

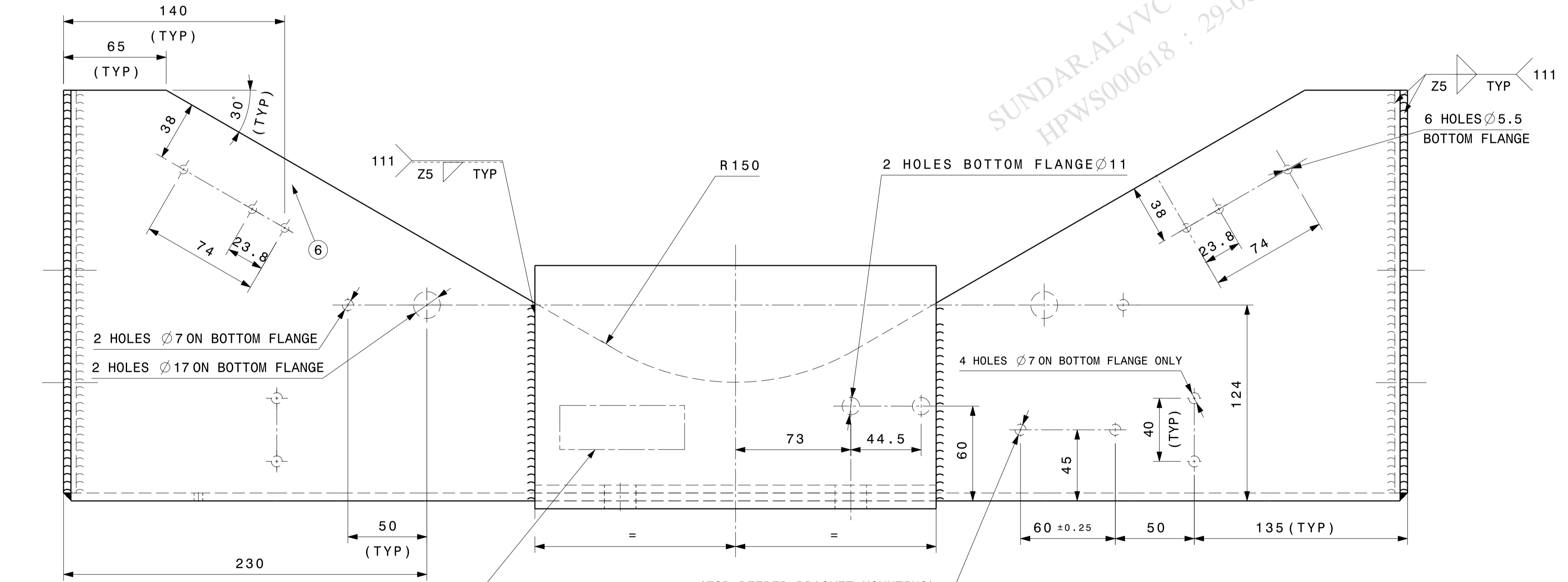
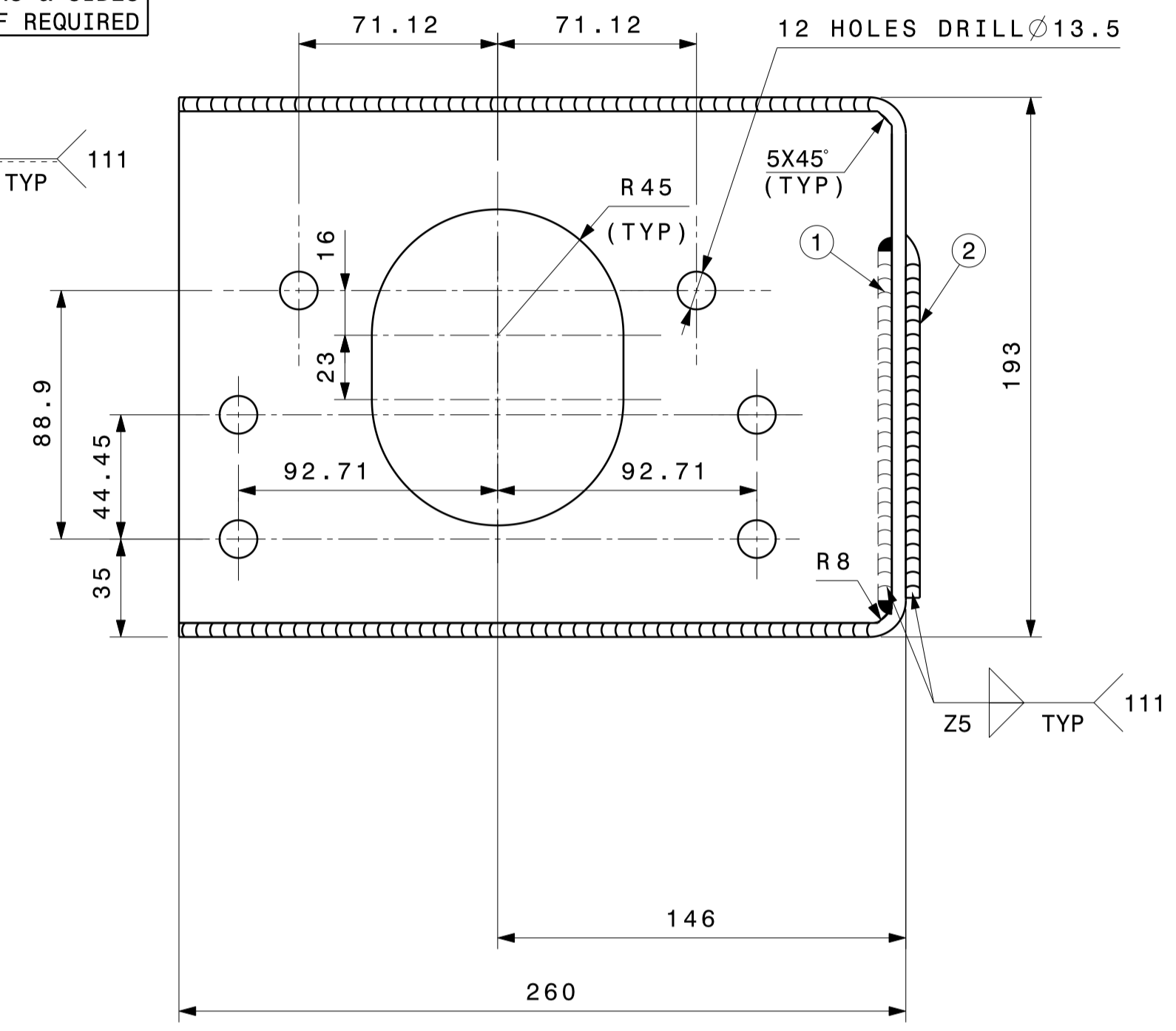
