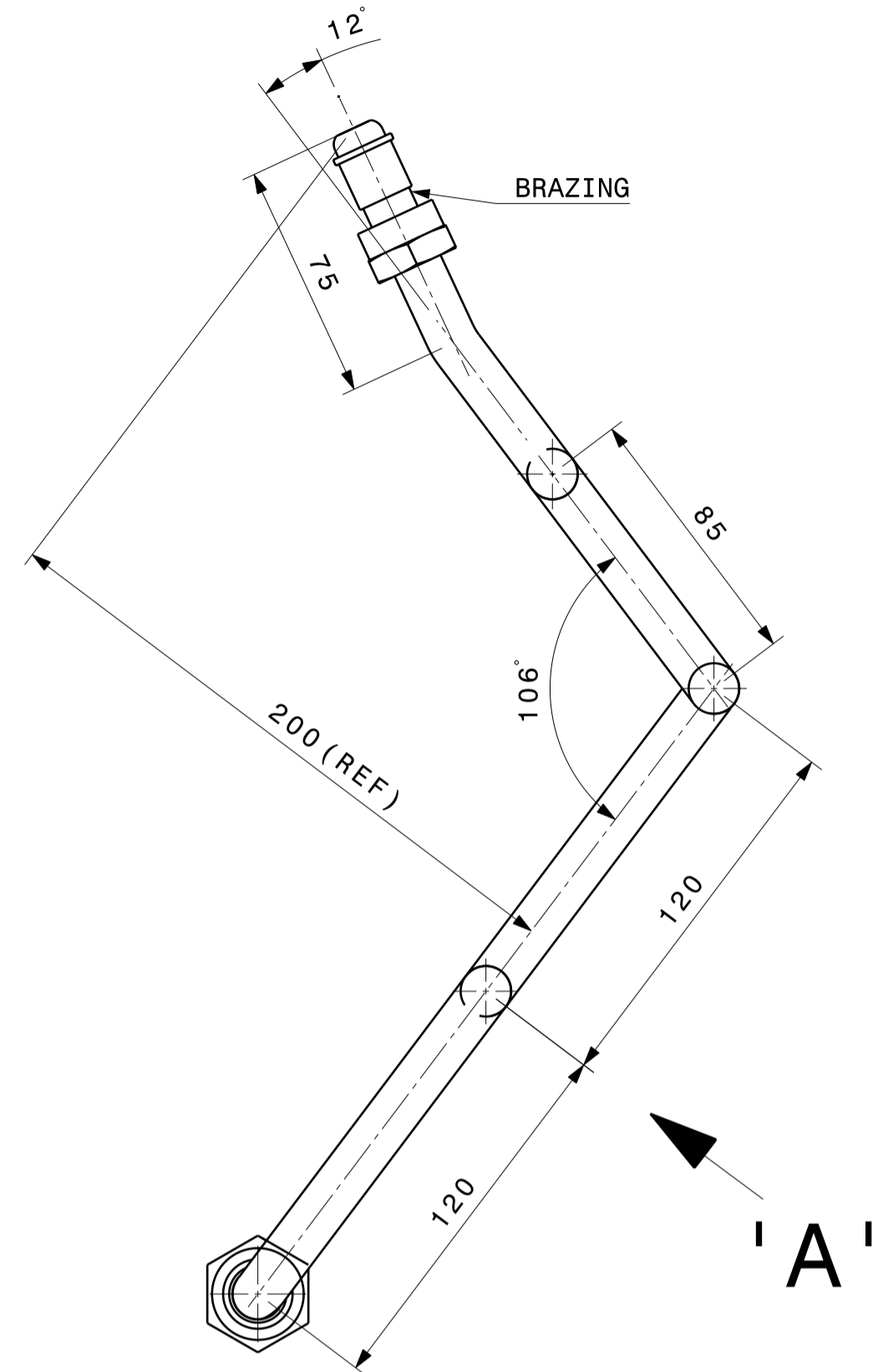
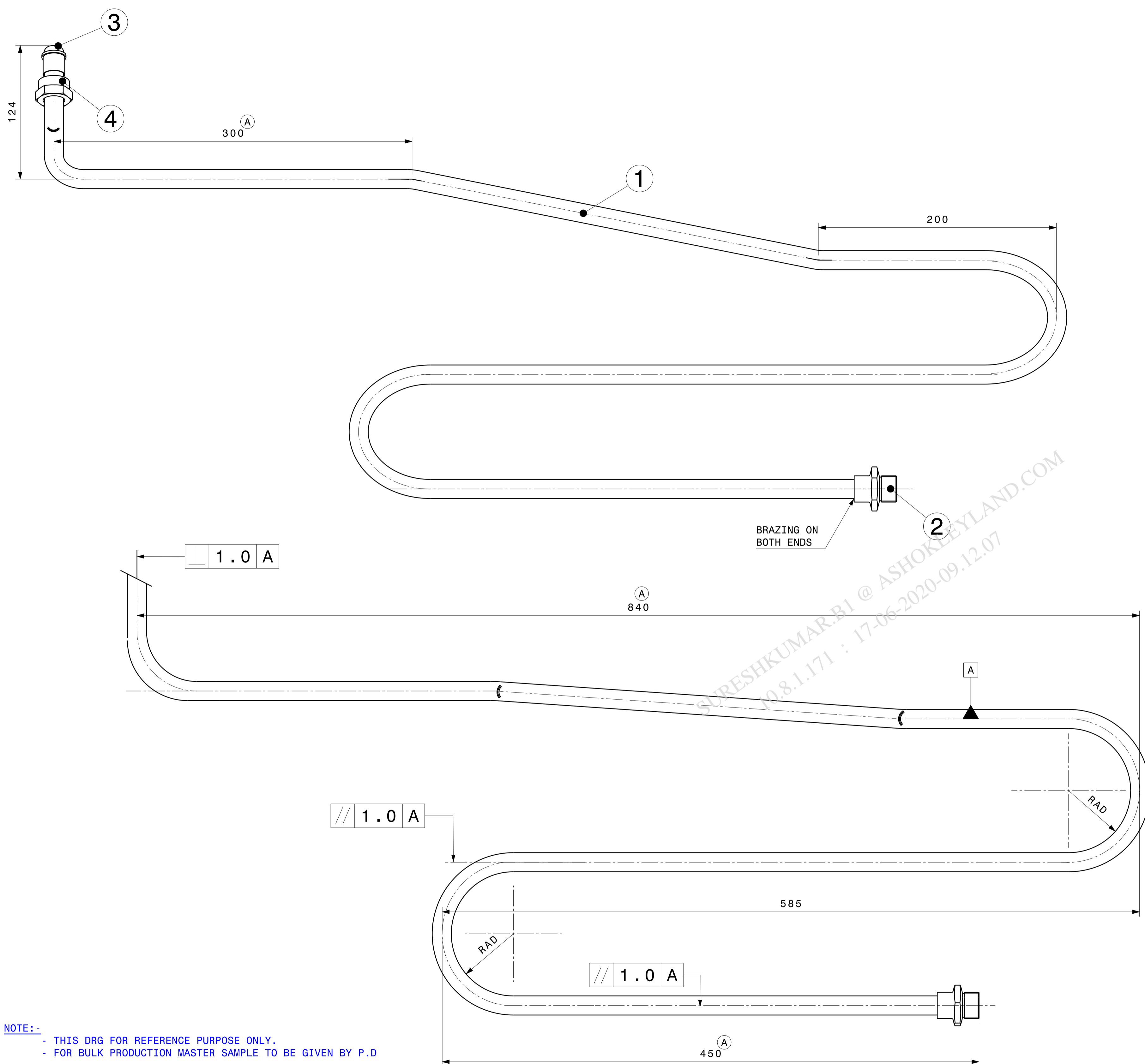




