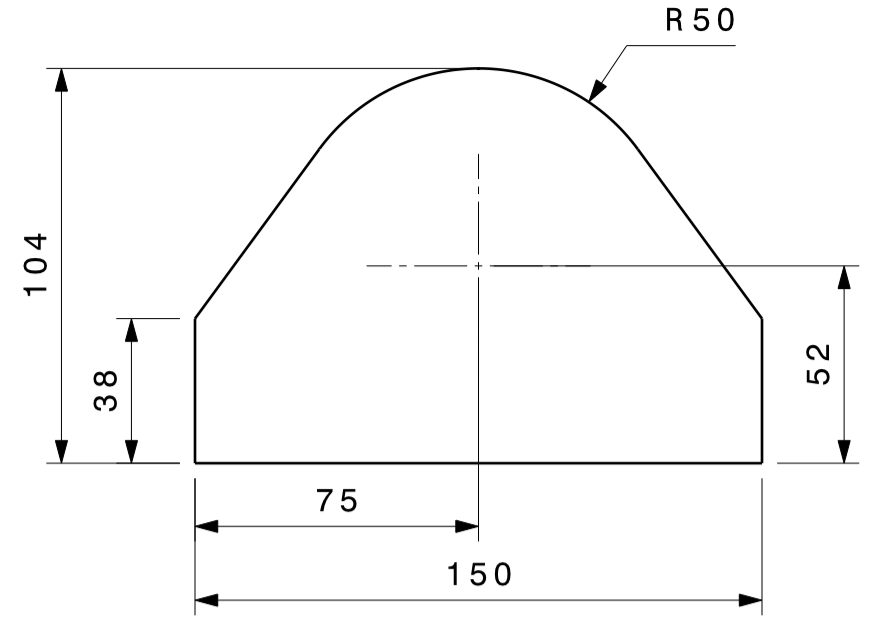


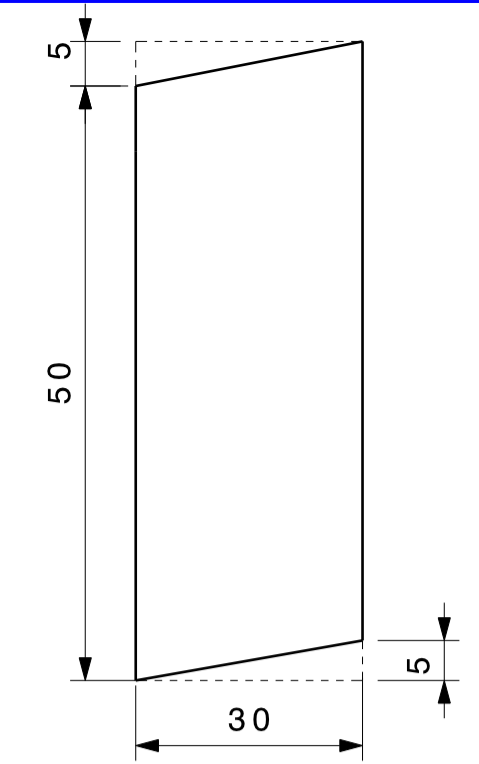


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