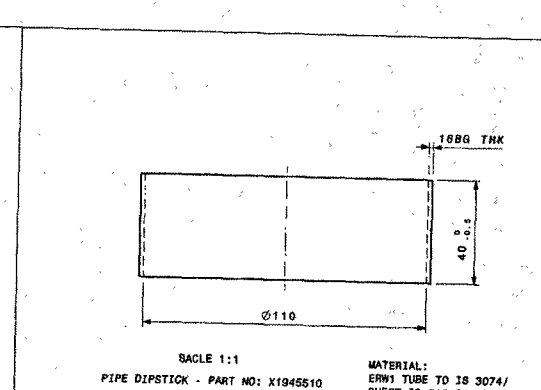
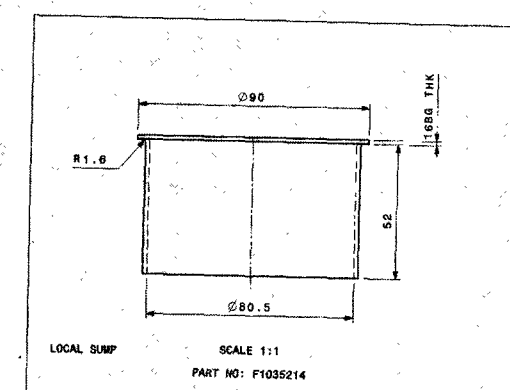
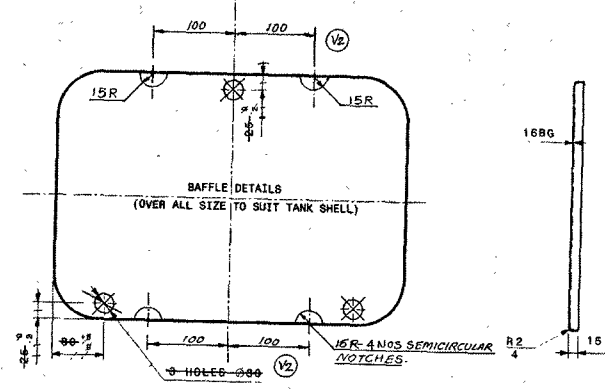
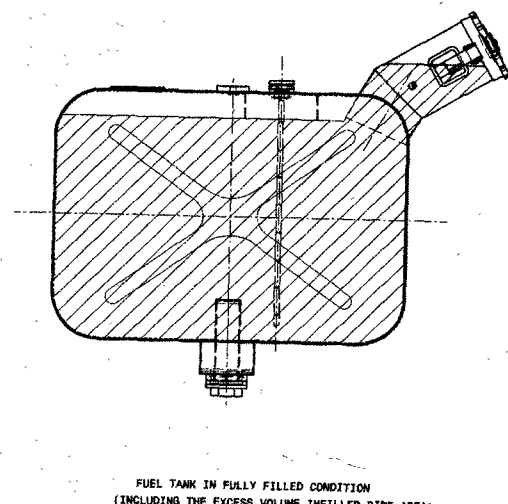
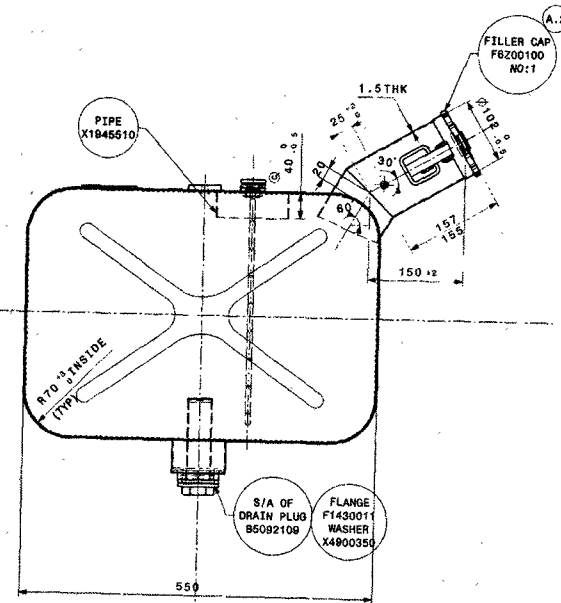
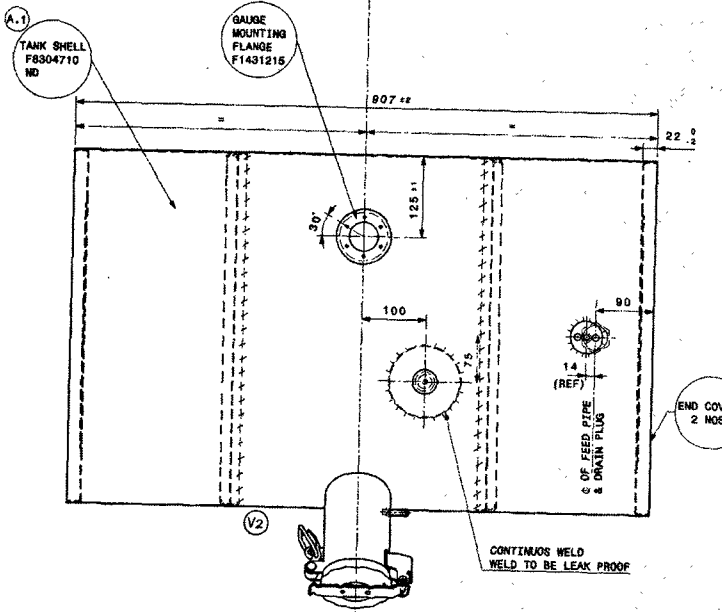
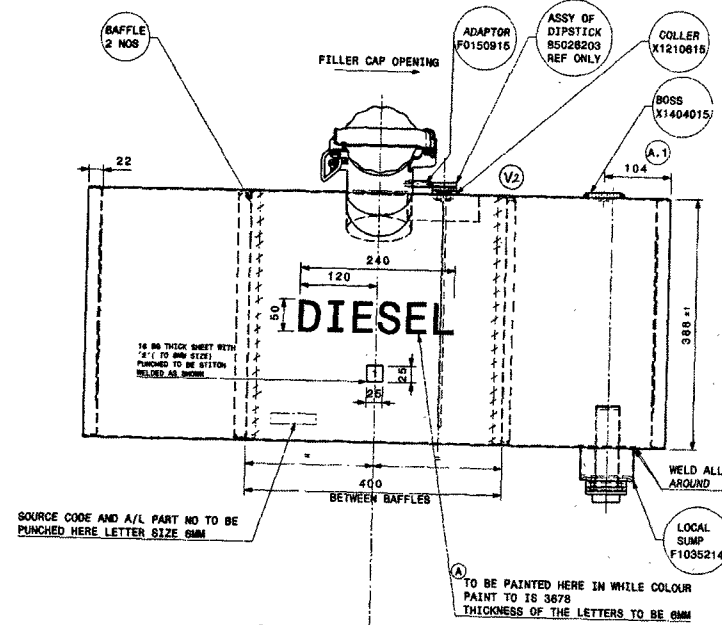


