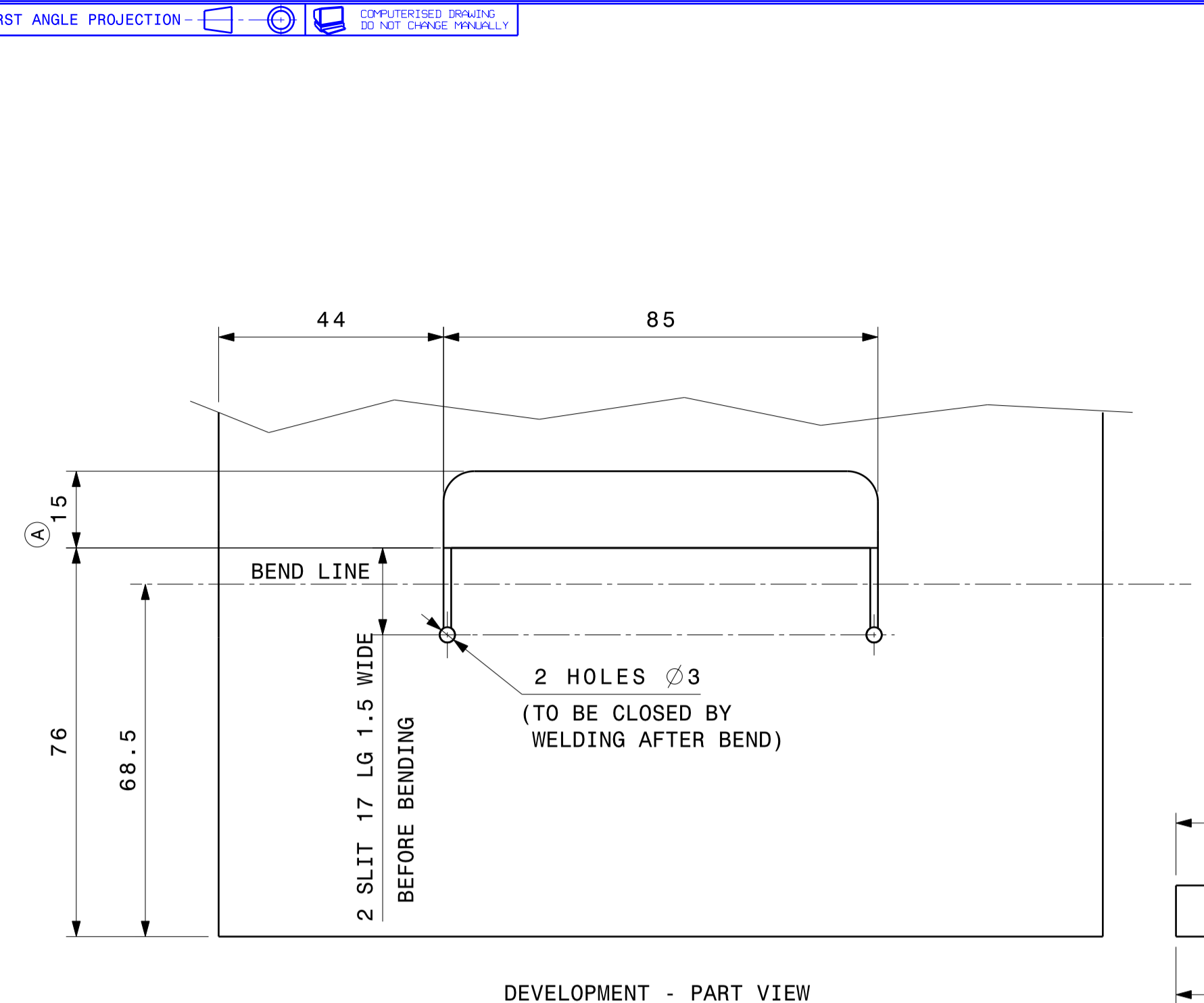




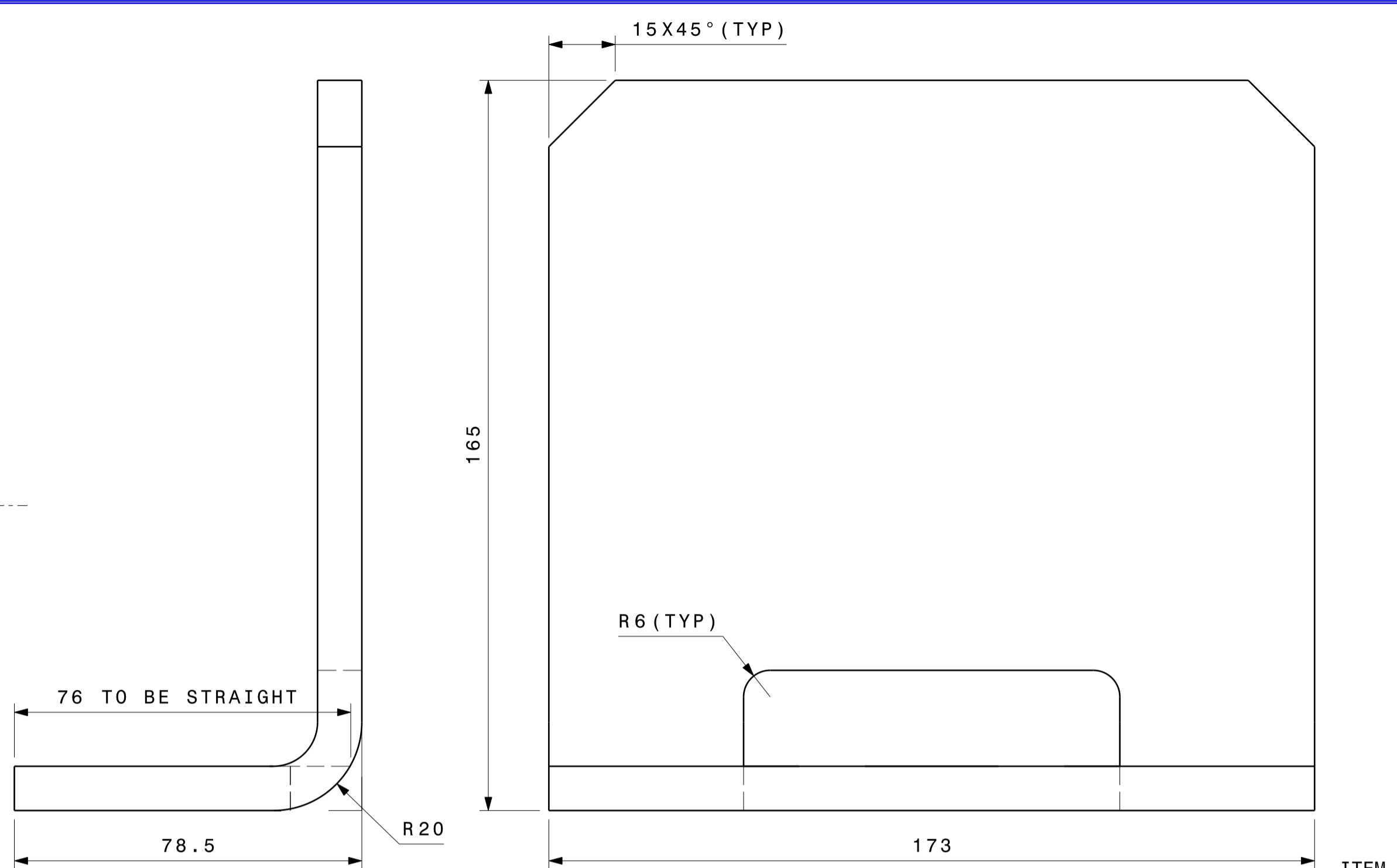
