

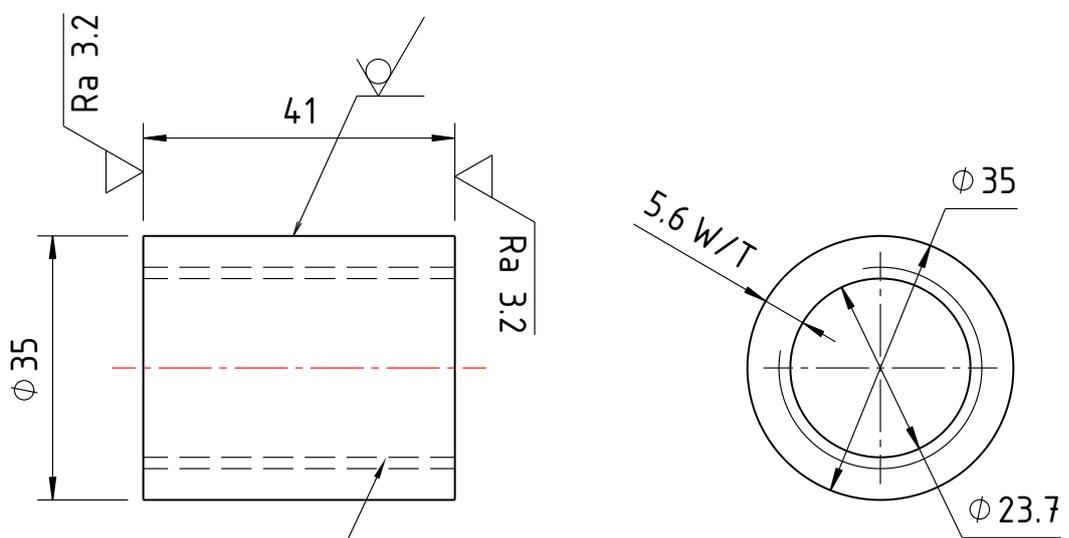
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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS CLASS - MEDIUM	RANGE	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 400	400 - 1000	1000 - 2000	2000 - 4000
	TOLERANCE	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
GENERAL TOLERANCES FOR LINEAR & ANGULAR DIMENSION SHALL BE AS 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:	MOCKUP/PROTO/PRODUCTION			
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				

MODEL	NEXT ASSY	QTY
843	843-41101	01

**UN CONTROLLED**



INTERNAL PIPE THREAD ISO G3/4  
(ISO 228-1)

**NOTES:**

1. FULL LENGTH INTERNAL PIPE THREAD: ISO G3/4 TO ISO 228-1.
2. ALL EDGE PREPARATIONS SHALL BE DONE BY MACHINING ONLY TO GRADE NO. N10.
3. REMOVE ALL SHARP EDGES & BURRS.

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

		CARBON STEEL SEAMLESS PIPE		Φ=35x5.6W/T;L=51					
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S		Wt. (Kg)		
					MATERIAL				
			PRODUCT	TRAIN B28					
			REF DRG						
			MATERIAL	E355+N; EN10297-1					
			HEAT TREAT.	APPD	BN		21.01.2026		
			SURFACE TREAT.	REVD	YB		21.01.2026		
			TITLE	CHKD	YB		21.01.2026		
			SEAMLESS PIPE	DRWN	BK		20.01.2026		
				SCALE	1:1		SHEET	1 OF 1	
			BANGALORE COMPLEX	DRG No.	843-41496		Wt.(kg)	0.16kg	
				ALT	0				
ALT.No.	ECN No./CHANGES		DATE	BY	CHKD	APPD			

