

ALTERATIONS		REV. DATE	BY	CHKD.
- ITEM 5 & 6 DELETED		21 09 02	-	A
- TWO HOLES Ø8.5 ADDED				
PAINTING DETAILS UPDATED DIN:021765	ABM	23 03 05	-	B
- 2 HOLES Ø7 ADDED.		02 07 09	-	C
- NOTES UPDATED.	VS			

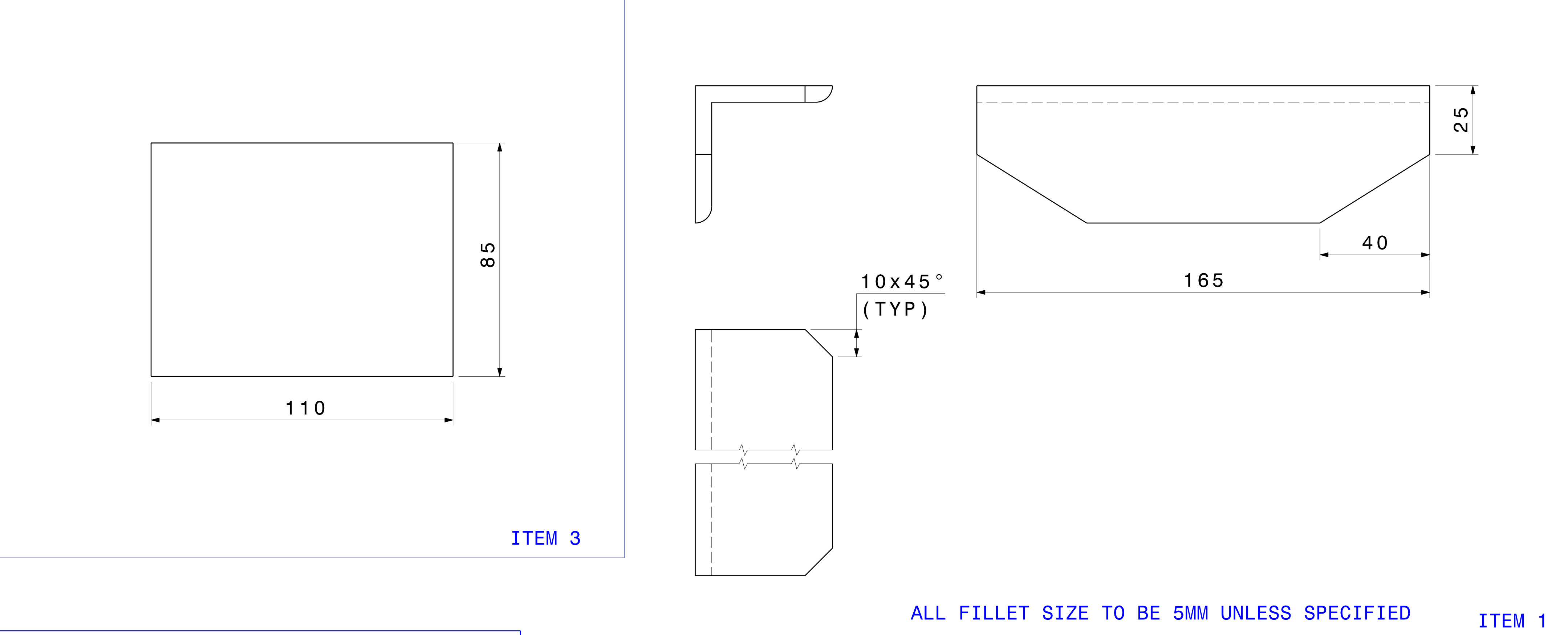
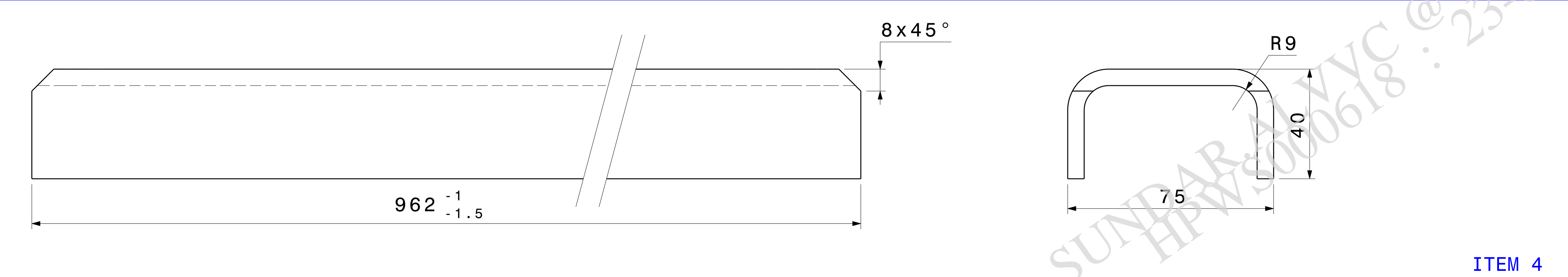
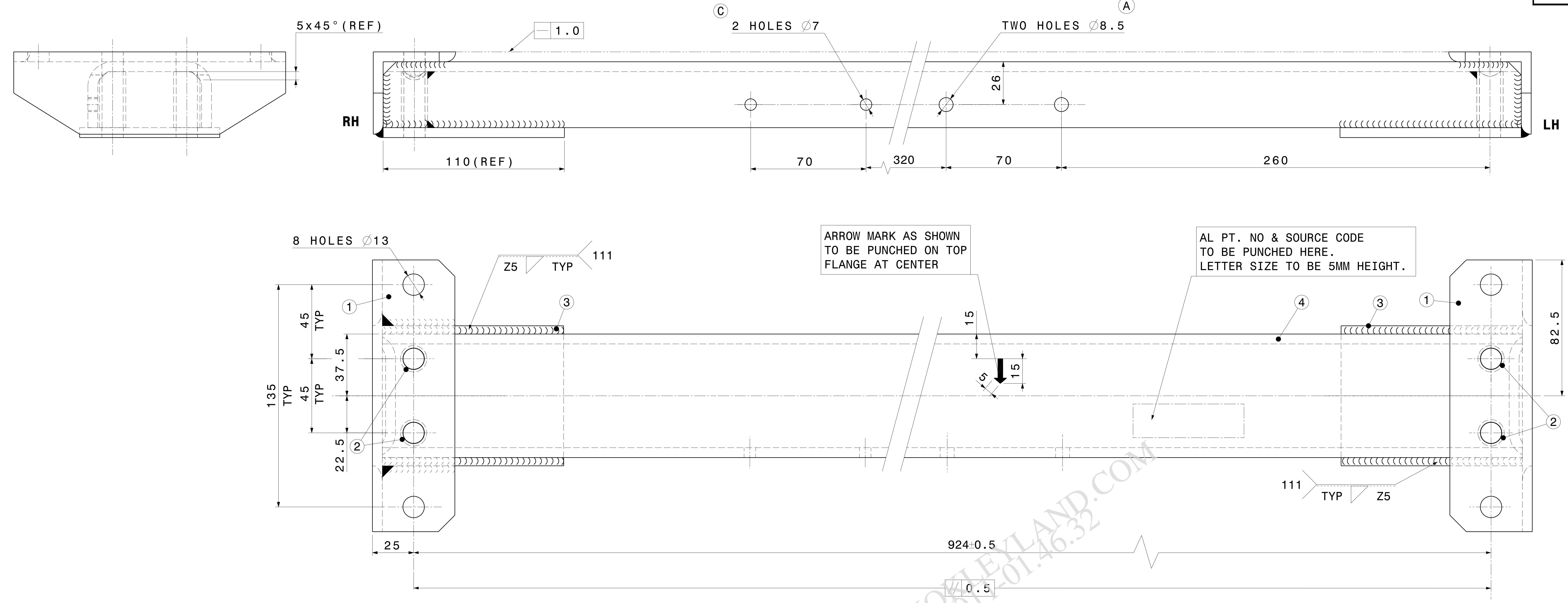
DRWN/ DATE	CHECKED/ DATE	MED. APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
DR 26.04.2002	SN 26.04.2002	C.S 12.08.2003	SN 26.04.2002	

