

**ORIGINAL  
SCANNED**  
01/01/2013  
**TECHNICAL CENTRE**

PART NO.									
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ALTERATIONS	DATE	GRADE	SUFFIX	W/O FILED

STAGE	CHECKED DATE	APPROVED DATE	ALTERATION LEVEL
I	18/02/03	18/02/03	#
II	21/10/03	21/10/03	#
III	21/10/03	21/10/03	#
DRWN	DATE	DATE	
18.02.03			
CHECKED	DATE	DATE	
20/10/03			
APPROVED	DATE	DATE	
21/10/03			

MATERIAL: EN32B/080M15/EN3B/070M20/EN1A/220M07 OF BS970.

HEAT TREATMENT: \_\_\_\_\_

REMARKS: MRLV

DESCRIPTION: TEE PIECE M18xM18xM18-60°

PART NO.	F	1	3	0	2	8	1	1	#
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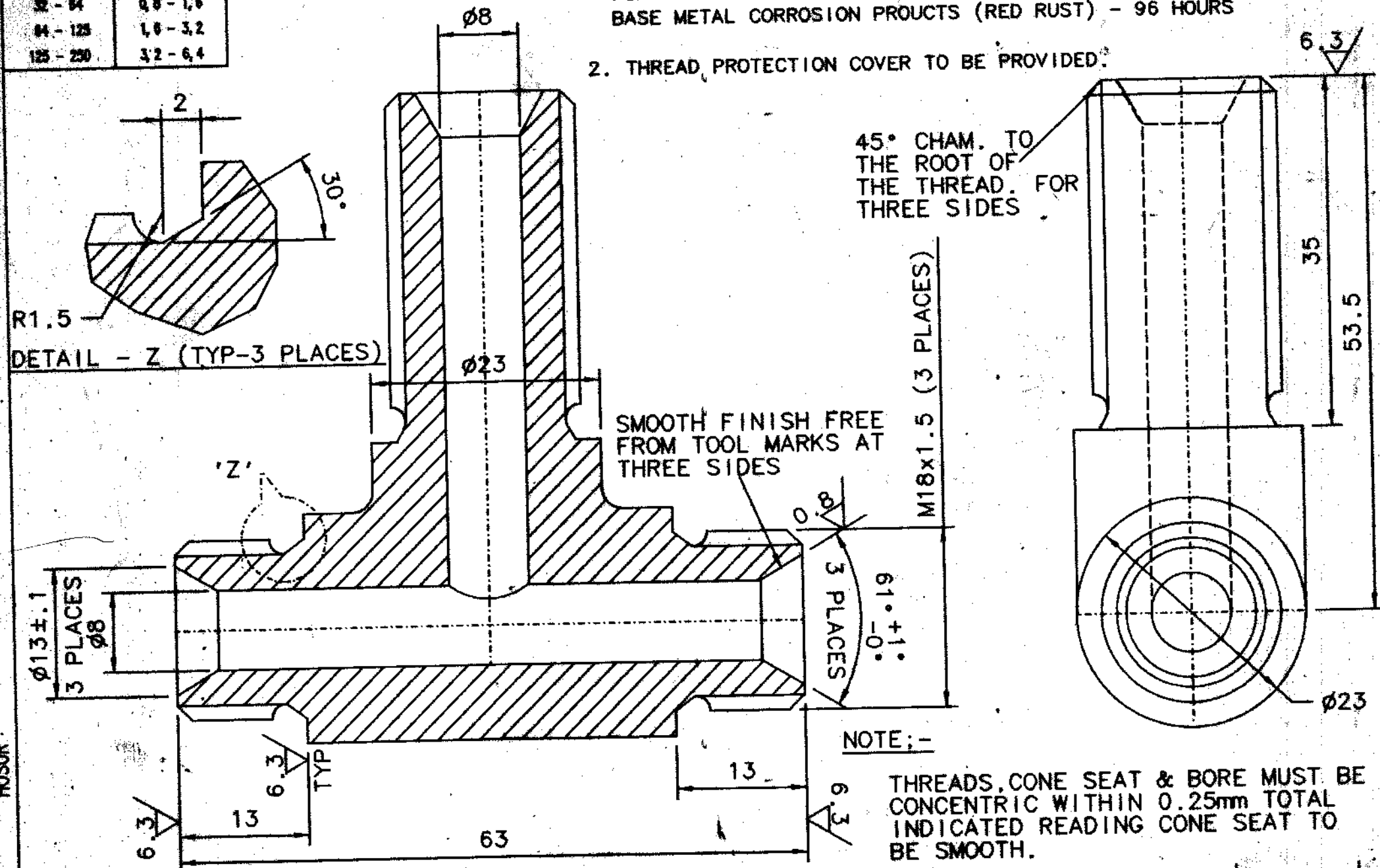
**SURFACE FINISH :-**

1. SURFACE COATING TO BE ZINC PLATED & YELLOW CHROMATE PASSIVATED PLATING THICKNESS 7 MICRONS MIN. MINIMUM EXPOSURE SALT SPRAY TEST AS PER (ASTM B117) WITHOUT EVIDENCE OF CORROSION FOR WHITE ZINC CORROSION PRODUCTS - 48 HOURS BASE METAL CORROSION PRODUCTS (RED RUST) - 96 HOURS
2. THREAD PROTECTION COVER TO BE PROVIDED.

**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

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**NOTE :-**

THREADS, CONE SEAT & BORE MUST BE CONCENTRIC WITHIN 0.25mm TOTAL INDICATED READING CONE SEAT TO BE SMOOTH.

SPECIAL INSTRUCTION / NOTE : SUPPLIER CODE & AL PART NO TO BE STAMPED

UNLESS OTHERWISE SPECIFIED

FABRICATED COMPONENTS TO BE PHOSPHATED TO CLASS 'C' AS PER IS:3618 AND APPLIED IMMEDIATELY WITH ZINC PHOSPHATE GREY PRIMER TO ALPS04 MACHINED SURFACES TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS:2104.

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

DIM	OVER	6	30	120	315	1000	2000	> 4000
±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±5

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:4216, CLASS 6g EXTERNAL OR 6h INTERNAL.

DO NOT SCALE DRAWING. ALL DIMENSIONS ARE IN MM.

SL. NO.	PART NO.	DESCRIPTION	MATERIAL	QTY
<b>BILL OF MATERIALS</b>				
REF PART NO.	F0132111	ISSUED UNDER	EDM / DIN	DATE
SUPERSEDES		BY		DATE
S/A PART NO.		DATE		
WEIGHT	ROUGH	FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED	NO
SCALE	2 : 1	APPROVAL NUMBER		05
SPEC. NO.	HAPA	ISSUED BY		

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