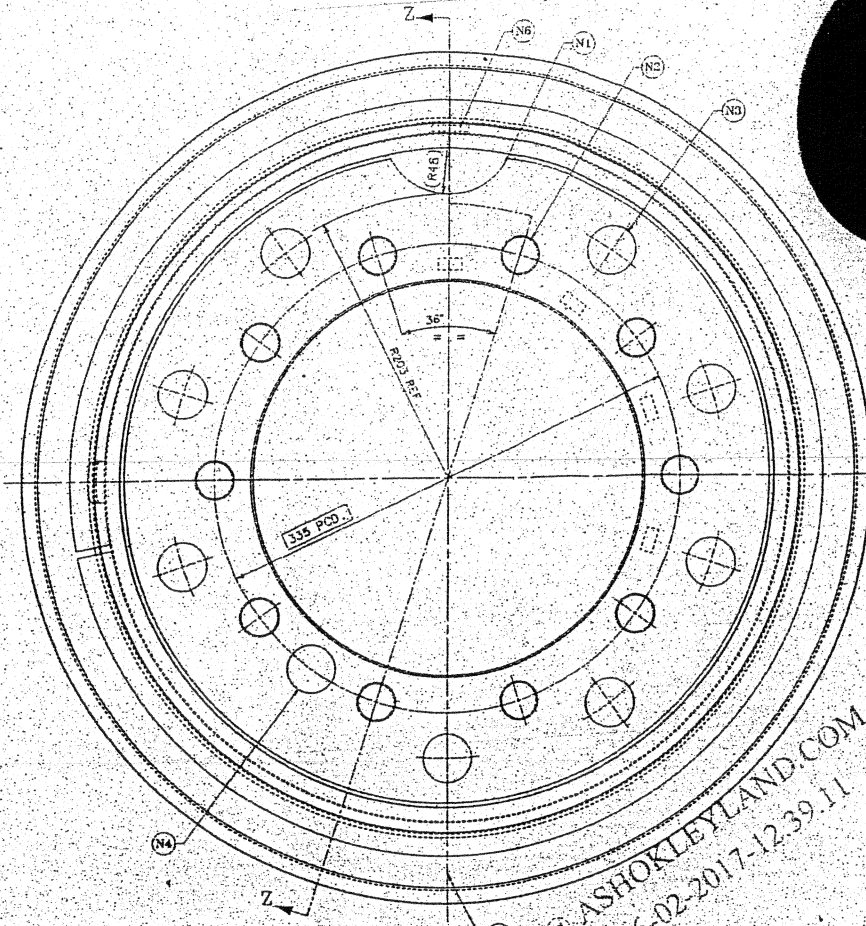
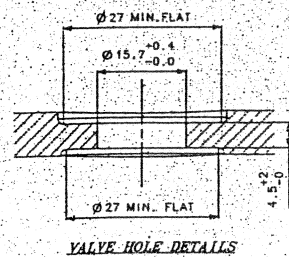
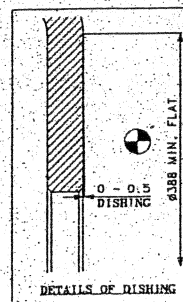
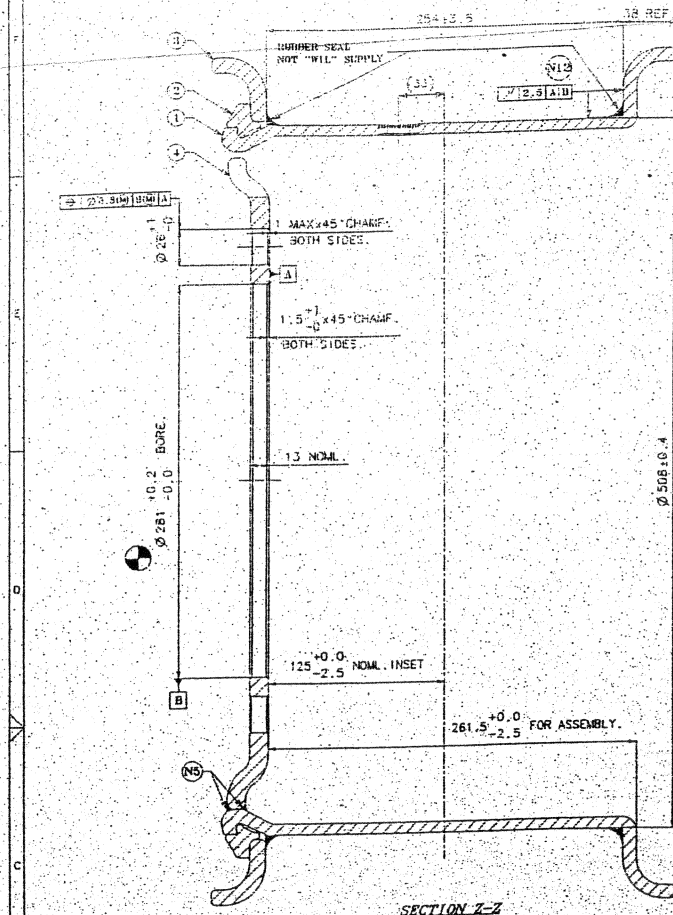
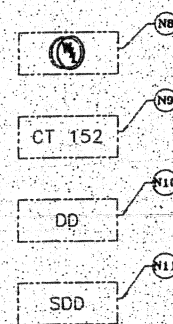


