

**PART No.**  
M 250681

**AL PL. No.** F8088500.

ECN No.	DATE	REV	SIGN

2.0  
1.5 PRE-LOAD OF AIR CYLINDER

DO NOT SCALE IF IN DOUBT ASK

NOTCH IS PARALLEL TO THE POSITION OF THE BAFFLE PLATE

ASSY PART No. AND BATCH No. ARE SHOWN HERE

INLET PORT M12x1.5, DEEP 12 TIGHTENING TORQUE 21 Nm max.

SPHERE R 80

C'BORE  $\phi$ 16

$\phi$ 7

SEALING SURFACE TO BE FREE FROM NICKS/CUTMARKS AND DAMAGES

PRODUCT SPECIFICATION No. : PSSC 87C  
 CYLINDER BORE : 40 mm  
 CYLINDER STROKE : 40.5 mm  
 WORKING PRESSURE : 10 bar max.  
 THERMAL RANGE OF APPLICATION : -30°C TO +150°C  
 OPEN PORT IS FITTED WITH CLOSURE PLUG AND HOUSING IS FITTED WITH CLOSURE COVER - 2OFF FOR STORAGE AND TRANSIT PURPOSES.

T 663  
100 Nos.  
31/03/96

AL PL. No. F8088500. 070498

**CD TVS SUNDARAM CLAYTON LTD., MADRAS - 600 050**

REPLIOTED FOR CUSTOMER		SIGN		DATE	MATERIAL	---	CONFIDENTIAL DRAWING	UNLESS OTHERWISE SPECIFIED	GENERAL TOLERANCES				SCALE	PART No.	
DRN	V.Paulraj	09.03.98	ALTERNATE MATERIAL	---	THIS DRAWING IS THE SOLE PROPERTY OF SUNDARAM CLAYTON LIMITED. IT SHOULD NOT BE COPIED OR COMMUNICATED TO ANY PERSON WITHOUT THE WRITTEN APPROVAL OF SUNDARAM CLAYTON LIMITED. © 1995	---	ALL DIMENSIONS IN mm	RANGE OF NOMINAL DIMENSIONS (± mm)	△	FORCE, POWER, PRESSURE etc.	1 : 1	M 250681		P	GA
CHD	K.P.N	09.03.98	SURFACE PROTECTION	---	REMOVE BURRS AND SHARP EDGES FROM FINISHED PARTS	---	ALL DIMENSIONS ARE AFTER SURFACE PROTECTION / TREATMENT.	≤ 50	1	50 - 180	2	EXHAUST BRAKE ASSY			
APD	S.Selvamani	10.03.98	RAW PART No.	---	MALE THREAD TO IS : 4218 - 6g	---	FEMALE THREAD TO IS : 4218 - 6H	> 180	3	≤ 400	4	M 250681			
								> 400	5	> 400	10				

<b>M250681</b>	<b>F8088500</b>	<b>Qty : -</b>	<b>Qty : -</b>	<b>-</b>
<b>Supplier Part No</b>	<b>AL Part No</b>	<b>Sample</b>	<b>Pilot</b>	<b>Production</b>

**A.0** NOTE:  
 SURFACE PROTECTION:  
 1. FOR METALLIC PARTS  
 CLASS 'C' AS PER ALS.268.03  
 2. FOR FASTENER  
 CLASS 'D' AS PER ALS.268.03

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
<b>UNLESS OTHERWISE SPECIFIED</b>					
TOLERANCES REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION					
SURFACE FINISH AS PER IS:3073(CLA VALUE)					
SHARP EDGES TO BE REMOVED					
DIMENSIONS ARE IN MM					
DO NOT SCALE DRAWING					
<b>BILL OF MATERIALS</b>					
APPEARANCE ITEM		ER-DIN	DATE		
YES		---	---		
NO		---	---		
FINISHED WEIGHT (APPROX):		REF PT NO:	---		
SUPERSEDES:		S/A PT NO:	---		
SCALE		SPEC NO:	---		
1:1		---	---		

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
SURFACE PROTECTION NOTE UPDATED & NEW TEMPLATE UPDATED	10/10/11	-	A.0
<b>AL PLM VAULT</b>			
REVISION : A.0	DATE : 25/11/2011	STATUS : RELEASE	
STAGE : III	ER-DIN NO : ER-DIN-0008543	DATE : 25/11/2011	
ALTERED BY : sundar.alvvc	CHECKED BY : jnr.alvvc		
MED APPROVAL : visu.alvvc	APPROVED BY : snagarajan.alvvc		
<b>DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED</b>			
DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL /DATE	APPROVED/ DATE
V. PAULRAJ 09.03.98	K. P. N 09.03.98	XXXX XX.XX.XXXX	S. SELVAMANI 10.03.98
MATERIAL		REF DRG	
HEAT TREATMENT			
REMARKS			
FOR STALLION			
DESCRIPTION			
<b>EXHAUST BRAKE ASSY.</b>			
PART NO.	F 8 0 8 8 5 0 0		A.0
SHEET NO: .....1..... OF... 1.....		A3	