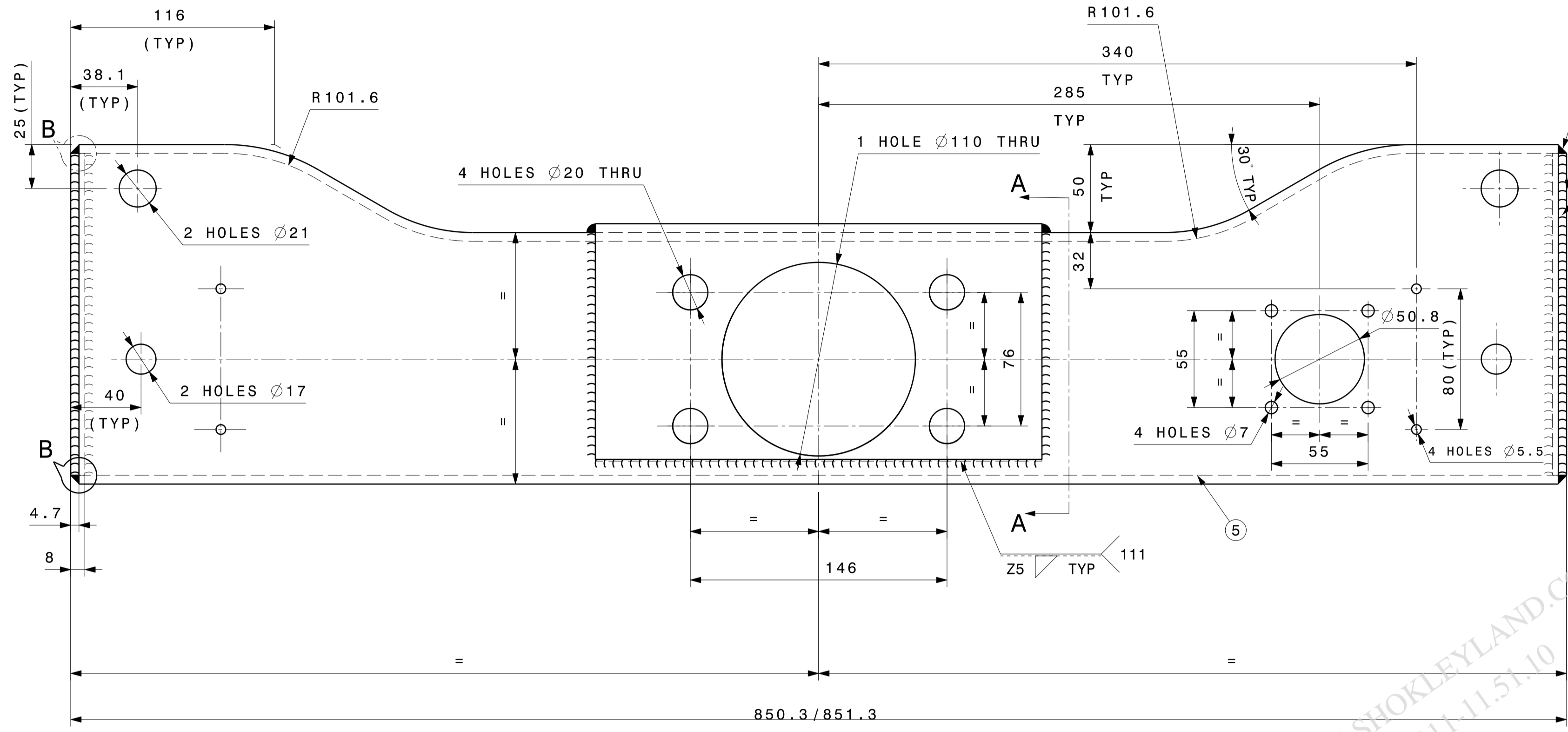


