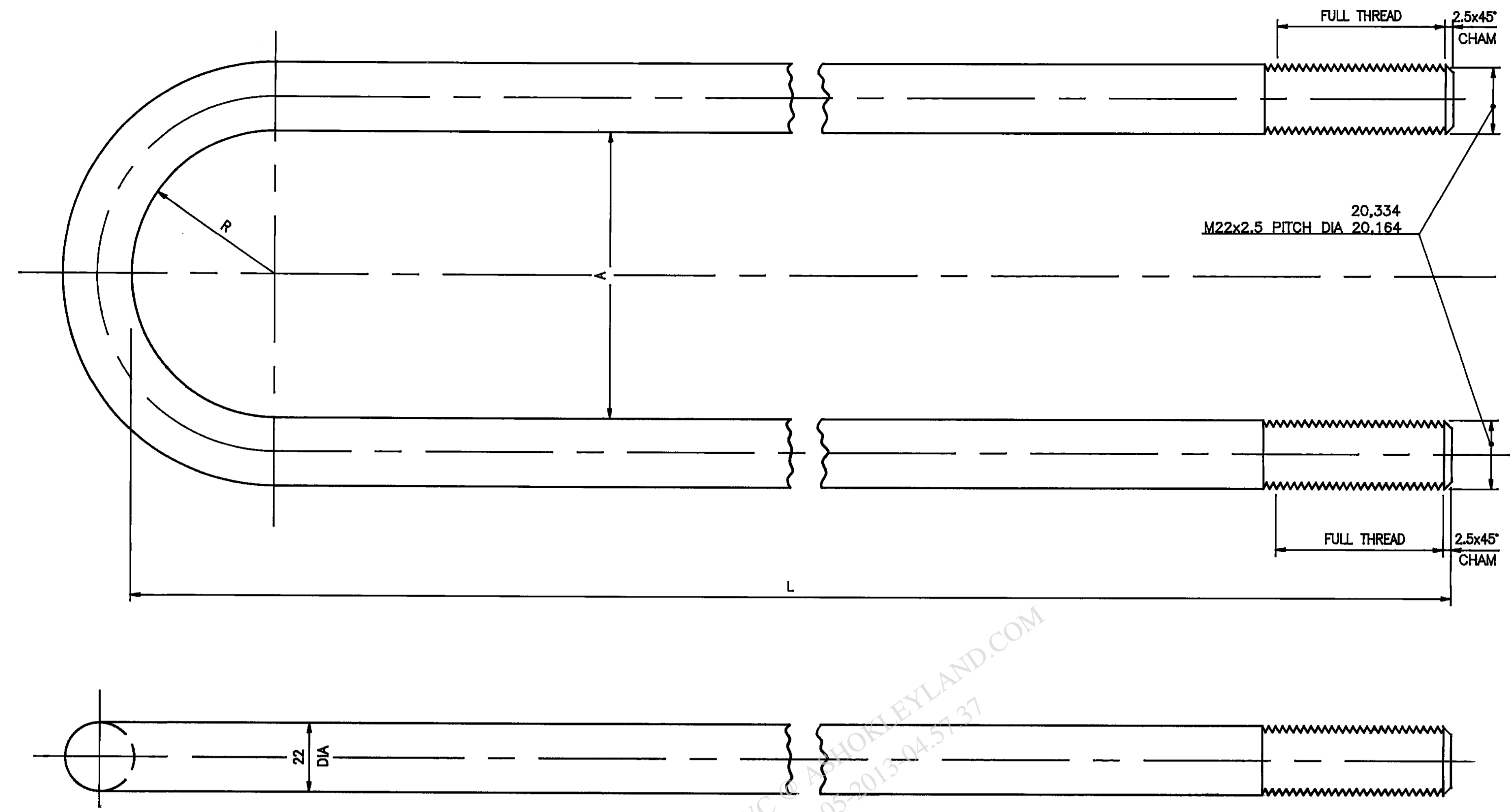


SURFACE FINISH AS PER IS:2073 (CLA VALUE)	
MICROMETERS	MICROMETRES
BELOW 8	BELOW 0.2
8-16	0.2-0.4
16-32	0.4-0.8
32-64	0.8-1.6
64-128	1.6-3.2
128-250	

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ASHOK LEYLAND LTD. ENNORE MADRAS