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ASHOK LEYLAND LTD.
TECHNICAL CENTRE, VELLIVOYALCHAVADI



NOTE:-
- THIS DRG FOR REFERENCE PURPOSE ONLY.
- FOR BULK PRODUCTION MASTER SAMPLE TO BE GIVEN BY P.D

VIEW 'A'

SL.No.	PART NUMBER	MATERIAL	QTY
4	F2935015	NUT	1
3	F2901615	NIPPLE	1
2	F0154915	ADAPTOR	1
1	-----	STEEL TUBE TO IS 3074 - CEW 1, SIZE 16 OD, 2 THICK	1

BILL OF MATERIALS			
APPEARANCE ITEM	ER-DIN	DATE	
YES	NO	023273	19/05/06
FINISHED WEIGHT (APPROX)	REF. PT. No.	B2205401	
SCALE	S/A PT No.	-----	
1:2	SUPERSEDES	-----	
	SPEC NO.	ALSG19	

ALTERATIONS			
DESCRIPTION	ER-DIN DATE	BY	REVISION
MATL. UPDATED FOR ITEM DIMNS UPDATED DESCRIPTION CHANGED DIN:023739	EA/SN 26/08/06	-	A
IN ITEM NO.2:- PT. NO. F0154915 WAS F0161515			
IN ITEM NO.3:- PT. NO. F2901615 WAS F2939815	25/09/06	-	B
IN ITEM NO.4:- PT. NO. F2935015 WAS F2940015 DIN:023855	EA/SN		
SL.NO.1 MATERIAL CEW 1 WAS CDS 1, BRAZINGNOTE:LEAK PROOF PRESSURE 105 BAR WAS 150 BAR.	SRR/EAK 10/11/07	-	B.1
SURFACE PROTECTION NOTE ADDED	RSK/BSV 26/07/11	-	C.0

AL PLM VAULT
REVISION : C0 DATE : 11/8/2011 STATUS : RELEASE
STAGE : III ER-DIN NO : ER-DIN-000890 DATE : 11/8/2011
ALTERED BY : sundaralvce CHECKED BY : jeevalvce
MED APPROVAL : visualvce APPROVED BY : saagarajanalvce

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
AA 19/05/05	SN 19/05/05	PRAKASH SHAH 22/05/06	SN 19/05/05	---

MATERIAL SEE B.O.M
HEAT TREATMENT

REMARKS FOR STALLION MARK IV
DESCRIPTION STEERING PIPE - RETURN LINE
PART No. **B 2 2 3 8 2 1 2 C.0**
SHEET NO.1.....OF.....1..... **A1**

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	
LEYLAND	SURFACE PROTECTION		
	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:
- HYDRAULIC TEST TO BE DONE AS PER IS-3074.
- LIMIT OF DEVIATION FROM ROUNDNESS AFTER FORMING SHOULD NOT BE MORE THAN 10% OF NOMINAL OUTER DIA OF TUBE (AS OER IVECO STD 10.4418 CLASS 4.12)
- BRAZING TO BE LEAK PROOF AT A PRESSURE OF 105 BAR.(AS PER ALS 276.01)

SURFACE PROTECTION NOTE:
CLASS D AS PER ALS.268.03