- FUEL TANK TO MEET THE FOLLOWING PERFORMANCE TESTS
- 1) FROM A TANK FILLED WITH LIQUID FUEL, THE RATE OF LEAKAGE FROM A FUEL TANK AND FITTINGS SHALL NOT EXCEED 50g/min WHEN INVERTED FOR 5 MINUTES RELATIVE TO ITS INSTALLED POSITION ON THE VEHICLE. THE FUEL OUTLET PIPE AND OTHER CONNECTION HOLES/PIPES SHALL BE PLUGGED WHILE CARRYING OUT THE TEST ( REF STD: IS 12055)
  - 2) PRESSURE TEST: THE FUEL TANK SHALL BE CAPABLE OF WITHSTANDING WITHOUT LEAKAGE AN INTERNAL PRESSURE OF 130KPA ( 1.3 ATMOSPHERE) CHANGE OF SHAPE IS PERMITTED ( REF STD: IS 12058)
  - 3) VIBRATION TESTS: THE TANK SHOULD BE ABLE TO WITHSTAND HIGH VIBRATIONS VARYING FROM 5-40Hz ( REF STD:SAE J703)
  - 4) DROP TEST: FILLING THE TANK WITH QUANTITY OF WATER EQUAL TO WEIGHT OF MAX FUEL AND THEN DROP IT BY 3.1 METRES (REF STD:SAE J703)
  - 5) FILL PIPE TEST: FILLING THE TANK WITH QUANTITY OF WATER EQUAL TO WEIGHT OF MAX FUEL AND THEN DROP IT BY 3.1 METRES LANDING SQUARELY ON THE FILL PIPE SECTION (REF STD: SAE J703)
  - 6) LEAKAGE TEST: ENTIRE FUEL TANK ASSEMBLY SHOULD NOT LEAK MORE THAN 28gms/min IN ANY STATIC POSITION THE TANK COULD ASSUME DURING THE TEST (REF STD: SAE J703)

- NOTE:
- \* B5028203 SHOWN FOR REF ONLY AND THIS IS NOT A PART OF B5028201
  - \* FUEL TANK CAPACITY IS 160 LITRES (ESTIMATED) THE CAPACITY MENTIONED IS UP TO THE INTRUDED END PART OF THE FILLER PIPE SHOWN IN THE DRAWING
  - \* VOLUME OF EXCESS FUEL THAT GETS FILLED IN THE FILLER PIPE AREA = 1.24 LITRES (ESTIMATED)
  - \* TOTAL FILLING CAPACITY INCLUSIVE OF THE FUEL IN THE FILLER PIPE AREA TO BE CHECKED ON SAMPLE DURING INSPECTION/APPROVAL
  - \* IT IS RECOMMENDED TO FILL THE FUEL TANK ONLY TILL THE INTRUDED PART OF THE FILLER PIPE



- NOTE:
- 1) MACHINE AT
  - 2) SURFACE TREATMENT OUTER SURFACE ONLY \* TO BE PAINTED WITH ENAMEL SCAMIC GREEN CONFORM TO GRADE NO: 284 IS:5 (REF DRG NO: X9715000)
  - 3) PHOSPHATING ON OUTER SURFACE BEFORE DRIVING USING THREE IN ONE AQUAPHOS.

VFJ

ALTERATIONS		DATE	BY	CHKD
X1945510-PIPE FOR DIPSTICK ADDED, LETTER 'DIESEL' ADDED.	SN	28/08/02	-	A
PT. NO. F8304710 WAS PT. NO. X3815000 D1M 104 WAS 90	SR/EA/K	02/11/07	-	A.1
PT. NO. F8200100 WAS X7437800	80/BSV	28/07/08	-	A.2
CH. NOTE NO- 50336/VI - 10-05-2011 NOTE FOR SURFACE TREATMENT CORRECTED.			JWM/TSS	JWM/MS
CH. NOTE NO- 50340 (V2) DATED - 31-05-2011 1) 2 NO BAFFLE PLATES FITTING ORIENTATION CHANGED TOWARDS END COVERS AND 3 NO HOLES OF 30 DIA AND ITS LOCATION ON BAFFLE PLATES ARE DELETED. 2) 4 NO SEMICIRCULAR NOTCHES OF 15R AT 100MM DISTANCE OF EACH FROM CENTRE ARE ADDED IN THE BAFFLE PLATES.			JWM/TSS	JWM/MS

- 1) BAFFLES TO BE SPOT WELD WITH SHELL. SPOTS TO BE SPACED AT 30(30).
- 2) END COVERS FLANGE ADAPTORS ETC TO BE WELDED WITH SHELL CONTINUOUSLY
- 3) WELDING ELECTRODE TO CONFORM ER70 S8 OF AWS A 5-18
- 4) INNER SURFACE OF FUEL TANK
- 5) COMPLETE INNER SURFACE OF TANK AND INDIVIDUAL COMPONENTS SUCH AS PIPE, FUEL MOUTH ETC. INCLUDING BAFFLES, END COVERS SHOULD BE PHOSPHATED TO CLASS 'C' AS PER IS 90610 AND TO BE CLEANED WITH DIESEL. CARE SHOULD BE TAKEN SO THAT WIRE GAUGE TO THE FUEL FILTER AND MOUTH INNER SIDE ARE NOT COATED WITH PAINT

SAFETY @ IMPORTANT. THIS DRG. CONTAINS SAFETY CHARACTERISTICS UNLESS OTHERWISE SPECIFIED

REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION

FABRICATED COMPONENTS TO BE DEGREASED, DECALCIFIED, APPLY ZINC PHOSPHATE, APPLY EPOXY PRIMER AND APPLY ENAMEL TO MEET 300 HRS OF SALT SPRAY LIFE WHEN TESTED AS PER ASTM B117 (UNDER PELLICULAR CORROSION < 2mm. NO BUBBLING IS ALLOWED.)

MACHINED SURFACE TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS 1154

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS-4219 CLASS 94 EXTERNAL OR 94 INTERNAL.

SHARP EDGES TO BE REMOVED

DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED

DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

SL. NO.	PART NO.	DESCRIPTION	MATERIAL	QTY.
BILL OF MATERIALS				
APPEARANCE ITEM	ER-DIN	DATE		
NO	021081	09/02/06		
FINISHED WEIGHT (APPROX)	REF. PT. NO.	BS082104		
	S/A. PT. NO.	A5028200		
SCALE	SUPERSEDES			
1:1	SPEC. NO.	ALOT 101		

DRWN/ DATE	CHECKED/ DATE	MD APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
RK 24/04/02	SN 07/05/02	CS 28/08/03	SN 07/05/02	

MATERIAL: COLD ROLLED SHEET STEEL 168G THK TO IS 513 0E0D

REVISION: A.2 [DATE: 31-07-2008] [STATUS: APPROVED]  
 STAGE: II [ER-DIN NO/DATE: ER-DIN-0001984 / 11-08-2008]  
 ALTERED BY: aeshokumar.alvvc [CHECKED: jr.alvvc]  
 MED APPROVAL: anantha.almdch [APPROVED: anagarajan.alvvc]  
 DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DESCRIPTION: S/A FUEL TANK LH (160 LITRES)

PART NO. **B 5 0 2 8 2 0 2** A.2

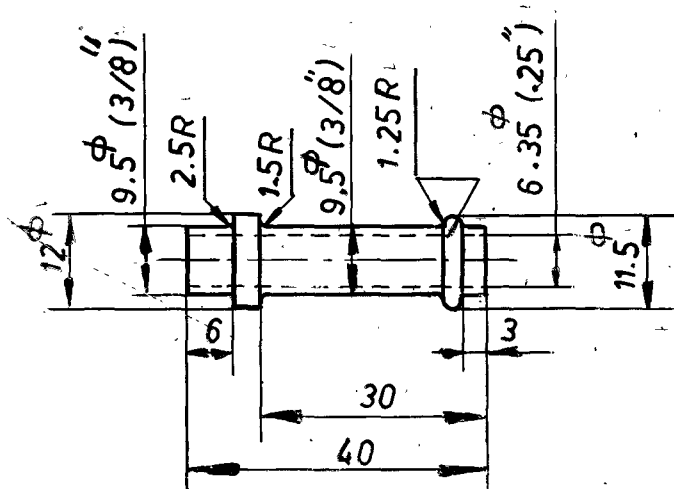
SHEET # 1

DRG. NO F 0150915

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SIGNATURE.....**

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UNLESS OTHERWISE STATED.



