



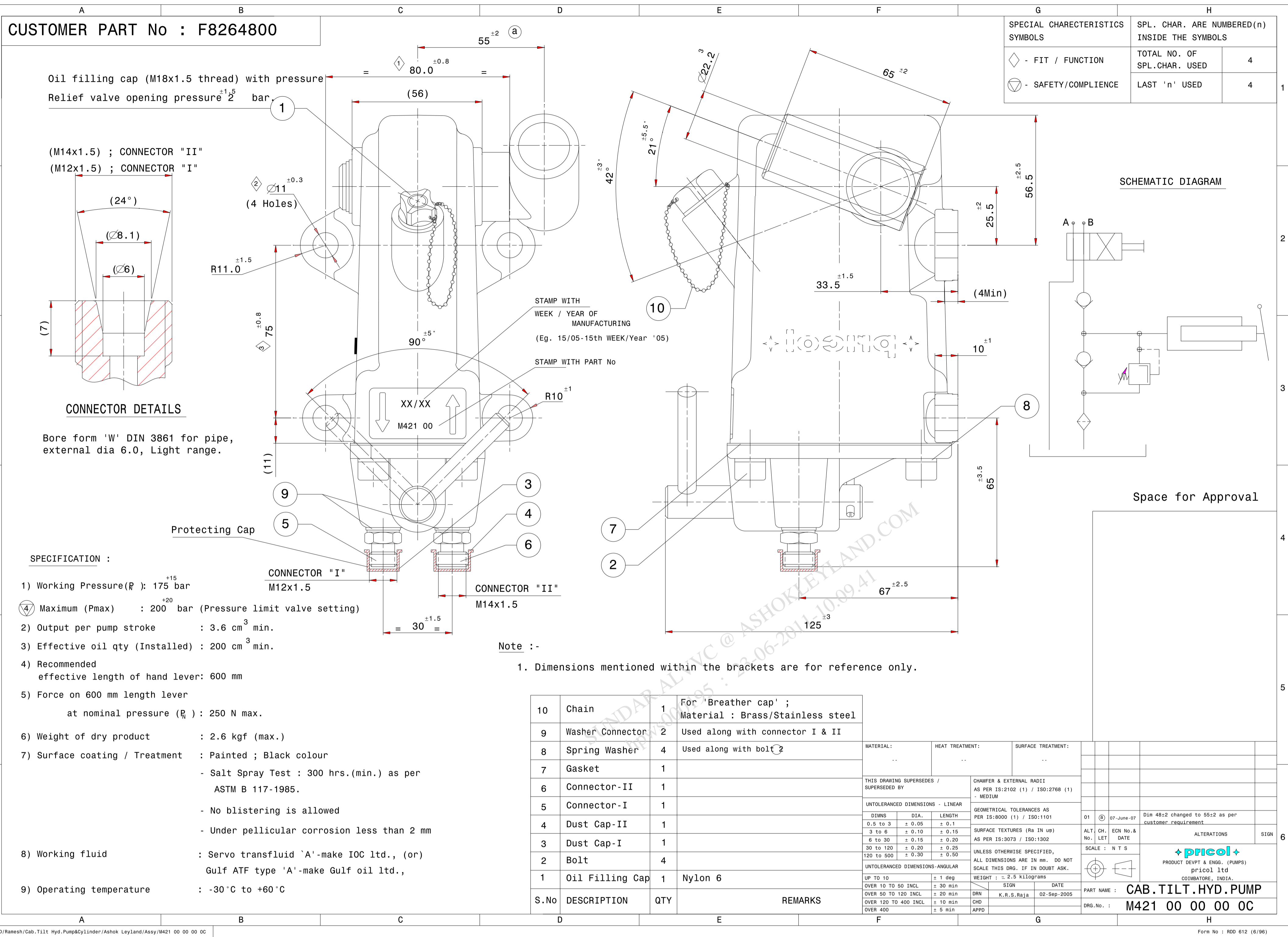
LEYLAND

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ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOLCHAVADI



