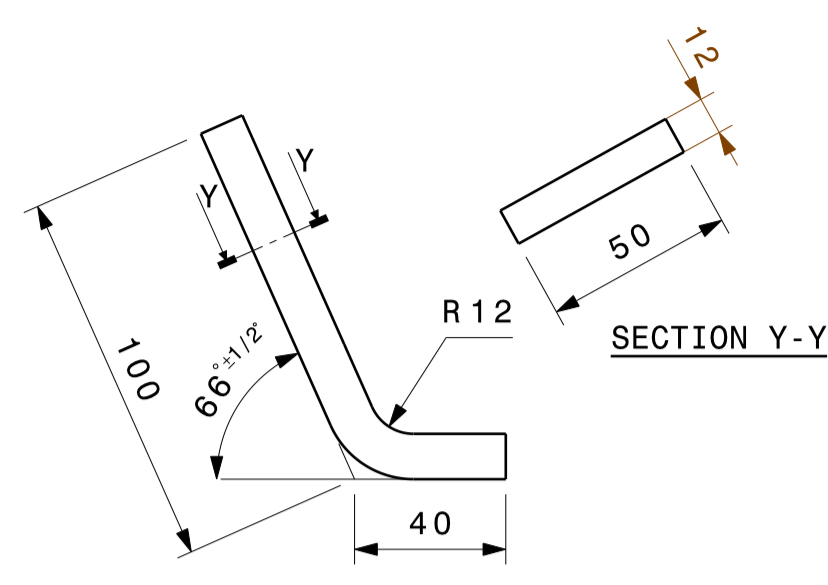




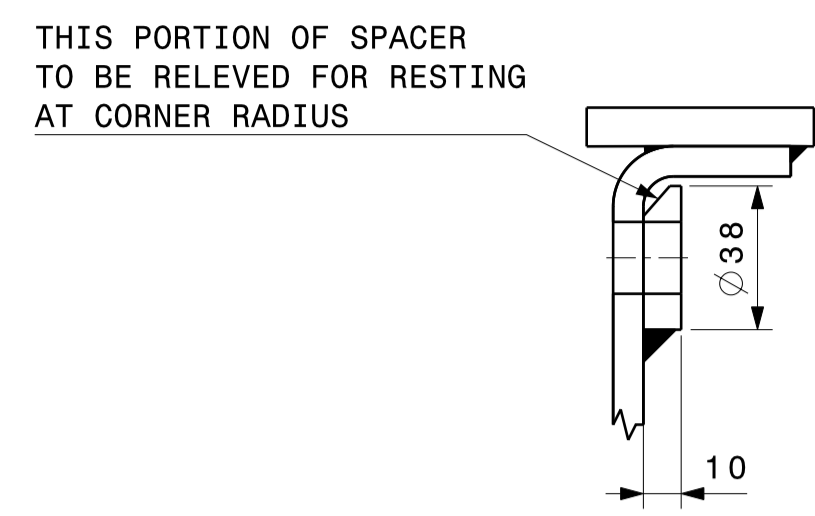
This design is strictly private and confidential. It is the exclusive property of Ashok Leyland Ltd., and must not be used, copied or reproduced in part or whole without the company's written permission.



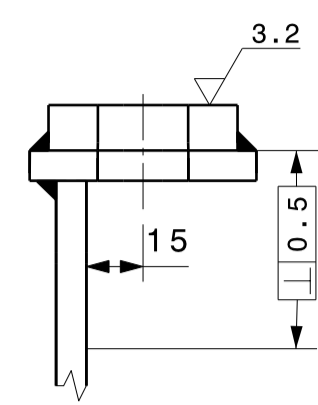
ALTERATIONS		DR. DATE	REVISION
PART NO WAS D9063910 RH. D9063610 LH	SN	21 09 96	-
DIMN 5 WAS 15 AND 117 WAS 107. DIMN 30 WAS 40	SN	12 11 96	- A
FOR MTG HOLES DIMN 20 FROM FRONT END ADDED AND DIMN 30 AT REAR END RELATED LENGTH 506 WAS 510 RAD IN TOP PLATE 20 MM WAS R16 MIN SQUARENESS FOR BOT. FLANGE. SECTION 'UU' ADDED. DIN H5423	SN	24 02 97	- B
TWO SLOTS 24X15 WAS 24X13.5 DIN H5772	SN	26 08 97	- C
TWO SLOTS 24X13.5 WAS 24X15 DIN H5901	SN	21 11 97	- D
DRG. REDRAWN IN CATIA. ONE HOLE Ø19 ADDED WITH DIMS 41 AND 7 MM	SN	17 07 09	- E



