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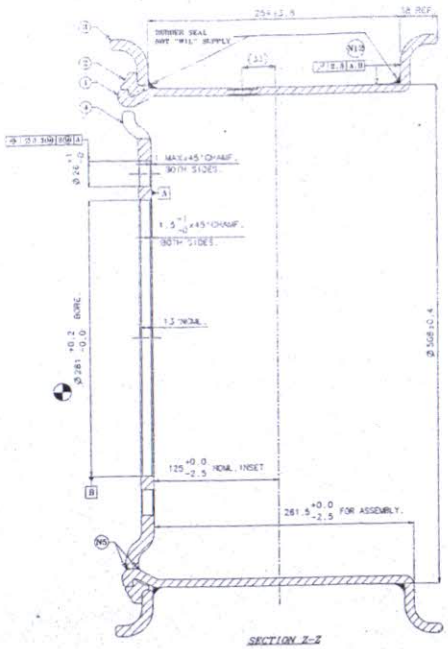
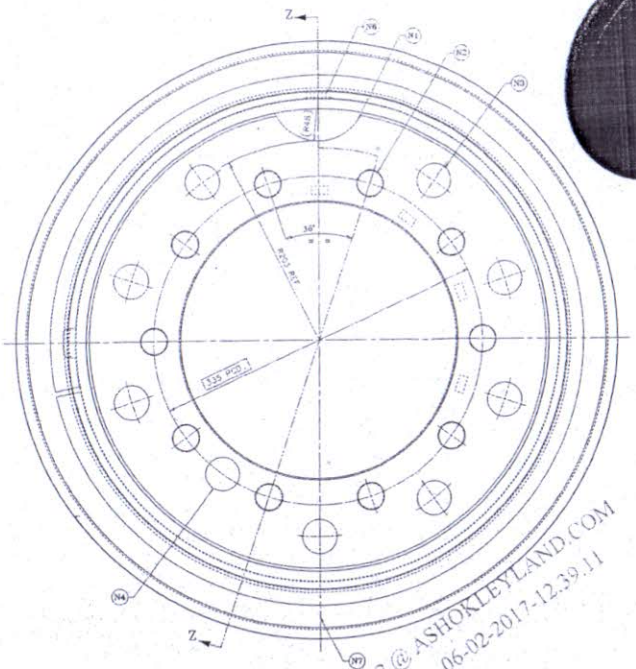
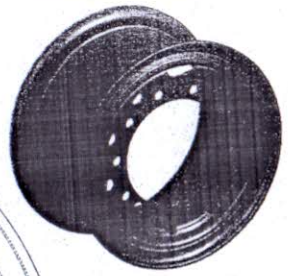
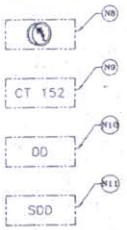
ASHOK LEYLAND LTD.
TECHNICAL CENTRE, VELLIVOYALCHAVADI







WHEEL MARKING



NOTE REF	GRID REF	NOTE
N1	F4	ONE CLIPPING SPACER AT VALVE HOLE CENTER LINE.
N2	F4	10 STUD HOLES EQUALLY SPACED.
N3	F3	SEVEN VENT HOLES ARE EQUALLY WITH SPACED WITH STUD HOLES.
N4	C5	ONE PLAIN HOLE POSITIONED IN-BETWEEN BOLT HOLES FOR 335 PCD.
N5	C5	CONTINUOUS WELD ON BOTH SIDES, EXCEPT CUT OUT REGION 5 TO 10 mm TO WELD NEAR CUT OUT REGION.
N6	F4	VALVE HOLE POSITION.
N7	C4	RIM BUTT WELD JOINT LOCATION.
N8	D2	MANUFACTURER'S LOGO MARKING.
N9	D2	MANUFACTURER'S WHEEL CODE MARKING.
N10	D2	YEAR & MONTH CODE MARKING.(TYPICAL)
N11	C2	SHIFT & DATE MARKING. (TYPICAL/OPTIONAL)
N12	F7	RUNOUT NOT TO BE CHECKED FOR 100 mm EITHER SIDE OF RIM BUTT WELD.

