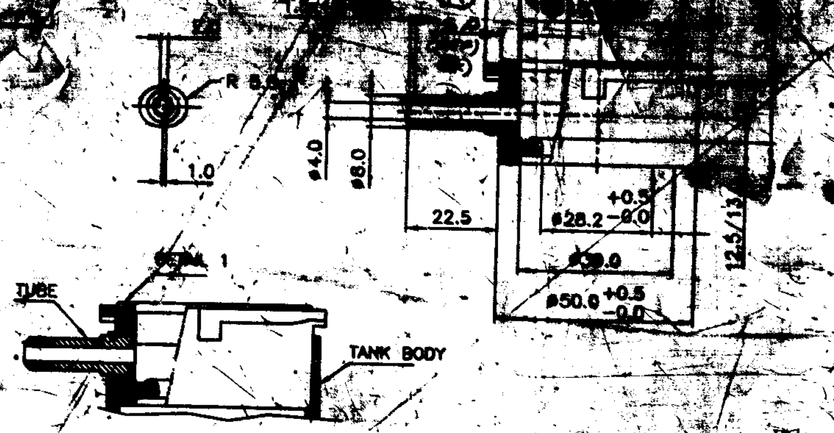
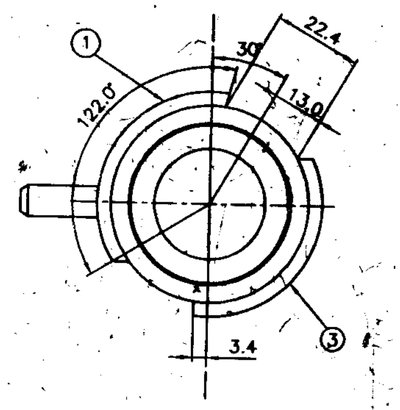
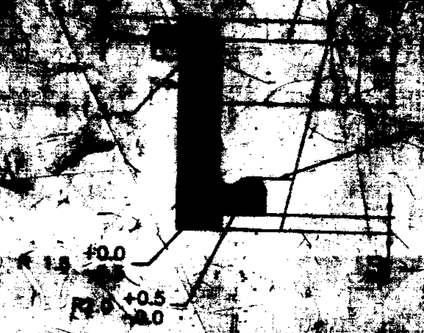
ASHOK LEYLAND LTD. HOSUR

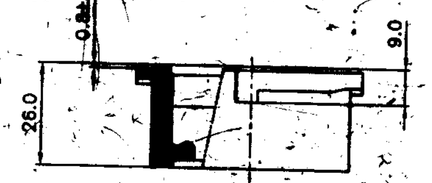


ALTERNATE: FUSION BY FRICTION WELDING BETWEEN TUBE TO DETAIL1 PERMITTED.

