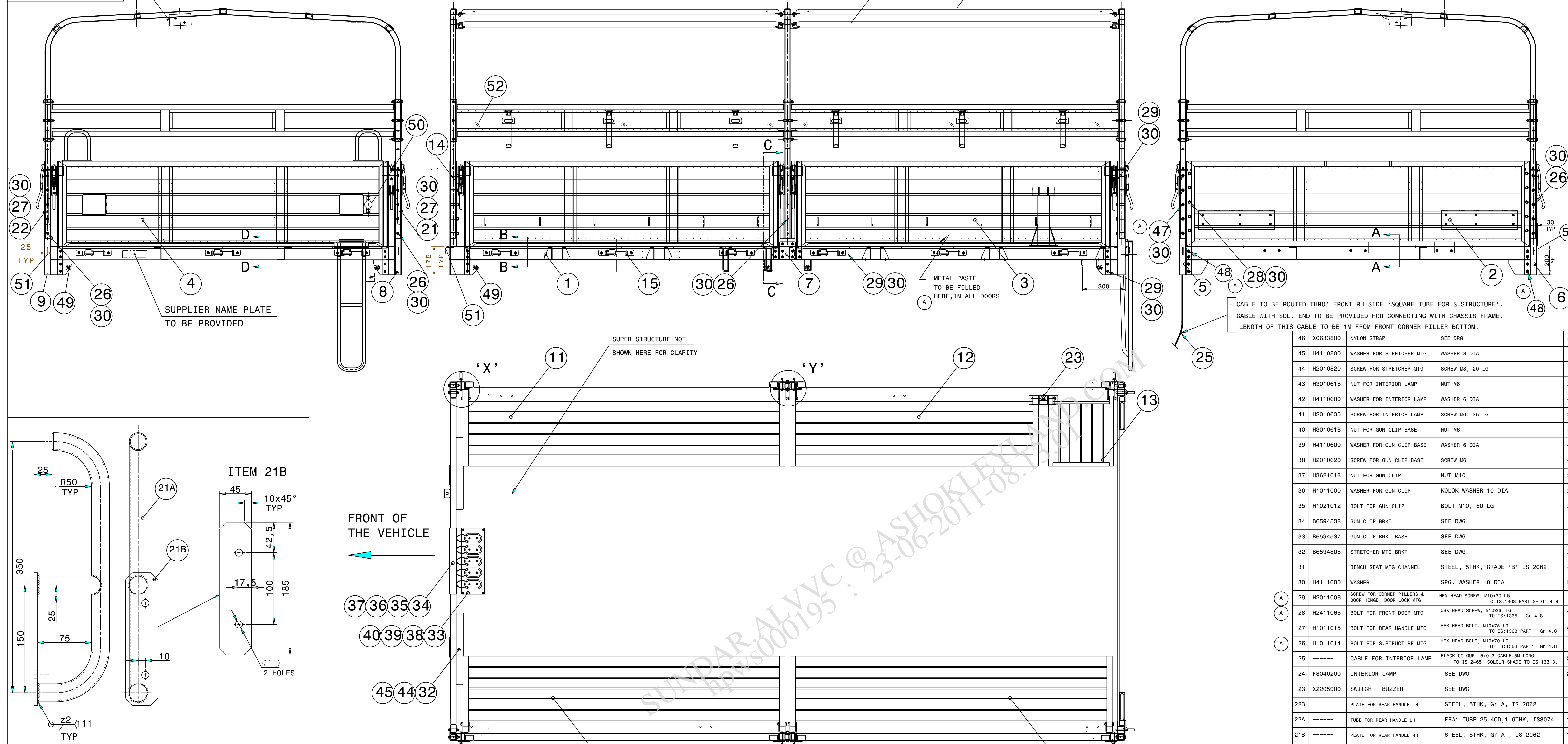


