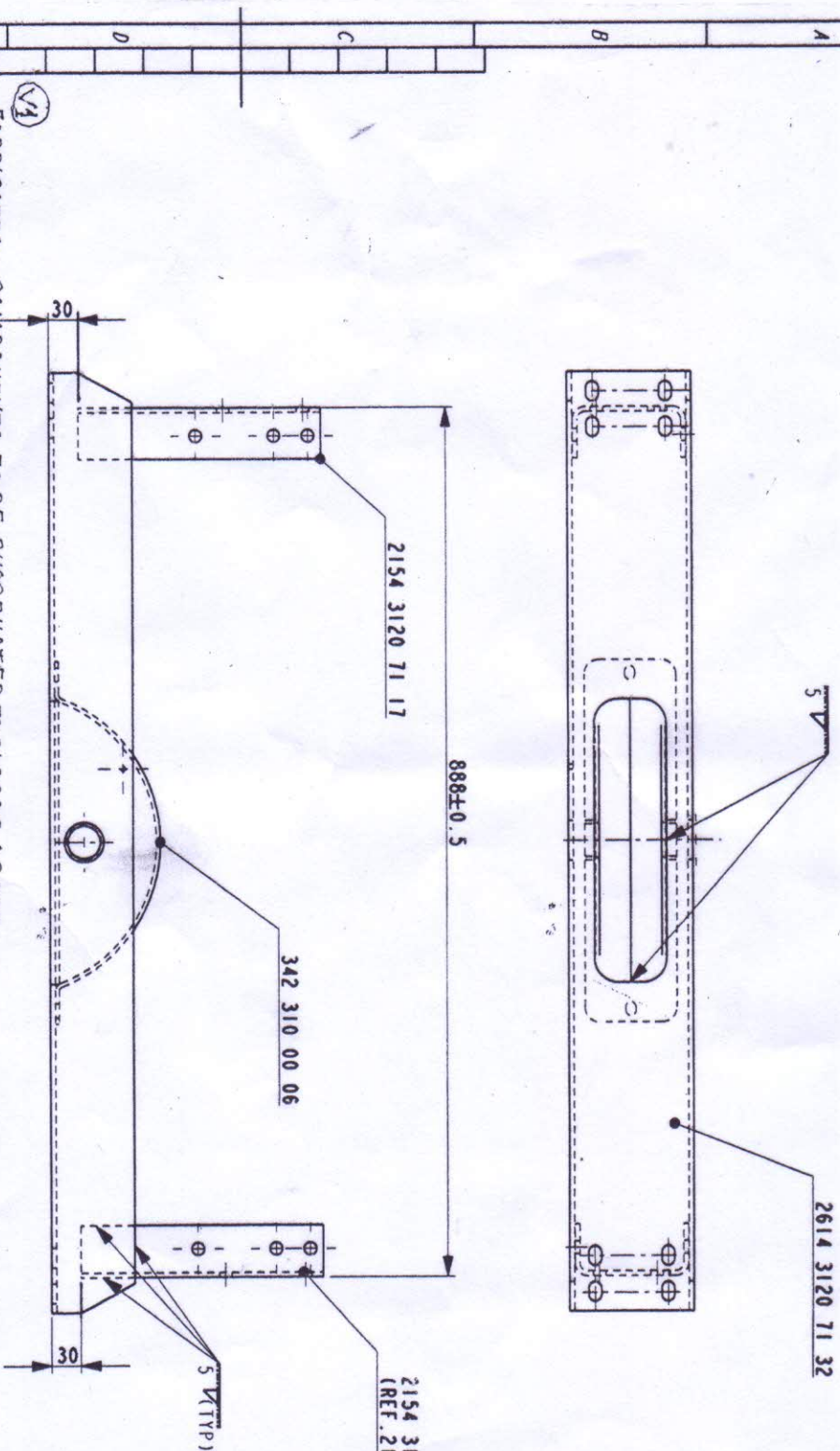


1	2	3	4	5	6	7	8
				Do not scale the drg. If in doubt, Ask	Unless otherwise stated, \varnothing All dim in mm. ② Drg. drawn to first angle projection	Nominal Dim	Tolerance in mm



(V4)
 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.

NOTE
 * TO BE PAINTED WITH PAINT-PRIMER-RED OXIDE-
 ZINC CHROMATE TO SS-7222-IS-25140

FINISH PAINT TO BE APPLIED READY MIXED BRUSHING / SPRAYING
 STOVING WITH SCAMIC (OLIVE GREEN) TO IS: 5: 1994 COLOUR
 SHADE NO 294 PAINT SHOULD CONFIRM TO IS: 8982-91

Machining Deviation as per ISO 2168 m

Over	6	30	120	400	1000	2000	4000
Dim	mm	mm	mm	mm	mm	mm	mm
Tolerance	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2

class to ISO 2168

SURFACE ROUGHNESS SYMBOLS / VALUES IN $\mu m R_a$

Symbol	$\sqrt{1.6}$	$\sqrt{3.2}$	$\sqrt{6.3}$	$\sqrt{12.5}$	$\sqrt{25}$	$\sqrt{50}$	$\sqrt{100}$	$\sqrt{200}$	$\sqrt{400}$
Value	0.8	1.6	3.2	6.3	12.5	25	50	100	200

FOR OTHER ROUGHNESS SYMBOLS & VALUES, SEE IS 18719

Material Description, Size, Spec. Std. No.		CR. NO.	0033	14-5-13	NOTES ADDED
Classification of characteristics:		DATE	09/09		
<ul style="list-style-type: none"> ● Critical, Key Instruction ○ Major, (House) Minor □ Applies to upper limit ■ Applies to lower limit 		DATE	20/09		
This drawing is the sole property of Tata Motors Limited. If should not be copied or communicated to any person without the written approval of Tata Motors Limited.		DATE	09/09		
 TATA MOTORS LIMITED ERC - JAMSHEDPUR		DATE	09/09		
Drg. /Part Designation		Scale:	1:5	Product/Group No.	
ASSY. CROSS MEMBER				LPIA. 1131C/32EUR0111	
WITHOUT AIR FILTER MITG BKT				NEW RELEASE	
Drg. /Part No.		2154 3120 0116		Surface protection as per Std.	
Sheet No. 1 of 1				★	
References Drg. No. 215431200106				Tol. as per Std.	
Replaces Drg.				Tol. as per Std.	
Opp. Head Drg. / Pl. No.				Tol. as per Std.	
Drg. /Part No.		2154 3120 0116		Tol. as per Std.	
Sheet No. 1 of 1				Tol. as per Std.	