NOTE —

MATERIAL —

- 1 STEEL TO B.S. 970 EN 3B.
- 2 TO BE PHOSPHATED AND SEALED WITH OIL TO IS 3618-1966, CLASS 'A' COATING.
- 3 ALTERNATE MATERIAL — STEEL TO B.S. 970-EN 8M.

PART NO.	DESCRIPTION	MATERIAL	NO.OFF	DRG. NO.	DIFFERENCE
----------	-------------	----------	--------	----------	------------

Gen.Tol/Not Specified	Linear Dimension	Angular Dim.	Index	ALTERATION	Date	Signature	Zone	Shop	Approved
0-6	±0.1	±1°	~ Unmachined	DRAWING RETRACED	02-3-02	JGM			JGM / TS
6-30	±0.2	±30'	▽ Rough						
30-120	±0.3	±20'	∇ Smooth						
120-315	±0.5	±10'	∇∇ Finish						
315-1000	±0.8		Ⓣ C.Hard						
1000-2000	±1.2		Ⓢ Hardened						
			Ⓛ Gr. after Hard.						

		Description <u>ADAPTOR</u> For <u>FUEL TANK</u> Group <u>STALLION MARK-III</u>	Scale <u>1:1</u> Ref. Drg.
		Replaced by ..... Replacement for.....	Vehicle Factory JABALPUR