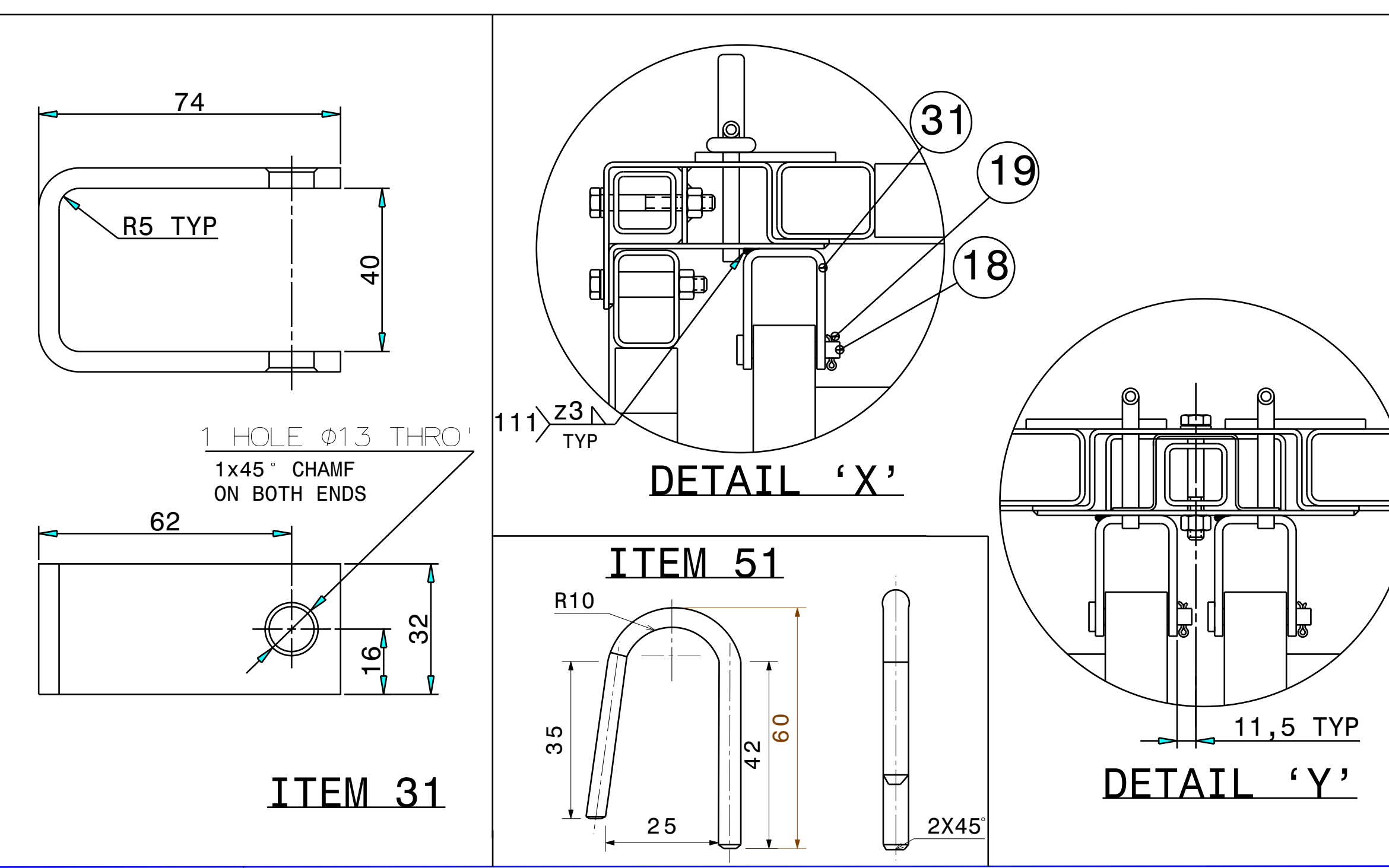
