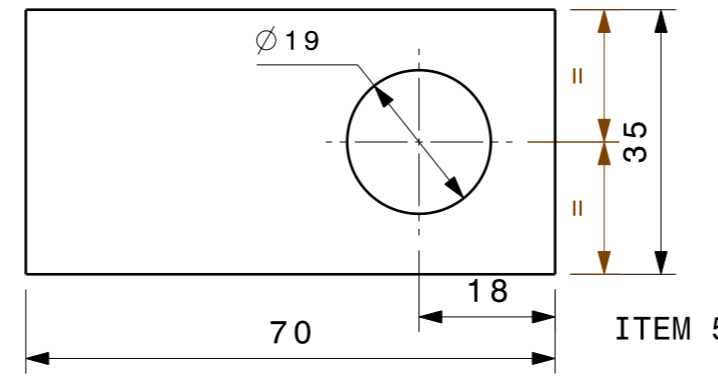
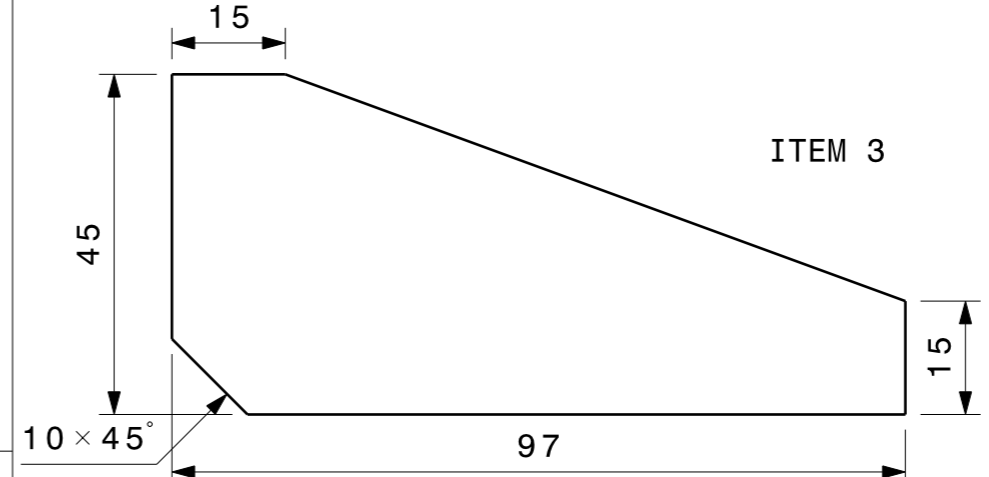
