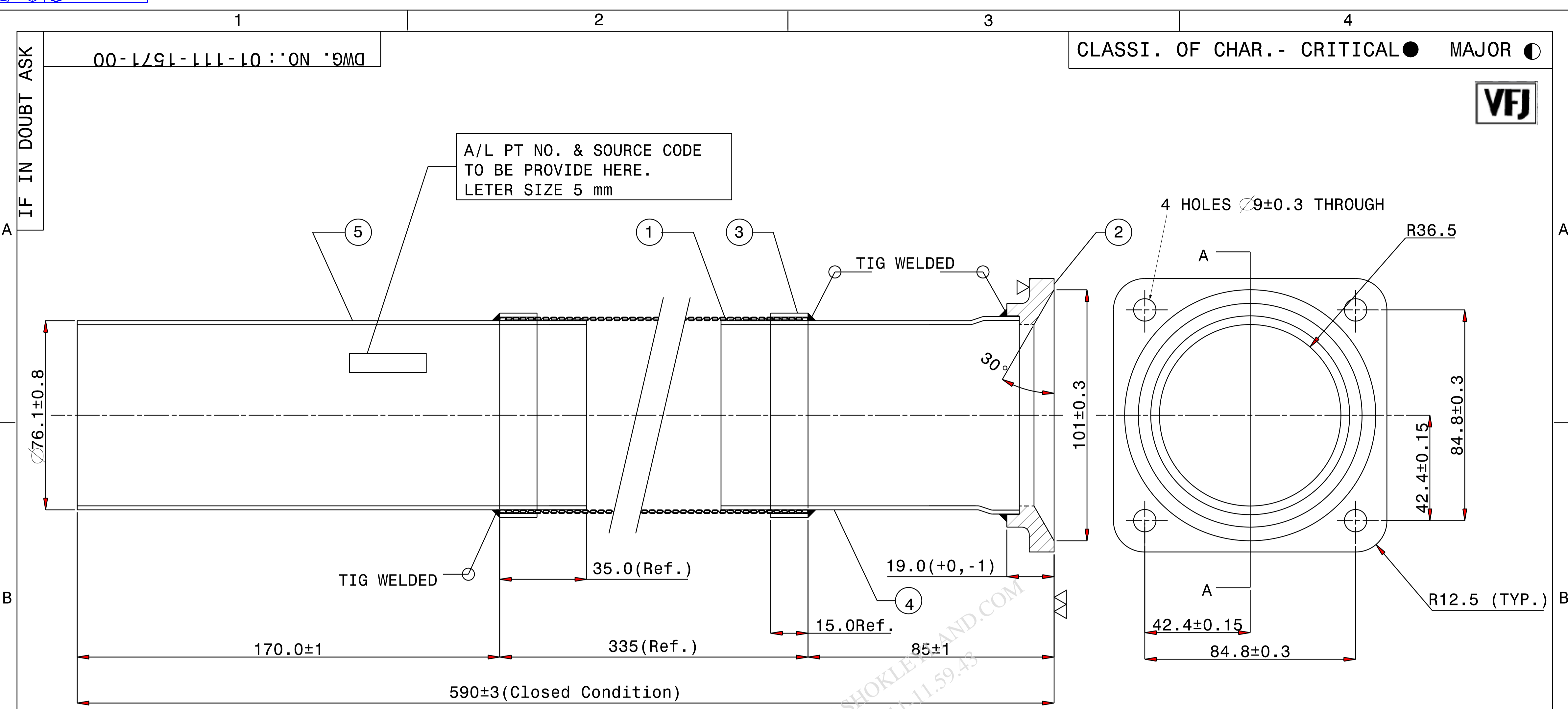




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ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOALCHAVADI

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DESIGN & TEST PARAMETERS
 TYPE : POLYGON 20 SIDES
 HOSE ID : 76.2mm±1.0
 LEAK PROOF AT 2.5 BAR LINE PRESSURE
 LATERAL SHIFT: ±55mm

NOTE: REMOVE BURRS & SHARP EDGES UNLESS OTHERWISE SPECIFIED
 TOLERANCE FOR FABRICATED PARTS ±0.5MM
 FINISH : MAT'L : REF TABLE

MACHINING DEVIATIONS WHERE NOT SPECIFIED												
LENGTH or Ø	0-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	OVER 4000	LENGTH IN MM OF SHORTER SIDE OF ANGLES			
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	Upto 6	6-30	30-120	120-400
									±1'	±30'	±20'	±10'

Sl.No	DESCRIPTION	MATL	QTY	REMARKS
5	PIPE 2 (1.6Thk) L=205	CS	1	ERW PIPE ALUMINIUM PAINTED
4	PIPE 1 (1.6Thk) L=120	CS	1	ERW PIPE ALUMINIUM PAINTED
3	FUSING SLEEVE (1.6 Thk.)	SS304	2	
2	FLANGE	CS	1	
1	INTERLOCK HOSE (0.3 Thk)	SS304	1	

TOLERANCES TO ISO 2768 UNLESS OTHERWISE STATED
 SCALE: NTS All DIMENSIONS ARE IN mm SHT. 20F3
Title: FLEXIBLE EXHAUST PIPE
 DWG. NO.: 01-111-1571-00 Rev. 0

RANFLEX INDIA Pvt. Ltd.
 Works: N067A/1, CHAKLET BAGLUR ROAD
 YELAHANKA, BANGALORE - NORTH - 562149, INDIA

ALTERATIONS		ER-DIN DATE	QTY	REVISION
DRG REVISED FOR PRODUCTION APPROVAL		24 06 09	-	#.1

AL PLM VAULT
 REVISION: #.1 | DATE: 26-06-2009 | STATUS: RELEASE
 STAGE: III | ER-DIN NO/DATE: ER-DIN-0002079 / 26-06-2009
 ALTERED BY: jnr.alvvc | CHECKED: jnr.alvvc
 MED APPROVAL: -NA- | APPROVED: snagapajan.alvvc
 DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

SUPPLIER PART NO	AL PART NO.	SAMPLE	TRAIL	PRODUCTION	SAMPLE	TRAIL	SAMPLE	TRAIL	PRODUCTION
01-111-1571-00	B4573702			004745 24.06.09					SN 24.06.09
01-111-1571-00	B4573702		T02998 11.07.07					50	SN 11.07.07

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

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.)

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:

SL.No.	PART NO.	DESCRIPTION	MATERIAL	QTY.

BILL OF MATERIALS		
APPEARANCE ITEM	ER-DIN	DATE
YES	NO	ER-DIN-XXXXXX XX.XX.XXXX
FINISHED WEIGHT (APPROX)	REF. PT. No.	B4573701
XXX.XXX Kgs	S/A PT No.	
SCALE	SUPERSEDES	
NTS	SPEC NO.	

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
RP 11.07.07	XXXX XX.XX.XXXX	XXXX XX.XX.XXXX	XXXX XX.XX.XXXX	

MATERIAL: _____

HEAT TREATMENT: _____

REMARKS: STALLION MK III LHD BS-2

DESCRIPTION	
FLEXIBLE EXHAUST PIPE	

PART No. **B 4 5 7 3 7 0 2 #.1**

SHEET NO.1.....OF.....1..... **A1**