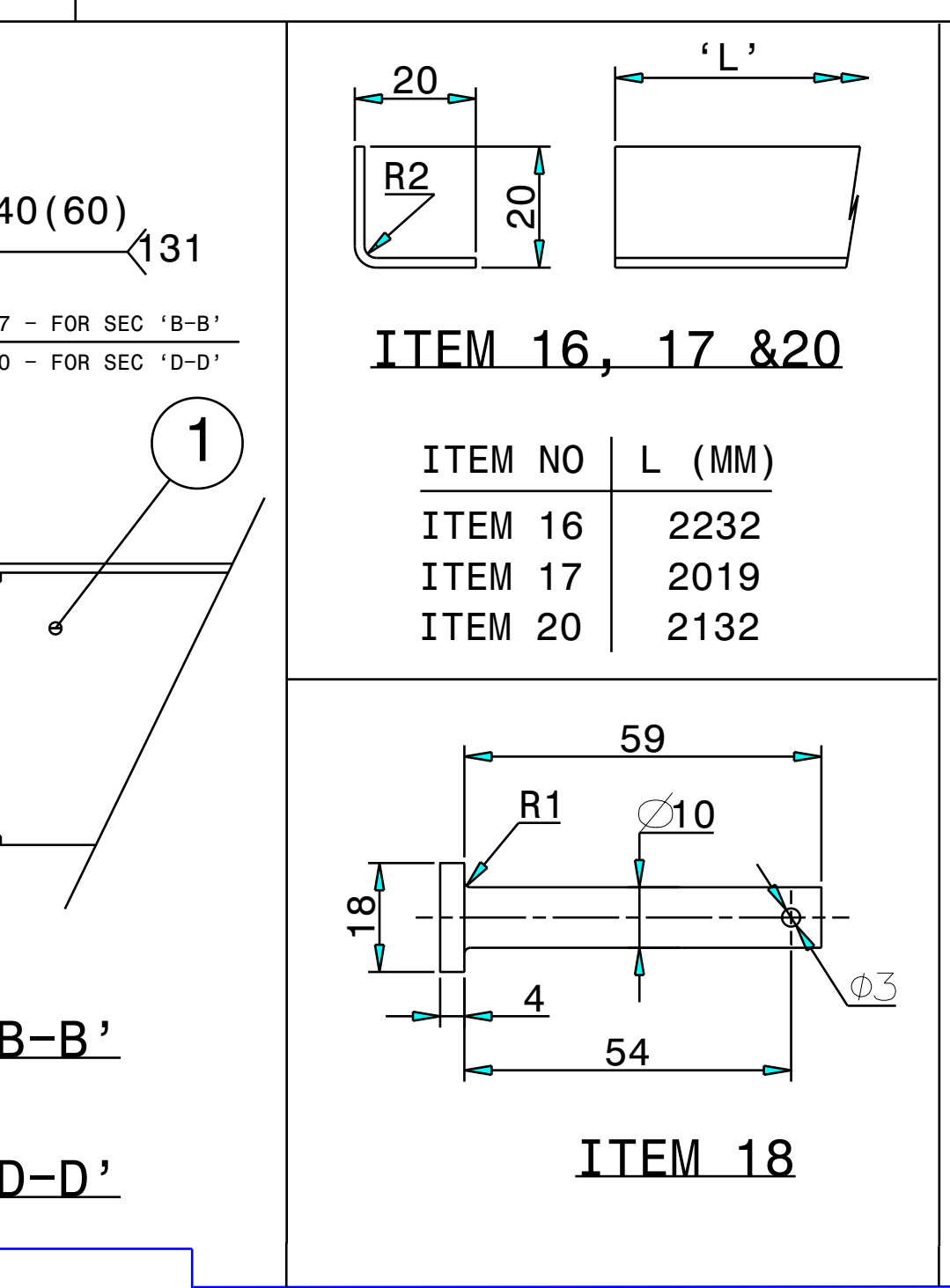