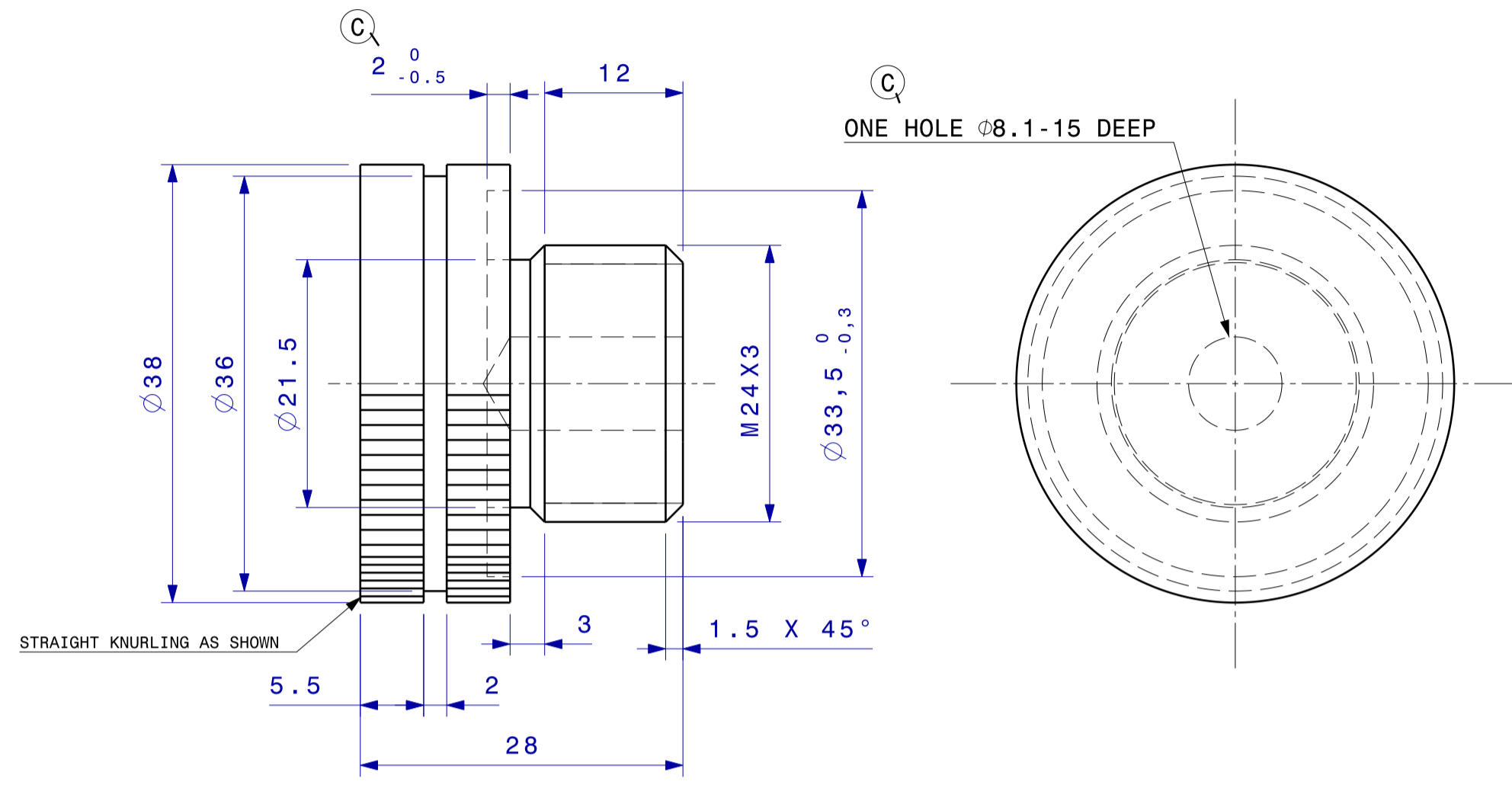
F 0150915

B

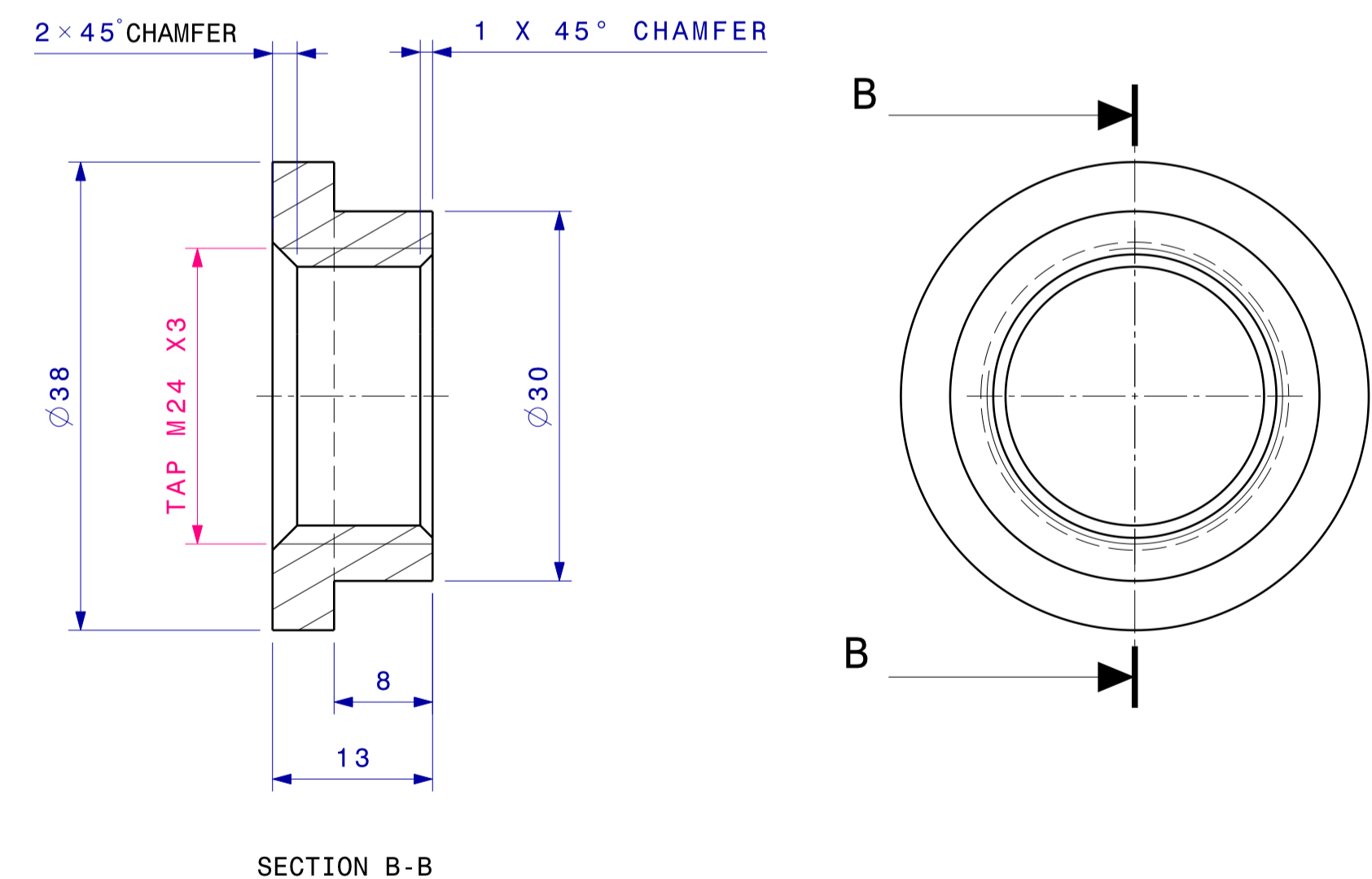


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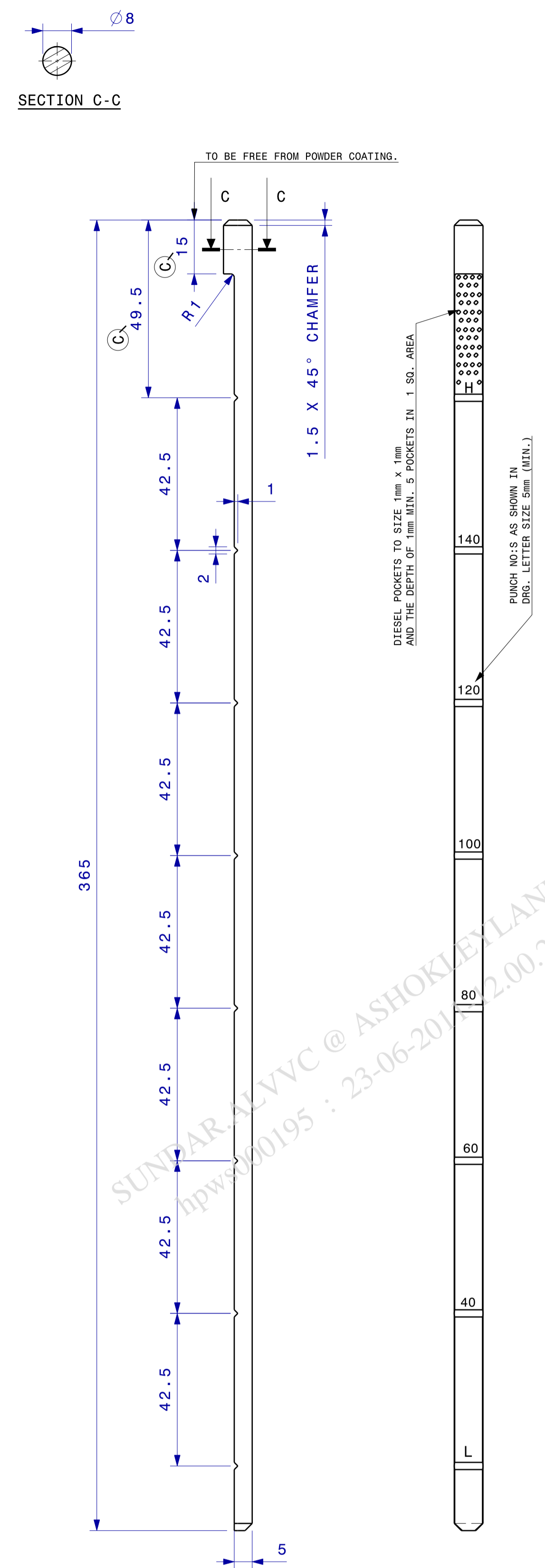
ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOVALCHAVADI



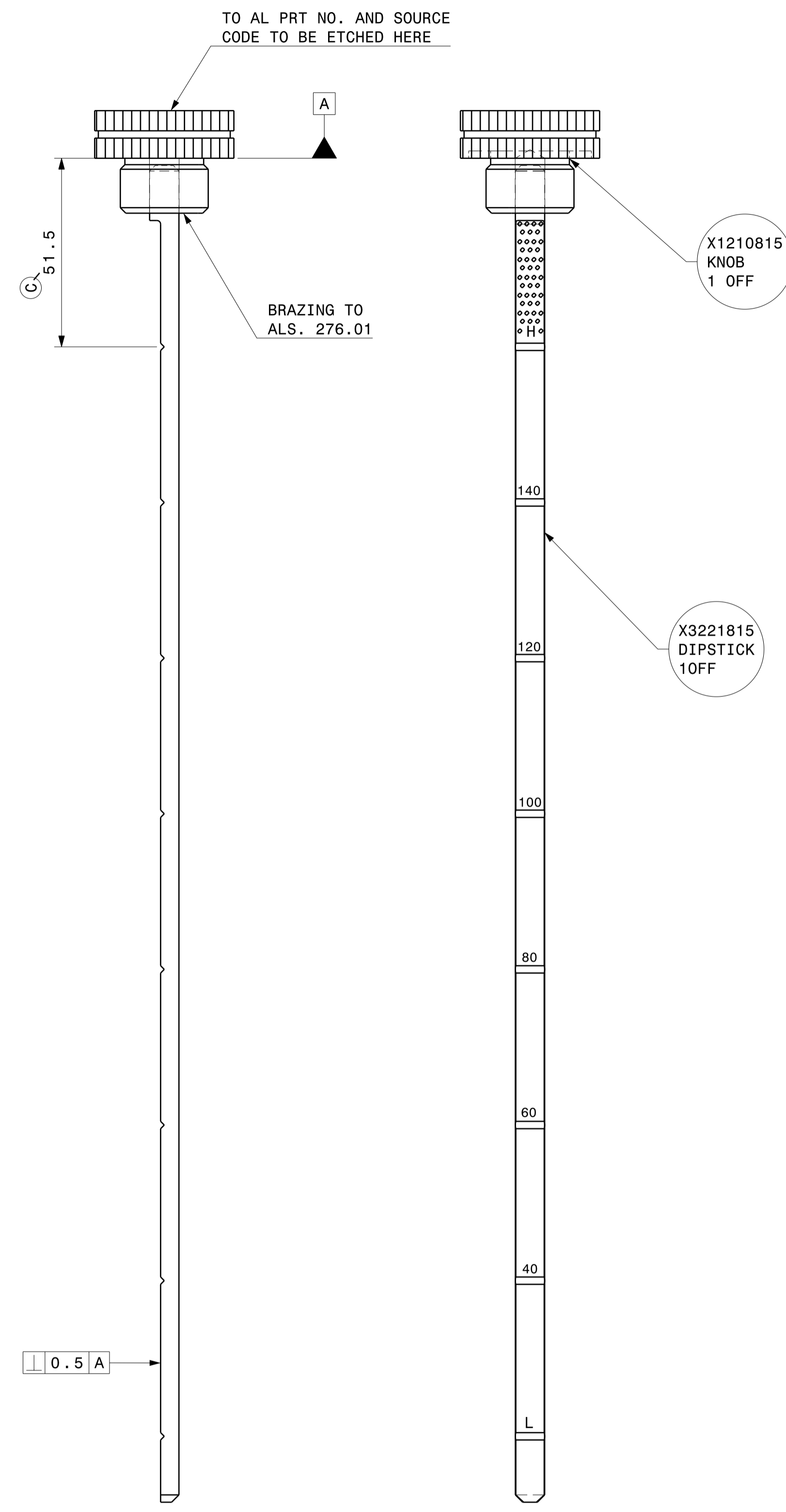
**KNOB - X1210815**  
MATL: EN 1A/220M07 OR EN32B/080M15/EN3B/070M20 OF BS970