LEYLAND

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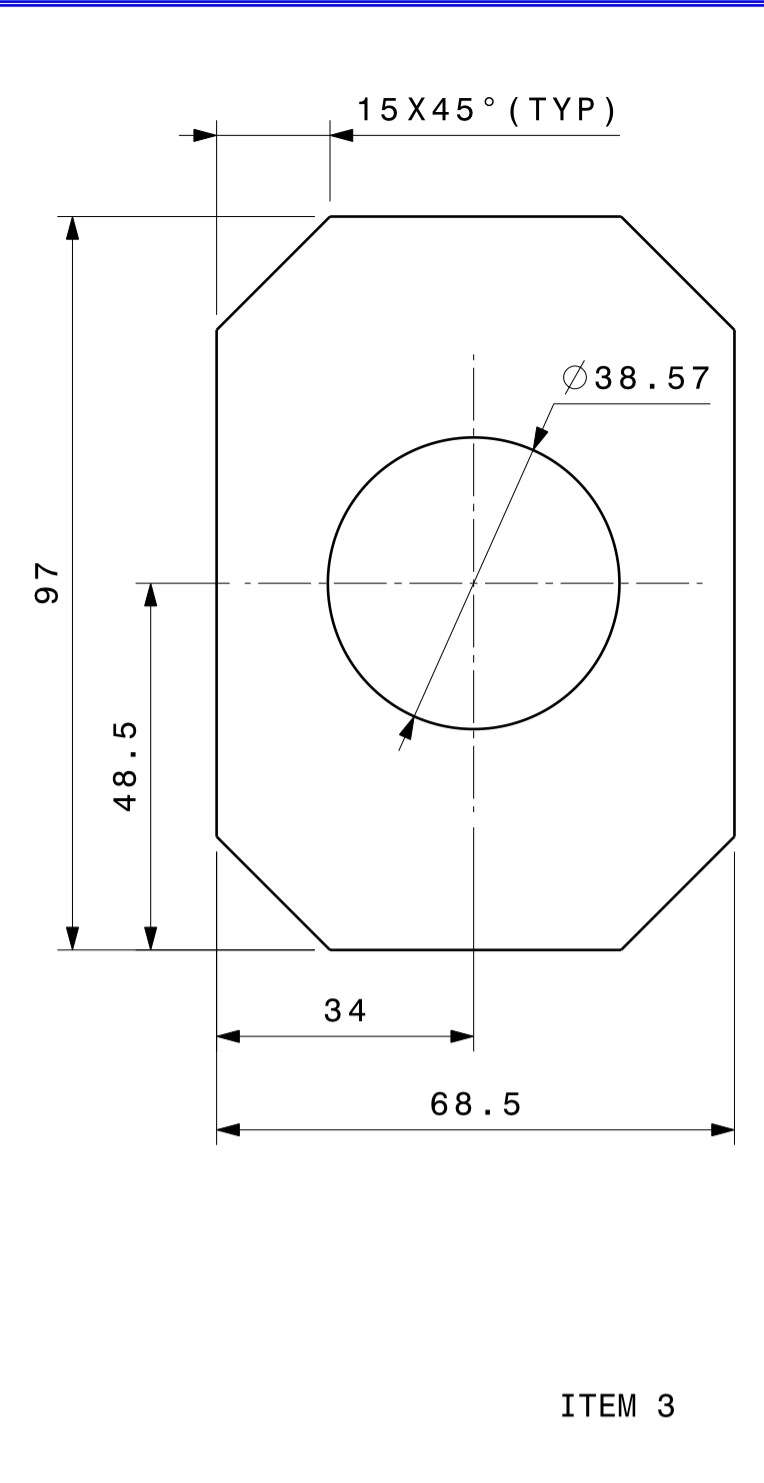
ASHOK LEYLAND LTD. TECHNICAL CENTRE, VELLIVOLCHAVADI



