



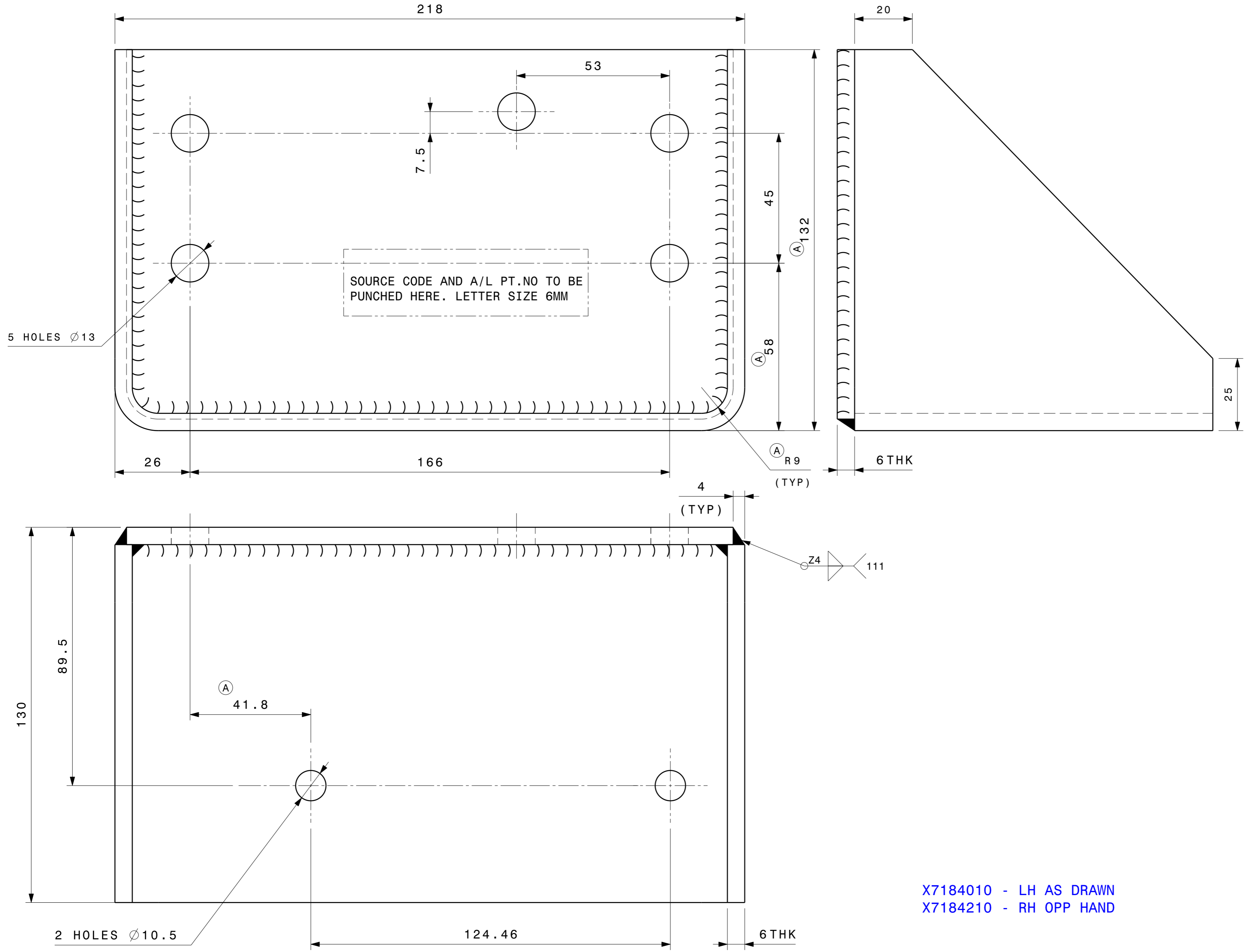
LEYLAND

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**ASHOK LEYLAND LTD.**  
TECHNICAL CENTRE VELLIVAYALCHAVADI



LEYLAND



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
DIMN 58 WAS 26, 132 WAS 100 & 41.8 WAS 20.8, DIMN RADIUS 9 WAS 6 ABM	23/04/03	—	A
PAINTING DETAILS UPDATED DIN: 021765 ABM	23/03/05	—	B
*DRG-REDRAWN IN CAD. *NOTE FOR ENAMEL REQUIREMENT AS PER IS 8982 DELETED. *OTHER SPECIAL INSTRUCTION NOTES ADDED. SG/KG	20/07/10	—	B.1

AL PLM VAULT  
 REVISION : B.1 DATE : 7/9/2010 STATUS : APPROVED  
 STAGE : II ER-DIN NO : ER-DIN-0005705 DATE : 13/9/2010  
 ALTERED BY : sundar.alvvc CHECKED BY : jnr.alvvc  
 MED APPROVAL : visu.alvvc APPROVED BY : snagarajan.alvvc

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
DR 27/04/02	SN 27/04/02	CS 20/08/03	SN 27/04/02	—

MATERIAL  
 PLATE 6 THICK IS 2062 GRADE 'A'

HEAT TREATMENT —

REMARKS  
 STALLION MARK IV

DESCRIPTION  
 REAR BUFFER BRACKET

PART NO. **X 7 1 8 4 0 1 0 B.1**

SHEET No .....1..... OF .....1..... **A2**

**C** -CRITICAL **S** -SAFETY **I** -IMPORTANT. THIS DRAWING CONTAINS SAFETY CHARACTERISTICS

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:4218 CLASS 6g EXTERNAL OR 5H INTERNAL SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

- \* GENERAL TOLERANCE TO BE ±1-0.5 MM
- \* TOLERANCE ON HOLE PITCHES & SIZES TO BE ±0.25MM
- \* TOLERANCE ON OVERALL DIMENSIONS TO BE ±1 MM
- \* BEND LINE BE ⊥ TO GRAIN FLOW DIRECTION.
- \* WELDING ELECTRODE TO BE AWS E6012 OR E6013
- \* WELDS TO CONFIRM TO REQUIREMENTS OF ALS.276.02
- \* TO BE PAINTED WITH ENAMEL SCAMIC GREEN CONFORM TO AL PT NO X9715000

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
<b>BILL OF MATERIALS</b>					

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