**COLLER - X1210615**  
MATL: EN 1A/220M07 OR EN32B/080M15/EN3B/070M20 OF BS970



**DIPSTICK - X3221815**  
MATERIAL: STEEL-EN 1A/220M07 OR EN32B/070M20/EN3B/070M20 OF BS970



**ASSY OF DIPSTICK**  
PT NO: B5028203

ALTERATIONS		ER-DIN DATE	ISSUE	REVISION
SURFACE TREATMENT ADDED FOR ASSEMBLY.		06/11/07	-	#.1

AL PLM VAULT  
REVISION: #1 DATE: 11/12/2010 STATUS: RELEASE  
STAGE: III ER-DIN NO: ER-DIN-0006263 DATE: 11/12/2010  
ALTERED BY: ashokkumar.alvvc CHECKED BY: rchandran.alvvc  
MED APPROVAL: sureshp.alvvc APPROVED BY: sagarajan.alvvc

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
RK 23.04.02	SN 07.05.02	CS 23/08/03	SN 07.05.02	

MATERIAL: SEE DRG  
HEAT TREATMENT: \_\_\_\_\_

Q - IMPORTANT Q - CRITICAL Q - SAFETY. THIS DRG. CONTAINS SAFETY CHARACTERISTIC

**UNLESS OTHERWISE SPECIFIED**

ASHOK	TOLERANCES	REFER IS:2102 : MEDIUM FOR MACHINING AND COARSE FOR FABRICATION
LEYLAND	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 DO NOT SCALE DRAWING

**SPECIAL INSTRUCTIONS/NOTE:**

#.1 SURFACE TREATMENT: -  
TO BE POWDER COATED TO A COATING THICKNESS OF 60 MICRONS AND COLOUR TO BE BLACK. TO BE SUBJECTED TO PRETREATMENT AT POWDER COATING PLANT AS PER DRG X9803900. TO WITHSTAND 300 HOURS MIN OF SALT SPRAY LIFE WHEN TESTED AS PER ASTM B117. (UNDER PELLICULAR CORROSION <= 2mm. NO BLISTERING IS ALLOWED.)

SL.No.	PART NO.	DESCRIPTION	MATERIAL	QTY.
<b>BILL OF MATERIALS</b>				
APPEARANCE ITEM	ER-DIN	DATE		
YES	NO	021081	09/02/05	
FINISHED WEIGHT (APPROX)	REF. PT. No.	B5094806		
	S/A PT No.	A5028200		
SCALE	SUPERSEDES			
1:1	SPEC NO.	ALOT101		

REMARKS: FOR STALLION 4X4 MARK-IV

DESCRIPTION: **S/A OF DIPSTICK**

PART No. **B 5 0 2 8 2 0 3 #.1**

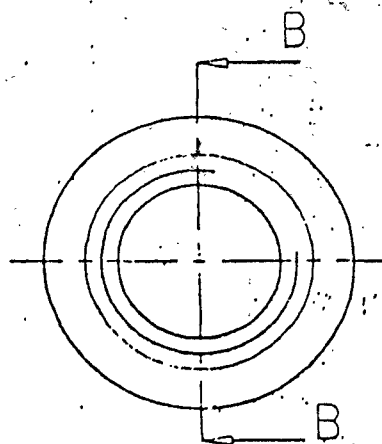
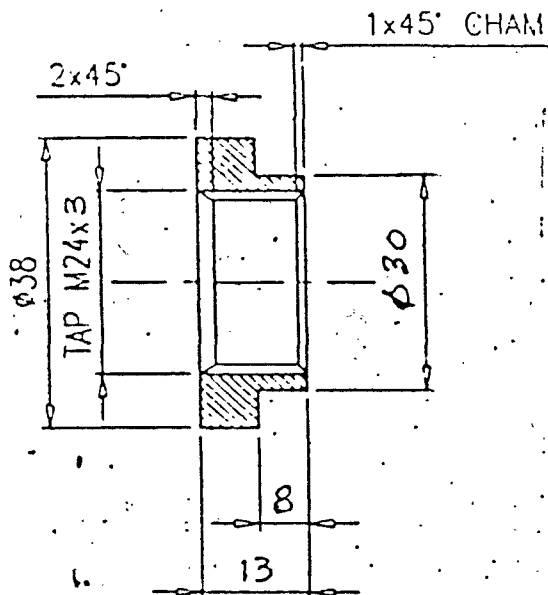
SHEET NO. ....1.....OF.....1..... **A1**

PARTNO X 1210615

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COPY DATE.....  
SIGNATURE.....**

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ALL DIMENSIONS ARE IN MM.



SECTION B-B

MATL: EN 1A (OR) EN 32B TO BS970  
TO BE ZINC PLATED

**MASTER COPY**

PART NO.	DESCRIPTION	MATERIAL	NO.OFF	DRG. NO.	DIFFERENCE
Gen Tol/Not Specified					
Linear Dimension				Drawn	Date Name Approved
0-6 ±0.1				Traced	10.11.99 [Signature]
6-30 ±0.2				Checked	10.11.99 [Signature]
30-120 ±0.3					10.11.99 [Signature]
120-315 ±0.5					
315-1000 ±0.8					
1000-2000 ±1.2	SEPRATE DRG. TRACED		10.11.99 [Signature]	Shop	[Signature]
Angular Dim.	Index	ALTERATION	Date	Sign	Zone
0-10 ±1°	~ Unmachined				
10-50 ±30'	∇ Rough				
50-100 ±20'	∇∇ Smooth				
> 100 ±10'	∇∇∇ Finish				
	(22) C.Hard				
	(24) Hardened				
	(14) Gr. after Hard.				
				Scale 1:1 Ref. Drg. B5094806 A 	
Description <b>COLLER</b> <b>FUEL TANK</b>		For..... Group <b>STALLION MK-III</b>		Replaced by..... Replacement for.....	
<b>VEHICLE FACTORY</b> <b>JABALPUR</b>		Part No. <b>X-1210615</b>		CHG NO.	

