



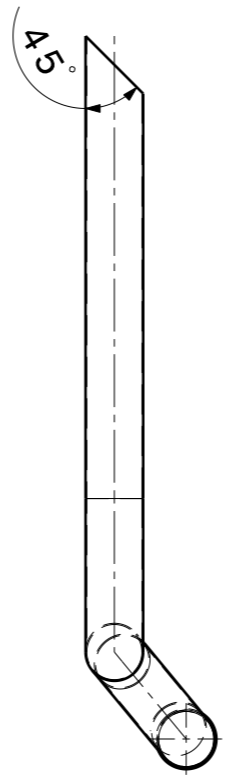
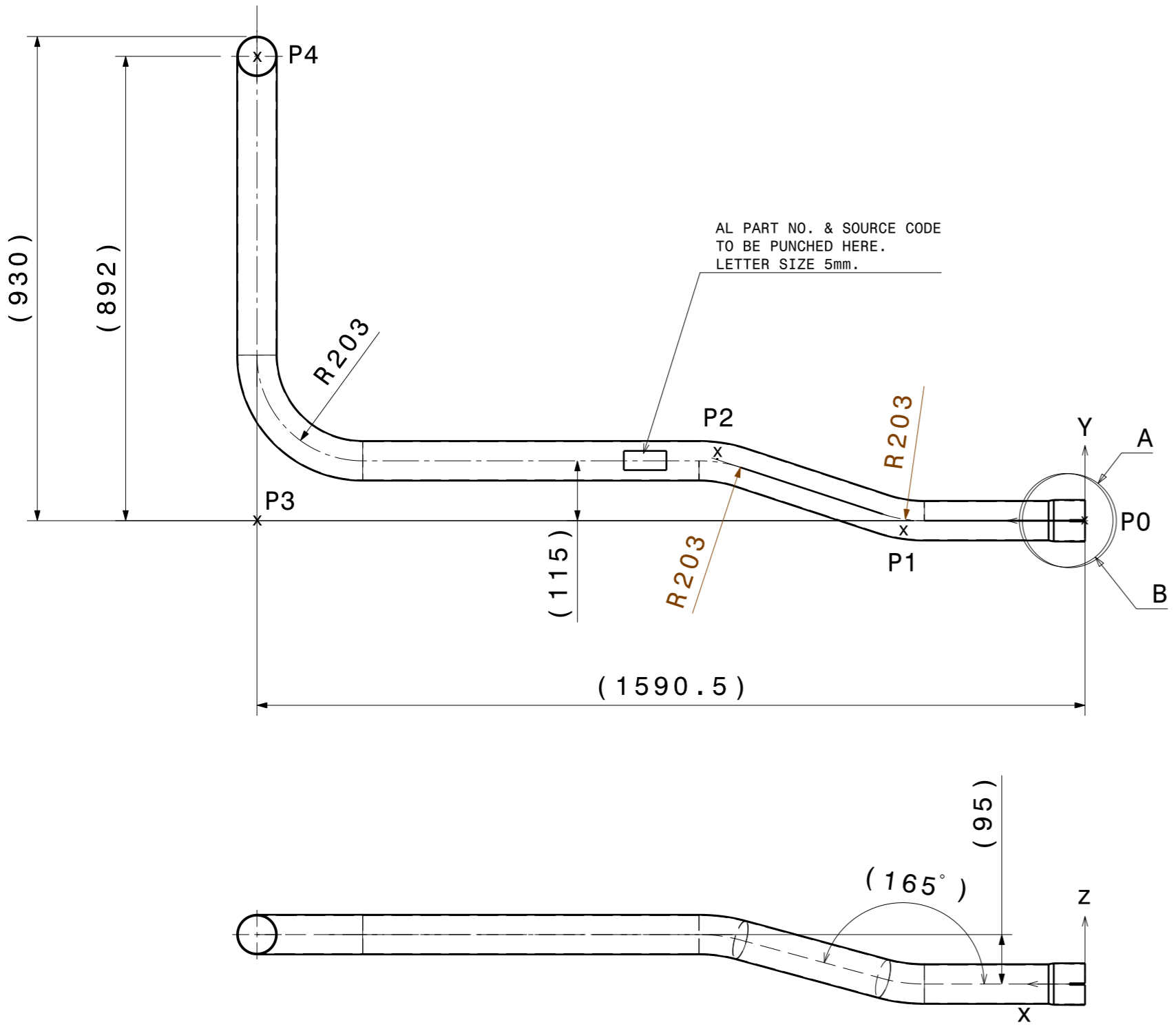
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ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVoyalCHAVADI

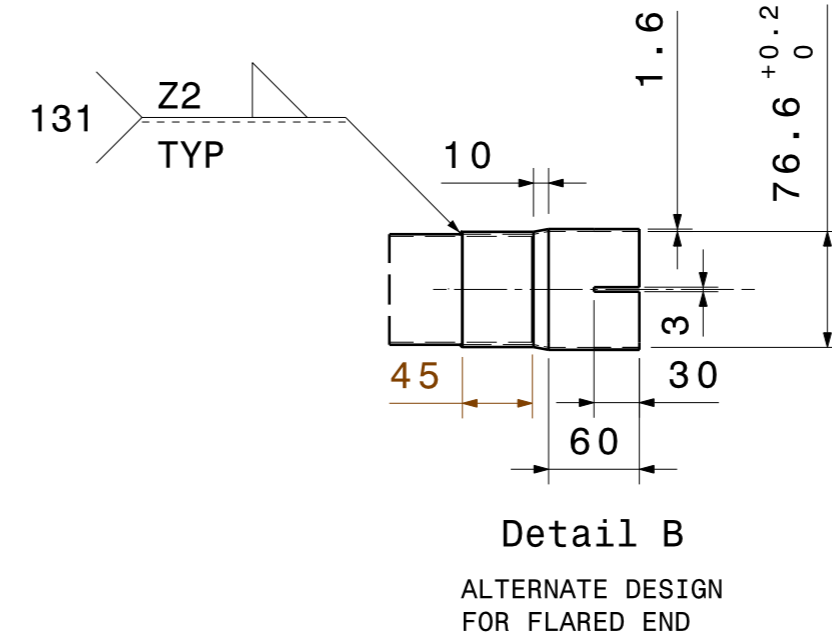
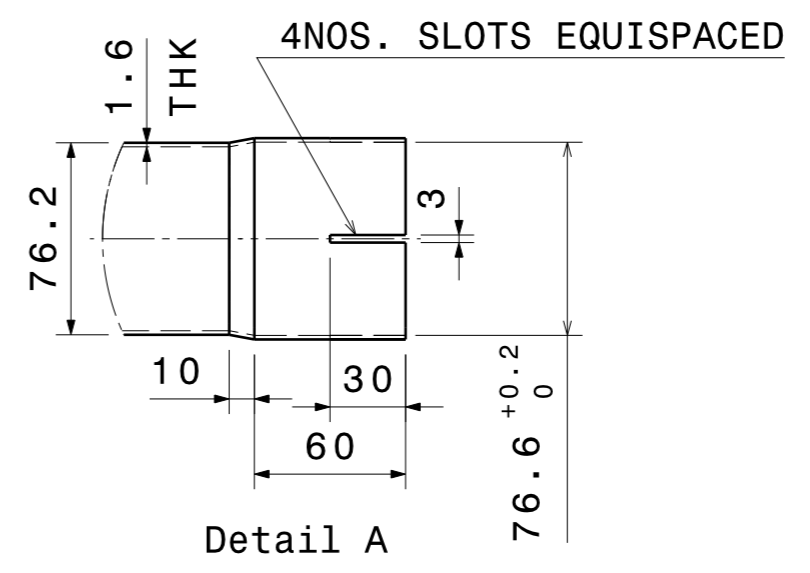


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POINTS TABLE:

POINTS	X	Y	Z
P0	0	0	0
P1	350	0	0
P2	700	115	95
P3	1590.5	115	95
P4	1590.5	930	95



NOTE:

AT NO POINT IN THE TUBE SHALL VARIATION ON OUTER DIA BE ±0.5mm GREATER THAN THE TOLERANCE ON THE MEAN DIAMETER OF THE PIPE SPECIFIED.

SURFACE TREATMENT:

TAIL PIPE --->SHOT BLAST---> PAINTING ON OUTER SURFACE ONLY---> SPRAYING / DIPPING IN HEAT RESISTANT SILICONE ALUMINIUM PAINT---> BAKING AT 200°C/ 30 MIN. TO MEET TEST REQUIREMENTS AS PER IS 13183 GRADE 1 WHEN CHECKED ON COLD ROLLED STEEL SHEETS.

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX

AL PLM VAULT
 REVISION:#.0 |DATE:5-8-2009 |STATUS:APPROVED
 STAGE:II |ER-DIN NO/DATE: ER-DIN-0003479 / 14-08-2009
 ALTERED BY:jagtaptushar.ades |CHECKED:samson.alvvc
 MED APPROVAL:ganeshpm.alvvc |APPROVED:samson.alvvc
 DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
MPK 13.07.2009	SDC 16.07.2009	XXXX 13.07.2009	KSH 16.07.2009	---

MATERIAL STEEL TUBE 1.6 THK IS:3074 GRADE ERW-1

HEAT TREATMENT

REMARKS STALLION MKIV 180 HP RHD-BS-III

DESCRIPTION TAIL PIPE

PART NO. **F N 1 0 0 4 1 5 #.0**

SHEET No1..... OF1..... **A2**

-CRITICAL -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:

1. TUBE TOLANCE AS PER IS 5429.
2. WELDING TO CONFIRM TO ALS.276.02
3. BEND LINE TO BE PERPENDICULAR TO THE GRAIN FLOW DIRECTION

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY

BILL OF MATERIALS

APPEARANCE ITEM	ER-DIN	DATE
<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	ER-DIN-XXXXXX	XX/XX/XX
FINISHED WEIGHT (APPROX)	REF PART NO:	---
6.8 Kgs	S/A PART NO:	---
SCALE	SUPERSEDES	---
1:1	SPEC NO:	---