

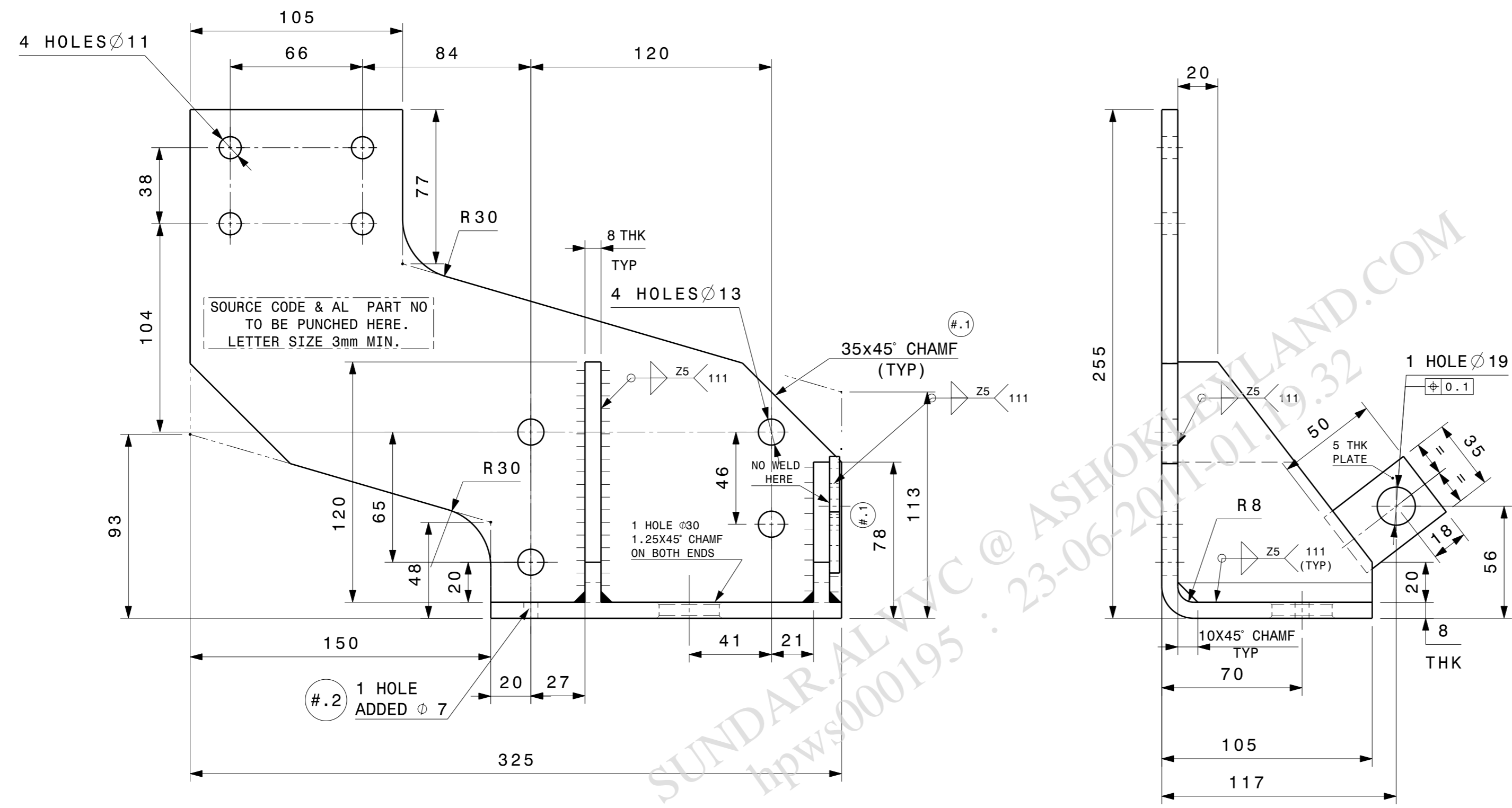


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ASHOK LEYLAND LTD.
 TECHNICAL CENTRE VELLIVAYALCHAVADI



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
CHAMF 50X45° DELETED, CHAMF 35X45° MADE TYPICAL, DIM 78 ADDED. JR/EAK	25/02/08	-	#.1
1 HOLE ADDED ϕ 7 SG/SV	10/12/09	-	#.2



SURFACE TREATMENT:
SCAMIC GREEN PAINTING TO BE DONE INLINE WITH DRG TO AL.PART NO :X9715000

AL PLM VAULT

REVISION : #2	DATE : 13/12/2010	STATUS : RELEASE
STAGE : III	ER-DIN NO : ER-DIN-0003616	DATE : 13/12/2010
ALTERED BY : ashokkumar.alvvc	CHECKED BY : sundar.alvvc	
MED APPROVAL : N/A	APPROVED BY : snagarajan.alvvc	

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
AA 02/07/05	SN 02/07/05	PS 12/05/06	SN 02/07/05	

MATERIAL: STEEL T0 IS:2062 Gr'B'

HEAT TREATMENT: _____

- SPECIAL INSTRUCTIONS/NOTE:**
- GENERAL TOLERANCE TO BE ± 0.5 MM.
 - TOLERANCE ON HOLE PITCHES & SIZES TO BE ± 0.25 MM.
 - TOLERANCE ON OVERALL DIMENSIONS TO BE ± 1 MM.
 - WELDING TO CONFORM TO ALS.276.02. WELDING SYMBOLS AS PER IS 813.
 - WELD ELECTRODE TO SPEC AWS E0613/E6012.
 - BEND LINE TO BE TO GRAIN FLOW DIRECTION.

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY

BILL OF MATERIALS

APPEARANCE ITEM	ER-DIN	DATE
<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	ER-DIN-023236	11/05/06
FINISHED WEIGHT (APPROX)	REF PART NO:	X7188410
	S/A PART NO:	
SCALE	SUPERSEDES	
1:2	SPEC NO:	HAF147

REMARKS: STALLION MK-IV

DESCRIPTION: SHOCK ABSORBER MTG BRKT

PART NO. **F 8 4 2 5 1 1 4 #.2**

SHEET No1..... OF1..... **A2**

UNLESS OTHERWISE SPECIFIED

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 \leq 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:4218 CLASS 6g EXTERNAL OR 5H INTERNAL
	SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

-CRITICAL
 -SAFETY
 -IMPORTANT. THIS DRAWING CONTAINS
 SAFETY CHARACTERISTICS