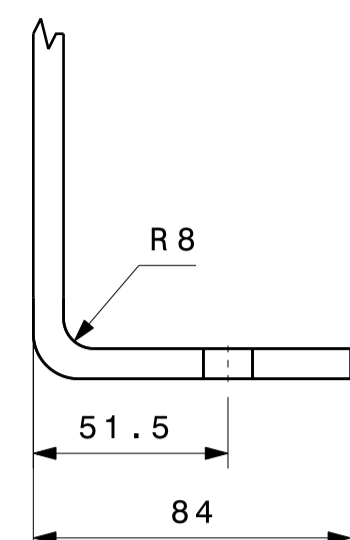
DETAILS FOR STIFFENER



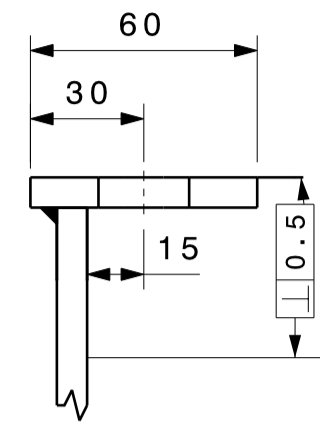
SECTION 'TT' (APPLICABLE TO X0444410)



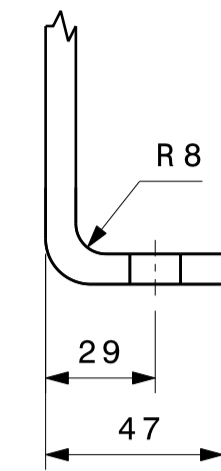
SECTION 'UU'



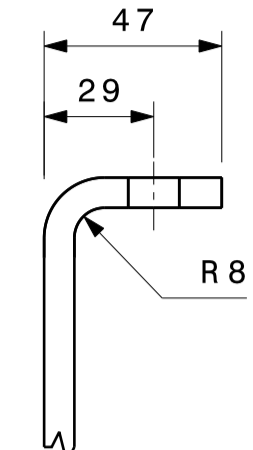
SECTION- 'SS'



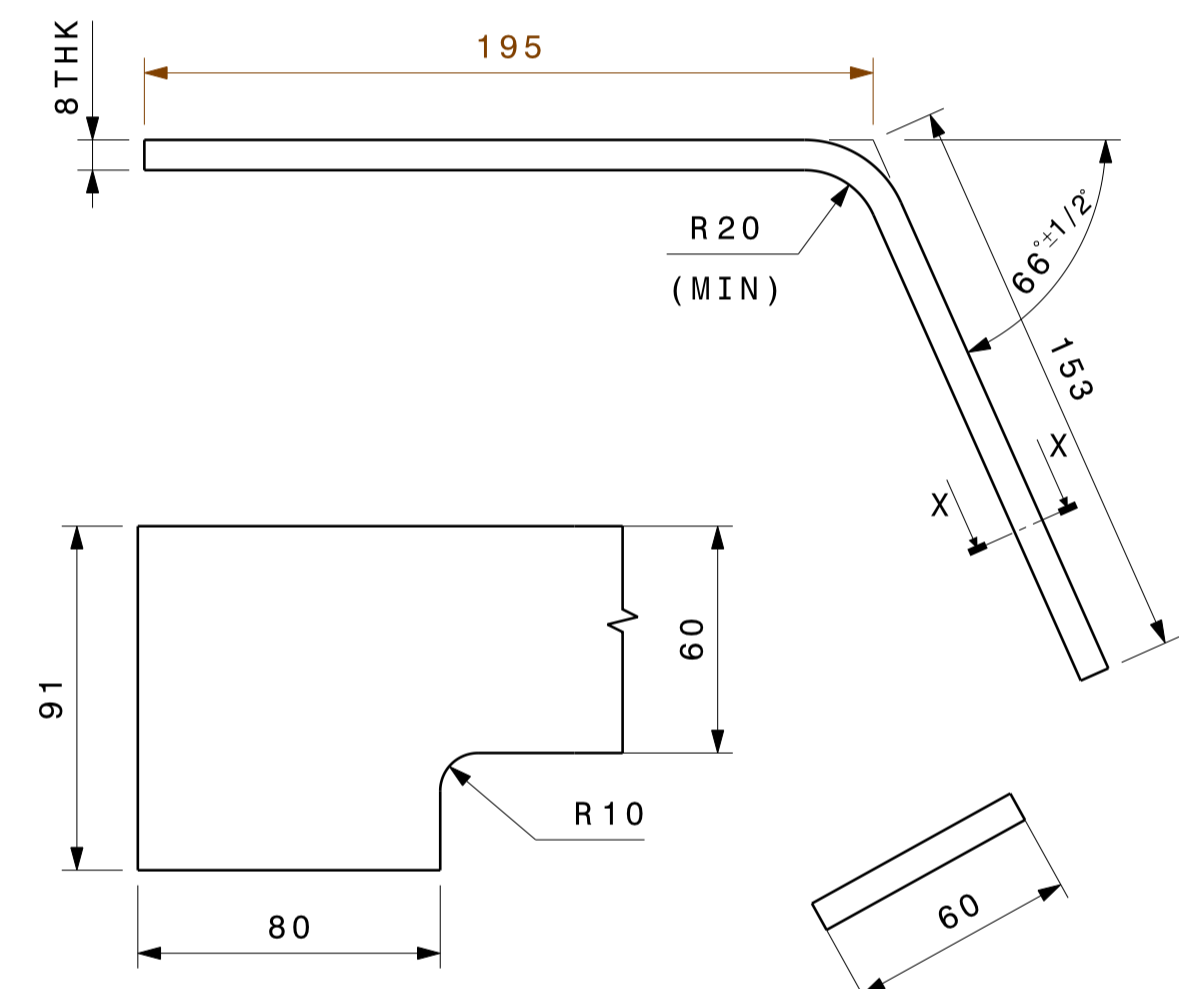
SECTION - 'RR'