ALTERATIONS		REVISED DATE	GRADE/SUFFIX
SUPPLIER DRAWING APPROVED & RELEASED ER-DIN-000217		15.06.07	A.0
DRG TEMPLATE UPDATED		26.11.10	A.1



S.No	DESCRIPTION	QTY	REMARKS
10	Chain	1	For 'Breather cap' ; Material : Brass/Stainless steel
9	Washer Connector	2	Used along with connector I & II
8	Spring Washer	4	Used along with bolt
7	Gasket	1	
6	Connector-II	1	
5	Connector-I	1	
4	Dust Cap-II	1	
3	Dust Cap-I	1	
2	Bolt	4	
1	Oil Filling Cap	1	Nylon 6

MATERIAL:	HEAT TREATMENT:	SURFACE TREATMENT:
THIS DRAWING SUPERSEDES / SUPERSEDED BY	CHAMFER & EXTERNAL RADIUS AS PER IS:2102 (1) / ISO:2768 (1) - MEDIUM	GEOMETRICAL TOLERANCES AS PER IS:8000 (1) / ISO:1101
UNTOLERANCED DIMENSIONS - LINEAR	UNTOLERANCED DIMENSIONS - ANGULAR	SCALE: N T S
DIMS DIA LENGTH	UP TO 10 ± 1 deg	WEIGHT : ± 2.5 kilograms
0.5 to 3 ± 0.05 ± 0.1	OVER 10 TO 50 INCL ± 30 min	DATE
3 to 6 ± 0.10 ± 0.15	OVER 50 TO 120 INCL ± 20 min	DRN K. R. S. Raja 02-Sep-2005
6 to 30 ± 0.15 ± 0.20	OVER 120 TO 400 INCL ± 10 min	CHD
30 to 120 ± 0.20 ± 0.25	OVER 400 ± 5 min	APPRO
120 to 500 ± 0.30 ± 0.50		

SUPPLIER PART NO	A.L PART NO	SAMPLE	TRAIL	PRODUCTION	SAMPLE	TRAIL	SAMPLE	TRAIL	PRODUCTION
M421 00 00 00 0C	F8264800								
M421 00 00 00 0C	F8264800								
		A.L APPROVAL NO. & DATE			QUANTITY		APPROVED BY/DATE		

M421 00 00 00 0C	F8264800	Qty : -	Qty : -	
Supplier Part No	AL Part No	Sample	Pilot	Production

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

UNLESS OTHERWISE SPECIFIED 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 <math>\leq 2mm</math>, NO BLISTERING IS ALLOWED.)

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 66 EXTERNAL, OR 5H INTERNAL. SHARP EDGES TO BE REMOVED AND DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

BILL OF MATERIALS		ER-DIN	DATE
APPEARANCE ITEM	YES	NO	
FINISHED WEIGHT (APPROX)	XXX.XXX Kgs	REF. PT. No.	-----
SCALE	NTS	S/A PT No.	-----
		SUPERSEDES	-----
		SPEC. NO.	HACM21/2

AL PLM VAULT	
REVISION : A.1	DATE : 3/12/2010
STAGE : III	ER-DIN NO : ER-DIN-0006139
ALTERED BY : sandaralvce	CHECKED BY : jeevalvce
MED APPROVAL : N/A	APPROVED BY : sanaganjan.alvce
DIGITALLY SIGNED, PHYSICAL SIGNATURE NOT REQUIRED	
DRAWN/ DATE	CHECKED/ DATE
HJ 16.2.2006	HJ 16.2.2006
MATERIAL	SN 21.2.2006
HEAT TREATMENT	
REMARKS	STALLION MARK III
DESCRIPTION	CAB TILT. PUMP
PART No.	F 8 2 6 4 8 0 0 A.1
SHEET NO.	OF