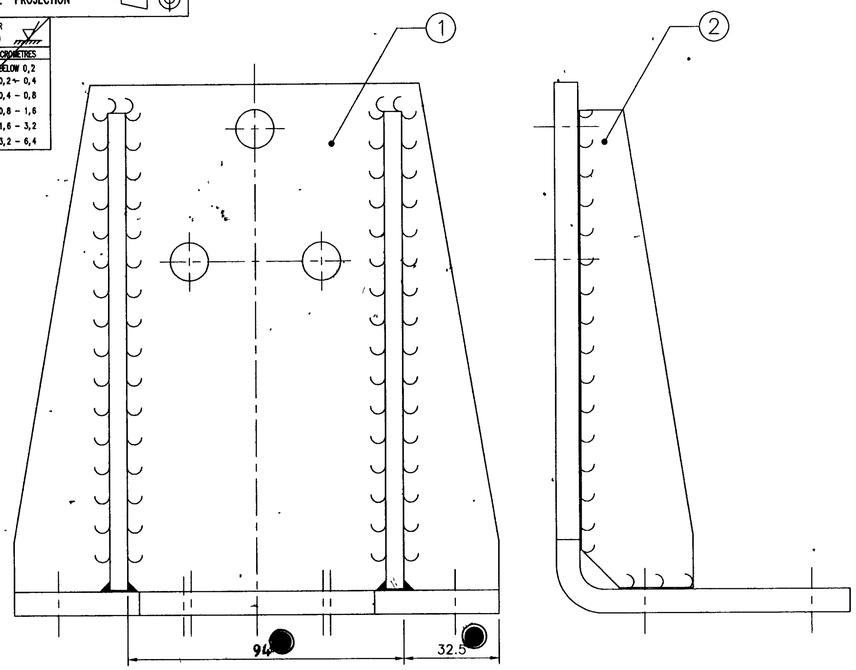
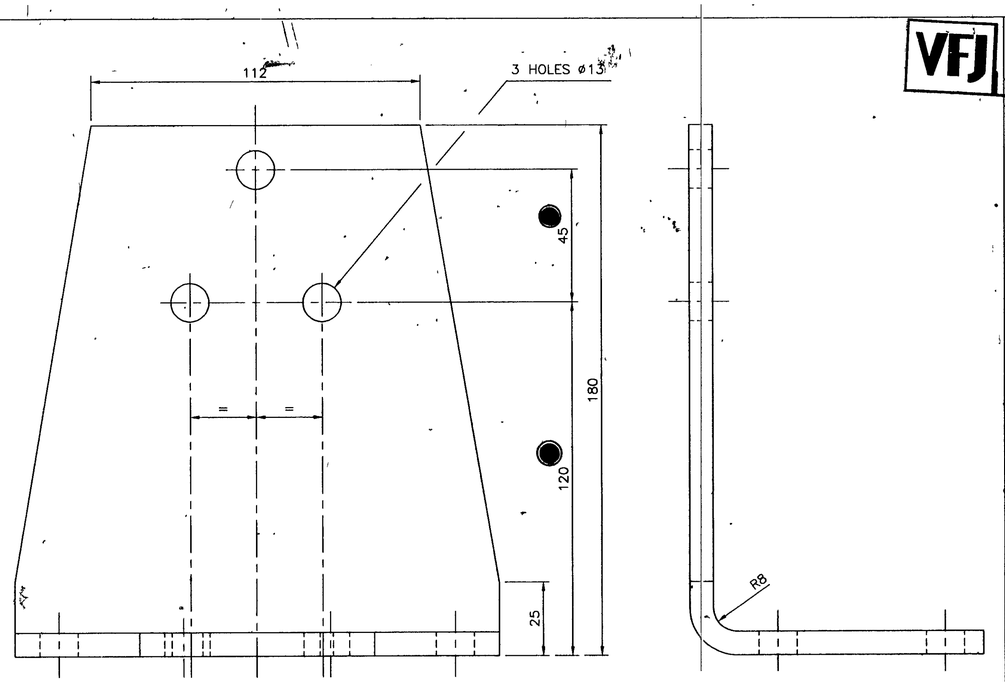
ASHOK LEYLAND