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ASHOK LEYLAND LTD.
TECHNICAL CENTRE, VELLIVOLCHAVADI



WHEEL MARKING



NOTE	GRID	NOTES
N1	F4	ONE CUTOUT DIMENSIONED AT VALVE HOLE CENTER LINE.
N2	F4	10 STUD HOLES EQUALLY SPACED.
N3	F3	SEVEN VENT HOLES 130 EQUALLY SPACED WITH STUD HOLES.
N4	C5	ONE PLAIN HOLE POSITIONED IN-BETWEEN HOLE HOLES ON 135 PCD.
N5	C9	CONTINUOUS WELD ON BOTH SIDES, EXCEPT CUT OUT REGION 5 TO 10 mm NO WELD NEAR CUT OUT REGION.
N6	F4	VALVE HOLE POSITION.
N7	C4	RIM BUTT WELD JOINT LOCATION.
N8	D2	MANUFACTURER'S LOGO MARKING.
N9	D2	MANUFACTURER'S WHEEL CODE MARKING.
N10	D2	YEAR & MONTH CODE MARKING (TYPICAL).
N11	C2	SHIFT & DATE MARKING (TYPICAL/OPTIONAL).
N12	F7	RUNOUT NOT TO BE CHECKED FOR 100 mm EITHER SIDE OF RIM BUTT WELD.

GENERAL NOTES:-
1. TYRE SIZE : 14.00 R20 22PR (TUBELESS TYRE)
2. MAXIMUM TYRE LOAD : 5000 kg.
3. PAINT:-
PRIMER : ZCD
FINISH : OLIVE GREEN
PAINT THICKNESS : 60 MICRONS MAX. ON MOUNTING REGION.
4. SURFACE PROTECTION: CLASS 'C' AS PER ALS 268.03
5. TEST SPECIFICATION AS PER IS8438
6. MARKING POSITIONS ARE ONLY FOR REFERENCE.

SL. NO.	DESCRIPTION	QTY	REMARKS
1	10.00 x 20 RIM	1	DIN17100 Rst 37-2 OR EQUIVALENT
2	WHEEL DISC	1	DIN17100 Rst 42-2 OR EQUIVALENT
3	LOCKRING	1	DIN17100 Rst 50-2 OR EQUIVALENT
4	FLANGE	1	DIN17100 Rst 42-2 OR EQUIVALENT

SL. NO.	DESCRIPTION	QTY	REMARKS
1	10.00 x 20 TUBELESS RIMBASE	1	

SL. NO.	DESCRIPTION	PART NO.
1	HUB	
2	FASTENERS	
3	OTHER DETAILS	

VEHICLE MODEL : HMV 6X6 MERITOR AXLE
CALCULATED WHEEL WEIGHT : 63.1 kg
REFERENCE CUSTOMER PART No. : F7862714
CUSTOMER PART No. : 8330701

SOFTWARE USED: UNIGRAPHICS	PROJECTION: FIRST ANGLE	SCALE: 1:2	DRAWN: THP	CHECKED: THP	APPROVED: CH(PAD)	DATE: 30.07.2012
THIS DRAWING IS THE PROPERTY OF WHEELS INDIA LTD. AND MUST NOT BE COPIED OR REISSUED WITHOUT PERMISSION.				WHEELS INDIA LTD., CHENNAI - 600 050		
WHEEL CODE:- CT 152				DRAWING No. HCC 486		
TITLE:- TUBELESS WHEEL				CUSTOMER: ASHOK LEYLAND		
SIZE:- 10.00 x 20						

ISSUE	A	B	C	D	E
MOD No.	14699	15425	16572	17511	17534
BY	G.R	C.A	C.A	C.A	C.A
DATE	24.01.2013	18.2.2014	15.05.2014	26.08.2014	02.09.2014

SK 8082	B3306701	Qty: -	Qty: 01 Nos	-
Supplier Part No	AL Part No	Sample	Pilot	Production
Q. IMPORTANT Q. CRITICAL Q. SAFETY. THIS ORG. CONTAINS SAFETY CHARACTERISTIC				
UNLESS OTHERWISE SPECIFIED				
ASHOK	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			
SURFACE FINISH AS PER IS:3073 (CLA VALUE)	METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4219. DISCREPANCY ARE IN MM DO NOT SCALE DRAWING			

SPECIAL INSTRUCTIONS/NOTE:
SURFACE PROTECTION:
CLASS C AS PER ALS : 268.03

8/3
JWM/ODC
WM/ODC
DR/ODC

APPEARANCE ITEM	ER-DIN	DATE
FINISHED WEIGHT (APPROX)	REF. PT. 210	
SCALE	SUPPLEMENTED	

BILL OF MATERIALS	
PART No.	83306701
SHEET No. 1 OF 1	

REVISION: 01	DATE: 30/08/14	STATUS
STAGE: II	ER-DIN NO: ER-DIN-001276	DATE: 13
ALTERED BY: ramakrishna.g	CHECKED BY: ramakrishna.g	APPROVED BY: ramakrishna.g
MEP APPROVAL: ramakrishna.g	APPROVED BY: ramakrishna.g	
DRAWN/ DATE	CHECKED/ DATE	MEP APPROVAL/ DATE
VKS	VKN	RR
07/06/12	07/06/12	07/06/12
MATERIAL REFER DRAWING		
HEAT TREATMENT		
REMARKS		
HMV 6X6 MERITOR AXLE		
WHEEL RIM - TUBELESS		