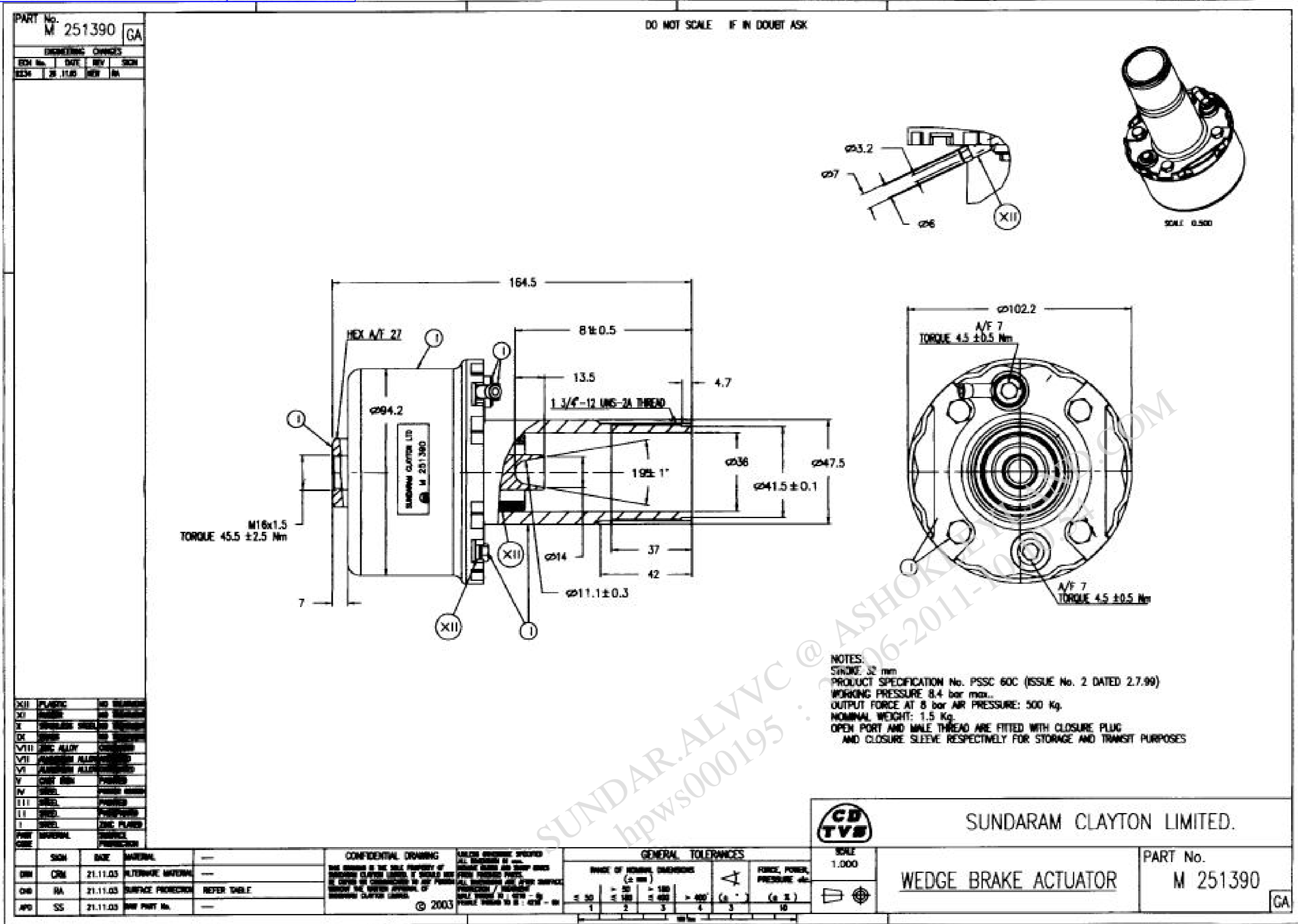




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ASHOK LEYLAND LTD.
 TECHNICAL CENTRE VELLIVoyalCHAVADI



REV	DATE	BY	CHK	DESCRIPTION
01	21.11.03	NEW	RA	ISSUE FOR PRODUCTION

REV	DATE	BY	CHK	DESCRIPTION
01	21.11.03	NEW	RA	ISSUE FOR PRODUCTION

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01	21.11.03	NEW	RA	ISSUE FOR PRODUCTION

REV	DATE	BY	CHK	DESCRIPTION
01	21.11.03	NEW	RA	ISSUE FOR PRODUCTION

M 251390	F8289600	Qty : -	Qty : -	-
Supplier Part No	AL Part No	Sample	Pilot	<input checked="" type="checkbox"/> Production

M 251390	F8289600	—	T02429	18.05.06	—	200	—	—	SN	18.05.06	—
M 251390	F8289600	—	T01792	09.02.05	—	25	—	—	SN	09.02.05	—
SUPPLIER PART NO	A.L PART NO	SAMPLE	TRAIL	PRODUCTION	SAMPLE	TRAIL	SAMPLE	TRAIL	PRODUCTION		
			A.L APPROVAL NO. & DATE			QUANTITY		APPROVED BY/DATE			

UNLESS OTHERWISE SPECIFIED		
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	
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:

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
BILL OF MATERIALS					
APPEARANCE ITEM		ER-DIN	DATE		
<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		ER-DIN-XXXXXX	XX/XX/XX		
FINISHED WEIGHT (APPROX)		REF PART NO:	—		
XXX.XXX Kgs		S/A PART NO:	—		
SCALE		SUPERSEDES	—		
NTS		SPEC NO:	—		

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
DRAWING TEMPLATE CHANGED JNR/SN	03.12.10	-	#.1
F8289600 WAS F8289200 JNR/SN	03.12.10	-	#.2

AL PLM VAULT			
REVISION : #2	DATE : 3/12/2010	STATUS : RELEASE	
STAGE : III	ER-DIN NO : ER-DIN-0006139	DATE : 3/12/2010	
ALTERED BY : jnr.alvvc	CHECKED BY : sundar.alvvc		
MED APPROVAL : N/A	APPROVED BY : snagarajan.alvvc		

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
AA 18.05.06	SN 18.05.06	XXXX XX.XX.XXXX	SN 18.05.06	—

MATERIAL				
HEAT TREATMENT				
REMARKS FOR STALLION MK-IV				
DESCRIPTION WEDGE BRAKE ACTUATOR				
PART NO.	F 8 2 8 9 6 0 0			#.2
SHEET No1..... OF1.....				A2