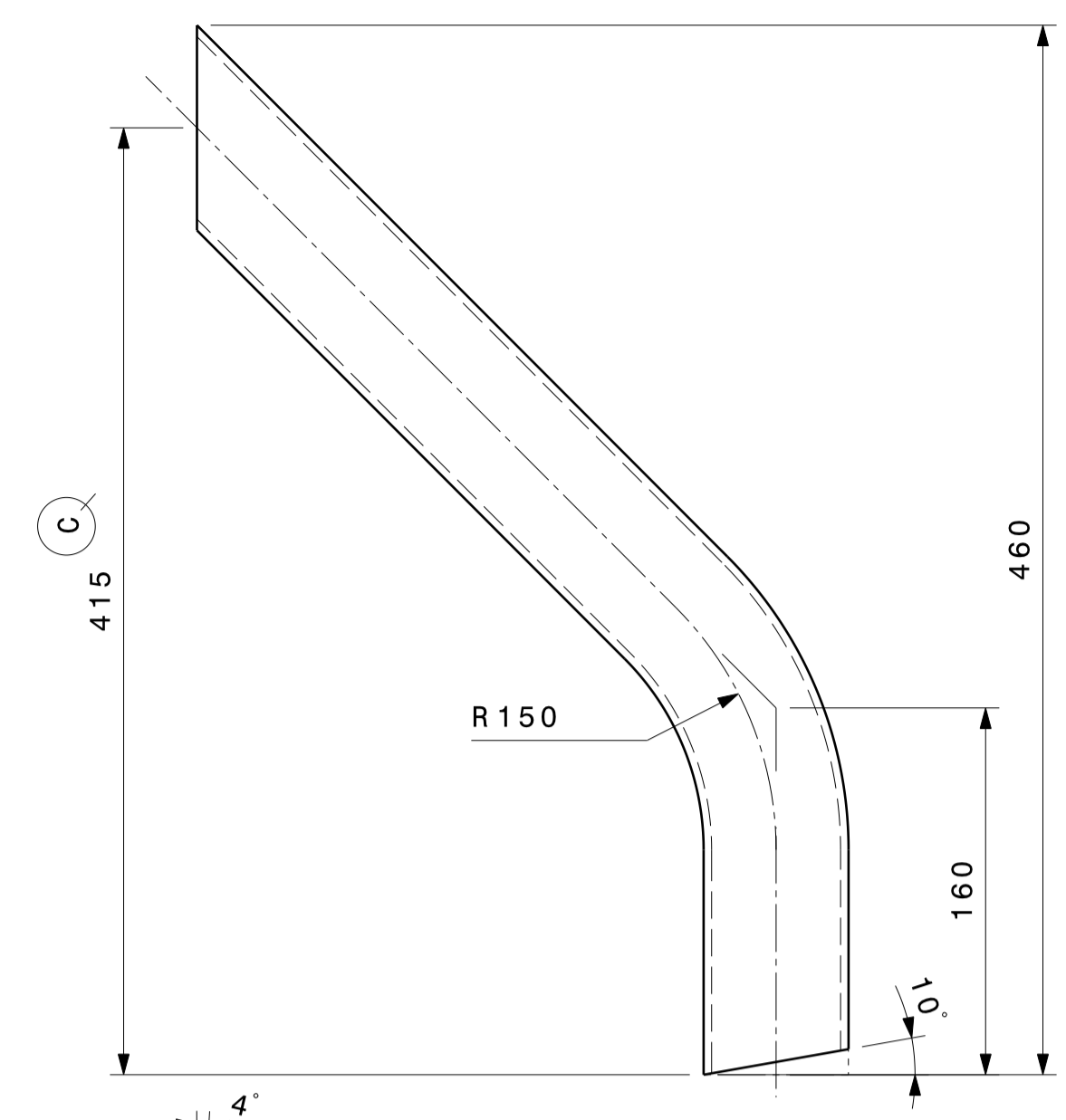
ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOLCHAVADI



