



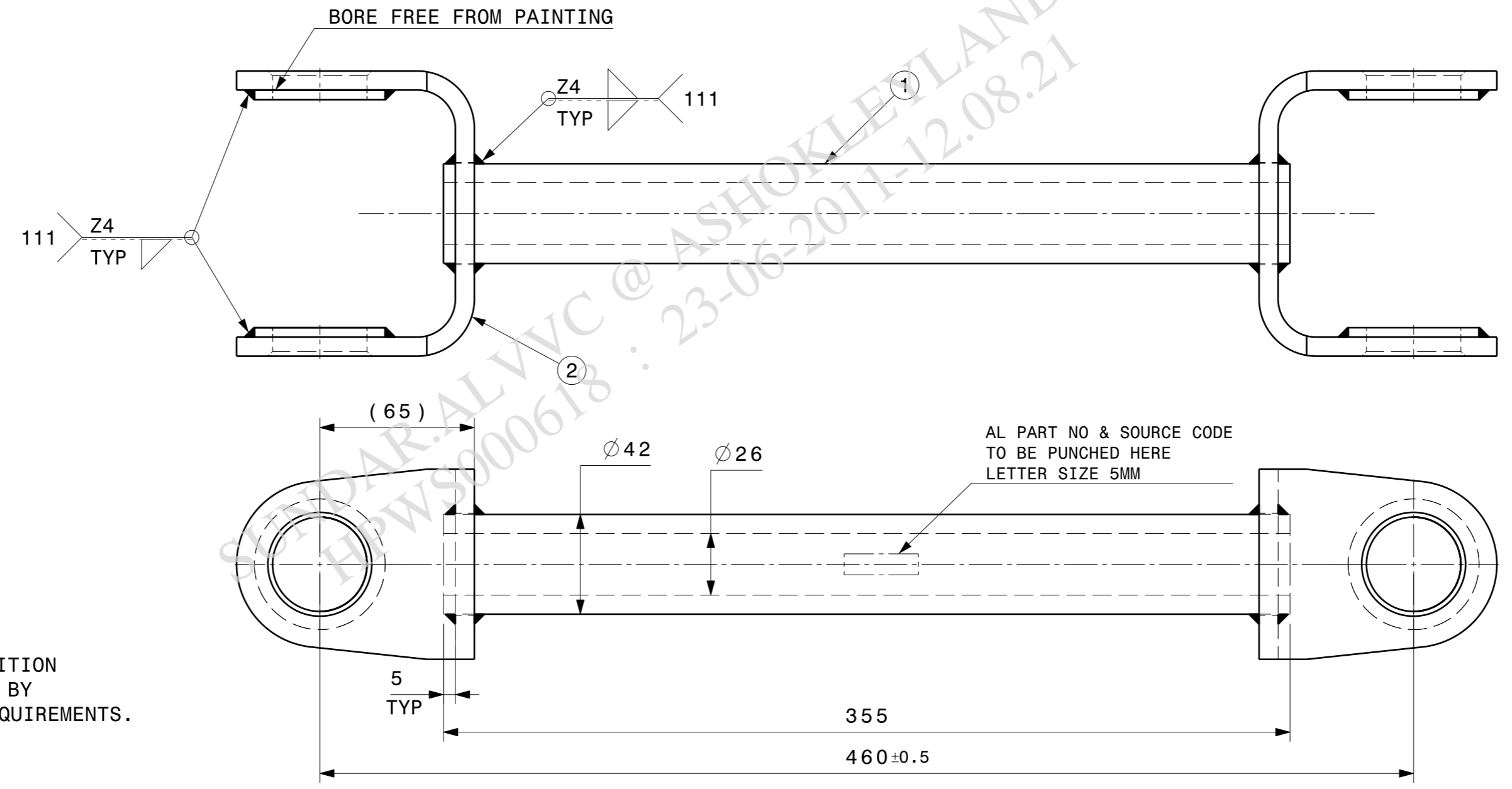
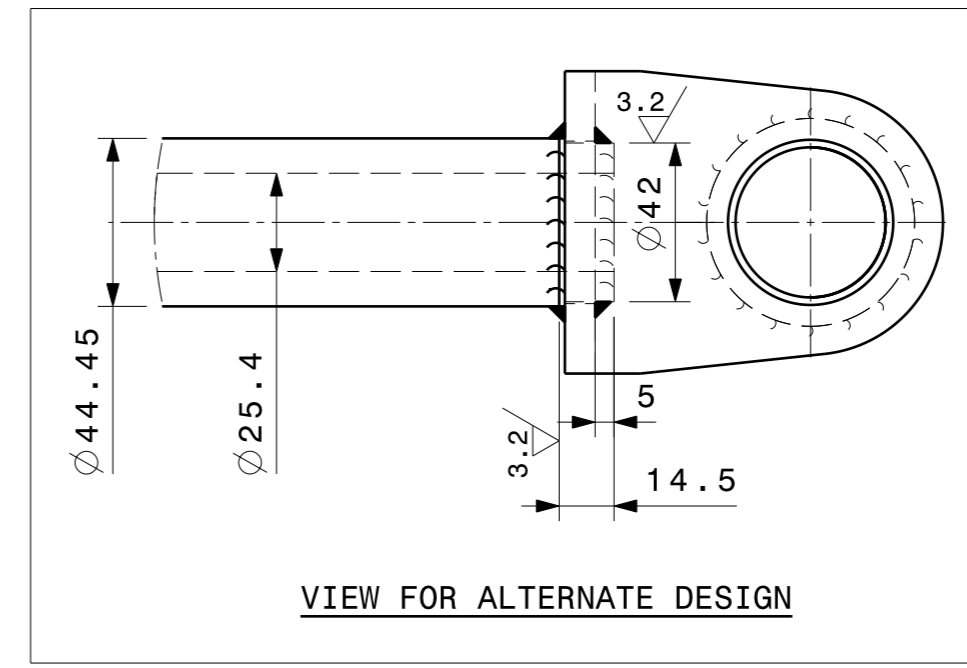
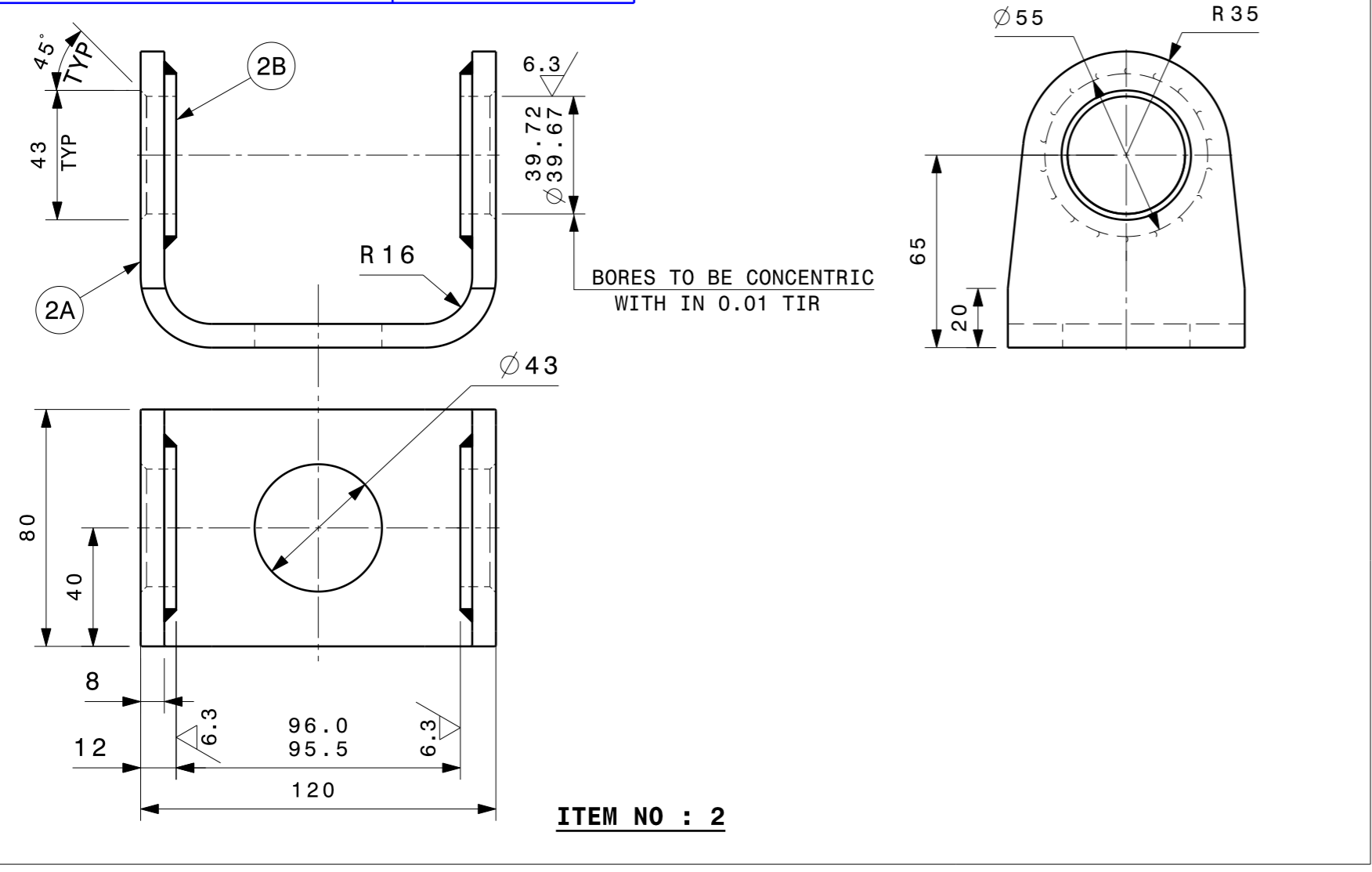
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ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVAYALCHAVADI



