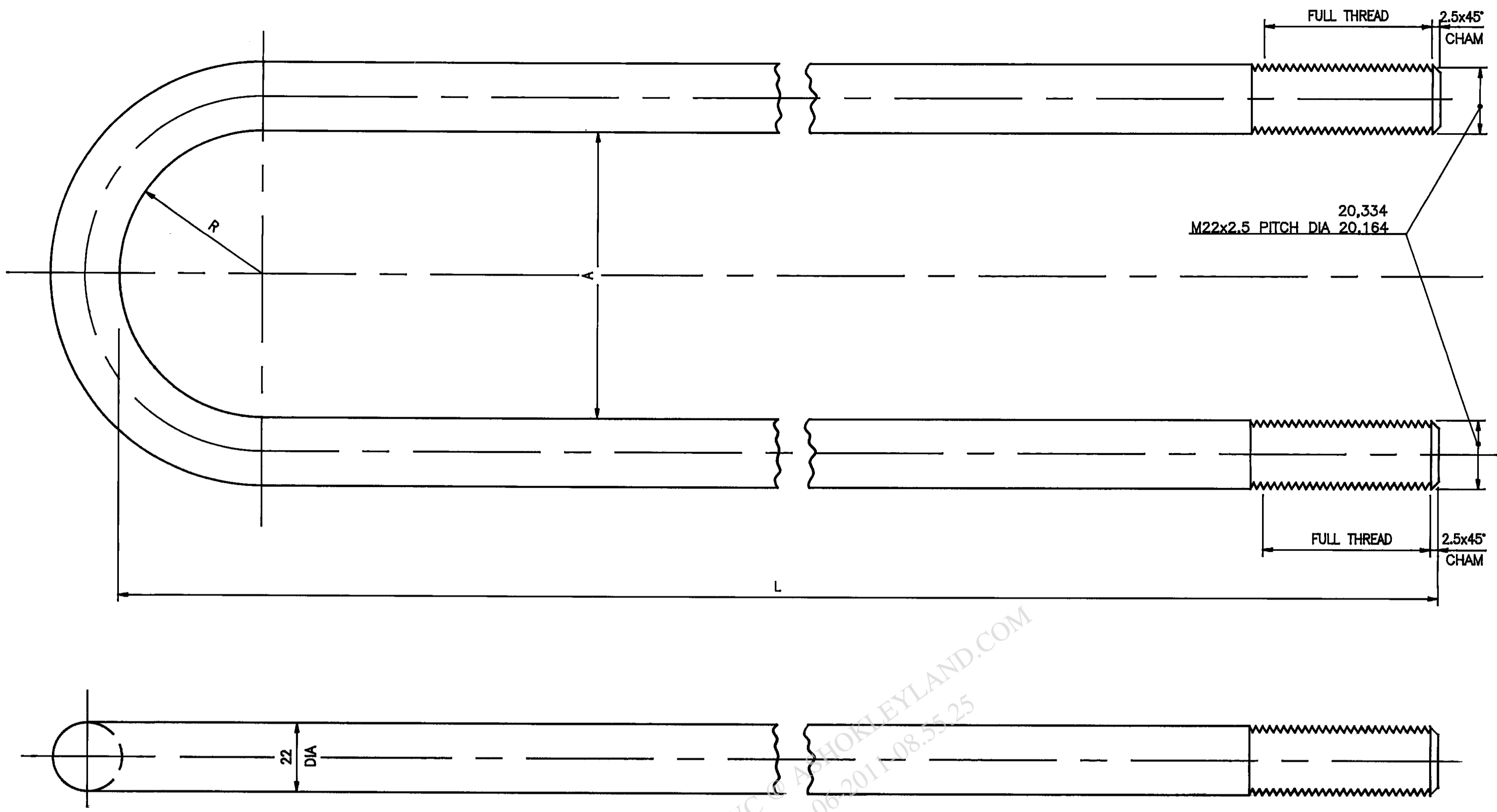


SURFACE FINISH AS PER IS:2073 (CLA VALUE)	
MICROMETERS	MICROMETRES
BELOW 8	BELOW 0.2
8-16	0.2-0.4
16-32	0.4-0.8
32-64	0.8-1.6
64-128	1.6-3.2
128-250	

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ASHOK LEYLAND LTD. ENNORE MADRAS