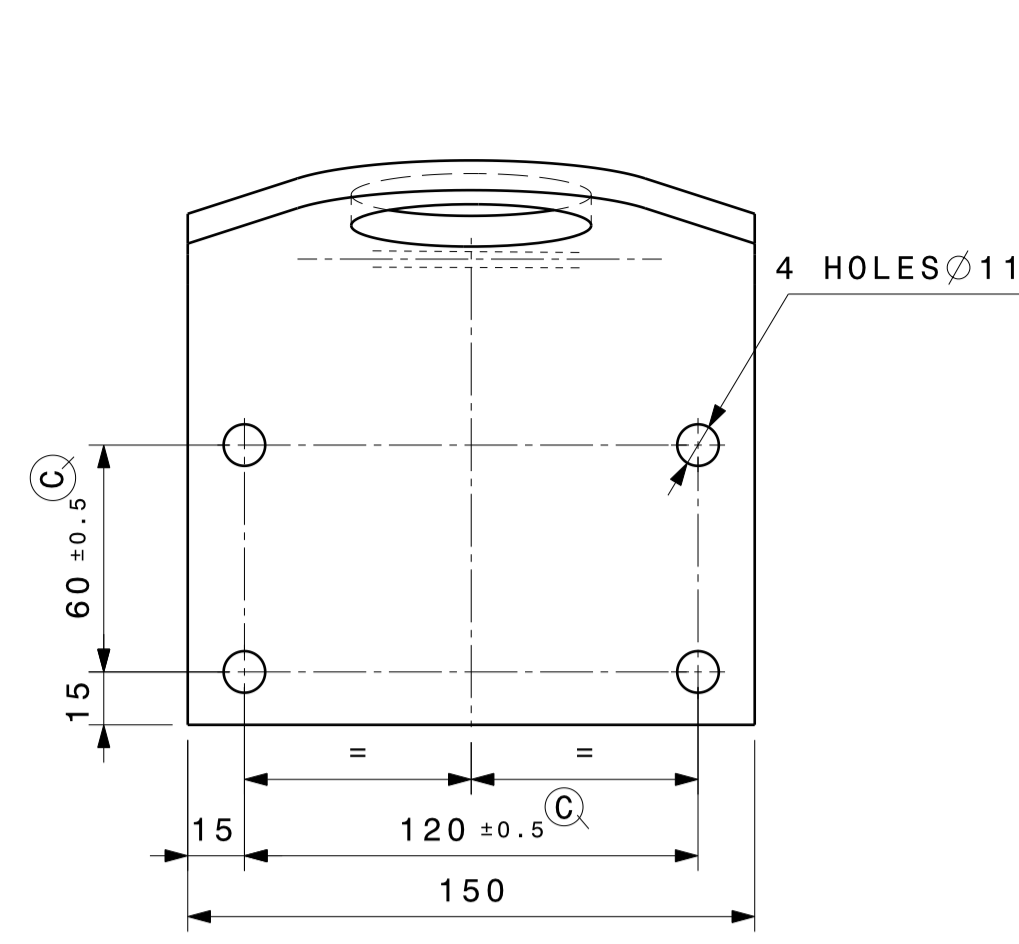
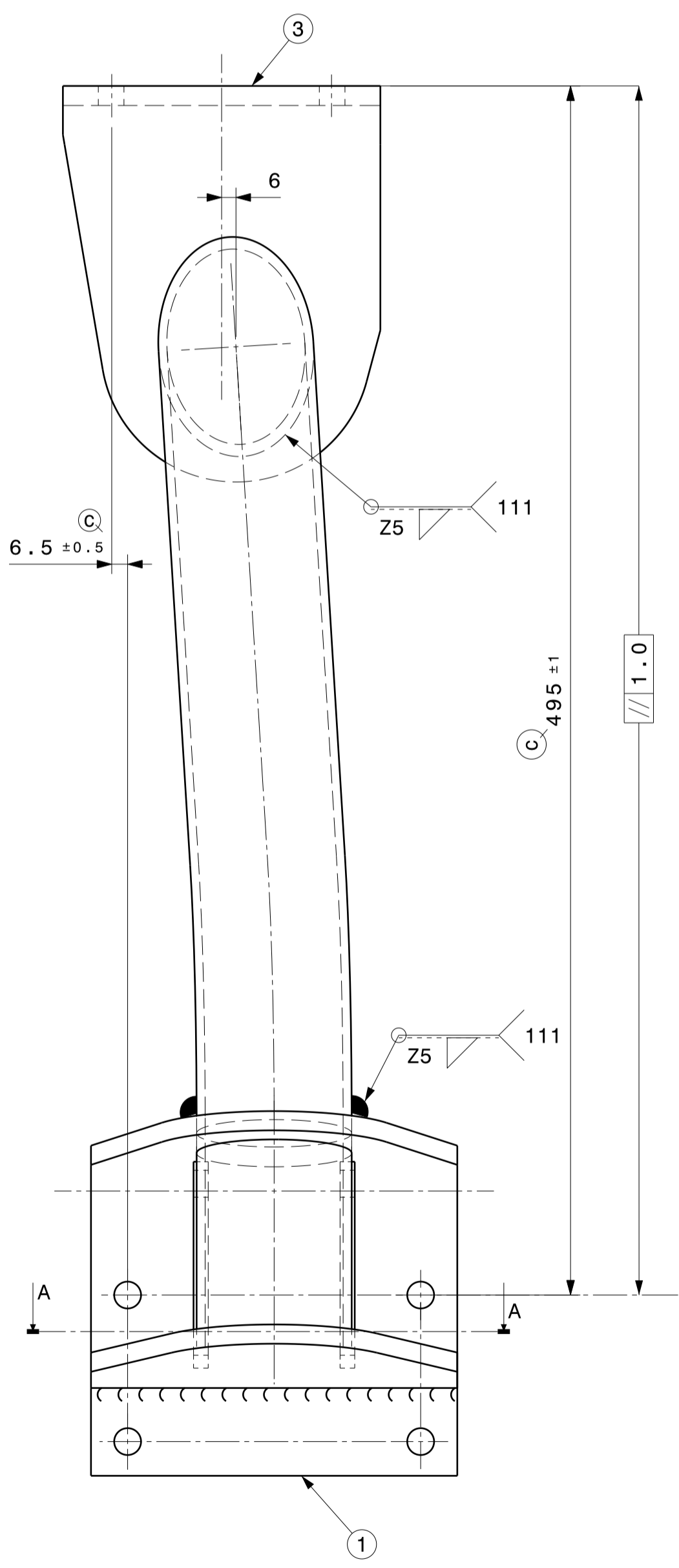
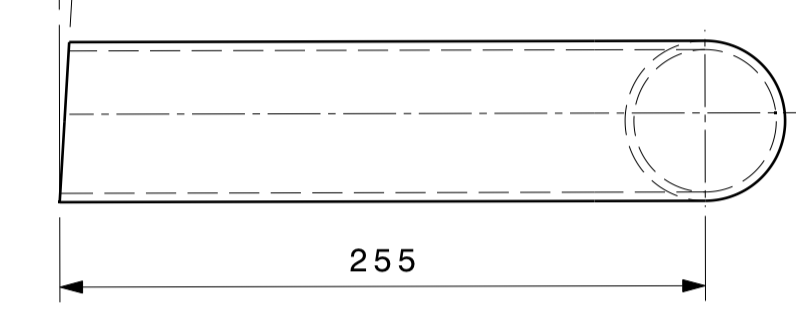
ITEM NO 5



