ASHOK LEYLAND

FIRST ANGLE PROJECTION

SURFACE FINISH AS PER IS:3073. (CLA VALUE)

MICRO INCHES	MICROMETRES
BELOW 8	BELOW 0,2
8 - 16	0,2 - 0,4
16 - 32	0,4 - 0,8
32 - 64	0,8 - 1,6
64 - 125	1,6 - 3,2
125 - 250	3,2 - 6,4

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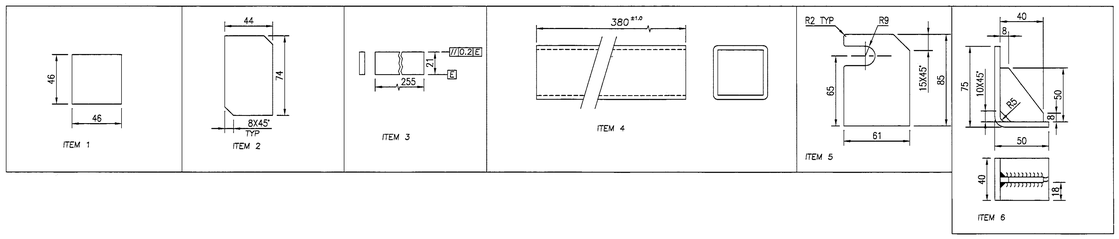
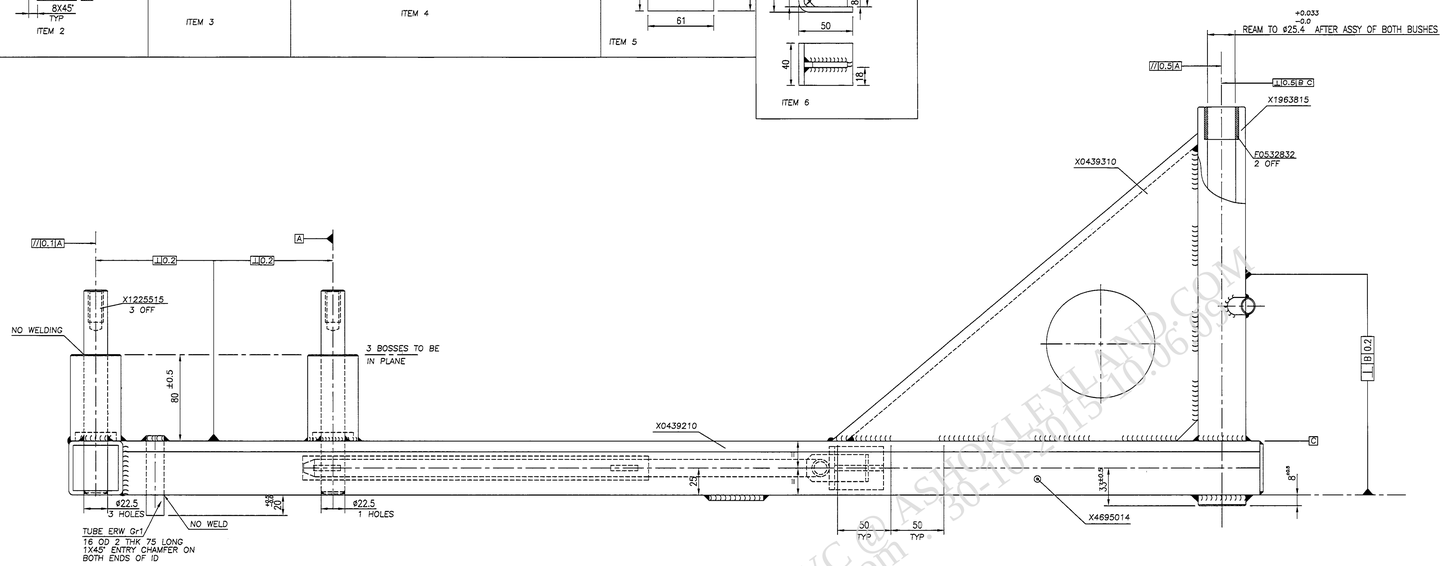
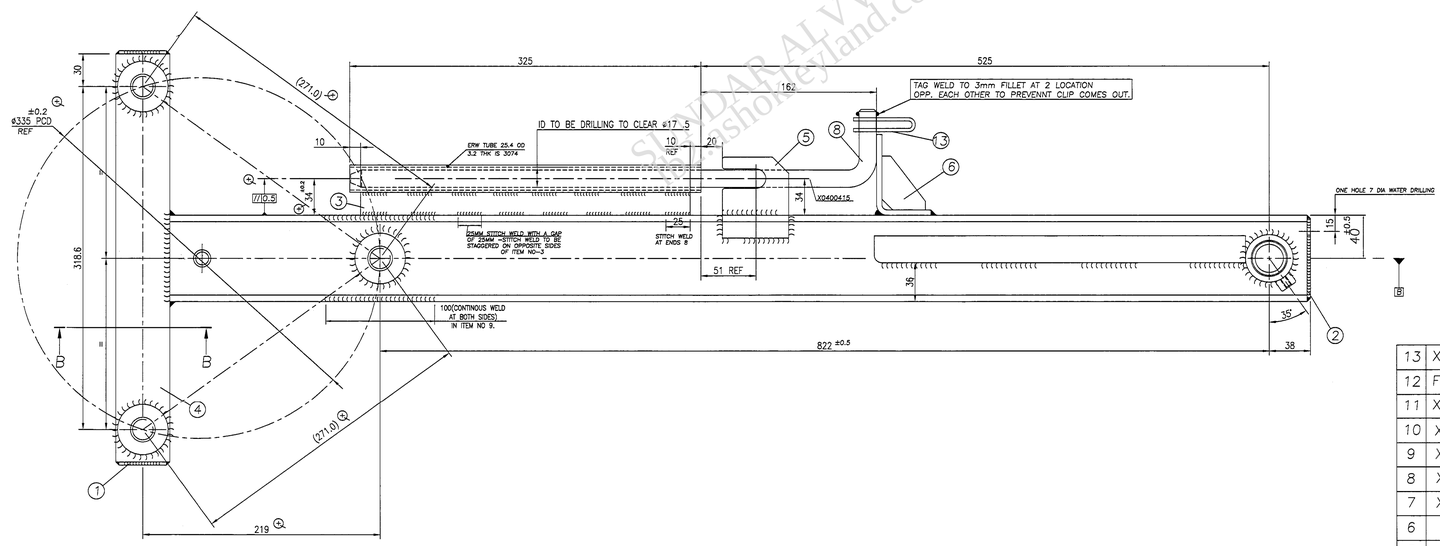
ASHOK LEYLAND LTD.,
TECHNICAL CENTRE, VELLIVOYALCHAVADI.