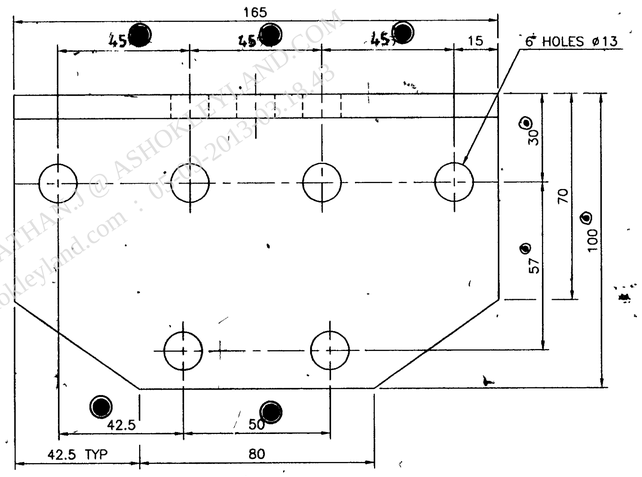
FIRST ANGLE PROJECTION

SURFACE FINISH AS PER IS.3073 (CLA VALUE)

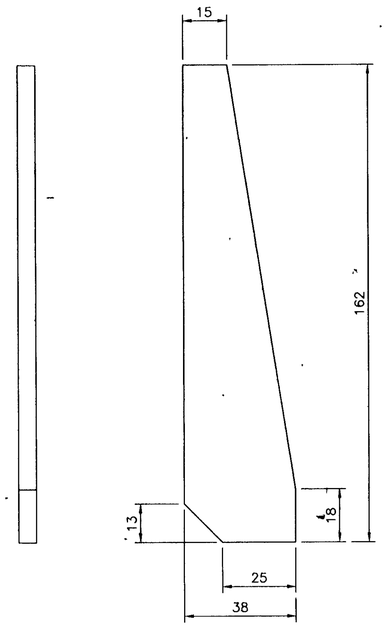
MICRO INCHES	MICROMETRES
BELOW 8	BELOW 0,2
8 - 16	0,2 - 0,4
16 - 32	0,4 - 0,8
32 - 64	0,8 - 1,6
64 - 125	1,6 - 3,2
125 - 250	3,2 - 6,4







ITEM 1



ITEM 2

CRITICAL DIMENSIONS

VFJ

PART NO.

ALTERATIONS

E.D.M. DATE	GRADE	SUFFIX	MICRO FILMED

STAGE	CHECKED	DATE	APPROVED	DATE	ALTERATION LEVEL
I					
II		19/8/97		25/8	#
III		4/12/97		1/1/97	#

DRAWN	DATE	VR 19.8.97	RETRACED / DATE
CHECKED	DATE	19/8/97	M.E.D. APPROVAL / DATE
APPROVED	DATE	25/8	STD.S APPROVAL / DATE

MATERIAL: REF.TABULAR COLUMN

HEAT TREATMENT

REMARKS: STALLION 4X4 MARK-III

DESCRIPTION: BRKT FOR CROSS MEMBER

PART NO. X 0 4 7 6 2 1 0 #

SHEET NO. 1 OF 1

SL. NO	PART NUMBER	DESCRIPTION	MATERIAL	QTY
2	———	GUSSET	6 THK IS 2062 Gr Fe 410 WB	2
1	———	PLATE FOR BRACKET	8 THK IS 2062 Gr Fe 410 WB	1

BILL OF MATERIALS

REF PART NO.	X0472414	ISSUED UNDER		MICROFILMED	
SUPERSEDES	———	DIM / DIN	DATE	BY	———
S/A PART NO.		H5767	23 8 97	DATE	———
WEIGHT	ROUGH / FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED		YES	NO
SCALE	1:1	APPROVAL NUMBER	———		
SPEC. NO.	HAF-3	SPECIAL STD.	———		

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 FILLET - 5mm
WELDING ELECTRODE TO SPEC AWS E6013.
TO BE APPLIED WITH ZINC PHOSPHATE GREY PRIMER TO ALB804

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