VFI PART NO. F3578415 I

ALTERATIONS	NO.	GRADE	SUPPL.	MICRO HEAD
LENGTH 512/514 WAS 531/529: STRAIGHT LENGTH 1024 WAS 1147 FOR F3578915 EDM 90056	2 3 84		1 A	
FOR PART NO F3578715 LENGTH 489/487 WAS 497/495. STRAIGHT LENGTH 1056 WAS 1072 EDM 5872 TM/KGG	16/ 8/ 85		1 B	
PT. NO. F3581915 ADDED PT. NO. F3578415 IN TITLE BLOCK WAS F3578415 - F3578715 TM EDM 5961.	27/ 12/ 85			C
DIMN 1113 WAS 1024 IN STRAIGHT LENGTH (mm) FOR F3578915. EDM 90056A	19/ 3/ 80		0 D	
FOR PART NO : X3501815 STRAIGHT LENGTH 872 WAS 972MM. EDM 90383 DT. 21.3.86 SM	21 3 86		1 E	
PT NO: F3582915 ADDED RLK. ALDN 7748	25 9 86		1 F	
PT NO: F3595615 ADDED	14 8 92		1 G	
PT NO : F3520710 ADDED. DIM NO: 17750	05 09 2001			H
PT NO F3523610 ADDED DIM NO 018265	03 09 02			I US A-10-02

PART NUMBER	"A"	"L"	"R"	FULL THREAD	STRAIGHT LENGTH. MM	REPLACED PT. NO (7/8BSF)	REMARKS
F3523610	78.5 77.7	504 502	39	64.5 63.5	1086 APPROX		ALRS69
F3520710	82.3 81.5	457 455	41	58.5 51.0	951 APPROX		ALSES 61/4
F3595615	78.5 77.7	541 539	39	64.5 63.5	1160 APROX		AL RS 38/9
X3501815	82.3 81.5	396 394	41	53.5 51.0	(E) 872 APPROX		AL RS 23/90
F3582915	82.3 81.5	436 434	41	64.5 63.5	952 APPROX		AL RS 23/2
F3581915 (C)	78.5 77.7	469 467	39	64.5 63.5	1016 APPROX		AL RS 38/1
F3580315	78.5 77.7	443 441	39	56.0 55.0	963 APPROX		AL RS 40
F3578415	78.5 77.7	479 477	39	64.5 63.5	1036 APPROX	F3577515	AL RS 24/3
F3578515 (B)	78.5 77.7	489 487	39	64.5 63.5	(B) 1056 APPROX	F3575815	AL RS 27/2,38
F3578615	91.31 90.50	423 421	45.5	73.50 72.50	930 APPROX	F3571815 (AL 9318)	AL RS 10
F3578715	82.3 81.5	386 384	41	53.5 51.0	852 APPROX	F3573615	AL RS 23
F3578915	91.30 90.50	512 514	45.5	56.0 53.5	1113 APPROX	F3531315 (AL 4092)	AL RS 9
F3579015	91.30 90.50	455 453	45.5	56.0 53.5	995 APPROX	F3575415	AL RS 9/1
F3579115	78.50 77.70	458 456	39	64.5 63.5	993 APPROX	F3574615	AL RS 29/2
F3579615	91.70 90.50	542 540	45.5	56.0 53.5	1170 APPROX		FOR BEAVER WITH 3 PIECE AXLE
F3579715	78.50 77.70	450 448	39	64.5 63.5	977 APPROX		WELDED AXLE WITH 54" SPRING AL8529

STAGE	CHECKED	DATE	APPROVED	DATE	ALTERATION LEVEL
I					
II					
III					

MATERIAL: STEEL EN10
HEAT TREATMENT: HEAT TREATED CONDITION Y BRINELL P02.3414

UNLESS OTHERWISE SPECIFIED

SPECIAL INSTRUCTIONS/NOTE

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 DIMENSION WILL AS PER IS:2102	
DIM	TOLERANCE
0-1	±0.1
1-3	±0.15
3-6	±0.2
6-30	±0.3
30-120	±0.5
120-315	±0.8
315-1000	±1.2
1000-2000	±1.5
2000-4000	±2.0
>4000	±3.0

REF. PT. NO.	DESCRIPTION	QUANTITY	UNIT	REMARKS
BILL OF MATERIAL				
SUPERGRIDS	EDM/DIN	DATE	BY	MICROFILMED
S/A PT NO.				DATE
WEIGHT	ROUGH	FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED	NO
SCALE	APPROVAL NO. :			
SPEC NO.	TESTING STD. :			

REF. PT. NO.	DESCRIPTION	QUANTITY	UNIT	REMARKS
BILL OF MATERIAL				
SUPERGRIDS	EDM/DIN	DATE	BY	MICROFILMED
S/A PT NO.				DATE
WEIGHT	ROUGH	FINISH	SUPPLIER'S DRAWING APPROVAL REQUIRED	NO
SCALE	APPROVAL NO. :			
SPEC NO.	TESTING STD. :			

REMARK: U BOLT
PART NO. F3578415 I
SHEET NO. OF