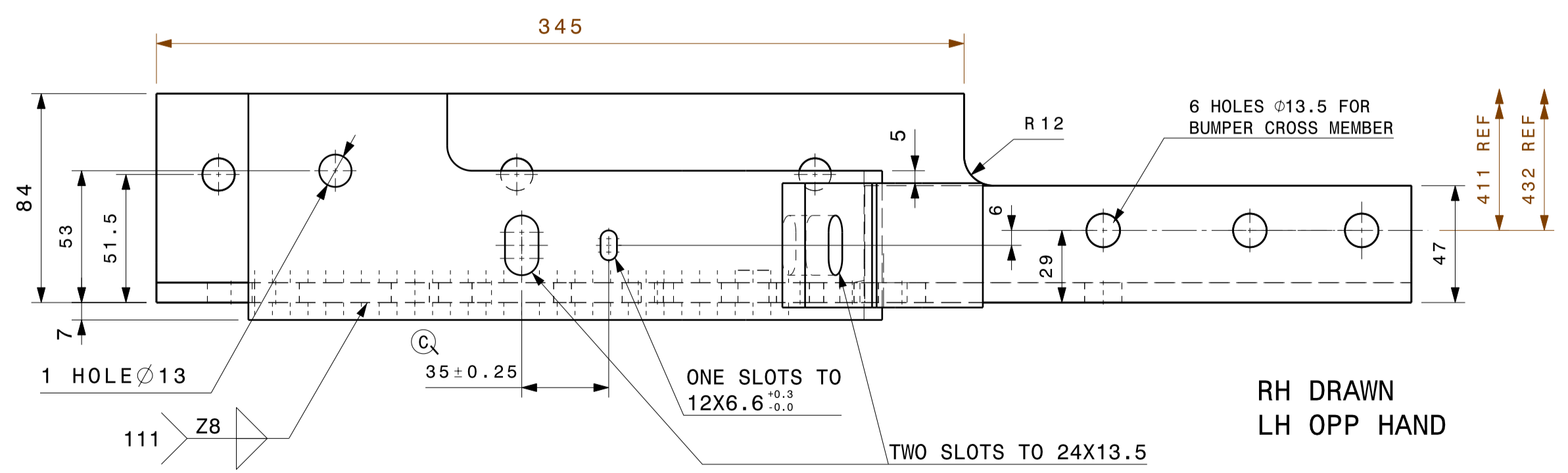
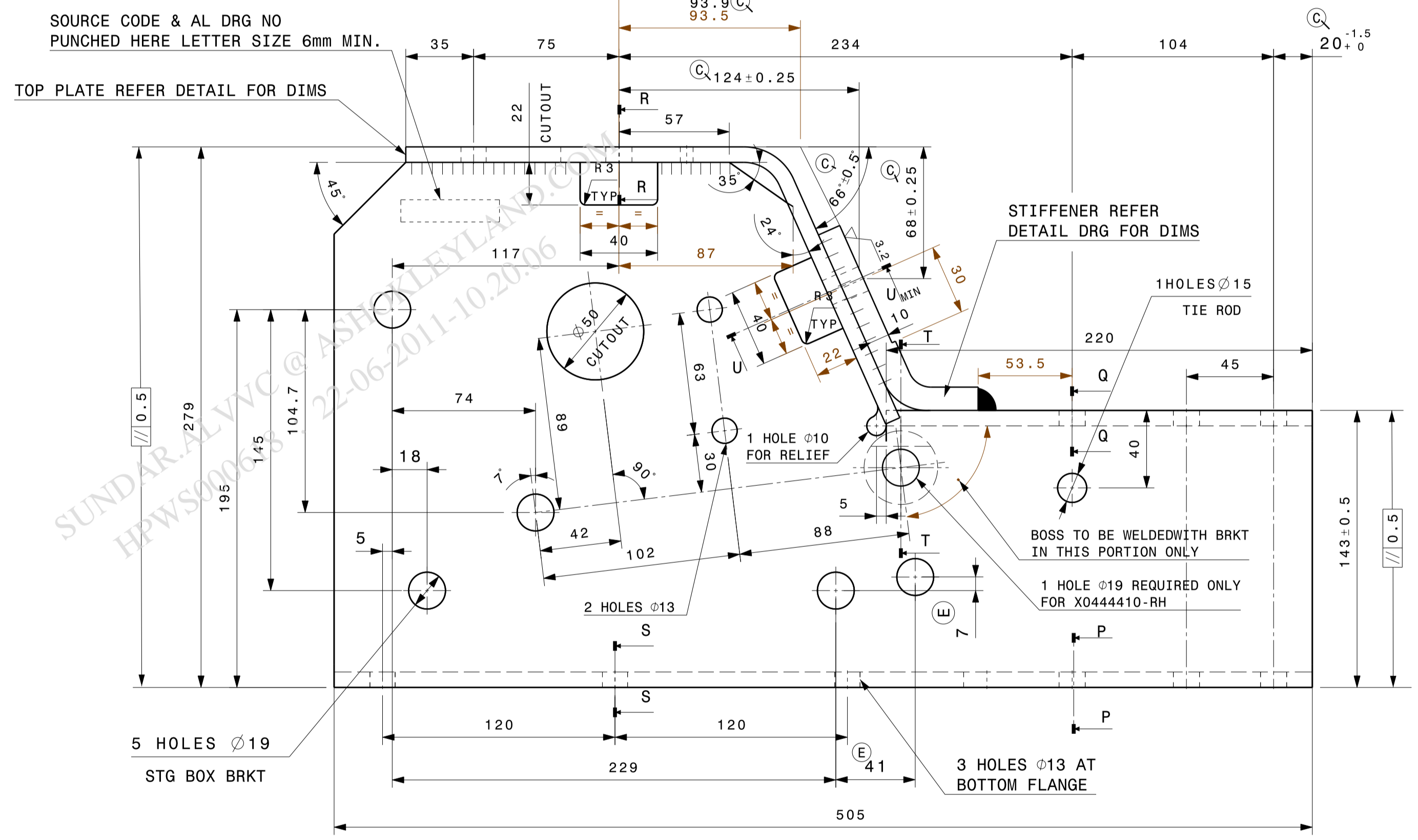