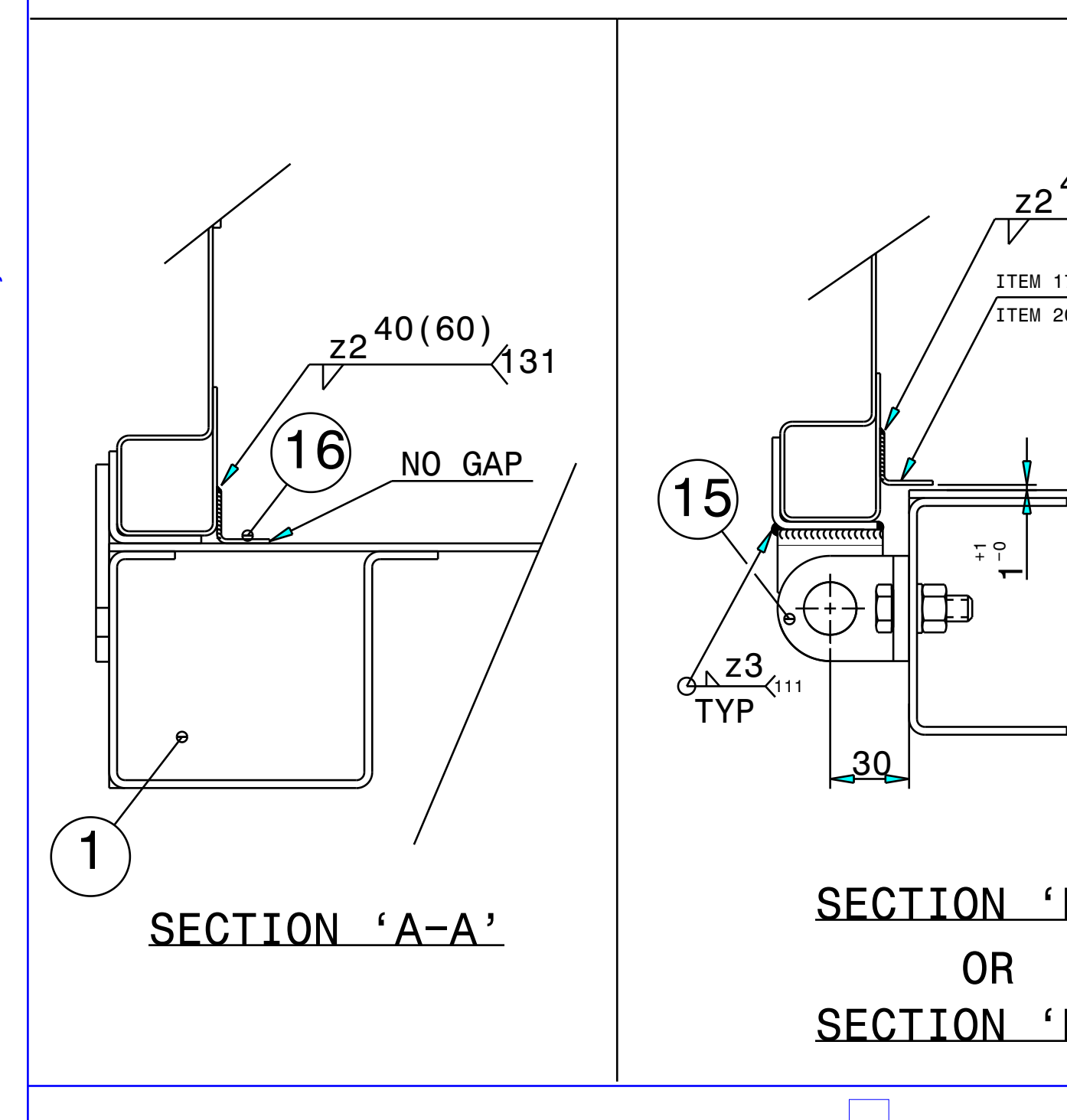
FIRST ANGLE PROJECTION