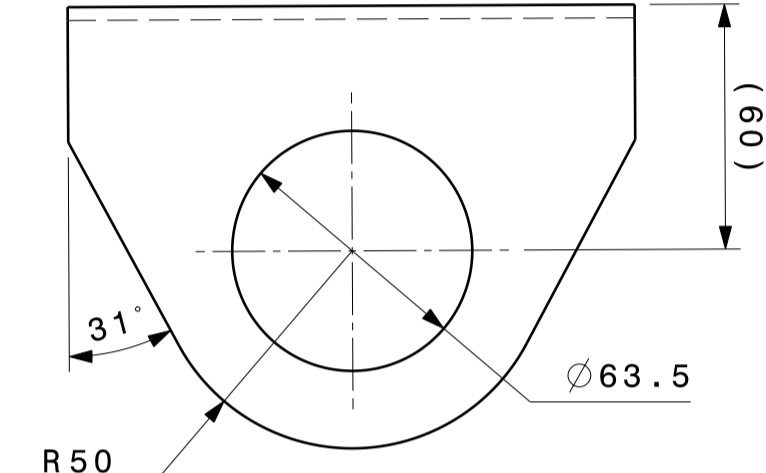
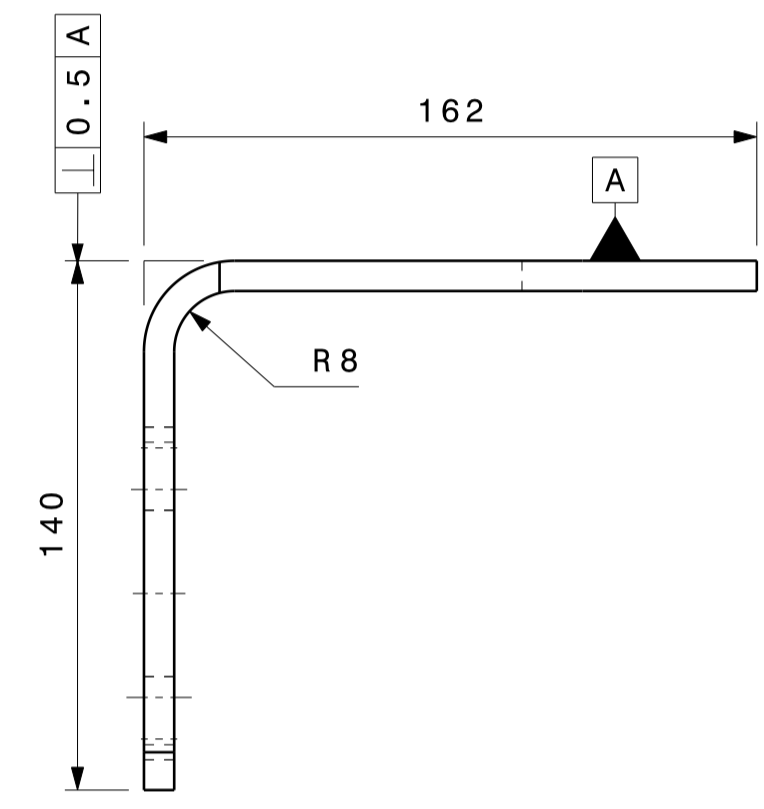
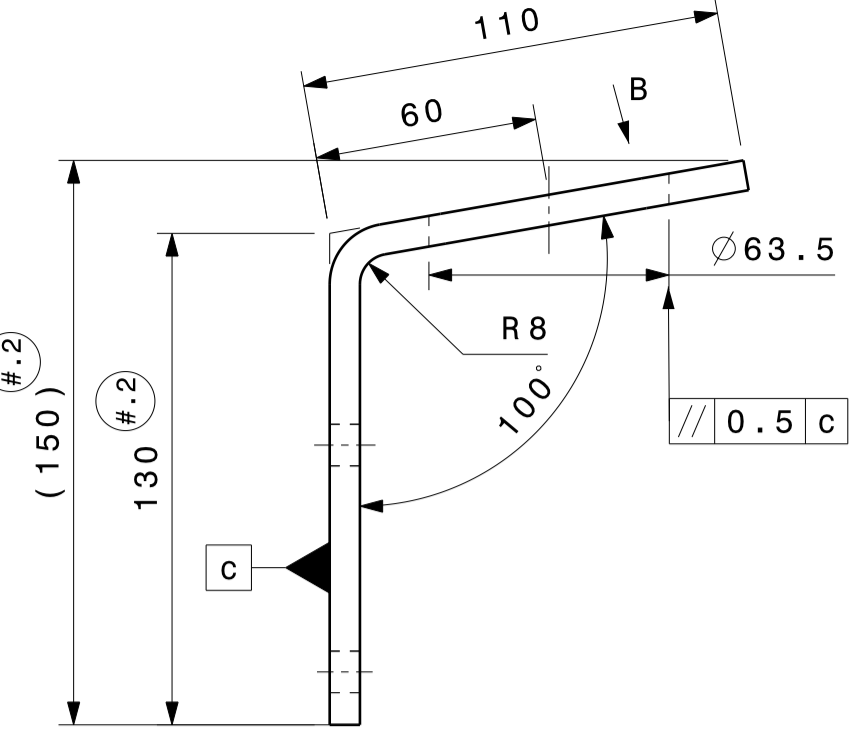
ITEM NO 4



