

ASHOK



LEYLAND

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PRODUCTION ENGINEERING & PROJECTS ASHOK LEYLAND LTD. HOSUR

ASHOK



LEYLAND

A2

PROJECT

MAGIRUS



THIRD ANGLE PROJECTION
FIRST ANGLE PROJECTION

REFER IS 2102 - 1969 FOR ALLOWABLE
DEVIATION FOR DIMENSIONS
SPECIFIED TOLERANCES

SHARP EDGES TO BE REMOVED
DO NOT SCALE DRAWING

DIMENSIONS ARE IN MILLIMETERS
UNLESS OTHERWISE STATED

SURFACE FINISH SYMBOLS									
Symbol	~	▽	▽▽	▽▽▽	▽▽▽▽	▽▽▽▽▽	▽▽▽▽▽▽	▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽
Description	Raw	Roughing	Smoothing	Finishing	Fine Finishing	Ground	HRD	HRD & GD	HRD & GD
Ra Value in um	50	12.5-25	0.6-0.3	0.4-0.2	0.2-0.12	0.4-0.2	0.4-0.2	0.4-0.2	0.4-0.2

THIS DRG IS MADE AS PER AWH
APPROVED. DRG. OF TRINITY

23.8.97

IF IN DOUBT ASK.

DRG. NO.

SD 90 563 1 1

ALTERATIONS

① $\phi 56$ WAS $\phi 54$ DRG

MODIFIED 12.11.97
30/11/97

20/11/97

H.T. HARDEN & TEMPER TO 'V'
CONDITION WAS ANNEALED
& HARDNESS 269-331 BHN
WAS 230 BHN MAX. CHANGE
AS PER FINISH DRG.
Kp. Call

DIM. 17, NOTE FOR SUPPLIER
CODE & HEAT/BATCH NO. ADDED
& SUPPLIER CODE, HEAT
CODE DELETED AS PER
DGM/TS LINO. 9556/FUR-
VEH/AL/XL/CD0-II, DT.
4-12-2000.

DIM. 57 ϕ WAS $\phi 56$
CHANGE AS PER JNM/DT
MEMO NO. QAT/GSS/UT
DT. 10-11-2002 AND
1/6 UJ/GS letter NO. GS/UT
DRG. 178 DT. 12-11-02
LOCATION AND CLAMPING
ON 69 WIDTH FACES &
CLAMPING ON 60 ϕ
FACE DELETED.
LOCATION & CLAMPING
ON 60 ϕ ADDED.
CHANGE TO SUIT VET
FACING CENTRING M/C
VET 2783 HMT SAM
Y-295.

matl spec DIN:1654 added
as per JEGM/TS LINO. 9556/
Fur-Veh/AL/AGB/CD0-II,
dt. 13-11-03 & JNM/DT
LINO. 461/QAT/ POLICY/03,
dt. 15-11-03. Kp. Call

PART NO. SD 90 563 1 1

DESCRIPTION DRIVE SHAFT

REPLACES DRG. NO.

DRAWN T.G.P. TRACED

CHECKED DATE 9-2-98

APPROVED SCALE NTS

TITLE DRIVE SHAFT

DRG. NO.

SD 90 563 1 1

SD 90 563 1 1

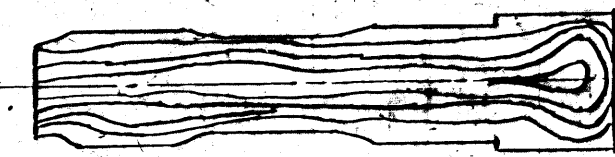
SD 90 563 1 1

SD 90 563 1 1

NOTES:

- 1) ALL DIMENSIONS ARE IN MM.
- 2) ALL LOCATING, RESTING & CLAMPING SURFACES TO BE CLEAN, SMOOTH, FLAT & CYLINDRICAL.
- 3) STAMPING TO BE SHOT BLASTED, MAGNETICALLY CRACK DETECTED 100% & HARDNESS TESTED 100%.
- 4) ALL RADII MUST BE BLENDED SMOOTHLY AND FREE FROM SCALES AND DAMAGE.
- 5) ALL DIMENSIONS & DRAFT ANGLES TAKEN TO SHARP CORNERS.
- 6) CLOSE TRIM FLASH EXTENSIONS.
- 7) SUPPLY CONDITION: - ANNEALED. HARDEN & TEMPER TO 'V' CONDITION

GRAIN FLOW REQUIREMENT



- REST
- LOCATE
- CLAMP

HARDNESS: - 269 - 331 BHN

REF DRG: TRINITY FORGING DRG U302.

* UNSPECIFIED FORGING TOLERANCE *	
MATERIAL :- 42 CrV6, DIN:1654	LENGTH :- +1.6 - 0.0
HARDNESS :- 230 BHN MAX.	WIDTH :- +1.6 - 0.0
DRAFT ANGLES :- 5° + 2° - 1°	STRAIGHTNESS :- 0.9
CORNER RADII :- R2.5 + 50% - 25%	MISMATCH :- 0.6
FILLET RADII :- R2.5 + 50% - 25%	SURFACE :- 0.5
THICKNESS & DIE :- +1.6 - 0.0	HEAT TREATMENT :-

Forging Wt: Calculated - 7.15 Kg

Roll No. 2D NOTE