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ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVAYALCHAVADI



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
TRAIL ORDER QUANTITY 1000 NOS WAS 100 NOS. KV/BSV	28.09.10	-	#.1

ZFI SCOPE OF SUPPLY				
ZFI POWER STEERING GEAR KIT FOR ASHOK LEYLAND VEHICLE - STALLION 4 x 4 MK IV - RHD				
ITEM	SR. NO.	DESCRIPTION	QTY.	ZFI PART NO. / A.L. PART NO.
A		ZFI POWER STEERING GEAR KIT WITH DROP ARM & BRACKET (A = C + D + E + 05)	01	8043 975 016 / B 2238219
B		ZFI POWER POWER STEERING GEAR KIT WITH DROP ARM (B = C + D)	01	8043 975 016/1 / B 2238218
C		P S G KIT FOR STALLION MK IV RHD (C = 01 + 02 + 03 + 04)	01	8043 975 016/2 / B 2238217
D		DROP ARM	01	7373 012 830 / X 3206611
E		ADAPTOR BRACKET (RHD) STG GEAR MTG	01	8043 890 800 / X 0405722
01	a	POWER STEERING GEAR - RHD WITH LOCKING WASHER & HEX. NUT	01	8043 955 804 / X 7407500
	b	M16 BANJO BODY	01	7723 041 807 / X 3110415
	c	M16 BANJO BOLT	01	0636 015 814 / X 3103015
	d	M18 BANJO BODY	01	7723 041 802 / X 3103115
	e	M18 BANJO BOLT	01	0636 015 808 / X 3103215
02		OIL TANK ASSY.	01	7632 472 806 / F 7464000
03	i	BANJO BODY - M26 - FOR OIL TANK	01	7723 022 802 / F 3149715
	ii	BANJO BOLT - M26 X 15 - FOR OIL TANK	01	0636 015 815 / F 3149815
04		VANE PUMP ASSEMBLY KIT (04 = 1+2+3+4+5)	01	7673 975 816 / B 2238216
05	1	VANE PUMP ASSEMBLY WITH WOODRUFF KEY	01	7673 955 807 / X 8834800
	i	SPRING WASHER - M14 - TYPE B - IS : 3063 - 1994 / DIN 127	01	0630 301 802/1 / L 4111400
		HEX NUT (THIN) - M14 x 15 (DIN 936 / IS : 1364 - 2002)	01	0637 009 112/1 / L 3121418
	2	BANJO BODY - M26	01	7723 041 809 / F 8Y00215
	3	BANJO BOLT - M26 x 15	01	0636 015 815 / F 3149815
	4	BANJO BODY - M16	01	7723 041 810 / F 8Y00115
	5	BANJO BOLT - M16 x 15	01	0636 015 816 / X 3106915
	a	HEX. BOLT - M18 x 15 x 60 L (CLASS 10.9)	04	0636 015 818 / X 3554515
		SPRING WASHER - M18 - TYPE B - IS : 3063 - 1994 / DIN 127	04	0630 301 808 / L 4111800

SR NO.	MOD CODE	AMENDMENTS	DATE	NAME	APPD.