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ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOLCHAVADI



ALTERATIONS		ER-DIN DATE	GRADE	REVISION
ITEM NO 3,4,6 DELETED		06/05/06	-	A
DIN NO:023215		EA/SN		
PAINT DETAILS UPDATED		29.04.11		B.0
SHEET 1 OF 2		VEE/BSV		



AL PART NO & SOURCE CODE TO BE PUNCHED HERE LETTER SIZE 6MM

(FOR BEEPER BRACKET MOUNTING) 2 HOLES Ø7 BOTTOM FLANGE ONLY

AL PLM VAULT
 REVISION : B.0 DATE : 27/6/2011 STATUS : RELEASE
 STAGE : III ER-DIN NO : ER-DIN-0007630 DATE : 27/6/2011
 ALTERED BY : sundar.alvvc CHECKED BY : jee.alvvc
 MED APPROVAL : visal.vvc APPROVED BY : saagarjan.alvvc

SL. No.	PART NO.	DESCRIPTION	MATERIAL	QTY.
6	ITEM 6	GUSSET	STEEL PLATE S THICK 15 2062 GRADE 'A'	2
5	ITEM 5	CROSS MEMBER	STEEL PLATE S THICK 15 2062 GRADE 'A'	1
4	ITEM 4	BRACKET (PURGE TANK)	STEEL PLATE S THICK 15 2062 GRADE 'A'	1
3	ITEM 3	BRACKET (AIR DRYER)	STEEL PLATE S THICK 15 2062 GRADE 'A'	1
2	ITEM 2	'L' PLATE	STEEL PLATE S THICK 15 2062 GRADE 'A'	1
1	ITEM 1	SUPPORT PLATE	STEEL PLATE S THICK 15 2062 GRADE 'A'	1

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED				
DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
MBC 23/03/02	SN 26/04/02	CS 11/08/03	MRK 29/04/02	

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

SPECIAL INSTRUCTIONS/NOTE:
 * USE WELDING ELECTRODE TO SPEC E 6013 OR EQUIVALENT
 * WELDING FILLET SIZE 5MM
 * TO BE PAINTED WITH ENAMEL SCAMIC GREEN CONFORM TO SHADE NO:294, IS:5. (REF DRG NO: X9715000)

BILL OF MATERIALS		
APPEARANCE ITEM	ER-DIN	DATE
YES	NO	ER-DIN-023048 30/03/06
FINISHED WEIGHT (APPROX)	REF. PT. No.	X4685714
SCALE	S/A PT No.	A8136500
1:2	SUPERSEDES	
	SPEC NO.	HAF147