PL 102

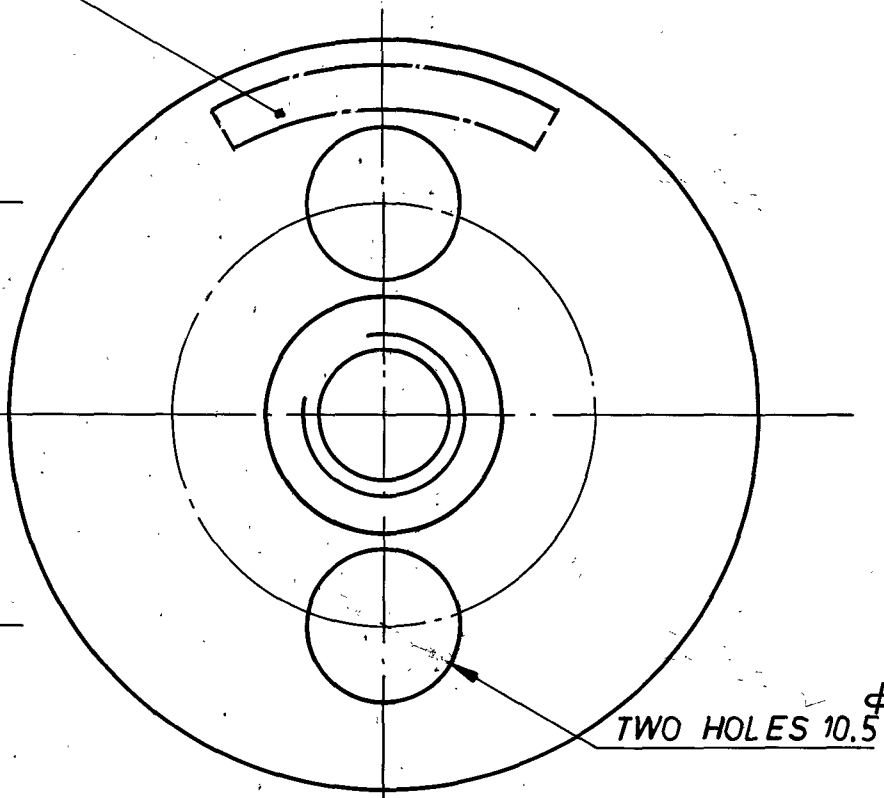
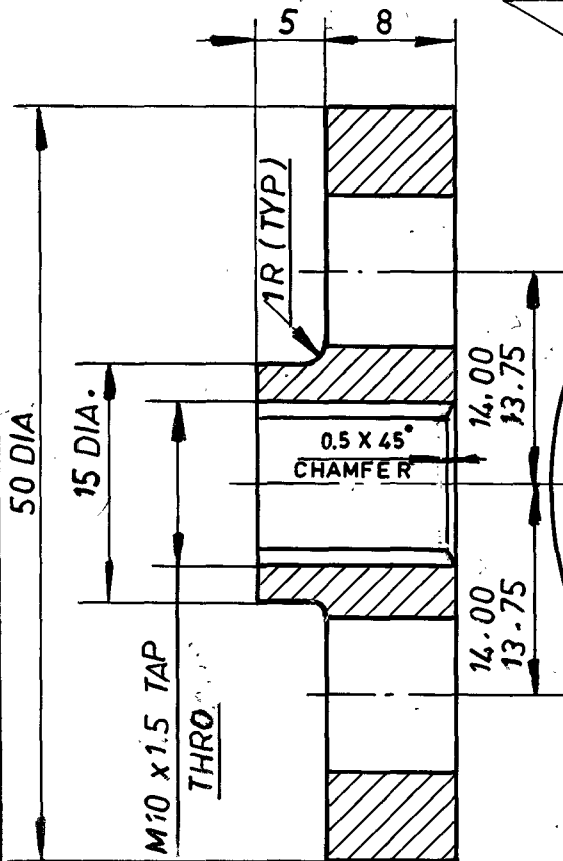
DRG. NO X 1404015

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ALL DIMENSIONS ARE IN m.m.

SOURCE CODE AND A/L PART NO. TO BE PROVIDED HERE. LETTER SIZE 3 m.m.



MATERIAL - EN-32-B ✓

SURFACE PROTECTION - MACHINED SURFACE TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS: 1154 ✓

MACHINING TOLERANCE FOR OPEN DIMENSIONS WILL BE AS PER IS: 2102 ✓  
SHARP EDGES TO BE REMOVED. ✓

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES IN THE CURRENT IS: 4218 CLASS 5H INTERNAL OR 6g EXTERNAL

PART NO.	DESCRIPTION	MATERIAL	NO.OFF	DRG. NO.	DIFFERENCE
Gen.Tol.Not Specified					
Linear Dimension				Drawn	Date Name Approved
0-6 ±0.1				Traced	25.2.02 ✓
6-30 ±0.2				Checked	25.2.02 THOSAR
30-120 ±0.3				JWM/STD	25-2-02 ✓
120-315 ±0.5					
315-1000 ±0.8					
1000-2000 ±1.2	DRAWING RETRACED	25-2-02	✓	✓	✓
Angular Dim.	Index	ALTERATION	Date	Sign	JGM/TS
0-10 ±1°	~ Unmachined				
10-50 ±30'	∇ Rough				
50-100 ±20'	∇∇ Smooth				
> 100 ±10'	∇∇∇ Finish				
	②② C.Hard				
	②④ Hardened				
	①④ Gr. after Hard.				
		<b>FLANGE</b> <b>FUEL TANK</b> <b>STALLION MARK - III</b>		Scale <b>2:1</b>	Ref. Drg. 
		<b>VEHICLE FACTORY</b> <b>JABALPUR</b>		Replaced by ..... Replacement for ..... <b>X 1404015 ✓</b>	

1 2 3 4 5 6 7 8 CHG NO.

ALL DIMENSIONS ARE IN m.m.

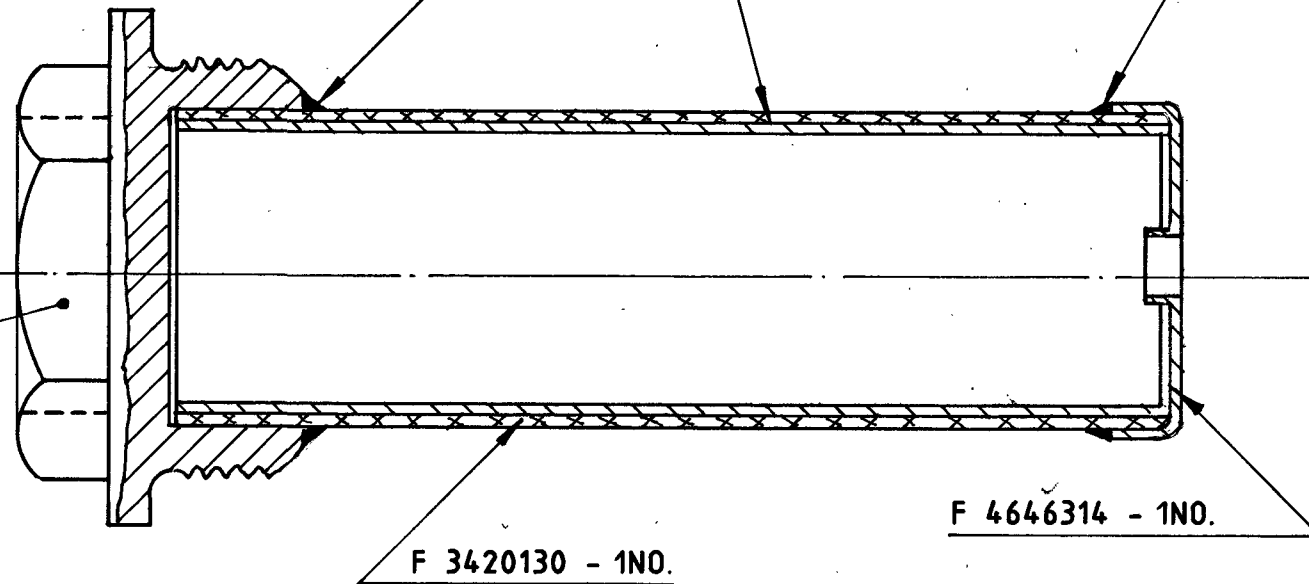
X 3000130 1 NOS-(ND) REF.