GENERAL NOTES:-
1. TYRE SIZE : 14.00 R20 22PR (TUBELESS TYRE)
2. MAXIMUM TYRE LOAD : 5000 Kg
3. PAINT:-
PRIMER : CED
FINISH : OLIVE GREEN
PAINT THICKNESS - 60 MICRONS MAX. ON MOUNTING REGION
4. SURFACE PROTECTION:CLASS 'C' AS PER ALS 268.03'
5. TEST SPECIFICATION AS PER IS8438
6. MARKING POSITIONS ARE ONLY FOR REFERENCE.

MATERIAL SPECIFICATIONS :-

4.	10.00x20 RIM	DIN17100 Rst 37-2 OR EQUIVALENT
3.	WHEEL DISC	DIN17100 Rst 42-2 OR EQUIVALENT
2.	LOCKRING	DIN17100 st 60-2 OR EQUIVALENT
1.	FLANGE	DIN17100 Rst 42-2 OR EQUIVALENT

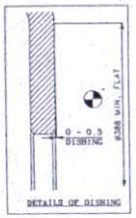
SL.NO	DESCRIPTION	QTY	REMARKS
4	DISC	1	-
3	FLANGE	1	-
2	LOCKRING	1	-
1	10.00 x 20 TUBELESS RIMBASE	1	-

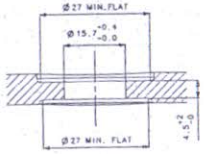
BILL OF MATERIALS

SL.NO	DESCRIPTION	PART NO.
4.	OTHER DETAILS	
3.	FASTENERS	
2.	BRAKE DRUM	
1.	HUB	

CUSTOMER ATTACHMENT DETAILS

VEHICLE MODEL : HMV 6x6 MERITOR AXLE
CALCULATED WHEEL WEIGHT : 62.1 kg.
REFERENCE CUSTOMER PART No. : F3602714
CUSTOMER PART No. : 82206701





SIGNIFICANT

SASIKUMAR.M2 @ ASHOKLEYLAND.COM
fb2.ashokleyland.com : 06-02-2017-12.39.11

ISSUE	A	B	C	D	E
MOD-No.	14699	16425	16572	17511	17534
BY	G.R	C.A	C.A	C.A	[illegible]
DATE	24.01.2013	18.2.2014	15.05.2014	28.08.2014	02.09.2014

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED. FOR INTERPRETATION OF GEOMETRICAL TOLERANCING SYMBOLS USED IN THIS DRAWING, PLEASE REFER TO ISO 1101

SOFTWARE USED:- UNIGRAPHICS
PROJECTION
SCALE 1:2
DRWN: TNP
CHKD: TNP
APPROVD: GM(R&D)
DATE: 30.07.2012

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WHEELS INDIA LTD., CHENNAI - 600 050

WHEEL CODE:- CT 152
TITLE:- TUBELESS WHEEL
SIZE:- 10.00 x 20
CUSTOMER : ASHOK LEYLAND

DRAWING No. WCC 406

AL FLOW VAULT
REVISION : 01 DATE : 3/9/2014 STATUS : RELEASE
STAGE : II ER-INV NO : ER-INV-001376 DATE : 3/9/2014
ALTERED BY : CHECKED BY :
MED APPROVAL : APPROVED BY :
DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP DATE
VKS 07/06/212	VKR 07/06/12	...	RR 07/06/12	07/06/12

MATERIAL: REFER DRAWING
HEAT TREATMENT: - - - - -
REMARKS: HMV 6X6 MERITOR AXLE
DESCRIPTION: WHEEL RIM -TUBELESS
PART No. B 3 3 0 6 7 0 1 #2

SK 8082	B3306701	Qty : -	Qty : 01 Nos	-
Supplier Part No	AL Part No	Sample	Pilot	Production

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

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

LEYLAND 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:

SURFACE PROTECTION:
CLASS C AS PER ALS : 268.03

BILL OF MATERIALS

APPEARANCE ITEM YES	APPEARANCE ITEM NO	ER-DIN	DATE
FINISHED WEIGHT(APPROX)		REF. PT. No.	.....
.....		S/A PT No.	.....
SCALE N T S		SUPERSEDES	.....
		SPEC NO.	...