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NOTE:
LINK TUBE MATERIAL
 SOLID DRAWN STEEL TUBE S93(WITH 1% NICKEL) CONDITION MS QUAD EHN GRAIN SIZE 6-8. TO BE NORMALISED BY SUPPLIER FROM A TEMP OF 850°C TO MEET THE S93 REQUIREMENTS.
 NOTE ALTERNATE MATERIAL SIZE FOR ITEM 01:
 LINK TUBE ALTERNATE MATERIAL SIZE 44.45 OD

ALTERNATE MATERIAL
 SAE 1040 NORMALISED GRADE

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:
PAINTING NOTES:
 *SCAMIC GREEN WITH ENAMEL, SCAMIC GREEN CONFORM TO AL DRG NO:X9715000
WELDING NOTES:
 * USE WELDING ELECTRODE TO SPEC E6013 OR EQUIVALENT
 * WELDS TO CONFORM TO REQUIREMENTS OF ALS.276.02
 * WELDING SYMBOLS AS PER IS:813
 * BEND LINE TO BE ⊥ TO GRAIN FLOW DIRECTION

| SL NO | PART NO | DESCRIPTION | MATERIAL | QTY |
|-------|---------|-------------|-----------------------------|-----|
| 4 | ITEM 2B | SPACER | STEEL IS 2062 GR FE 410 'A' | - |
| 3 | ITEM 2A | BRACKET | STEEL IS 2062 GR FE 410 'A' | - |
| 2 | ITEM 2 | BRACKET | - | 2 |
| 1 | ITEM 1 | LINK TUBE | REF DRG | 1 |

| APPEARANCE ITEM | ER-DIN | DATE |
|--------------------------|---------------|----------|
| YES NO | ER-DIN-XXXXXX | XX/XX/XX |
| FINISHED WEIGHT (APPROX) | REF PART NO: | B0302201 |
| XXX.XXX Kgs | S/A PART NO: | --- |
| SCALE | SUPERSEDES | --- |
| 1:2 | SPEC NO: | --- |

| ALTERATIONS | ER-DIN DATE | GRADE | SUFFIX |
|-------------|-------------|-------|--------|
| | | | |

AL PLM VAULT
 REVISION : #0 DATE : 3/12/2010 STATUS : RELEASE
 STAGE : III ER-DIN NO : ER-DIN-0006139 DATE : 3/12/2010
 ALTERED BY : ashokkumar.alvvc CHECKED BY : rchandra.alvvc
 MED APPROVAL : ganeshm.alvvc APPROVED BY : snagarajan.alvvc

| DRAWN/ DATE | CHECKED/ DATE | MED APPROVAL/ DATE | APPROVED/ DATE | STDS APP/ DATE |
|-------------|---------------|--------------------|----------------|----------------|
| SS 17.10.08 | EA 17.10.08 | | SN 17.10.08 | |

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED
 MATERIAL SEE BOM
 HEAT TREATMENT

REMARKS FOR STALLION MKIV UPGRADE
 DESCRIPTION S/A OF LINK TUBE
 PART NO. **B 0 3 0 3 1 0 1 #.0**
 SHEET No1..... OF1..... **A2**