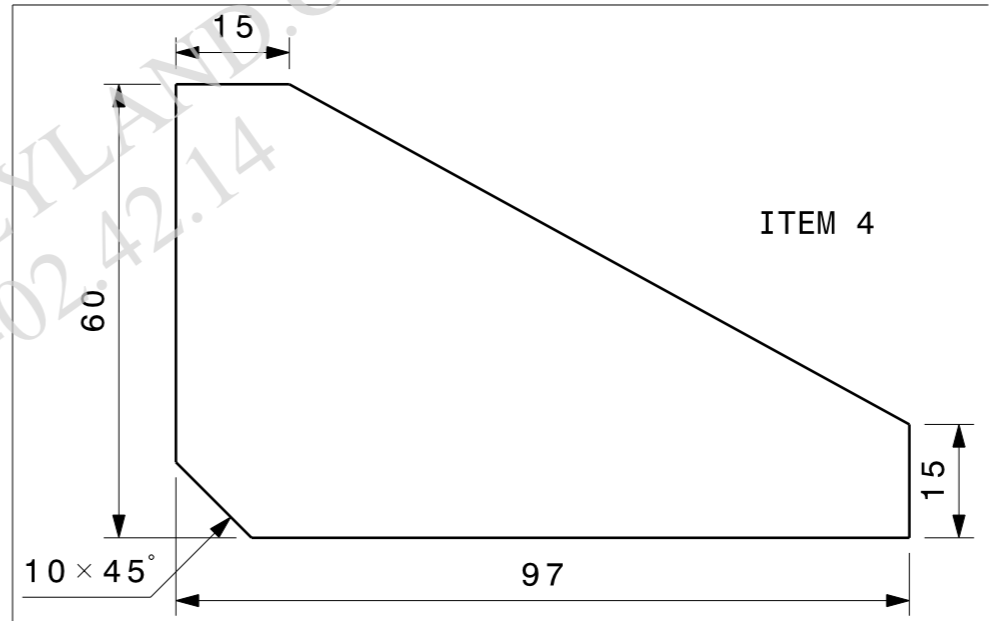
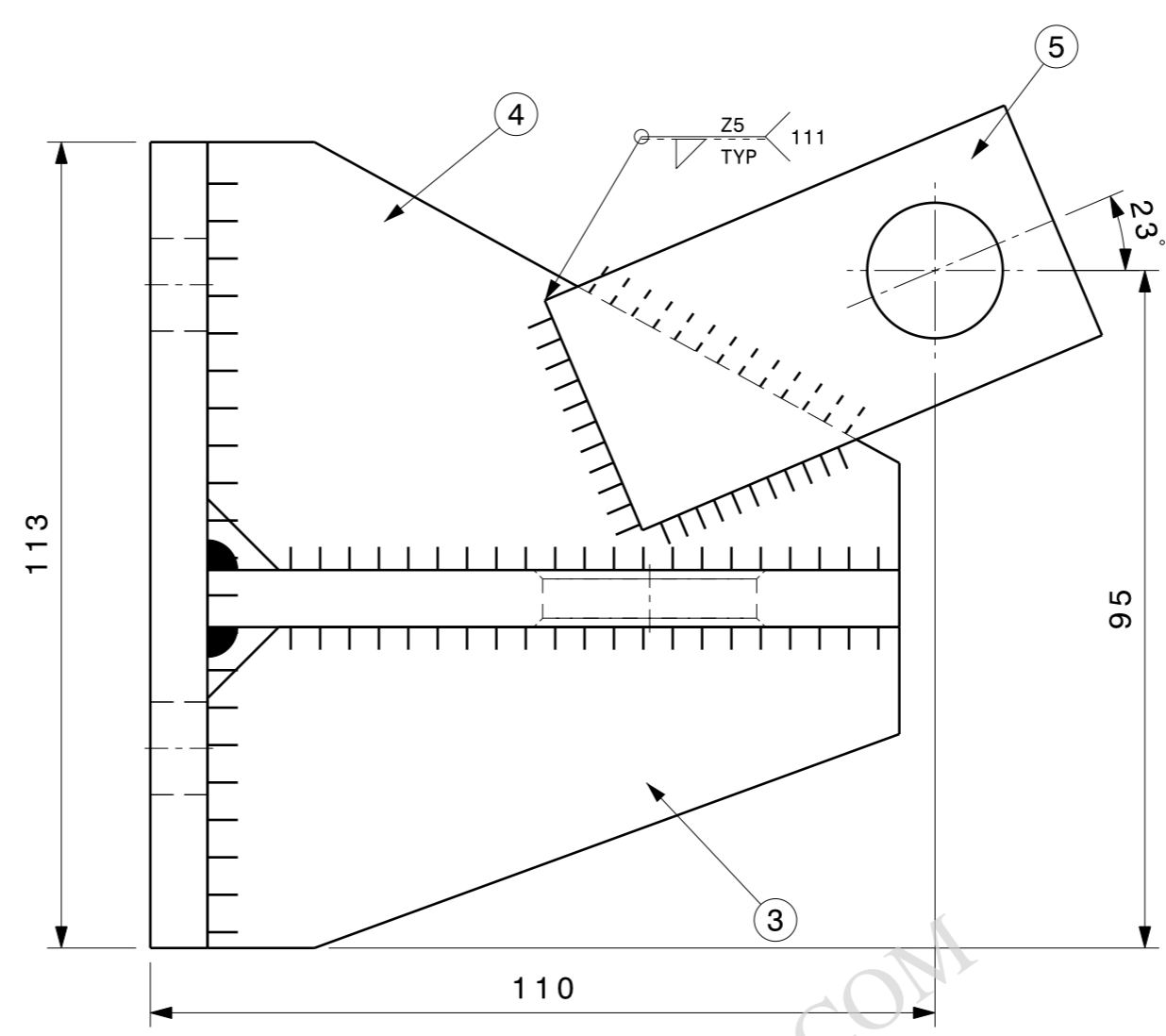