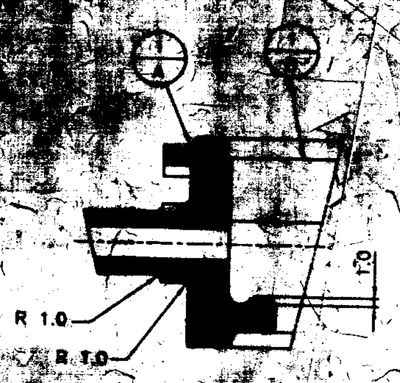




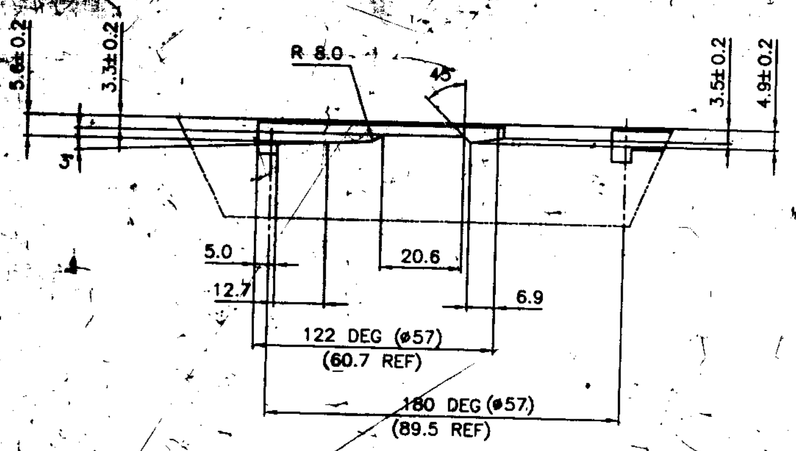
BASE SECTION



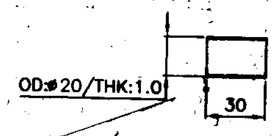
DETAIL: 1



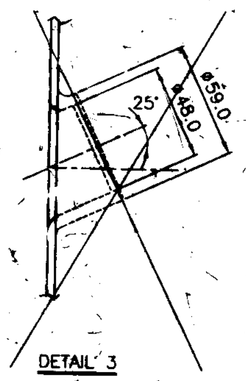
PART SECTION



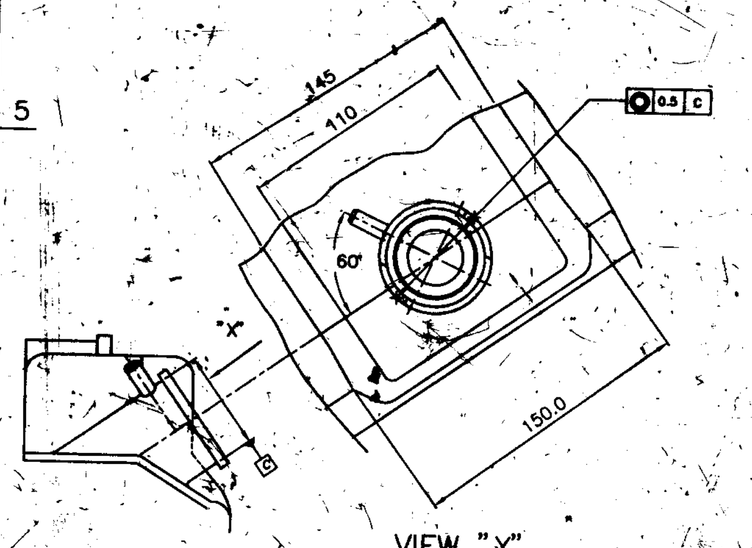
DEVELOPED FORM OF CAM (DETAIL 1)



DETAIL 5

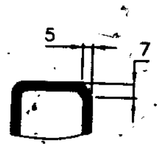


DETAIL 3

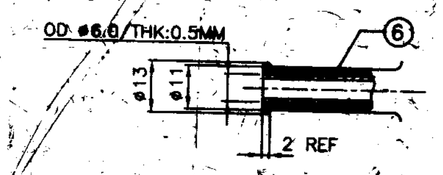


VIEW "X"

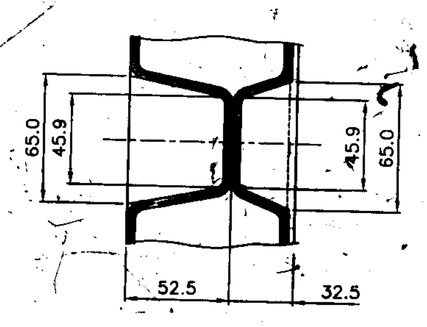
SECTION E-E



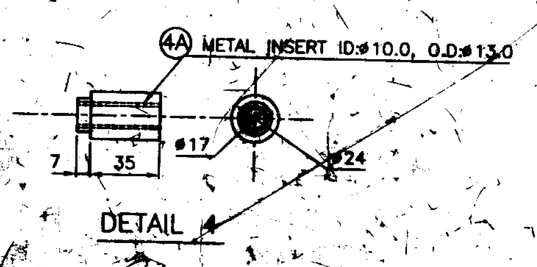
SEC – DD



DETAIL 2



SEC – CC



DETAIL 4

NOTE:
~~PROVISION HAS TO BE MADE IN THE MOULD/DIE TO HAVE A BOSS ON UP SIDE AS SHOWN FOR FUTURE REQUIREMENT ONLY.~~

UNLESS OTHERWISE SPECIFIED

SURFACE PROTECTION: ~~MACHINED~~ SURFACES TO BE PHOSPHATED AS CLASS 'C' AS PER IS:3618 AND APPLIED IMMEDIATELY WITH ~~RUST~~ PREVENTIVE CHEMICAL COMPOUND. ~~MACHINED~~ SURFACES TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS:1604.

MACHINING ALLOWANCES FOR OPEN DIMENSIONS WILL BE AS PER IS:2102									
UP TO	6	30	120	315	1000	2000	4000	> 4000
ALLOWANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0

SHARP EDGES ARE TO BE REMOVED.

ANGULAR TOLERANCE AS PER IS:2102

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT ISI/BIS, CLASS 6g EXTERNAL OR 5H INTERNAL

DO NOT SCALE DRAWING

ALL DIMENSIONS ARE IN MM

SPECIAL INSTRUCTION / NOTE:

SL. NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY
7		BILL OF MATERIALS		

REF PART NO.		ISSUED UNDER	REINSTATED
SUPERSEDES		REF / DN	DATE / BY
S/A PART NO.		C1444	11/11/97 DATE
WEIGHT	ROUGH / FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED	YES ✕ NO
SCALE	1:2	APPROVAL NUMBER	
SPEC. NO.		TESTING STD.	

CHANGES INCORPORATED AS PER SUFFIX 'B' INCORPORATED CHANG NOTE NO. 5008

STAGE	CHECKED	DATE	REVISED	DATE
I				
II				
III				

DRAWN DATE
CHECKED DATE
APPROVED DATE

MATERIAL: REF. NOTE:

HEAT TREATMENT:

REMARK: FOR CARGO

DESCRIPTION: DE-AERATION TANK (AL)

PART NO. X 1 0 0 6 7 0 0 B

SHEET NO. 2 OF