DETAIL 'Z'

BRAZE ALL AROUND TO BS: 1723

BRAZE ALL AROUND TO BS-1723

X 3502415 - 1NO.



F 3420130 - 1NO.

F 4646314 - 1NO.

**NOTE:-**

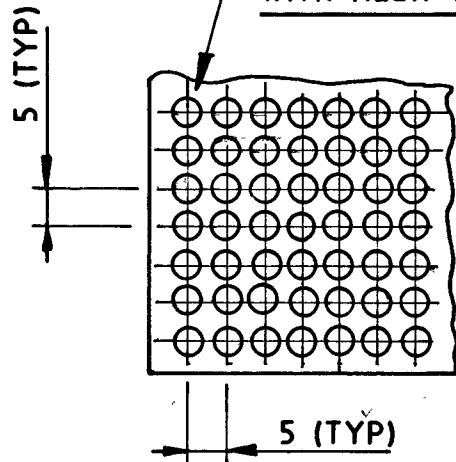
FABRICATED COMPONENTS TO BE PHOSPHATED TO CLASS 'C' AS PER IS: 3618 AND APPLIED IMMEDIATELY WITH RED OXIDE ZINC CHROMATE PRIMER TO IS: 2074

MACHINED SURFACE TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS: 1154.

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

SHARP EDGES TO BE REMOVED.

ALUMINIUM SHEET 1 m.m. THK. WITH HOLES  $\phi 3.0$  VER. & HOR. PITCHES AS SHOWN AND FOLDING WITH MESH TO SUIT SUPPLIER.



DETAIL-Z

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PART No.	DESCRIPTION	MATERIAL	NO. OFF	DRG. NO.	DIFFERENCE
Gen. Tol. Not Specified				Date	Name Approved
Linear Dimension				Drawn	
0 - 6 ± 0 - 1				Traced 5-3-04	M. SAHA
6 - 30 ± 0 - 2				Checked 5.3.04	THOSAR
30 - 120 ± 0 - 3					
120 - 315 ± 0 - 5					
315 - 1000 ± 0 - 8				JWM/STD 5.3.04	
1000 - 2000 ± 1 - 2				Shop	Jt.GM/TS
Angular Dim.	Index	ALTERATION	Date	JWM	D.O.
0 - 10 ± 1'	~ Unmachined				
10 - 50 ± 30'	∇ Rough				
50 - 100 ± 20'	∇∇ Smooth				
> 100 ± 10'	∇∇∇ Finish				
	22 C. Hard				
	24 Hardened				
	14 Gr. after Hard				
		<b>SUB ASSY. OF DRAIN PLUG AND SUCTION STRAINER</b> For FUEL TANK Group STALLION MK-III		Scale N.T.S.	Ref. Drg.
		VEHICLE FACTORY JABALPUR.		Replaced By .....	Replacement for .....
				B 5092109	

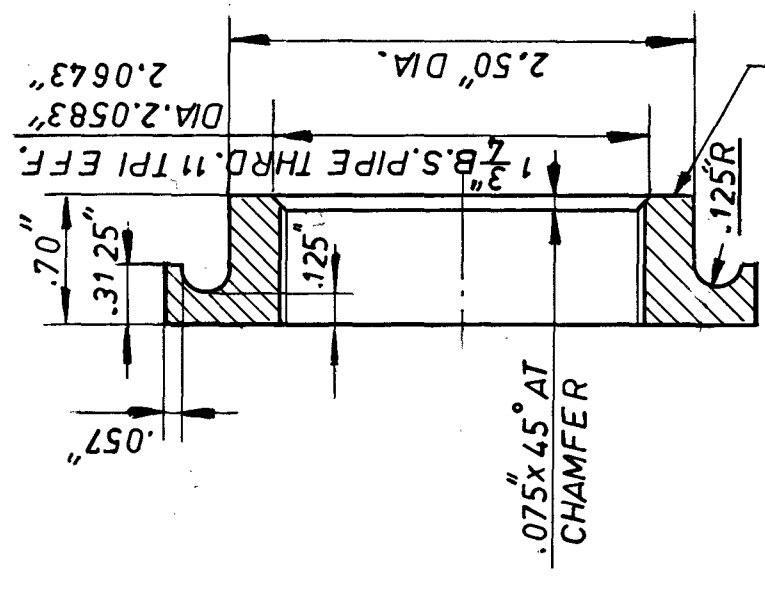
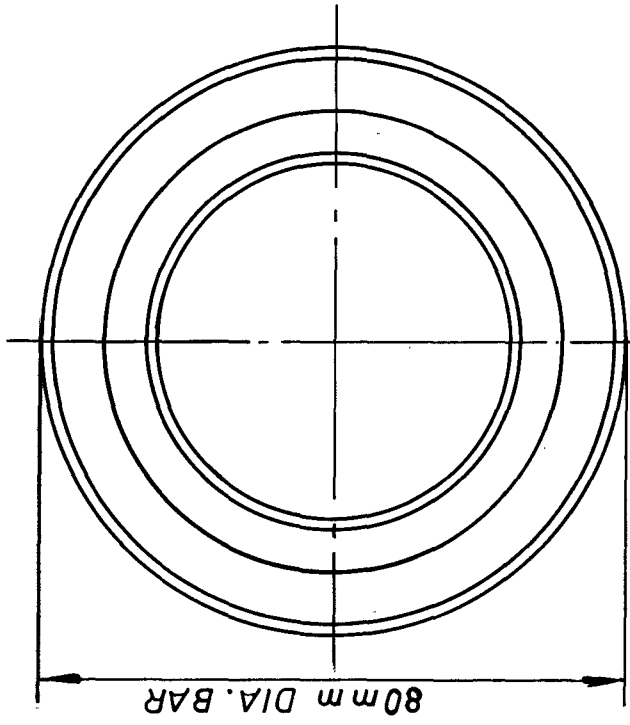
DRG. NO F 1430011

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MATERIAL — En 32 B FOR HOSUR UNIT ONLY

NOTE — (SURFACE TREATMENT CODE NO - 01)

TO BE PHOSPHATED TO CLASS 'C' AS PER IS: 3618 - 1966.

TO BE COATED WITH ZINC PHOSPHATE GREY PRIMER TO AL PS 04 MINIMUM THICKNESS - 25 MICRONS.

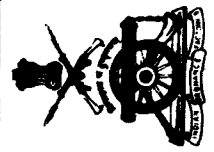
TO BE PAINTED WITH BLACK STOVING ENAMEL TO AL PS 06 MINIMUM THICKNESS - 25 MICRONS.

TOTAL THICKNESS OF COATING - 55 MICRONS MINIMUM.

THIS IS IDENTICAL TO LEYLAND PART NO. 242971 EXCEPT FOR DIMENSIONS 80 mm AND .057\"/>

FACE TO BE AT RIGHT ANGLES TO THREADS

Gen. Tol	Not Specified
Linear Dimension	
0-5	±0.1
6-30	±0.2
30-120	±0.3
120-315	±0.5
315-1000	±0.8
1000-2000	±1.2
Angular Dim.	
0-10	±1°
10-50	±30'
50-100	±20'
> 100	±10'



- U Unmachined
- R Rough
- S Smooth Finish
- 22 C. Hard
- 23 Hardened
- 15 Gr. after Hard.