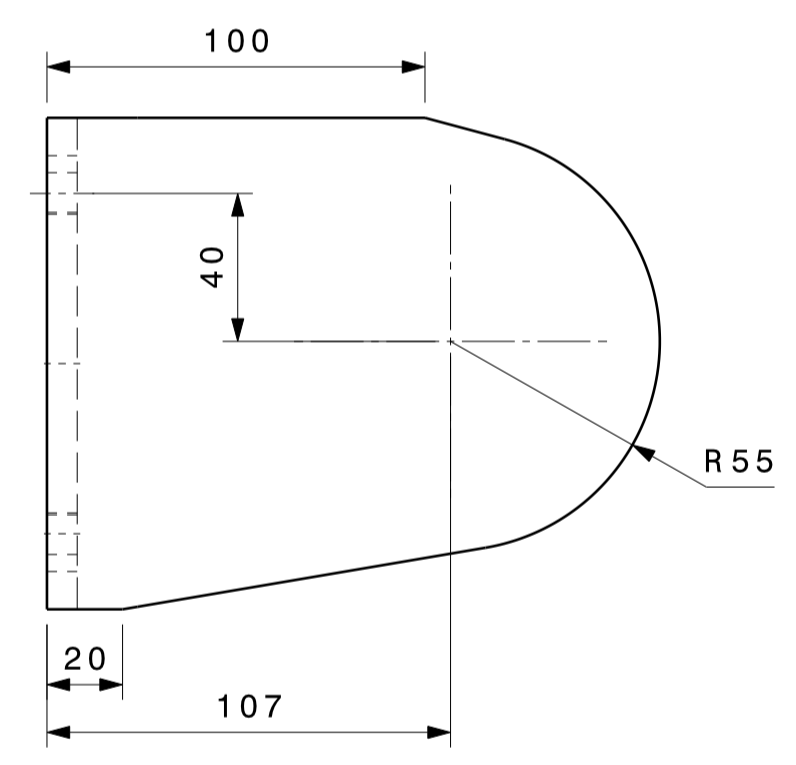
ITEM NO 2



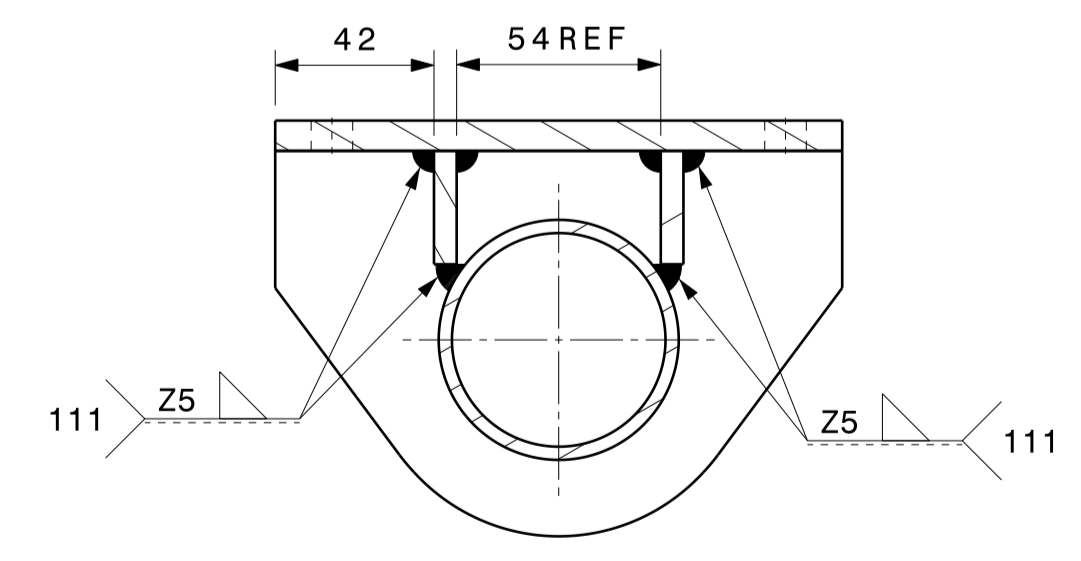
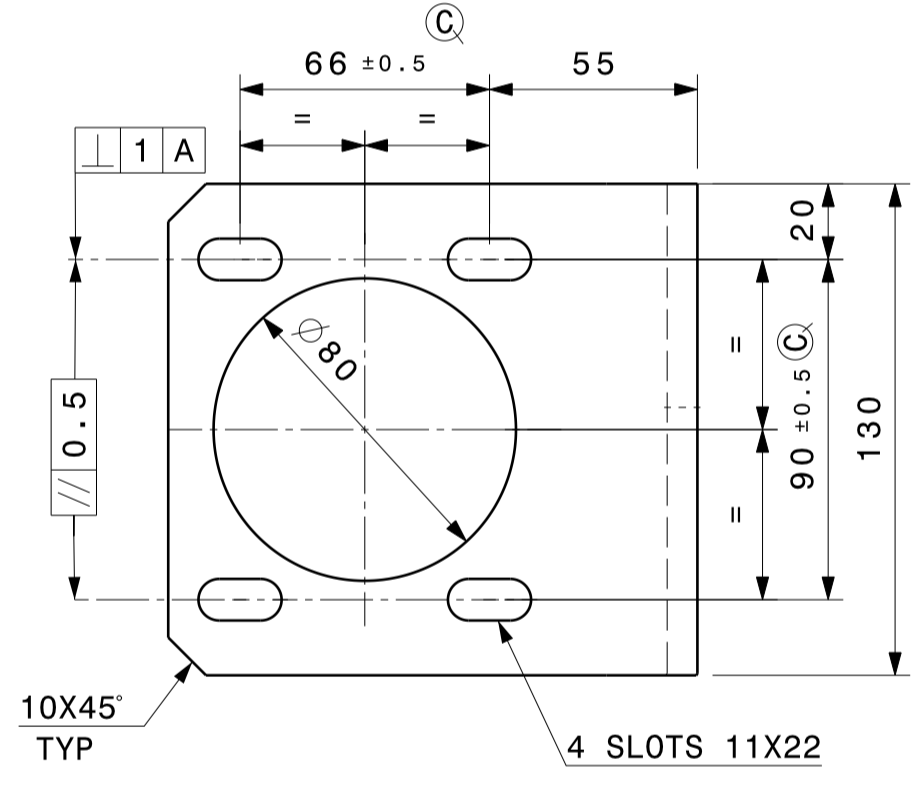
ITEM NO 1