ALTERATIONS	NO.	DATE	GRADE	SUPPL.	MICRO HEAD
LENGTH 512/514 WAS 531/529: STRAIGHT LENGTH 1024 WAS 1147 FOR F3578915 EDM 90056	2 3 84		1	A	
FOR PART NO F3578715 LENGTH 489/487 WAS 497/495. STRAIGHT LENGTH 1056 WAS 1072 EDM 5872 TM/KGG	16/ 8/ 85		1	B	
PT. NO. F3581915 ADDED PT. NO. F3578415 IN TITLE BLOCK WAS F3578415 - F3578715 TM EDM 5961.	27/ 12/ 85			C	
DIMN 1113 WAS 1024 IN STRAIGHT LENGTH (mm) FOR F3578915. EDM 90056A	19/ 3/ 80		0	D	
FOR PART NO : X3501815 STRAIGHT LENGTH 872 WAS 972MM. EDM 90383 DT. 21.3.86 SM	21 3 86		1	E	
PT NO: F3582915 ADDED RLK. ALDN 7748	25 9 86		1	F	
PT NO: F3595615 ADDED	14 8 92		1	G	
PT NO: F3520710 ADDED. DIM NO: 17750	05 09 2001			H	
PT NO F3523610 ADDED. DIM NO 018265	03 09 02			I	US A-10-02

PART NUMBER	"A"	"L"	"R"	FULL THREAD	STRAIGHT LENGTH. MM	REPLACED PT. NO (7/8BSF)	REMARKS
F3523610	78.5 77.7	504 502	39	64.5 63.5	1086 APPROX	-	ALRS69
F3520710	82.3 81.5	437 435	41	58.5 51.0	951 APPROX	-	AL SES 61/4
F3595615	78.5 77.7	541 539	39	64.5 63.5	1160 APROX	-	AL RS 38/9
X3501815	82.3 81.5	396 394	41	53.5 51.0	(E) 872 APPROX	-	AL RS 23/90
F3582915	82.3 81.5	436 434	41	64.5 63.5	952 APPROX	-	AL RS 23/2
F3581915 (C)	78.5 77.7	469 467	39	64.5 63.5	1016 APPROX	-	AL RS 38/1
F3580315	78.5 77.7	443 441	39	56.0 55.0	963 APPROX	-	AL RS 40
F3578415	78.5 77.7	479 477	39	64.5 63.5	1036 APPROX	F3577515	AL RS 24/3
F3578515 (B)	78.5 77.7	489 487	39	64.5 63.5	(B) 1056 APPROX	F3575815	AL RS 27/2,38
F3578615	91.31 90.50	423 421	45.5	73.50 72.50	930 APPROX	F3571815 (AL 9318)	AL RS 10
F3578715	82.3 81.5	386 384	41	53.5 51.0	852 APPROX	F3573615	AL RS 23
F3578915	91.30 90.50	512 514	45.5	56.0 53.5	1113 APPROX	F3531315 (AL 4092)	AL RS 9
F3579015	91.30 90.50	455 453	45.5	56.0 53.5	995 APPROX	F3575415	AL RS 9/1
F3579115	78.50 77.70	458 456	39	64.5 63.5	993 APPROX	F3574615	AL RS 29/2
F3579615	91.70 90.50	542 540	45.5	56.0 53.5	1170 APPROX	-	FOR BEAVER WITH 3 PIECE AXLE
F3579715	78.50 77.70	450 448	39	64.5 63.5	977 APPROX	-	WELDED AXLE WITH 54" SPRING AL8529

UNLESS OTHERWISE SPECIFIED

FABRICATED COMPONENTS TO BE PHOSPHATED TO CLASS 'C' AS PER IS:3618 AND APPLIED IMMEDIATELY WITH RED OXIDE ZINC CHROMATE PRIMER TO IS:2074 MACHINED SURFACE TO BE APPLIED WITH RUST PREVENTIVE OIL TO IS:1154

MACHINING TOLERANCE FOR OPEN DIMENSION WILL AS PER IS:2102

DIM	TOLERANCE	0-1	1-3	3-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	>4000
±	0.1	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05

SHARP EDGES TO BE REMOVED DO NOT SCALE DRG.

ANGULAR TOL. AS PER IS:2102

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4218 CLASS 6g EXTERNAL OR 6H INTERNAL.

SPECIAL INSTRUCTIONS/NOTE

SL.NO	PART NO.	DESCRIPTION	SIZE	MATERIAL	QTY
BILL OF MATERIAL					
REF. PT. NO.		ISSUED UNDER		MICROFILMED	
SUPERSEDED		EDM/DIN	DATE	BY	
S/A PT NO.				DATE	
WEIGHT	ROUGH	FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED		NO
SCALE	APPROVAL NO. :				
SPEC NO.	TESTING STD. :				

STAGE	CHECKED	DATE	APPROVED	DATE	ALTERATION LEVEL
I					
II					
III					

REMARK

HEAT TREATMENT

HEAT TREATED CONDITION Y BRINELL P02.3414

DESCRIPTION

U BOLT

PART NO. F3578415 I

SHEET NO. \_\_\_\_\_ OF \_\_\_\_\_