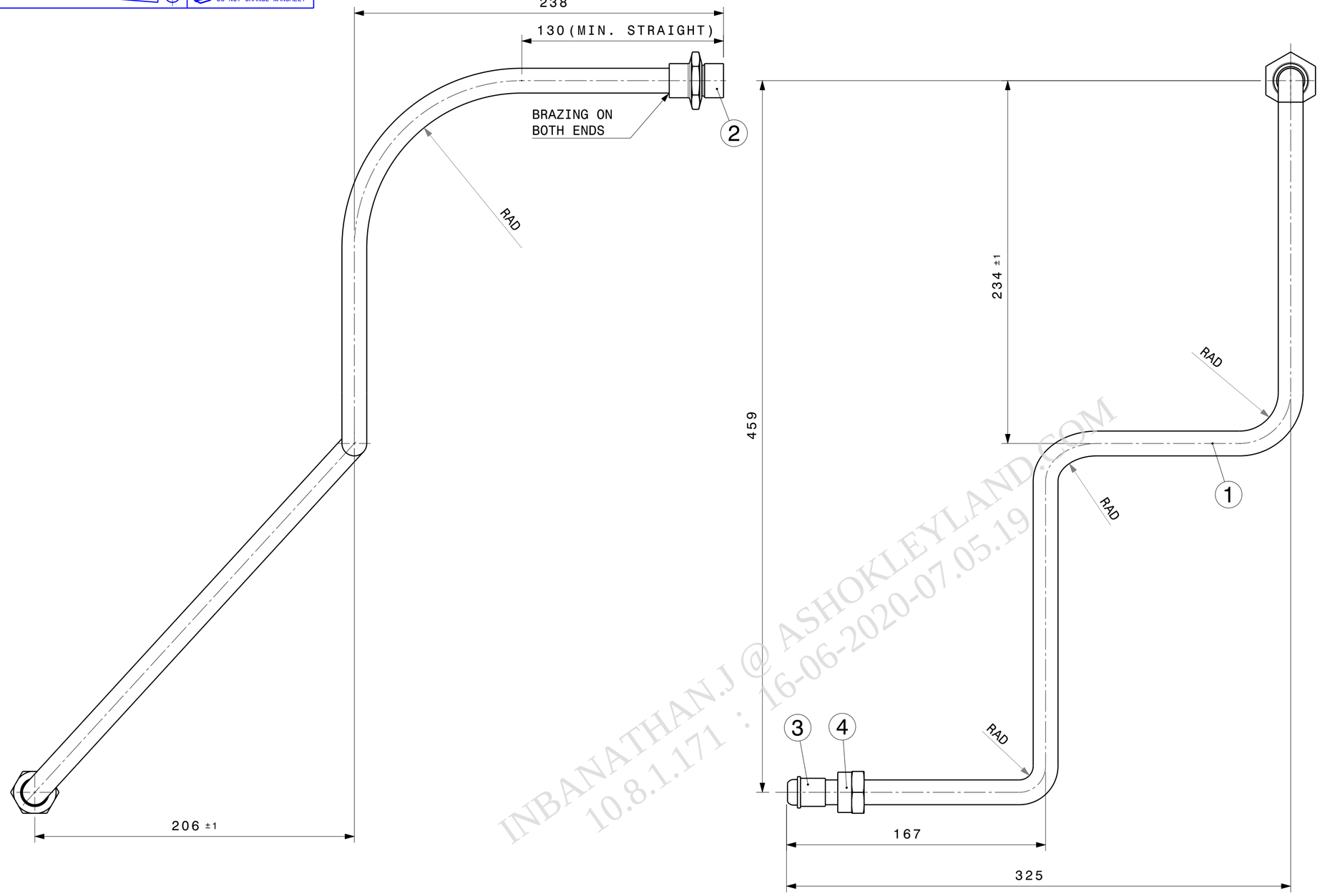
ASHOK LEYLAND

FIRST ANGLE PROJECTION

COMPUTERISED DRAWING
DO NOT CHANGE MANUALLY



INBANATHAN.J @ ASHOKLEYLAND.COM
10.8.1.171 : 16-06-2020-07.05.19

NOTE:-
- THIS DRG FOR REFERENCE PURPOSE ONLY
- FOR BULK PRODUCTION MASTER SAMPLE TO BE GIVEN BY P.D.

NOTE:-
- HYDRAULIC TEST TO BE DONE AS PER IS-3074
- FOR PLATING DETAILS REFER DRG:-F9615000
- LIMIT OF DEVIATION FROM ROUNDNESS AFTER FORMING SHOULD NOT BE MORE THAN 10% OF NOMINAL OUTER DIA OF TUBE (AS PER IVECO STD 10.4418 CLASS 4.1.2)
- BRAZING TO BE LEAK PROOF AT A PRESSURE OF 105 BAR.(AS PER ALS 276.01) B.1

	SNO	PART NO	DESCRIPTION	QTY
B	4	F2935015	NUT	1
B	3	F2901615	NIPPLE	1
B	2	F0154915	ADAPTOR	1
A B.1	1	---	STEEL TUBE TO IS 3074 - CEW 1, SIZE 16 OD,2 THICK	1

BILL OF MATERIALS

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
MATL. UPDATED FOR ITEM1 DISCRIPTION CHANGED DIN:023739 EA/SN	26/08/06	–	A
IN ITEM NO. 2:- PT.NO.F0154915 WAS F0161515 IN ITEM NO. 3:- PT.NO.F2901615 WAS F2939815 IN ITEM NO. 4:- PT.NO.F2935015 WAS F2940015 DIN:023855 EA/SN	25/09/06	–	B
SL.NO.1 MATERIAL CEW 1 WAS CDS 1, BRAZING NOTE:LEAK PROOF PRESSURE 105 BAR WAS 150 BAR. SRR/EAK	10/11/07	–	B.1

AL PLM VAULT

REVISION : B.1 DATE : 8/12/2010 STATUS : RELEASE
STAGE : III ER-DIN NO : ER-DIN-0006140 DATE : 8/12/2010
ALTERED BY : ashokkumar.alvvc CHECKED BY : rchandru.alvvc
MED APPROVAL : sureshp.alvvc APPROVED BY : snagarajan.alvvc

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
A.A 19/05/05	SN 19/05/05	PRAKASH SHAH 22/05/06	SN 19/05/05	———

MATERIAL: SEE B.O.M

HEAT TREATMENT: ——

REMARKS: FOR STALLION MARK IV

DESCRIPTION: STEERING PIPE-RETURN LINE

PART NO. B 2 2 3 8 2 1 1 B.1

SHEET No 1 OF 1 A2

C -CRITICAL S -SAFETY + -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:

APPEARANCE ITEM		ER-DIN	DATE
~~YES~~	NO	023273	19/05/06
FINISHED WEIGHT(APPROX)		REF PART NO:	B2205401
-		S/A PART NO:	———
SCALE 1:2		SUPERSEDES	———
		SPEC NO:	ALSG19

ASHOK LEYLAND LTD.
TECHNICAL CENTRE VELLIVOYALCHAVADI

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