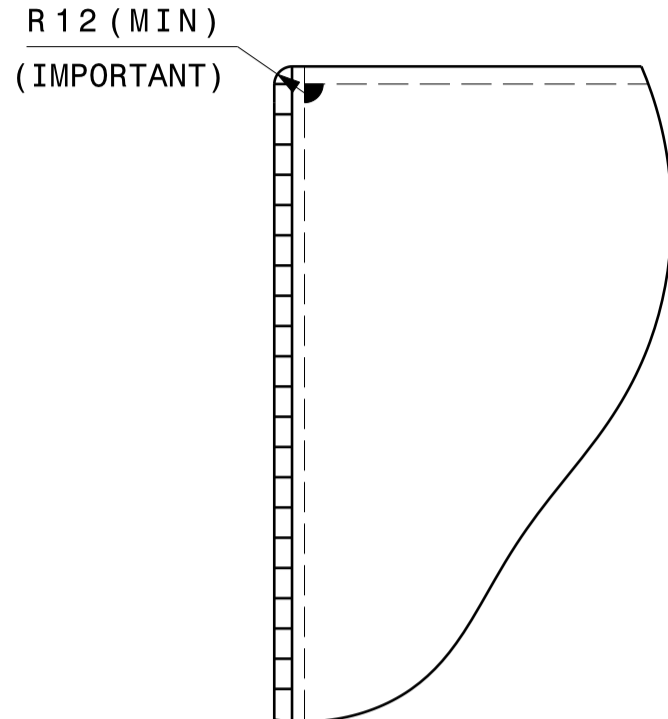
REMARKS	
STALLION MARK IV	
DESCRIPTION	
REAR TOW HOOK CROSS MEMBER	
PART No.	B 8 1 3 6 5 0 8 B.0
SHEET NO.1.....OF....2.....	A1

TOLERANCES	
ASHOK	REFER IS:2102 : MEDIUM FOR MACHINING AND COARSE FOR FABRICATION
SURFACE PROTECTION	
LEYLAND	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)	
LEYLAND	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