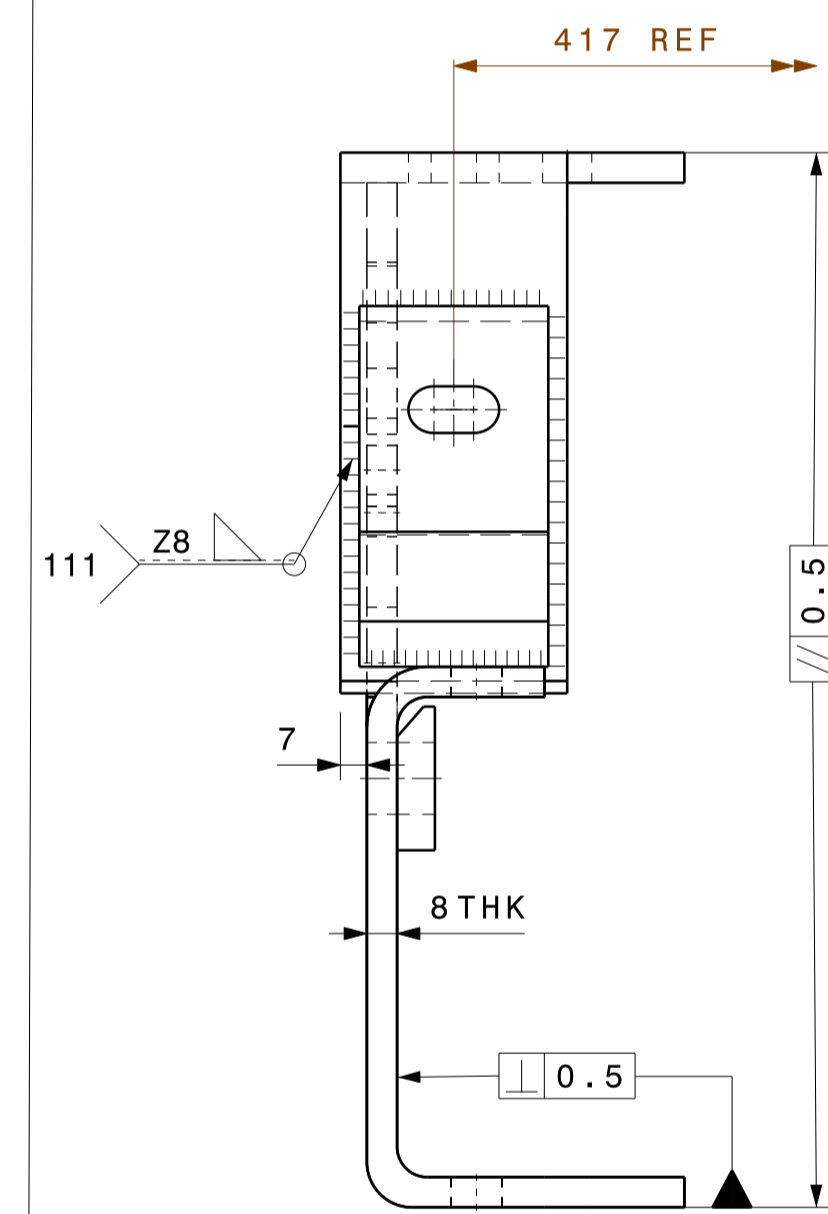
SECTION - 'PP'