Description **FLANGE**

For **FUEL TANK**

Group **STALLION MARK - III**

**VEHICLE FACTORY  
JABALPUR**

F 1430011

8 CHG NO. HA

PL/02

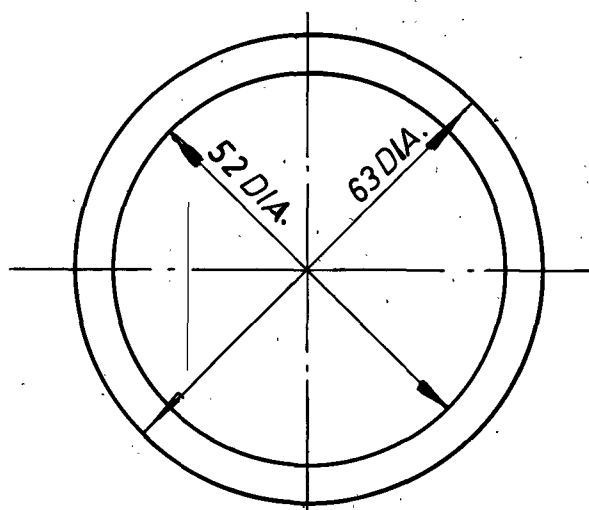
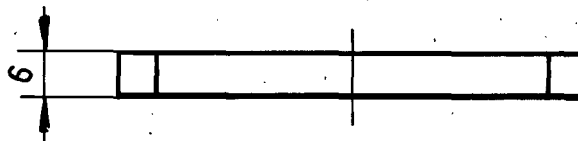
DRG. NO X 4900350

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COPY DATE.....  
SIGNATURE.....

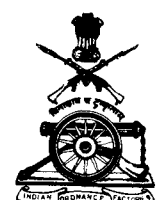

ALL DIMENSIONS ARE IN mm



MATERIAL — NITRILE RUBBER TO MEET SPECIFICATION SQM 2D  
9801 A OR SAE J 200 M6 BG 814 A14 B14 B014 EO 34

PART NO.	DESCRIPTION	MATERIAL	NO.OFF	DRG. NO.	DIFFERENCE

Gen.Tol/Not Specified	Linear Dimension	Date	Name	Approved	
0-6	±0.1	Drawn			
6-30	±0.2	Traced	22/2/02		
30-120	±0.3	Checked	22.2.02		
120-315	±0.5	JWM/STJ	23-2-02		
315-1000	±0.8				
1000-2000	±1.2				
Angular Dim.	Index	ALTERATION	Date	D. Signo.	JWM

 ~ Unmachined ▽ Rough ∇ Smooth ∇∇ Finish (22) C.Hard (24) Hardened (14) Gr. after Hard.	Description <b>RUBBER WASHER</b> For <b>FUEL TANK</b> Group <b>STALLION MARK - III</b>	Scale <b>1:1</b> Ref. Drg. 
	Replaced by ..... Replacement for .....	Vehicle Factory <b>JABALPUR</b>

1 2 3 4 5 6 7 8 CHG NO.



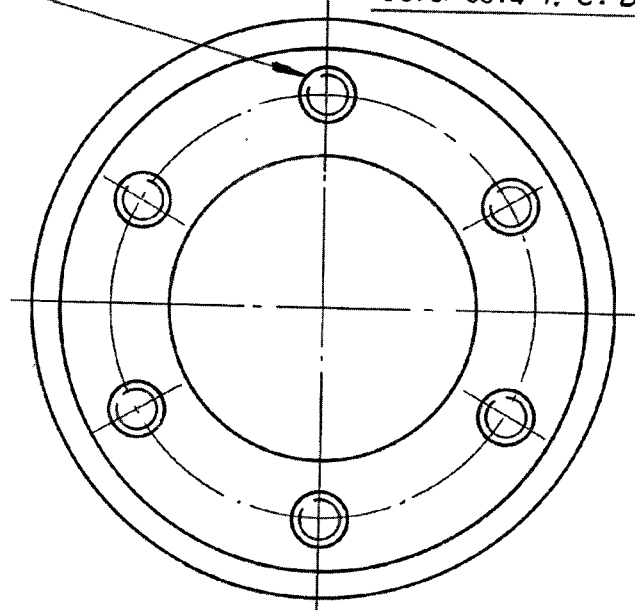
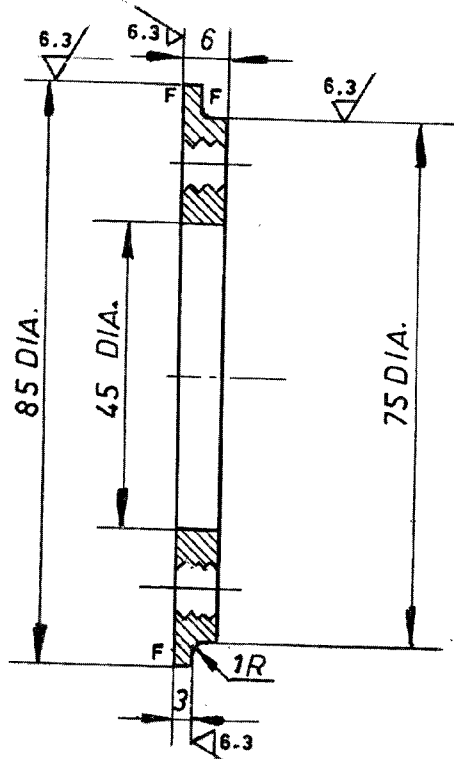
DRG. NO F 1431215

**SEALED  
CERTIFIED CORRECT  
COPY DATE.....  
SIGNATURE.....**

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ALL DIMENSIONS ARE IN m.m.

SIX TAPPED HOLES M5 x 0.8 EQ. SPACED ON 60.6/60.4 P.C. DIA.

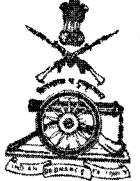




MATERIAL — STEEL, IS: 226 GRADE Fe 410 S.

NOTE — TO BE PHOSPHATED AND SEALED WITH OIL, CLASS A/A, IS: 3618-1966. SHARP EDGES TO BE REMOVED.

MACHINING DIMENSIONS NOT LIMITED TO BE ± 0.25

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS: 4218-1967, CLASS 6 TH INTERNAL.

PART NO.		DESCRIPTION	MATERIAL	NO. OFF	DRG. NO.	DIFFERENCE
Gen. Tol. Not Specified						
Linear Dimension						
0-6	±0.1				Drawn	Date
6-30	±0.2				Traced	6 3 02
30-120	±0.3				Checked	6 3 02
120-315	±0.5				JWM/STD	7 3 02
315-1000	±0.8					
1000-2000	±1.2					
Angular Dim.						
0-10	±1°				Shop	
10-50	±30'					
50-100	±20'					
> 100	±10'					
Index		ALTERATION		Date	Signature	Zone
~	Unmachined	7 3 02				
▽	Rough					
▽▽	Smooth					
▽▽▽	Finish					
Ⓢ	C. Hard					
Ⓢ	Hardened					
Ⓢ	Gr. after Hard.					
				Description <b>GAUGE MTG FLANGE</b> For <b>FUEL TANK</b> Group <b>STALLION MARK-III</b>		Scale <b>1:1</b> Ref. Drg. 
		<b>VEHICLE FACTORY JABALPUR</b>		Replaced by ..... Replacement for .....		<b>F 1431215</b>