



ASHOK LEYLAND - PART No.
 SPRING ASSY-WITHOUT BUSH : X4512410
 SPRING ASSY-WITH BUSH : B3107201

PART No. : REF. TABLE ABOVE

REF DRG. No. : -	ALL DIMN. ARE IN mm	SHEET : 1 of 1
DRG. No. : JPSL 017	DATE : 04.04.2003	ISSUE/REV.: 02/D
DESCRIPTION	CUSTOMER NAME	2008 DRAWN
ARMY-STALLION MK-IV FRONT SPRING ASSY.	ASHOK LEYLAND	CHECKED/APPROVED
		BY PSS ANUJ SUNIL
		SIGN

JAMNA AUTO INDUSTRIES LTD. INDIA

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DATE	MOD.No.	MODIFICATION	SIGN
10.08.2012	02/D	DIMN ADDED FOR NAMASKAR TYPE CLAMP AS PER CUSTOMER REQUIREMENT	PSS
10.08.2012	02/C	"U" TYPE CLAMP CHANGED TO NAMASKAR TYPE CLAMP TO AVOID COLLING WITH DAMPER REF MAIL DT.6.12.08N : 201050. BUSH INSTALLED TO CHANGED TO 130 MICRON PAINT BRAND NAME REMOVED AND MENTIONED SALT SPRAY HRS. REF MAIL : 08.08.12 ECRN NO : 2010163	PSS
29.03.2010	02/B	PANT SPEC. CHANGED AS PER CUSTOMER REQUIREMENT REF. MAIL DT.29/03/10 ETP U-BOLT PITCH CHANGED 104mm WAS 98mm.	PSS
04.09.2008	02/A	ETP U-BOLT SPACER 6mm MAX ADDED INSTEAD OF SUITABLE SPACER AS PER CUSTOMER REQD. THRU MAIL DT.2/9/08, ECRN No. : 20084	PSS

JPSL 017	B3107201	Qty : -	Qty : -
Supplier Part No	AL Part No	Sample	Pilot
			Production

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

TOLERANCES REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION

ASPHOK SURFACE PROTECTION FABRICATED COMPONENTS TO BE DEGREASED, DESCALD, APPLY ZINC PHOSPHATE, APPLY EPOXY PRIMER AND APPLY 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:4016 CLASS 6g EXTERNAL OR 5H INTERNAL SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

SURFACE PROTECTION NOTE:

- FOR METALLIC PARTS CLASS 'C' AS PER ALS.268.03 COLOR:SCAMIC GREEN; SHADE NO.294 AS PER IS:5
- FOR FASTENERS CLASS 'D' AS PER ALS.268.03

SL.No.	PART NO.	DESCRIPTION	MATERIAL	QTY.
BILL OF MATERIALS				
APPEARANCE ITEM		ER-DIN	DATE	
YES	NO	ER-DIN-XXXXXXX	XX.XX.XXXX	
FINISHED WEIGHT (APPROX)		REF.PT.NO.		
XXX.XXX Kgs		S/A.PT.NO.		
SCALE		SUPERSEDES		
1:1		SPEC.NO.		

AL PLM VAULT

REVISION : B DATE : 27/10/2012 STATUS : RELEASE

STAGE : III ER-DIN NO : ER-DIN-001075 DATE : 27/10/2012

ALTERED BY : sumdaralve CHECKED BY : jnaralve

MED APPROVAL : sivaakumar.vennu APPROVED BY : sngarajan.alve

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/DATE	CHECKED/DATE	DES APPROVAL/DATE	APPROVED/DATE	STDS APP/DATE
RP 29.04.2006	SN 29.04.2006		SN 29.04.2006	

MATERIAL REFER DRAWING

HEAT TREATMENT

REMARKS

STALLION MK-IV

DESCRIPTION FRONT SPRING ASSY-WITH BUSH

PART NO. **B 3 1 0 7 2 0 1 B.0**

SHEET NO 1 OF 1 AO