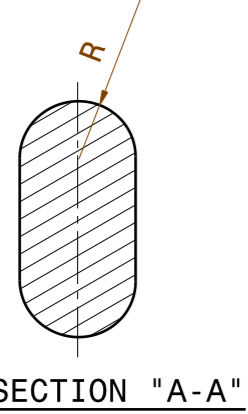
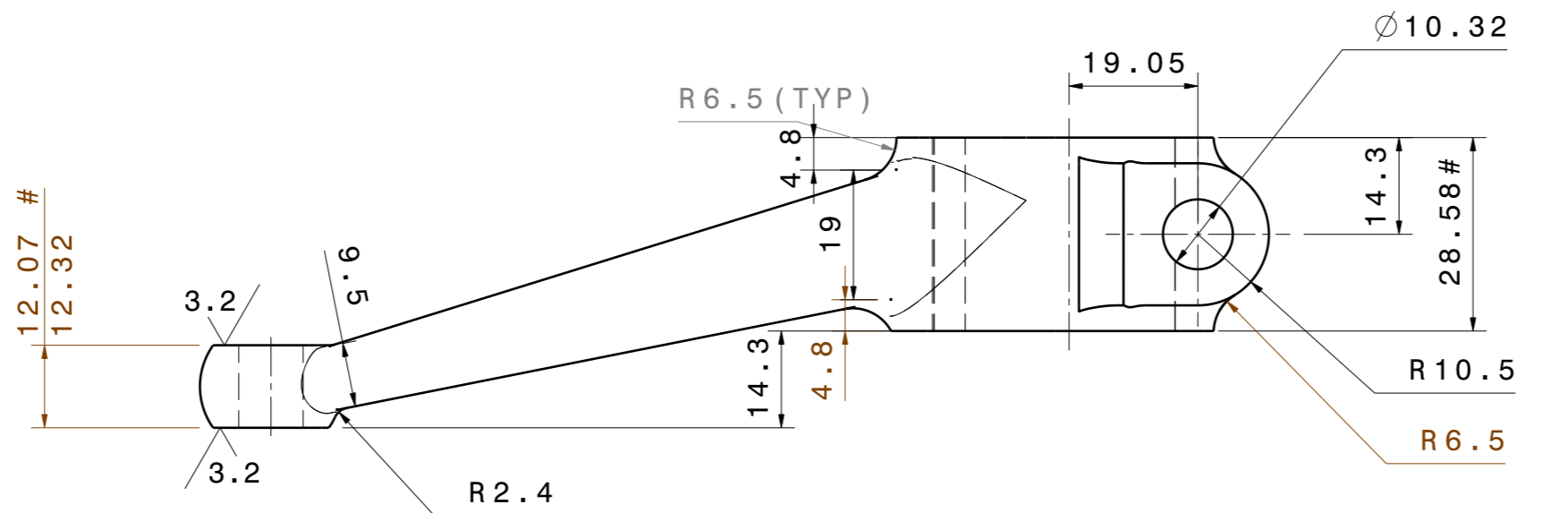