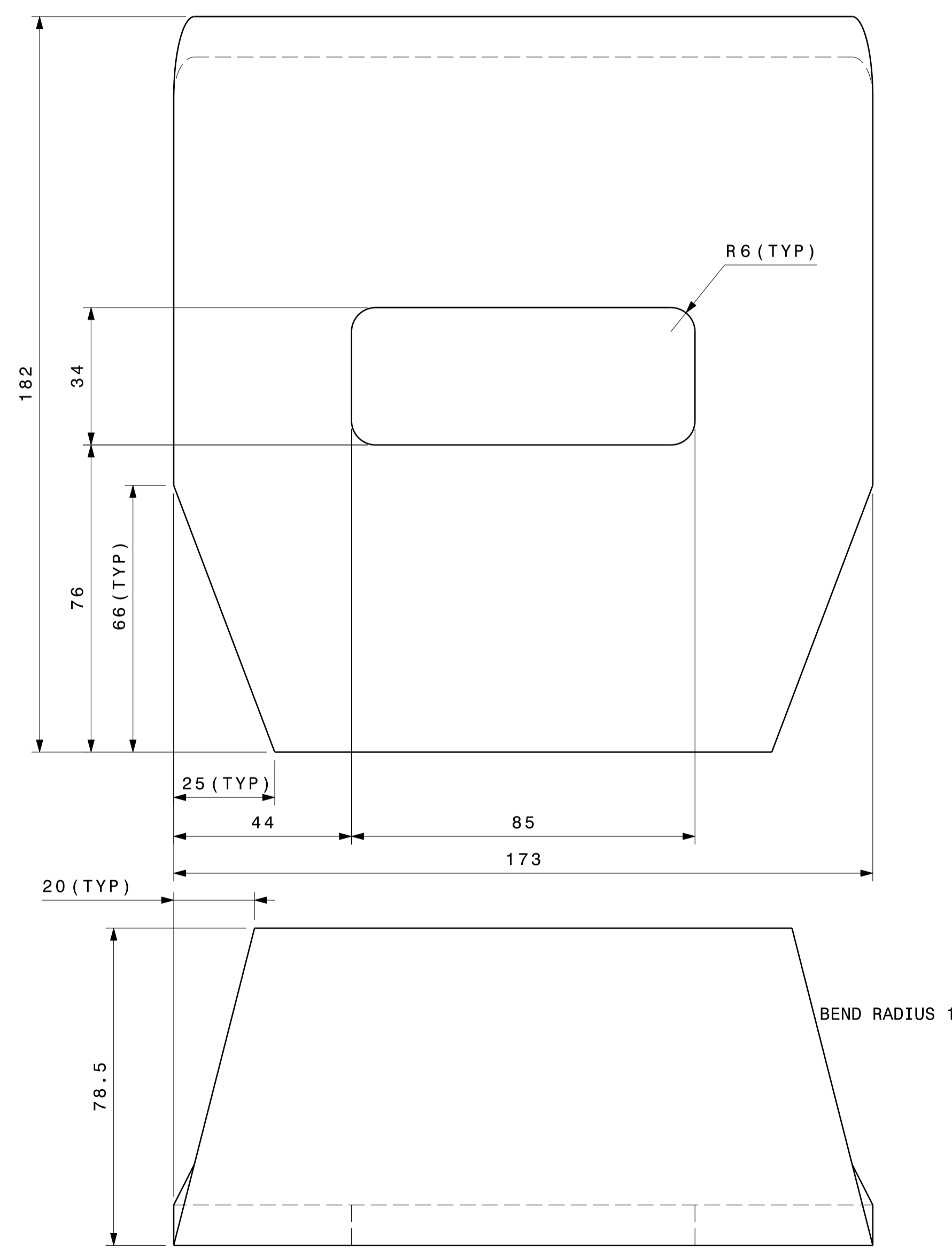
DEVELOPMENT - PART VIEW



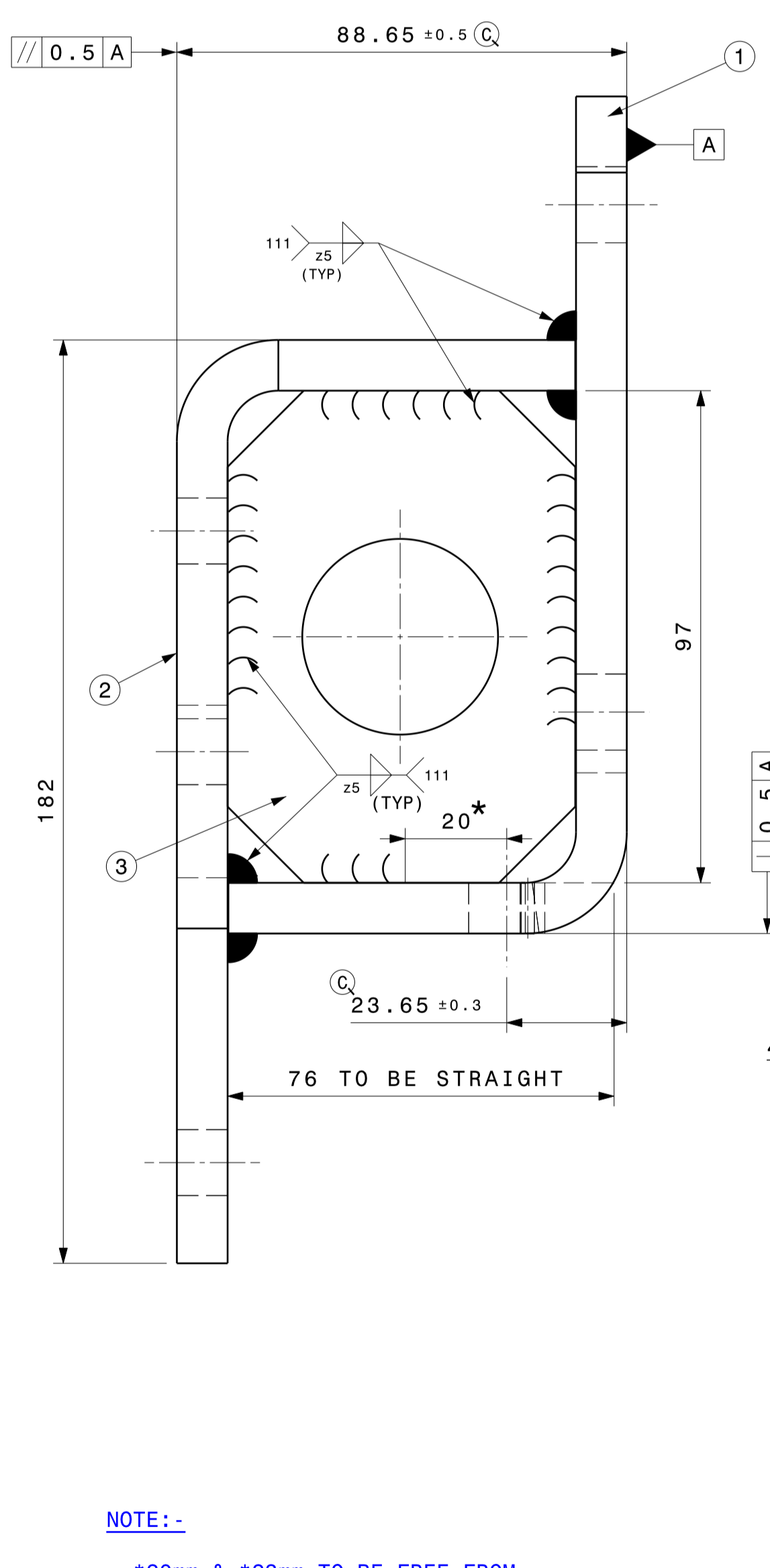
ITEM 1



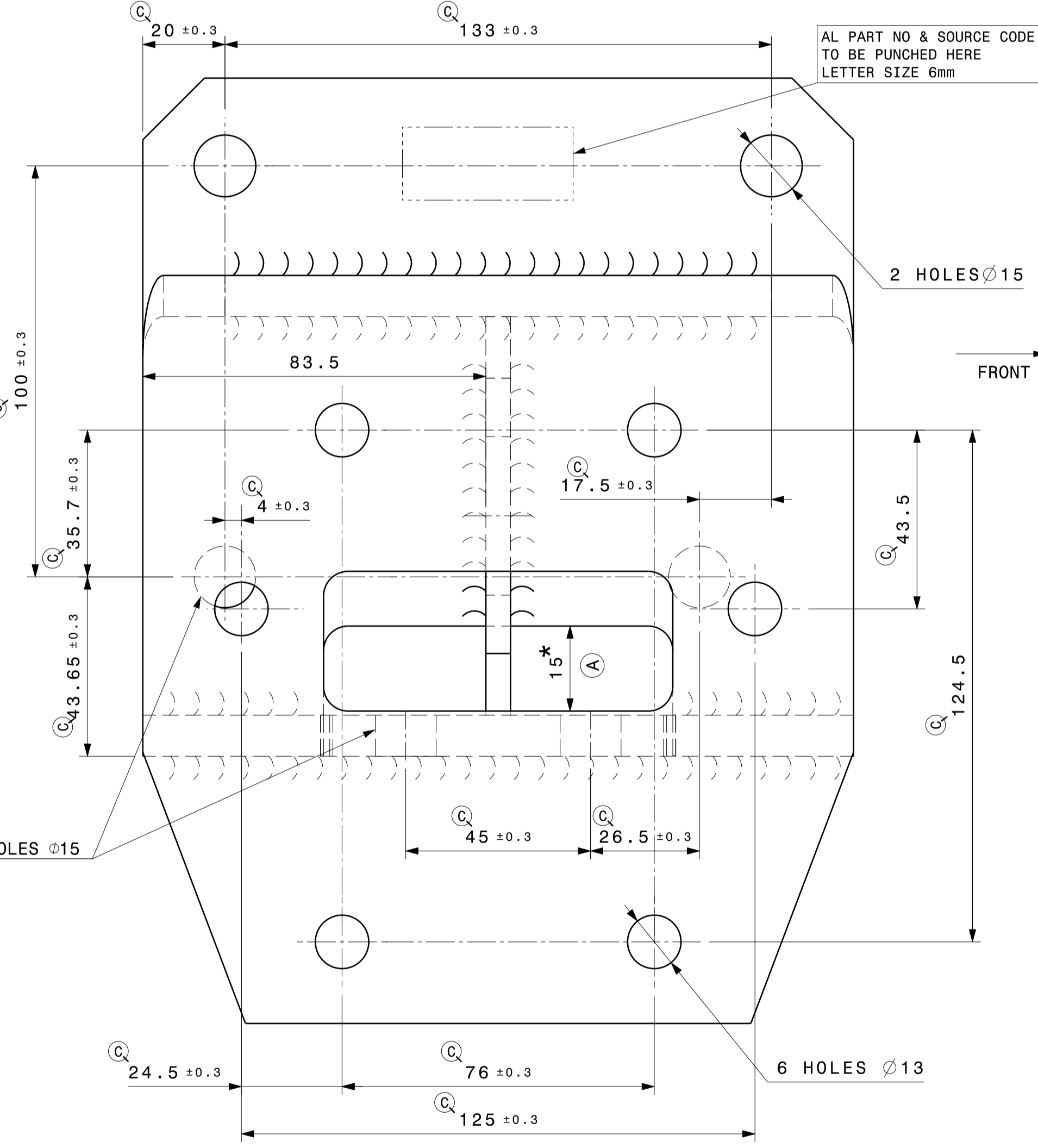
ITEM 3



ITEM 2



NOTE:-  
\*20mm & \*23mm TO BE FREE FROM WELD AT BOTH SIDES OF GUSSET



FRONT

AL PART NO & SOURCE CODE TO BE PUNCHED HERE LETTER SIZE 6mm

X7184410 (LH-DRAWN)  
X7184510 (RH-OPPO HAND)

ALTERATIONS		ER-DIN DATE	ISSUE	REVISION
DIM 15 WAS 23 SLOT WIDTH CHANGED	ABM	18/06/02	—	A
PAINTING DETAILS UPDATED DIN:023048	ABM	23/03/05	—	B
*DRG RE-DRAWN IN CAD. *NOTE ENAMEL REQUIREMENT TO IS 8982 DELETED. *OTHER SPECIAL INSTRUCTIONS ADDED.	SG/KG	20.07.10	—	B.1