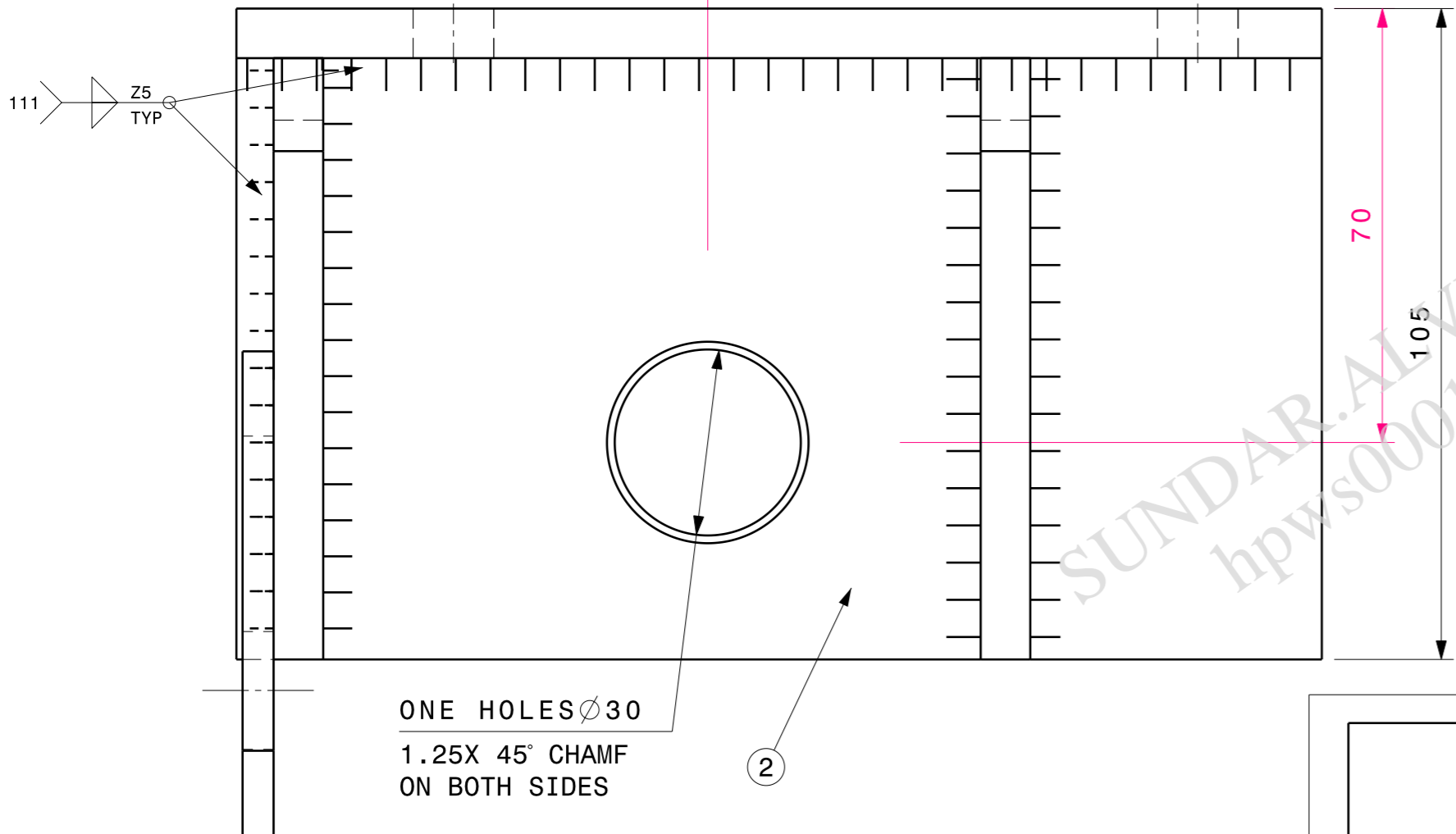
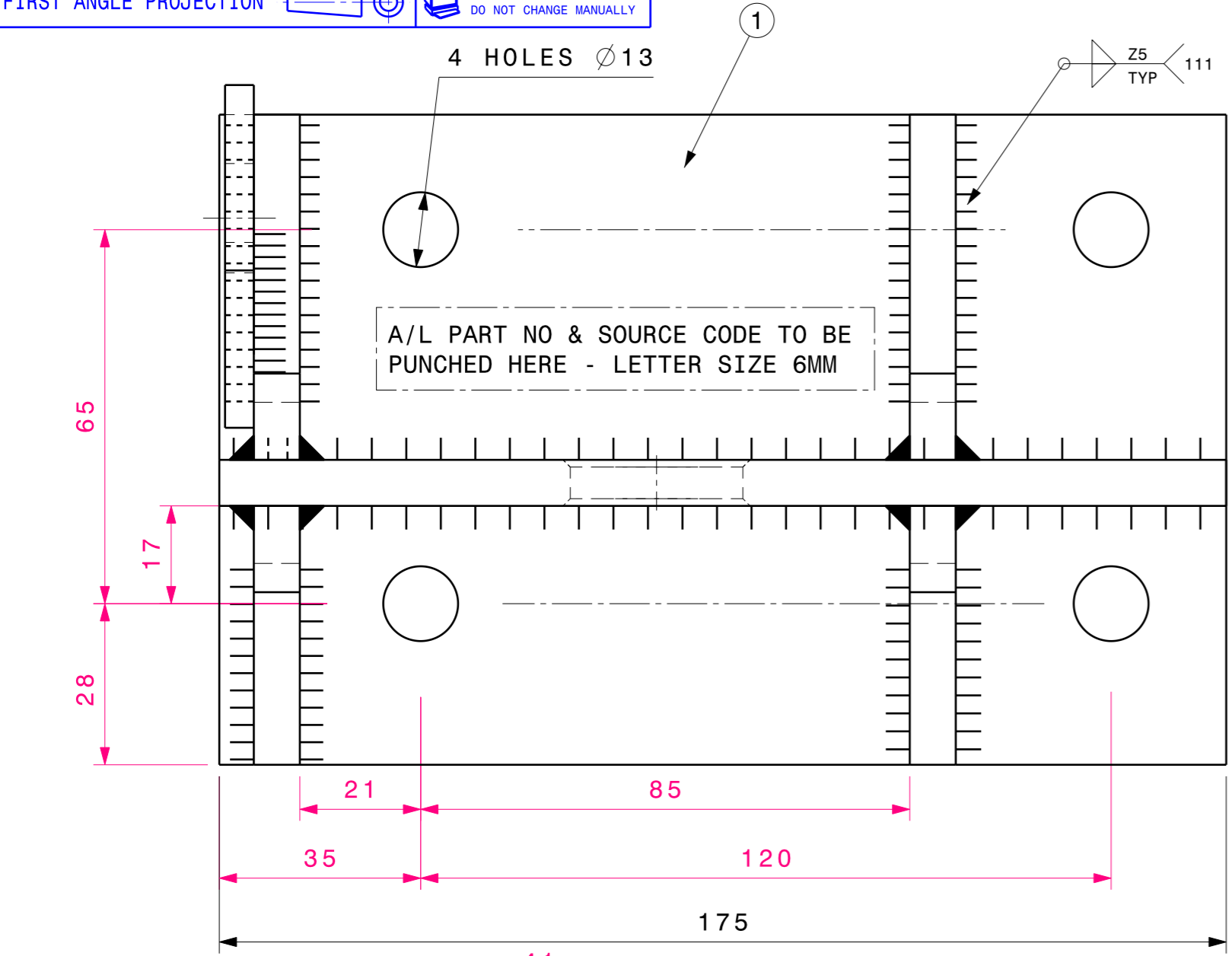




