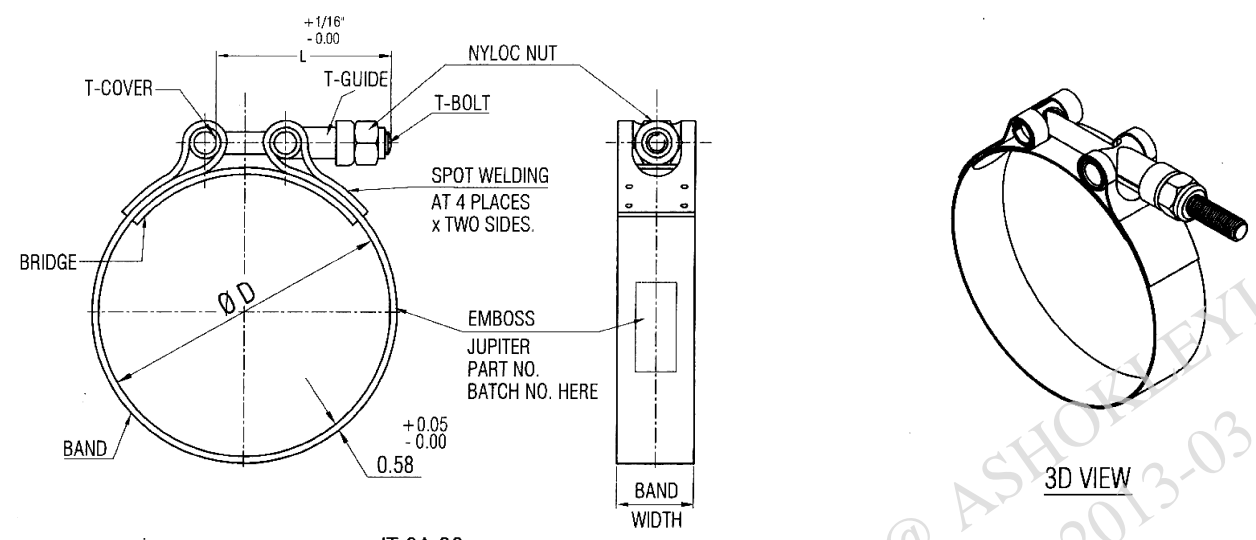


ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOLCHAVADI
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SR. NO.	CUSTOMER PART NO.	EMBOSSING	JUPITER DESIGN TYPE	CLAMP DIA		BAND		BRIDGE			T - BOLT			NUT		T-GUIDE MATERIAL	T-COVER MATERIAL	CLAMP WEIGHT
				MAX. DIA ØD	MIN.	WIDTH +0.15 -0.00	MATERIAL	WIDTH +0.15 -0.00	THICK +0.05 -0.00	MATERIAL	THD. x L.	MATERIAL	TREATMENT	MATERIAL	A/C FLAT ±0.1			
01	X3900310 (REF. NOTE - 3)	X3900310 70 - 78	JT 6A 20	78.0	70.0	19.05	AISI 201/J-1	19.05	0.58	AISI 201/J-1	1/4" -28 UNF x 73.0 MM	SAE 1541	HEAT TREATED & ZINC PLATED WITH OLIVE GREEN PASSI. 12TO15 MICRON	SAE 1010	11.0	IS 513 - CR1	IS 513 - CR1	69 GRAMS
02	X3900410 (REF. NOTE - 2)	X3900410 57 - 65	JT 6A 20	65.0	57.0	19.05	AISI 201/J-1	19.05	0.58	AISI 201/J-1	1/4" -28 UNF x 73.0 MM	SAE 1541	HEAT TREATED & ZINC PLATED WITH BLUE PASSIVATION	SAE 1010	11.0	IS 513 - CR1	IS 513 - CR1	66 GRAMS