AL PLM VAULT				
REVISION: C DATE: 7-7-2009 STATUS: RELEASE				
STAGE: III ER-DIN NO/DATE: ER-DIN-0003328 / 7-7-2009				
ALTERED BY: sundar.alvvc CHECKED: jnr.alvvc				
MED APPROVAL: ganeshpm.alvvc APPROVED: snagarajan.alvvc				
DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED				

S.NO	PT. NO.	DESCRIPTION	MATERIAL	QTY
4	ITEM 4		PLATE 6 THICK IS 2062 Gr 'A'	1
3	ITEM 3		PLATE 6 THICK IS 2062 Gr 'A'	3
2	ITEM 2		TUBE 16 OD 1.6 THK IS 3074 ERW-1	4
1	ITEM 1		ISA 50X50X6 IS 808	2

BILL OF MATERIALS			
APPEARANCE	ITEM	ER-DIN	DATE
YES	NO	ER-DIN-XXXXXXX	XX.XX.XXXX
FINISHED WEIGHT (APPROX)		REF.PT.NO.	X4694514
XXX.XXX Kgs		S/A.PT.NO.	AB136500
SCALE		SUPERSEDES	
1:1		SPEC.NO.	HAF

REMARKS				
STALLION MARK IV				
DESCRIPTION				
CROSS MEMBER BOTTOM				
PART NO.	X 4 6 3 2 6 1 4 C			
SHEET NO	1	OF	1	AO



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 ENAMEL TO MEET 300 HRS OF SALT SPRAY LIFE WHEN TESTED AS PER ASTM B117 (UNDER PELLICULAR CORROSION -- 20hr. 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:4216 CLASS 6g EXTERNAL OR 6h INTERNAL. SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

- SPECIAL INSTRUCTIONS/NOTE:
- GENERAL TOLERANCE TO BE ±0.5 MM.
 - TOLERANCE ON HOLE PITCHES & SIZES TO BE ±0.25MM.
 - TOLERANCE ON OVERALL DIMENSIONS TO BE ±1MM.
 - WELDING ELECTRODE TO BE AWS E6012 OR E6013
 - WELDS TO CONFIRM TO REQUIREMENTS OF ALS.276.02

- WELDING SYMBOL AS PER IS:813
 - BEND LINE TO BE ⊥ TO GRAIN FLOW DIRECTION.
- PAINTING NOTE:-
- SCAMIC GREEN PAINTING TO BE DONE AS PER AL RECOMMENDATION IN LINE WITH DRG NO:X9715000.
 - NOT RECOMMENDED FOR MAKING BY GAS CUTTING AND IF MADE BY GASCUTTING TO BE 100% FREE FROM GAS CUT MARK.

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