ANGLE WITHIN TOLERANCES SPECIFIED	LENGTH OF THE SHORTER LEG (mm)	DO NOT SCALE THE DRAWING	ALL DIMENSIONS ARE IN mm.	REMOVE ALL SHARP CORNERS AND BURRS
UP TO 10	UP TO 10		FIRST ANGLE PROJECTION METHOD	
OVER 10	OVER 10			
DEGREES: MINUTES	±1° ±30'	THIS IS THE PROPERTY OF ZF STEERING GEAR (I) LTD. THIS SHOULD NOT BE COPIED OR COMMUNICATED TO ANY PERSON WITHOUT WRITTEN APPROVAL OF PROPRIETOR		
OVER 100mm EACH	±0.05mm ±0.10mm ±0.15mm ±0.20mm	LAD DRAWING DO NOT CHANGE MANUALLY		
MACHINING DIMENSION WITH UNSPECIFIED TOLERANCES		TITLE		
GRADE	VALUE	SCOPE OF SUPPLY - KIT		
1 TO 30	±0.2	FOR STALLION 4x4 MK-IV RHD		
30 TO 180	±0.4	SCALE N.T.S. SIZE A3 REF B 2238207 NO.8043 975 857		
180 TO 500	±0.6	DRG NO. 8043 975 016		
500 TO 1000	±0.8			
1000 TO 2500	±1.0			
2500 TO 5000	±1.5			
5000 TO 10000	±2.0			
10000 TO 25000	±3.0			
25000 TO 50000	±4.0			
50000 TO 100000	±5.0			
100000 TO 250000	±7.0			
250000 TO 500000	±10.0			
500000 TO 1000000	±15.0			
1000000 TO 2500000	±20.0			
2500000 TO 5000000	±30.0			
5000000 TO 10000000	±40.0			
10000000 TO 25000000	±50.0			
25000000 TO 50000000	±60.0			
50000000 TO 100000000	±70.0			
100000000 TO 250000000	±80.0			
250000000 TO 500000000	±90.0			
500000000 TO 1000000000	±100.0			
1000000000 TO 2500000000	±120.0			
2500000000 TO 5000000000	±150.0			
5000000000 TO 10000000000	±200.0			
10000000000 TO 25000000000	±250.0			
25000000000 TO 50000000000	±300.0			
50000000000 TO 100000000000	±400.0			
100000000000 TO 250000000000	±500.0			
250000000000 TO 500000000000	±600.0			
500000000000 TO 1000000000000	±700.0			
1000000000000 TO 2500000000000	±800.0			
2500000000000 TO 5000000000000	±900.0			
5000000000000 TO 10000000000000	±1000.0			
10000000000000 TO 25000000000000	±1200.0			
25000000000000 TO 50000000000000	±1500.0			
50000000000000 TO 100000000000000	±2000.0			
100000000000000 TO 250000000000000	±2500.0			
250000000000000 TO 500000000000000	±3000.0			
500000000000000 TO 1000000000000000	±4000.0			
1000000000000000 TO 2500000000000000	±5000.0			
2500000000000000 TO 5000000000000000	±6000.0			
5000000000000000 TO 10000000000000000	±8000.0			
10000000000000000 TO 25000000000000000	±10000.0			
25000000000000000 TO 50000000000000000	±12000.0			
50000000000000000 TO 100000000000000000	±15000.0			
100000000000000000 TO 250000000000000000	±20000.0			
250000000000000000 TO 500000000000000000	±25000.0			
500000000000000000 TO 1000000000000000000	±30000.0			
1000000000000000000 TO 2500000000000000000	±40000.0			
2500000000000000000 TO 5000000000000000000	±50000.0			
5000000000000000000 TO 10000000000000000000	±60000.0			
10000000000000000000 TO 25000000000000000000	±80000.0			
25000000000000000000 TO 50000000000000000000	±100000.0			
50000000000000000000 TO 100000000000000000000	±120000.0			
100000000000000000000 TO 250000000000000000000	±150000.0			
250000000000000000000 TO 500000000000000000000	±200000.0			
500000000000000000000 TO 1000000000000000000000	±250000.0			
1000000000000000000000 TO 2500000000000000000000	±300000.0			
2500000000000000000000 TO 5000000000000000000000	±400000.0			
5000000000000000000000 TO 10000000000000000000000	±500000.0			
10000000000000000000000 TO 25000000000000000000000	±600000.0			
25000000000000000000000 TO 50000000000000000000000	±800000.0			
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10000000000000000000000000000000 TO 25000000000000000000000000000000	±300000000.0			
25000000000000000000000000000000 TO 50000000000000000000000000000000	±400000000.0			
50000000000000000000000000000000 TO 100000000000000000000000000000000	±500000000.0			
100000000000000000000000000000000 TO 250000000000000000000000000000000	±600000000.0			
250000000000000000000000000000000 TO 500000000000000000000000000000000	±800000000.0			
500000000000000000000000000000000 TO 1000000000000000000000000000000000	±1000000000.0			
1000000000000000000000000000000000 TO 2500000000000000000000000000000000	±1200000000.0			
2500000000000000000000000000000000 TO 5000000000000000000000000000000000	±1500000000.0			
5000000000000000000000000000000000 TO 10000000000000000000000000000000000	±2000000000.0			
10000000000000000000000000000000000 TO 25000000000000000000000000000000000	±2500000000.0			
25000000000000000000000000000000000 TO 50000000000000000000000000000000000	±3000000000.0			
50000000000000000000000000000000000 TO 100000000000000000000000000000000000	±4000000000.0			
100000000000000000000000000000000000 TO 250000000000000000000000000000000000	±5000000000.0			
250000000000000000000000000000000000 TO 500000000000000000000000000000000000	±6000000000.0			
500000000000000000000000000000000000 TO 1000000000000000000000000000000000000	±8000000000.0			
1000000000000000000000000000000000000 TO 2500000000000000000000000000000000000	±10000000000.0			
2500000000000000000000000000000000000 TO 5000000000000000000000000000000000000	±12000000000.0			
5000000000000000000000000000000000000 TO 10000000000000000000000000000000000000	±15000000000.0			
10000000000000000000000000000000000000 TO 25000000000000000000000000000000000000	±20000000000.0			
25000000000000000000000000000000000000 TO 50000000000000000000000000000000000000	±25000000000.0			
50000000000000000000000000000000000000 TO 100000000000000000000000000000000000000	±30000000000.0			
100000000000000000000000000000000000000 TO 250000000000000000000000000000000000000	±40000000000.0			
250000000000000000000000000000000000000 TO 500000000000000000000000000000000000000	±50000000000.0			
500000000000000000000000000000000000000 TO 1000000000000000000000000000000000000000	±60000000000.0			
1000000000000000000000000000000000000000 TO 2500000000000000000000000000000000000000	±80000000000.0			
2500000000000000000000000000000000000000 TO 5000000000000000000000000000000000000000	±100000000000.0			