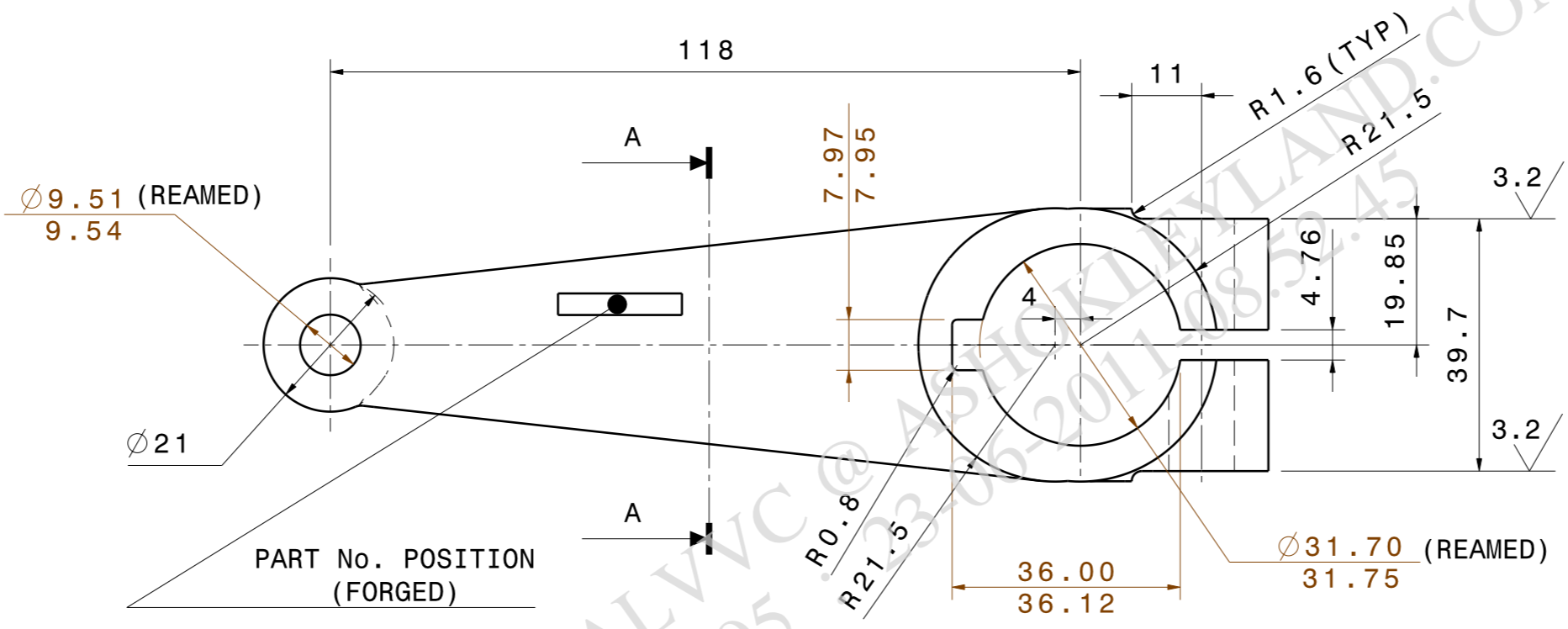
ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVAYALCHAVADI



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
SURFACE TREATMENT NOTE & TEST DETAILS ADDED SM/MGN	ER-DIN-3934 10-10-2009	--	A



DRAW OF FORGING = 5° (APPROX)



- A SURFACE TREATMENT:**  
TO BE ZINC PLATED AND GREEN CHROME PASSIVATED.  
PLATING THICKNESS 12MICRON MIN.
- SALT SPRAY TEST:**  
NO EVIDENCE OF WHITE RUST FORMATION TILL 120 Hrs.  
AND RED RUST TILL 300 Hrs. WHEN TESTED AS PER ASTM B117.

AL PLM VAULT  
REVISION:A |DATE:10-10-2009 |STATUS:RELEASE  
STAGE:III |ER-DIN NO/DATE: ER-DIN-0003934 / 12-10-2009  
ALTERED BY:shaikhmd.alh2 |CHECKED:nehrumg.alvvc  
MED APPROVAL:--NA-- |APPROVED:nehrumg.alvvc  
DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
K.T 13.03.2002	K.T 13.03.2002	SURESH 14.03.2002	VRG 14.03.2002	---

MATERIAL: En8 / 080M40 BS970  
HEAT TREATMENT: HARDENED-2 TEMPERED TO 179-229 BHN

C - CRITICAL S - SAFETY I - IMPORTANT. THIS DRAWING CONTAINS SAFETY CHARACTERISTICS		
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 <= 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

SPECIAL INSTRUCTIONS/NOTE:  
1.FACES TO BE COINED FLAT & PARALLEL TO EACH OTHER FOR FACE DIMN. MARKED THUS '#'.  
2.BURRS TO BE REMOVED.

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
BILL OF MATERIALS					
		APPEARANCE ITEM	ER-DIN	DATE	
		YES	NO	018331	17.10.02
		FINISHED WEIGHT (APPROX)	REF PART NO:	F2443911	
		550g	S/A PART NO:	---	
		SCALE	SUPERSEDES	---	
		1:1	SPEC NO:	ALCWG 19/18	

REMARKS: FOR 2516 TIPPER/VALED 380 DIA CLUTCH  
DESCRIPTION: CLUTCH OPERATING LEVER-OUTER  
PART NO. **F 2 4 1 4 9 1 1** **A**  
SHEET No .....1..... OF .....1..... **A2**