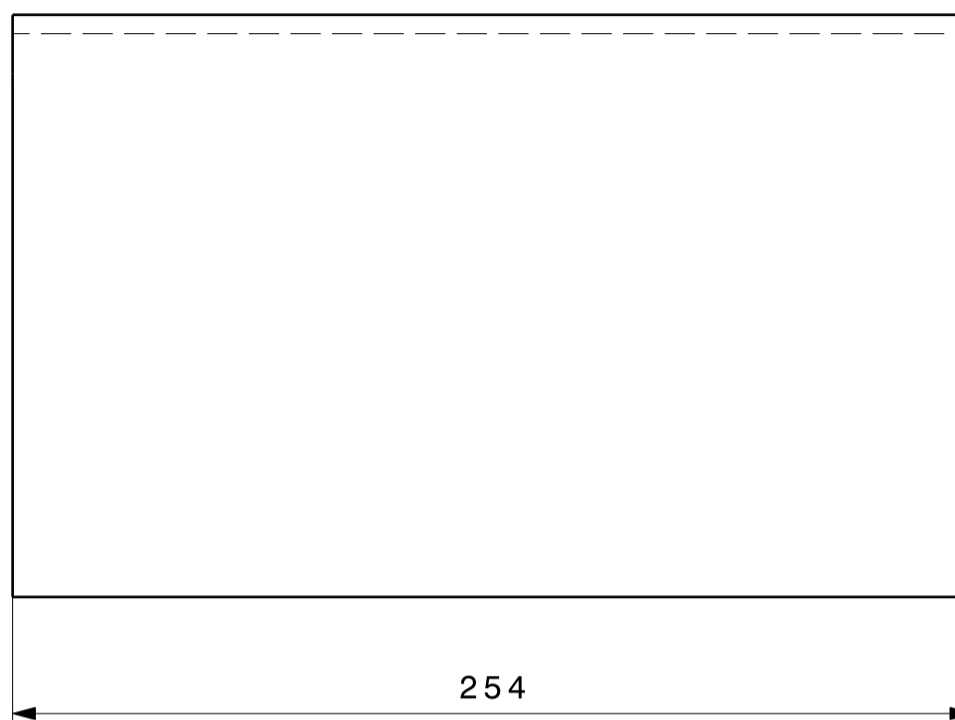


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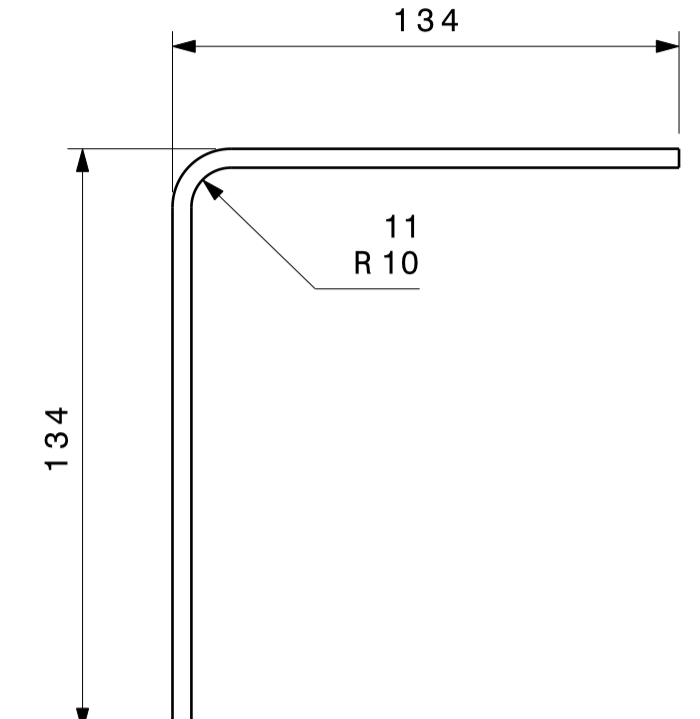
ASHOK LEYLAND LTD.
TECHNICAL CENTRE, VELLIVOYALCHAVADI



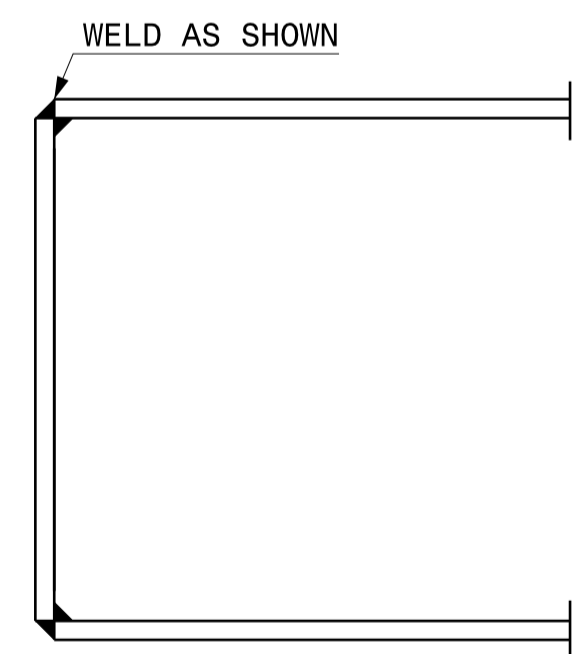
SCRAP VIEW 'B' SHOWING WELDS
NOTE: FILLET WELD AS SHOWN



DETAIL ITEM 2



DETAIL ITEM 1



SECTION-AA
ALTERNATE METHOD OF MAUFACTURE

ALTERATIONS		ER-DIN DATE	ISSUE	REVISION
FOR ALTERATION REF SH. NO.1 DIN: 023215	EA/SN	06/05/06	-	A
FOR ALTERATION REF SH. NO.1 VEE/BSV	VEE/BSV	29/04/11	-	B.0

AL PLM VAULT
REVISION : B.0 DATE : 27/6/2011 STATUS : RELEASE
STAGE : III ER-DIN NO : ER-DIN-0007630 DATE : 27/6/2011
ALTERED BY : sundaralvvc CHECKED BY : jee.alvvc
MED APPROVAL : visal.alvvc APPROVED BY : sagarajna.alvvc

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED				
DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
MBC 23/03/02	SN 26/04/02	CS 11/08/03	MRK 29/04/02	

MATERIAL: SEE SHEET 1
HEAT TREATMENT: _____

REMARKS: STALLION MARK IV

DESCRIPTION		PART No.	
REAR TOW HOOK CROSS MEMBER		B 8 1 3 6 5 0 8 B.0	
SHEET NO. 2 OF 2 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	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 4μ 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:

PAINTING DETAILS:
PAINTING DETAILS AS PER AL PT NO : X9715000

BILL OF MATERIALS			
APPEARANCE ITEM	ER-DIN	DATE	
YES	NO	ER-DIN-023048	30/03/06
FINISHED WEIGHT (APPROX)	REF. PT. No.	X4685714	
-	S/A PT No.	A8136500	
SCALE	SUPERSEDES		
1:2	SPEC NO.	HAF147	