NOTE:-
 1) ØD=SUPPLY DIA TO BE TESTED ON SOLID MANDREL WITH 80 lb-in TORQUE.
 2) T-GUIDE ASSY & T-COVER WILL BE ZINC PLATED WITH BLUE PASSIVATION, SAE 1010 NUT WILL BE YELLOW PASSIVATED.
 3) T-GUIDE ASSY, T-COVER, SAE 1010 NUT & T-BOLT WILL BE ZINC PLATED WITH OLIVE GREEN PASSIVATION WITH 12 TO 15 MICRON.
 4) COMPOSITION OF MATERIAL J-1 :- Ni - 3 TO 6 %, Cr - 14 TO 19 %, RESEMBLING TO AISI 200 SERIES.
 5) CLAMP SHOULD BE FREE FROM BURR.

JUPITER INDUSTRIAL WORKS THANE *PARISHRAM*RAM MARUTI ROAD THANE - 400602. INDIA					
DRN.	CHK.	CHK.	APP.	DATE	TITLE:- JUPITER T-BOLT CLAMP FOR M/s . ASHOK LEYLAND LTD.
REV	ITEM	SPEC WAS	CHANGED TO	SIGN.	DATE
REVISIONS					DRAWING No:- HT-2159/ 944 REV. 00 SCALE NTS

SPECIAL NOTE:
 1. HOSE CLIP RESIZED FOR FABRIC REINFORCED 3 PLY HOSES OF 5 TO 6 MM THK.
 2. INSTALLATION TORQUE FOR SILICON HOSES : 4 TO 5 Nm ; FOR OTHER TYPE OF HOSES, TORQUE NOT TO EXCEED 7 Nm WITHOUT BOTTOMING-UP AND SEALING TO BE ENSURED.

HT-2159/944	X3900310	Qty : -	Qty : -	-
Supplier Part No	AL Part No	Sample	Pilot	<input checked="" type="checkbox"/> Production

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
@ - CRITICAL S - SAFETY + - IMPORTANT. THIS DRAWING CONTAINS SAFETY CHARACTERISTICS					
UNLESS OTHERWISE SPECIFIED					
TOLERANCES REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION					
SURFACE FINISH AS PER IS:3073(CLA VALUE)					
SHARP EDGES TO BE REMOVED					
DIMENSIONS ARE IN MM DO NOT SCALE DRAWING					

APPEARANCE ITEM	ER-DIN	DATE
YES	ER-DIN-0011814	18.09.12
NO		
FINISHED WEIGHT (APPROX):	REF DRG	REF PT NO:
SUPERSEDES:	—	S/A PT NO:
SCALE	NTS	SPEC NO:
		ALAC125

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
SUPLIER DRAWING [HT-838/409] - JAN 2000 REF: VR/PD			A
1.SUPPLIER DRAWING HT-2159/944 PUT IN AL TEMPELATE FOR AL USE (X3900310 & X3900410). 2.CLIP TO PT.NOS. X3900310 & X3900410 RESIZED (CLAMP DIA WAS 79 MAX AND 71 MIN FOR X3900310; CLAMP DIA WAS 66 MAX AND 56 MIN FOR X3900410) CCTF - SV/RV	ER-DIN-0011814 18.09.12	3	B

AL PLM VAULT			
REVISION : B	DATE : 22/9/2012	STATUS : RELEASE	
STAGE : III	ER-DIN NO : ER-DIN-0011814	DATE : 22/9/2012	
ALTERED BY : venkatesan.s	CHECKED BY : vaidya.alvvc		
MED APPROVAL : SivaKumar.GK	APPROVED BY : vaidya.alvvc		

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED				
DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL /DATE	APPROVED/ DATE	STDS APP/ DATE
VENKATESAN 17.09.12	VAIDYANATHAN 17.09.12	SARATHKUMAR 17.09.12	K. S. SESHADRI 17.09.12	

MATERIAL REFER DRAWING

HEAT TREATMENT REFER DRAWING

REMARKS
 BUS

DESCRIPTION T BOLT CLAMP -JUPITER MAKE	
PART NO.	X 3 9 0 0 3 1 0 B
SHEET NO:1..... OF... 1.....
A3	