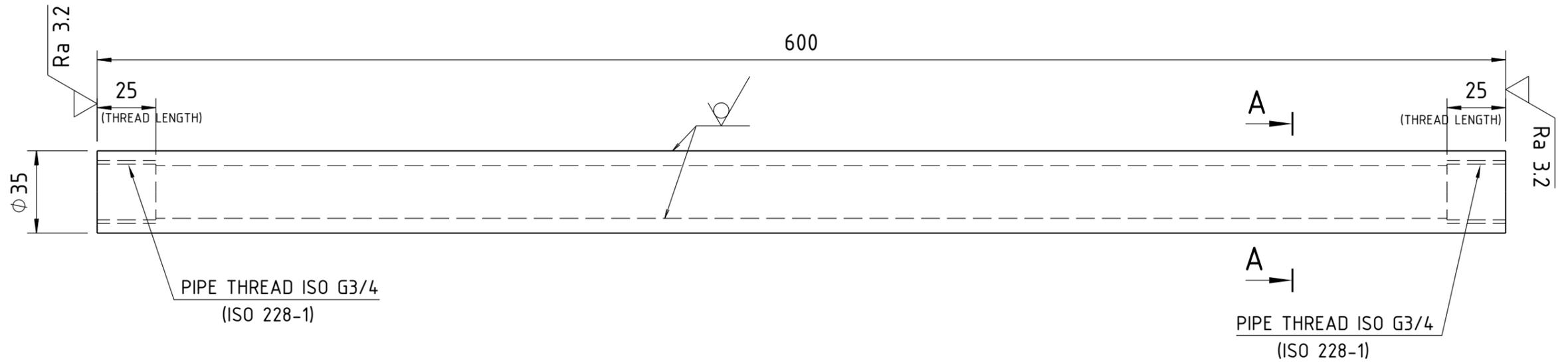


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MODEL	NEXT ASSY	QTY	MACHINING DEVIATIONS FOR LINEAR DIMENSIONS CLASS - MEDIUM	RANGE	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 400	400 - 1000	1000 - 2000	2000 - 4000
843	843-41010	02		TOLERANCE	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
843	843-41014	02	GENERAL TOLERANCES FOR LINEAR & ANGULAR DIMENSION SHALL BE AS PER ISO 2768-1				GENERAL GEOMETRICAL TOLERANCES SHALL BE AS PER ISO 2768-2					
				GENERAL TOLERANCES FOR WELDED STRUCTURE SHALL BE AS PER ISO 13920				VALUES OF SURFACE TEXTURE SHALL BE AS PER ISO 1302.				
				WELDING SHALL BE CARRIED OUT AS PER EN 15085-3			WELDING PROCESS SHALL BE AS PER EN ISO-4063			STATUS: <b>MOCK-UP/PROTO/PRODUCTION</b>		
				WELDING SYMBOLS SHALL BE AS PER EN ISO-2553			WELDING POSITIONS SHALL BE AS PER EN ISO 6947					
				QUALITY LEVELS FOR IMPERFECTIONS IN FUSION WELDED JOINTS SHALL BE AS PER EN ISO 5817								
				WELD JOINT PREPARATIONS SHALL BE AS PER EN ISO 9692 & EN 15085-3			INSPECTION & TESTING OF WELDED JOINTS SHALL BE AS PER EN 15085-5					



FOR REFERENCE ONLY

**NOTES:**

- ALL EDGE PREPARATIONS SHALL BE DONE BY MACHINING ONLY TO GRADE NO. N10.
- REMOVE ALL SHARP EDGES & BURRS.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)
			CARBON STEEL SEAMLESS PIPE	Ø35x6.3W/T; L=610		
			PRODUCT	TRAIN B28		
			REF DRG			
			MATERIAL	E355+N EN10297-1;		
			HEAT TREAT.	APPD	BN	03.12.2025
			SURFACE TREAT.	REVD	YB	03.12.2025
			TITLE	CHKD	YB	03.12.2025
				DRWN	SSM	03.12.2025
				SCALE	1:2	
				SHEET	1 OF 1	2.68kg
				DRG No.	843-41141	
				ALT	0	



GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	

SURFACE ROUGHNESS