VIEW AT 'B'



ITEM NO 3



SECTION A-A

SL NO	PART NO	DESCRIPTION	MATERIAL	QTY
5	ITEM 5	PLATE	STEEL 8THK TO IS:2062 Gr 'A'	1
4	ITEM 4	GUSSET	STEEL 6THK TO IS:2062 Gr 'A'	2
3	ITEM 3	CSO BRKT	STEEL 8THK TO IS:2062 Gr 'B'	1
2	ITEM 2	TUBE	TUBE ERW-1 Ø63.5 4THK TO IS 3074	1
1	ITEM 1	BASE BRKT	STEEL 8THK TO IS:2062 Gr 'B'	1

ALTERATIONS			
REVISION	DATE	BY	REASON
DRAWING REDRAWN	SS/EAK	23.12.08	- #.1
IN ITEM 1 DIM 130 WAS 100 AND DIM (150) WAS (120). DIM 78 WAS 50.	SS/SV	20.07.09	- #.2
NOTE- SURFACE TREATMENT UPDATED.	SG/KG	20.07.10	- #.3

AL PLM VAULT
 REVISION : #3 DATE : 6/9/2010 STATUS : APPROVED
 STAGE : II ER-DIN NO : ER-DIN-0003479 DATE : 13/9/2010
 ALTERED BY : sudarabvc CHECKED BY : jirabvc
 MED APPROVAL : visabvc APPROVED BY : saagarjanabvc

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
SRR 16.08.08	EAK 16.08.08		SN 16.08.08	

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED
 MATERIAL: _____
 HEAT TREATMENT: _____
 REMARKS: _____

FOR STALLION MKIV-BSIII
 DESCRIPTION: S/A OF CSO BRKT
 PART NO. B 1 7 4 2 8 0 1 #.3
 SHEET NO. _____ OF _____ | A1

Q- IMPORTANT Q- CRITICAL Q- SAFETY. THIS DRG. CONTAINS SAFETY CHARACTERISTIC
 UNLESS OTHERWISE SPECIFIED

- SPECIAL INSTRUCTIONS/NOTE:
- GENERAL TOLERANCE TO BE ±0.5MM.
 - TOLERANCE ON HOLE PITCHES & SIZES TO BE ±0.25MM.
 - TOLERANCE ON OVERALL DIMENSIONS TO BE ±1MM.
 - WELDING TO CONFORM TOOLS.276.02.
 - BEND LINE TO BE TO GRAIN FLOW DIRECTION.
 - WELDING ELECTRODE TO SPEC AWS E6013/E6012 OR EQUIVALENT.
 - WELDING SYMBOL AS PER IS:813
 - TO BE PAINTED WITH ENAMEL, SCAMIC GREEN TO BE DONE AS PER AL PT NO:X9715000. #.3

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:1514
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 6E EXTERNAL, OR 5H INTERNAL. SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

BILL OF MATERIALS		
APPEARANCE ITEM	ER-DIN	DATE
YES	NO	ER-DIN-XXXXXXX XX.XX.XXXX
FINISHED WEIGHT (APPROX)	REF. PT. No.	B1797503
XXX.XXX Kgs	S/A PT No.	
SCALE	SUPERSEDES	
NTS	SPEC NO.	