SURFACE FINISH AS PER IS:3073. (CLA VALUE)

MICRO INCHES	MICROMETRES
BELOW 8	BELOW 0.2
8 - 16	0.2 - 0.4
16 - 32	0.4 - 0.8
32 - 64	0.8 - 1.6
64 - 125	1.6 - 3.2
125 - 250	3.2 - 6.4



ITEM 21A, 21B, RH - DRAWN
ITEM 22A, 22B, LH - MIRROR IMAGE



ITEM NO	PART NO	DESCRIPTION	MATERIAL	QTY
46	X0633800	NYLON STRAP	SEE DRG	5
45	H4110800	WASHER FOR STRETCHER MTG	WASHER 8 DIA	12
44	H2010820	SCREW FOR STRETCHER MTG	SCREW M8, 20 LG	12
43	H3010618	NUT FOR INTERIOR LAMP	NUT M6	2
42	H4110600	WASHER FOR INTERIOR LAMP	WASHER 6 DIA	4
41	H2010635	SCREW FOR INTERIOR LAMP	SCREW M6, 35 LG	2
40	H3010618	NUT FOR GUN CLIP BASE	NUT M6	4
39	H4110600	WASHER FOR GUN CLIP BASE	WASHER 6 DIA	4
38	H2010620	SCREW FOR GUN CLIP BASE	SCREW M6	4
37	H3621018	NUT FOR GUN CLIP	NUT M10	2
36	H1011000	WASHER FOR GUN CLIP	KOLOK WASHER 10 DIA	2
35	H1021012	BOLT FOR GUN CLIP	BOLT M10, 60 LG	2
34	B6594538	GUN CLIP BRKT	SEE DRG	1
33	B6594537	GUN CLIP BRKT BASE	SEE DRG	1
32	B6594805	STRETCHER MTG BRKT	SEE DRG	2
31	-----	BENCH SEAT MTG CHANNEL	STEEL, 5THK, GRADE 'B' IS 2062	8
30	H4111000	WASHER	SPO. WASHER 10 DIA	142
29	H2011006	SCREW FOR CORNER FILLERS & DOOR HINGE, DOOR LOCK MTG	HEX HEAD SCREW, M10x30 LG TO IS:1363 PART 2- Gr 4.8	94
28	H2411065	BOLT FOR FRONT DOOR MTG	CSK HEAD SCREW, M10x45 LG TO IS:1365 - Gr 4.8	10
27	H1011015	BOLT FOR REAR HANDLE MTG	HEX HEAD BOLT, M10x75 LG TO IS:1363 PART-1- Gr 4.8	4
26	H1011014	BOLT FOR S.STRUCTURE MTG	HEX HEAD BOLT, M10x70 LG TO IS:1363 PART-1- Gr 4.8	16
25	-----	CABLE FOR INTERIOR LAMP	BLACK COLOUR 15/0.3 CABLE, 5M LONG TO IS 2465, COLOUR SHADE TO IS 13313.	2
24	F8040200	INTERIOR LAMP	SEE DRG	2
23	X2205900	SWITCH - BUZZER	SEE DRG	1
22B	-----	PLATE FOR REAR HANDLE LH	STEEL, 5THK, Gr A, IS 2062	1
22A	-----	TUBE FOR REAR HANDLE LH	ERW1 TUBE 25.400, 1.6THK, IS3074	1
21B	-----	PLATE FOR REAR HANDLE RH	STEEL, 5THK, Gr A, IS 2062	1
21A	-----	TUBE FOR REAR HANDLE RH	ERW1 TUBE 25.400, 1.6THK, IS3074	1
20	-----	L ANGLE - INSIDE RR DOOR	SHEET 1.6 THK IS 513, Gr 'D' (ROLLED PANEL)	1
19	-----	SPLIT PIN	SPLIT PIN 3x20 IS 549	10
18	-----	PIN	EN328/080M15/EN38/070M20 OF BS 970	10
17	-----	L ANGLE - INSIDE SIDE DOORS	SHEET 1.6 THK IS 513, Gr 'D' (ROLLED PANEL)	4
16	-----	L ANGLE - INSIDE FRNT DOOR	SHEET 1.6 THK IS 513, Gr 'D' (ROLLED PANEL)	1
15	X4102910	DOOR HINGE	SEE DRG	15
14	X4102810	DOOR LOCK	SEE DRG	10
13	B6510617	DHANDAMAN SEAT	SEE DRG	1
12	B6510616	BENCH SEAT - SHORTER	SEE DRG	1
11	B6510615	BENCH SEAT - LONGER	SEE DRG	3
10	B6510614	SUPER STRUCTURE	SEE DRG	1
9	B6510613	CORNER PILLAR REAR LH	SEE DRG	1
8	B6510612	CORNER PILLAR REAR RH	SEE DRG	1
7	B6510611	CENTER PILLAR	SEE DRG	2
6	B6510610	CORNER PILLAR FRNT LH	SEE DRG	1
5	B6510609	CORNER PILLAR FRNT RH	SEE DRG	1
4	B6510608	REAR DOOR	SEE DRG	1
3	B6510607	SIDE DOOR	SEE DRG	4
2	B6510606	FRONT DOOR	SEE DRG	1
1	B6510605	FLOOR ASSY	SEE DRG	1