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ASHOK LEYLAND LTD.
 TECHNICAL CENTRE VELLIVoyalCHAVADI



SL NO	PART NO	DESCRIPTION	MATERIAL	QTY
5	ITEM 5	PLATE	STEEL PLATE 5 THK IS 2062 GRADE 'A'	
4	ITEM 4	GUSSET-2	STEEL PLATE 8 THK IS 2062 GRADE 'A'	
3	ITEM 3	GUSSET-1	STEEL PLATE 8 THK IS 2062 GRADE 'A'	
2	ITEM 2	PLATE	STEEL PLATE 8 THK IS 2062 GRADE 'A'	
1	ITEM 1	BRKT	STEEL PLATE 8 THK IS 2062 GRADE 'A'	



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX

AL PLM VAULT

REVISION : #0 DATE : 11/12/2010 STATUS : RELEASE

STAGE : III ER-DIN NO : ER-DIN-0006263 DATE : 11/12/2010

ALTERED BY : ashokumar.alvvc CHECKED BY : rchandra.alvvc

MED APPROVAL : sureshp.alvvc APPROVED BY : snagarajan.alvvc

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
SRR 24/02/08				

MATERIAL SEE BOM

HEAT TREATMENT

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:4210 CLASS-6g EXTERNAL OR-5H INTERNAL
	SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

- * TO BE PAINTED WITH ENAMEL, SCAMIC GREEN CONFORM TO SHADE NO: 294, IS: 5. (REF DRG NO: X9715000).
- * WELDING ELECTRODE TO BE AWS E6012 OR E6013
- * WELDS TO CONFIRM TO REQUIREMENTS OF ALS 276.02
- * WELDING SYMBOL AS PER IS 813

BILL OF MATERIALS

APPEARANCE ITEM	ER-DIN	DATE
YES NO		
FINISHED WEIGHT (APPROX)	REF PART NO:	X7188310
	S/A PART NO:	A8136500
SCALE	SUPERSEDES	
1:1	SPEC NO:	HAF

REMARKS STALLION MARK IV

DESCRIPTION SHOCK ABSORBER MTG BRKT -RH

PART NO. **F 8 9 6 6 2 1 4 #.0**

SHEET No1..... OF1..... **A2**