ALTERATIONS	F.D.N. DATE	GRADE	SUFFIX	MICRO FILMED
VIEWS UPDATED INLINE WITH BOM DIN:023558 RP/EA	19 07 06	–	A	







NOTE:-
⊕ IMPORTANT DIMN.

SL. NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY
13	X0800910	CLIP	REF DRG.	1
12	F0532832	BUSH	REF DRG.	2
11	X1963815	TUBE PIVOT	REF DRG.	1
10	X0439310	GUSSET	REF DRG.	1
9	X4695014	ASSY. ARM	REF DRG.	1
8	X0400415	BOLT – TOWER	REF DRG.	3
7	X1225515	STUD	REF DRG.	1
6	———	BRKT – BOLT STOPPER	PLATE 5 THK. IS 2062 Gr'A'	1
5	———	PLATE – BOLT LOCK	PLATE 5 THK. IS 2062 Gr'A'	1
4	———	TUBE – SQR.	50x50x4 HF SHS. TO IS 4923 Gr YST 240	1
3	———	SUPPORT – BOLT TUBE	FLAT 5 THK. IS 2062 Gr'A'	1
2	———	CLOSURE PLATE	PLATE 3 THK. IS 1079 Gr 'O'	1
1	———	CLOSURE PLATE	PLATE 3 THK. IS 1079 Gr 'O'	2

UNLESS OTHERWISE SPECIFIED

SURFACE PROTECTION: FABRICATED COMPONENTS TO BE PHOSPHATED TO CLASS 'C' AS PER IS:3618 AND APPLIED IMMEDIATELY WITH RED OXIDE ZINC CHROMATE PRIMER TO IS:2074;
MACHINED SURFACES TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS:1154.

MACHINING TOLERANCES FOR OPEN DIMENSIONS WILL BE AS PER IS:2102

DIMN	OVER	–	6	30	120	315	1000	2000	> 4000
	UPTO & INCLUDING	6	30	120	315	1000	2000	4000	–
	TOLERANCE	±0,1	±0,2	±0,3	±0,5	±0,8	±1 2	± 2	±3

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 IS:4218. CLASS 6g EXTERNAL OR 5H INTERNAL

DO NOT SCALE DRAWING. ALL DIMENSIONS ARE IN MM

SPECIAL INSTRUCTION / NOTE :

WELDING SYMBOLS AS PER IS : 813.
USE WELDING ELECTRODES EQUIVALENT TO AWS E6012 OR E6013.
WELD FILLET TO BE 5mm.
PERMISSIBLE TWISTS & BOW = 3mm AFTER WELDING.

NOTE:
SCAMIC GREEN PAINT IS TO APPLIED, AS PER AL RECOMMENDATIONS IN LINE WITH DRG TO PT.NO: X9715000.

BILL OF MATERIALS

REF PART NO.	B0993603	ISSUED UNDER		MICROFILMED
SUPERSEDES		EDM / DIN	DATE	BY
S/A PART NO.	B0904101	021078	01.03.05	DATE
WEIGHT	ROUGH / FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED		YES / NO
SCALE	1:2	APPROVAL NUMBER		
SPEC. NO.	HASWC38	TESTING STD.		

STAGE	CHECKED / DATE	APPROVED / DATE	ALTERATION LEVEL
I	ABM 25.10.02	SN 25.10.02	#
II	ABM 10.07.03	SN 10.07.03	#
III			

DRAWN / DATE	MBC 25.10.02	RETRACED / DATE	———
CHECKED / DATE	ABM 25.10.02	M.E.D. APPROVAL / DATE	P.SURESH 12.07.03
APPROVED / DATE	SN 25.10.02	STDS APPROVAL / DATE	———

MATERIAL: SEE DRG

HEAT TREATMENT: ———

REMARKS: MRLV

DESCRIPTION: S/A ARM SWC

PART NO. B0904103 A

SHEET NO. 1 OF 1

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