ALTERATIONS

REV. NO	DATE	REASON	BY
01/10/02			A
09/03/04			B
23/05/06			C
1259			C.1
28/02/08			

QTY OF 'ITEM 26' 16 OFF WAS 26 OFF
'ITEM 28' WAS M10 HEX. HEAD BOLT
QTY OF 'ITEM 29' 94 OFF WAS 102 OFF
ON DOORS NOTES FOR METAL PASTE FILLING, ADDED

DIM 400 WAS 425
LOAD BOBY ASSY REDRAWN
ITEM 49,50,51,52 - ADDED

AL PLM VAULT
REVISION: C.1 DATE: 11/12/2010 STATUS: RELEASE
STAGE: III ER-DIN NO: ER-DIN-0006263 DATE: 11/12/2010
ALTERED BY: ashokkumar.alv checked BY: rchandran.alv
MED APPROVAL: suresh.alv APPROVED BY: sngarajan.alv

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED

DATE	CHECKED/DATE	MED APPROVAL/DATE	APPROVED/DATE	STDS APP/DATE
M. B. C 11.05.02	RR 30.05.02	MR 30.05.02		

FOR STALLION MARK IV
ASSY LOAD BOBY
PART NO. B 6 5 1 0 6 0 4 C.1
SHEET NO 1 OF 1 AO

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

ASHOK SURFACE PROTECTION

FABRICATED COMPONENTS TO BE DEGRASSED, DESCALED, 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

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:

- USAGE OF PROPER TEMPLATES ASSY. FIXTURES & INSPECTION FIXTURES TO BE DEVELOPED BY SUPPLIER TO ENSURE DIMENSIONAL CONSISTENCY OF INDIVIDUAL COMPONENTS & ASSEMBLY
- SUPPLIER NAME PLATE INDICATING SUPPLIER ADDRESS A/L PART NO. BODY SL. NO. TO BE FIXED BY RIVETS.
- THE MAX PERMISSIBLE BOW: VERTICAL AND HORIZONTAL DEFLECTION ON PANEL ASSY, FLOOR ASSY AND FINAL ASSY CONDITION SHALL NOT EXCEED 2MM PER METER.

NOTE FOR WELDING (IF NOT SPECIFIED):
JOINING OF STRUCTURES TO BE OF CONTINUOUS WELD STRUCTURE JOINING WITH FLOOR PANEL TO BE OF CONTINUOUS WELD AT WEB & FLANGE OF FLOOR PANEL OTHER PORTIONS TO BE 40MM STICH WELD WITH A GAP OF 60MM STICH WELD TO BE STAGGERED ON OPPOSITE SIDES FOR BOTH FLANGES OF SAME MEMBER MIN ACCEPTABLE BEND RAD FOR STRUCTURE IS 1 THICKNESS OF SHEET USED
ALL BRKTS AND FITMENT ITEMS TO BE OF CONTINUOUS WELD

PAINTING DETAILS:

- * SCAMIC GREEN PAINTING TO BE DONE AS PER AL RECOMMENDATION REF PART NO X9715000.
- * WELDING SYMBOLS AS PER IS : 813.
- * WELDING ELECTRODE TO BE AWS E6012 OR E6013.
- * WELDS TO CONFORM TO REQUIREMENTS OF ALS.276.02.

BILL OF MATERIALS

APPEARANCE	ITEM	ER-DIN	DATE
YES	NO	ER-DIN-XXXXXXX	XX.XX.XXXX
FINISHED WEIGHT (APPROX)	REF.PT.NO.	B6594536	
XXX.XXX Kgs	S/A.PT.NO.	B6510601	
SCALE	SUPERSEDES		
1:12	SPEC.NO.	HABS 88	

SUNDAR ALVVC @ ASHOKLEYLAND.COM
hpws000195 : 23-06-2011-08.13.01

AL PLM VAULT
REVISION : C1 DATE : 11/12/2010 STATUS : RELEASE
STAGE : III ER-DIN NO : ER-DIN-000263 DATE : 11/12/2010
ALTERED BY : ashokkumar.alvvc CHECKED BY : rchandra.alvvc
MED APPROVAL : suresh.alvvc APPROVED BY : sngarajan.alvvc

DIGITALLY SIGNED - PHYSICAL SIGNATURE NOT REQUIRED