SECTION- 'QQ'



DETAILS FOR TOP PLATE VIWE FROM ARROW F



RH DRAWN LH OPP HAND

- NOTE:
1. USE ELECTRODE EQUIVALENT TO SPEC AWS 6013/6012
  2. WELDING FILLET SIZE 8MM.
  3. MATERIAL THICKNESS NOT SPECIFIED TO BE 8.0MM.
  4. GENERAL FABRICATION TOLERANCE TO BE WITH IN ±1.0MM IF NOT SPECIFIED
  5. GENERAL TOLERANCE FOR PITCH DIST OF MTG HOLES TO BE WITH IN ±0.25MM.
  6. WELDING SYMBOLS AS PER IS:813

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	
LEYLAND	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:

BILL OF MATERIALS			
APPEARANCE ITEM	ER-DIN	DATE	
YES	NO	H5136	25.09.96
FINISHED WEIGHT (APPROX)		REF. PT. NO.	
XXX.XXX Kgs		S/A PT. NO.	A8187100
SCALE		SUPERSEDES	
1:2		SPEC NO.	HAF43/4

AL PLM VAULT  
 REVISION: E | DATE: 7-8-2009 | STATUS: RELEASE  
 STAGE: III | ER-DIN NO/DATE: ER-DIN-0003572 / 7-8-2009  
 ALTERED BY: sundar.alvvc | CHECKED: vankatesh.alvvc  
 MED APPROVAL: anantha.alvvc | APPROVED: snagarajan.alvvc  
 DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DRWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
M.ELALAPERUMAL 1996-09-20	SN 20.3.96	XXXX XX.XX.XXXX	MR 25.9.96	

MATERIAL: STEEL PLATE TO IS 2062 Gr 'B'

HEAT TREATMENT:

REMARKS: FOR STALLION CARGO MARK III

DESCRIPTION: CAB MTG BRKT RH & LH

PART No. X0444410E  
 SHEET NO. ....1..... OF..... A1