AL PLM VAULT				
REVISION: B.1	DATE: 8/9/2010	STATUS: APPROVED		
STAGE: II	ER-DIN NO: ER-DIN-005705	DATE: 13/9/2010		
ALTERED BY: sudaralvc	CHECKED BY: jeealvc			
MED APPROVAL: visalvc	APPROVED BY: sagarajalvc			

DRWN/ DATE	CHEKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
MBC 07/04/02	SN 15/04/02	CS 23/08/03	SN 15/04/02	—

MATERIAL	SEE BOM
HEAT TREATMENT	—

REMARKS	STALLION MARK IV
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SL NO	PART NO	DESCRIPTION	MATERIAL	QTY
3	ITEM 3	GUSSET	PLATE 6 THK IS 2062 Gr 'A'	1
2	ITEM 2	BRACKET-2	PLATE 10 THK IS 2062 Gr 'B'	1
1	ITEM 1	BRACKET-1	PLATE 10 THK IS 2062 Gr 'B'	1

BILL OF MATERIALS		ER-DIN	DATE
APPEARANCE ITEM	YES	ER-DIN-XXXXXX	XX.XX.XXXX
FINISHED WEIGHT (APPROX)	—	REF. PT. NO.	B8136501
SCALE	1:1	S/A PT NO.	A8136500
		SUPERSEDES	—
		SPEC NO.	HAF

DESCRIPTION	END BRKT ENGINE MTG FRONT
PART No.	X 7 1 8 4 4 1 0 B.1 LH
SHEET NO.	.....1.....OF.....1.....

Q - IMPORTANT	Q - CRITICAL	Q - SAFETY	THIS DRG. CONTAINS SAFETY CHARACTERISTIC
UNLESS OTHERWISE SPECIFIED			
ASHOK 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		
LEYLAND SURFACE FINISH AS PER IS:3073 (CLA VALUE)	METRIC-BREW-THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4210 CLASS-CG-EXTERNAL-OR-SH-INTERNAL. SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING		

SPECIAL INSTRUCTIONS/NOTE:	
ⓑ	* USE WELDING ELECTRODE TO SPEC E6012/E6013 OR EQUIVALENT
	* WELDS TO CONFIRM TO REQUIREMENTS OF ALS.276.02
	* WELDING SYMBOLS AS PER IS:813
	* TO BE PAINTED WITH ENAMEL SCAMIC GREEN CONFORM TO AL PART NO X9715000

- \* GENERAL TOLERANCE TO BE ±0.5 MM
- \* TOLERANCE ON HOLE PITCHES & SIZES TO BE ±0.25MM
- \* TOLERANCE ON OVERALL DIMENSIONS TO BE ±1 MM
- \* BEND LINE BE ⊥ TO GRAIN FLOW DIRECTION.