


**ASHOK LEYLAND LTD.**  
ENMORE MADRAS

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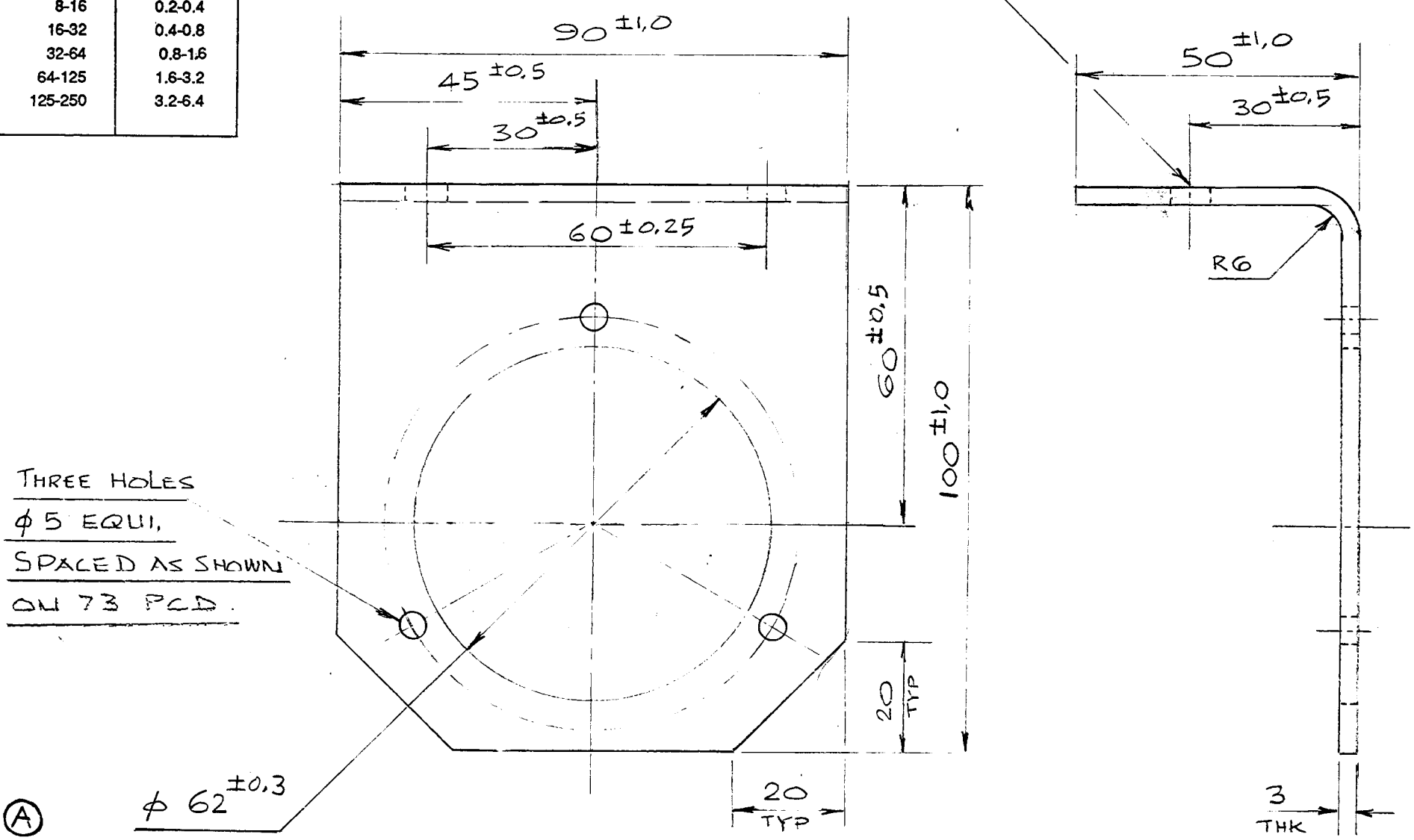
**ASHOK** **FIRST ANGLE PROJECTION** 

SURFACE FINISH AS PER IS: 3073 (CLA VALUE)	
MICROINCHES	MICROMETRES
BELOW 8	BELOW 0.2
8-16	0.2-0.4
16-32	0.4-0.8
32-64	0.8-1.6
64-125	1.6-3.2
125-250	3.2-6.4

**VFJ**

PART NO. **F7195914** (A)

ALTERATIONS		EDM DATE	GRADE	SUFFIX	MICRO FILMED
SURFACE PROTECTION NOTES 1, 2, 3 ADDED VGL/GP		8/17 5-01-93	1	A	1/11/93 22/01/93



NOTE 1. AFTER PHOSPHATING AND PRIMER COATING, ALLOW THE SURFACE TO DRY.  
 2. ON DRY SURFACE APPLY SYNTHETIC ENAMEL OF STEEL GREY COLOUR CONFORMING TO IS 5 SHADE NO 698  
 3. TEST REQUIREMENTS OF THE STEEL GREY SYNTHETIC ENAMEL PAINT SHALL CONFORM TO IS 2932

SPECIAL INSTRUCTIONS / NOTE:  
 BEND TO PERPENDICULAR TO GRAIN FLOW

**UNLESS OTHERWISE SPECIFIED**  
 SURFACE PROTECTION: 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 DIMENSIONS WILL BE AS PER IS: 2102									
DIMN.	OVER UPTO&INCLDG.	6	30	120	315	1000	2000	>4000	
TOLERANCE		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3

SHARP EDGES TO BE REMOVED. DO NOT SCALE DRG. DIMENSIONS ARE IN MM. ANGULAR TOLCE. AS PER IS: 2102. METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS: 4218 CLASS 6g EXTERNAL OR 5H INTERNAL

S.L.No.	PART NO.	DESCRIPTION	SIZE	MATERIAL	QTY.
<b>BILL OF MATERIALS</b>					
REF. PT. NO.	ISSUED UNDER		MICRO FILMED		
SUPERSEDES	EDM/DIN	DATE	BY	THROU	
S/A. PT.NO.			DATE	1005914	
WEIGHT	ROUGH	FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED		
SCALE	1:1		APPROVAL NO. : -		
SPEC. NO.	A.L.B.		TESTING STD. : -		

STAGE	CHECKED	DATE	APPROVED	DATE	ALTERATION LEVEL
I					
II					
III					
DRAWN	DATE	KRN	RETRACED	CHECKED	
CHECKED	DATE	7/24/93	MED. APPROVAL	DATE	9/12/93
APPROVED	DATE	26/1/93	STDS APPROVAL	DATE	DQA 369

MATERIAL: STEEL TO IS: 1079 - 1988 Gr. 'C'  
 HEAT TREATMENT: -

REMARKS: REVERSE-BEEPER MOUNTING  
 DESCRIPTION: BRACKET. REV. BEEPER

PART NO. **F7195914** (A)  
 SHEET No. **ONE** OF **ONE**