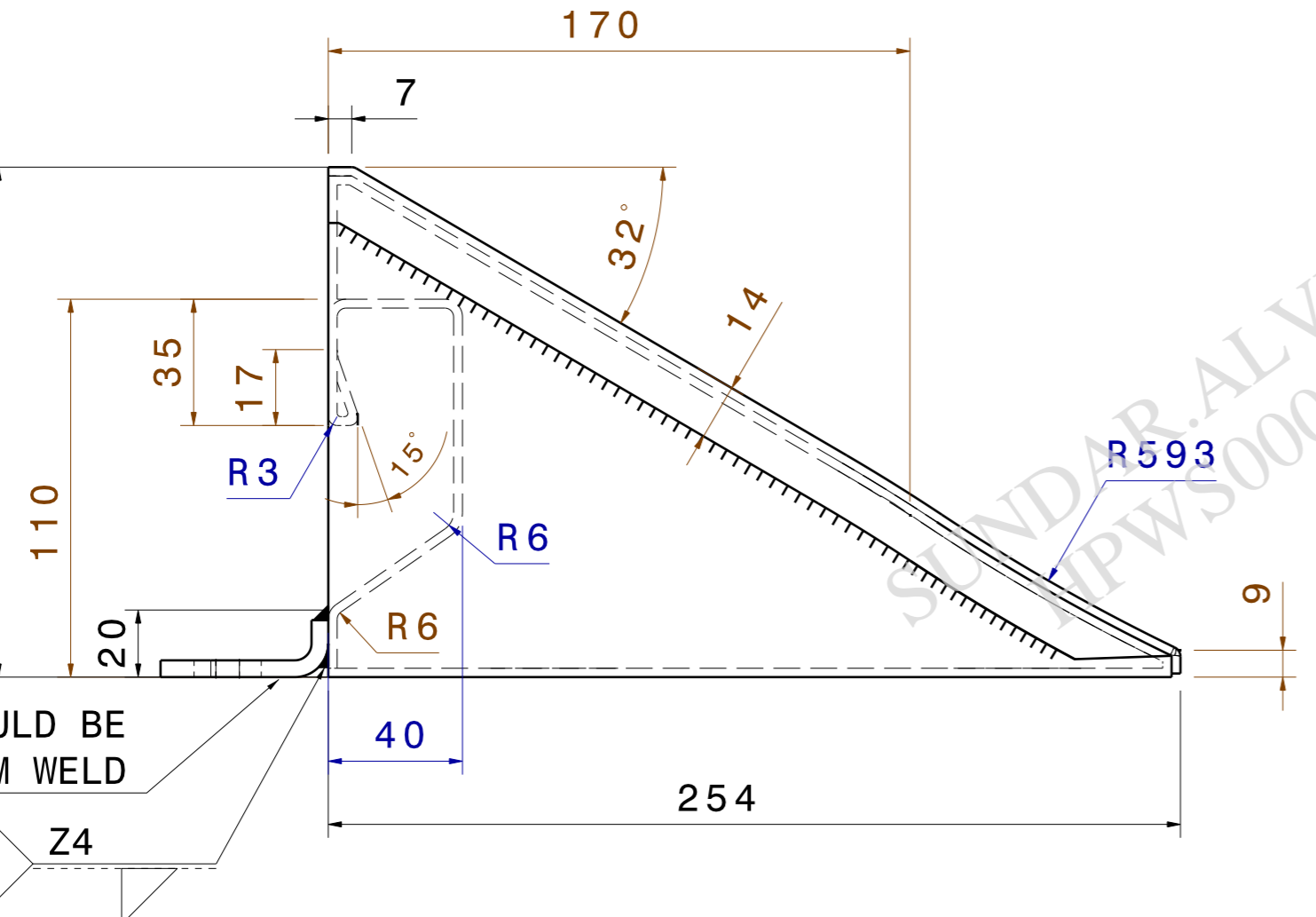
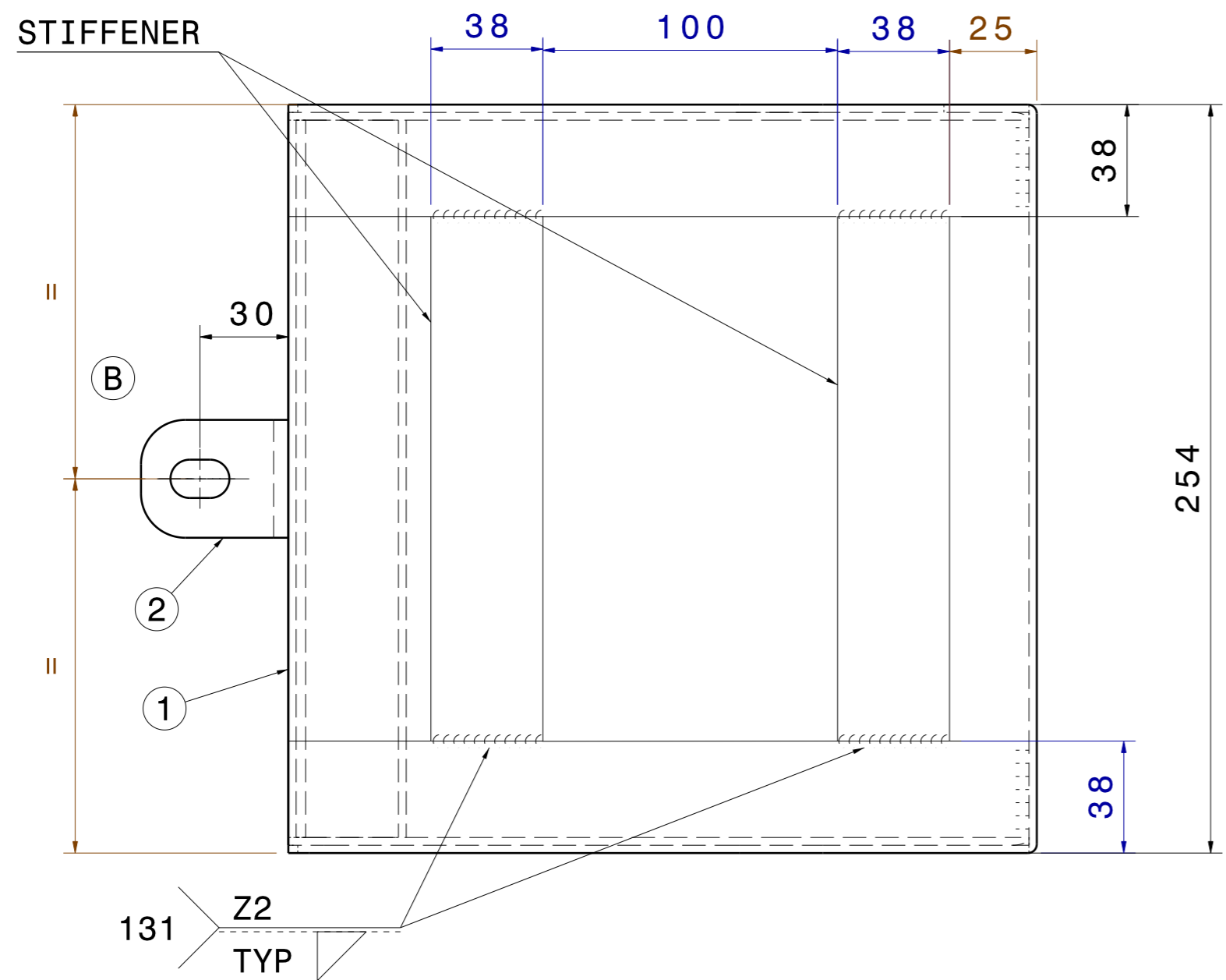
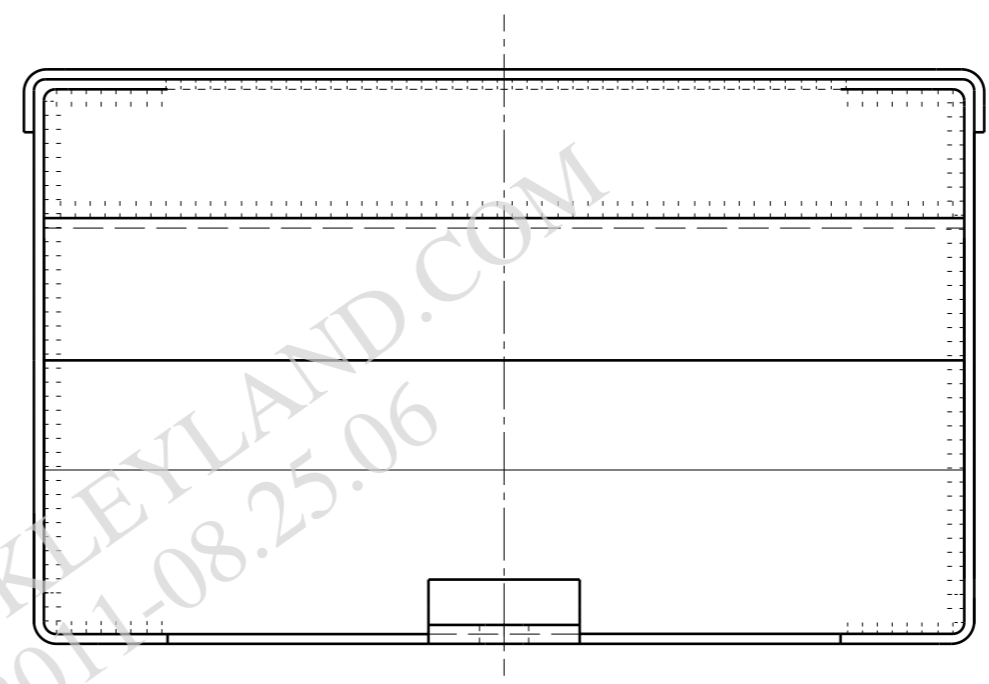
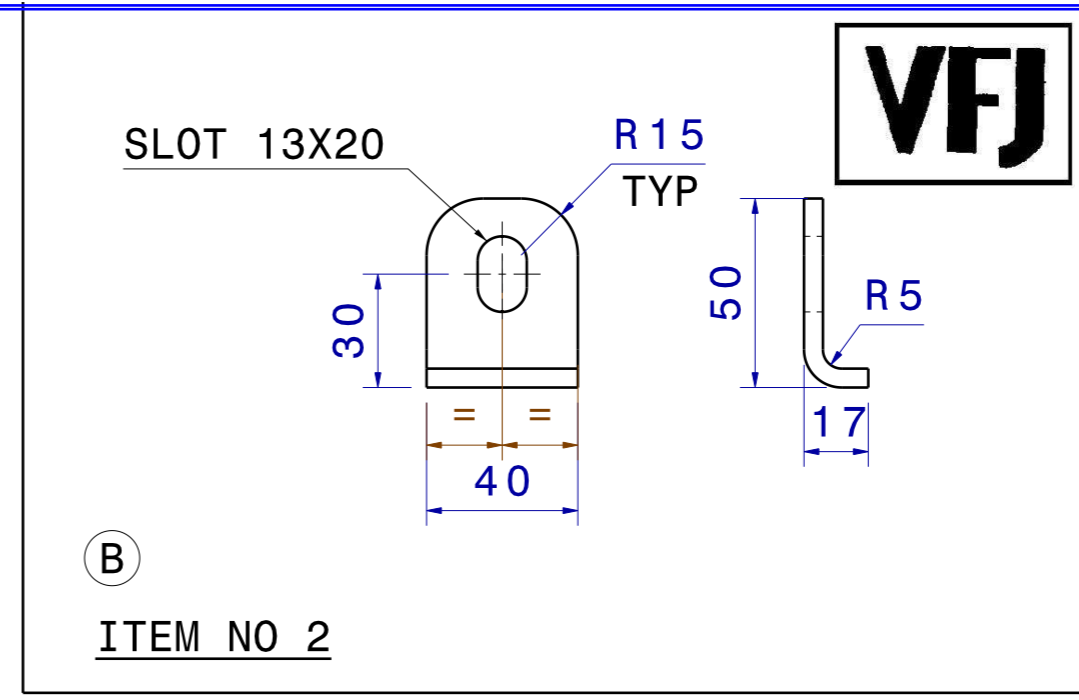




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ASHOK LEYLAND LTD.
 TECHNICAL CENTRE VELLIVAYALCHAVADI



FACE SHOULD BE FREE FROM WELD



VIEW IN DIRECTION OF ARROW-X

NOTE:-
 UNLESS OTHERWISE SPECIFIED RADIUS TO BE R3 MIN.
 WELDING FILLET SIZE 3 MM UNLESS OTHERWISE SPECIFIED.
 ABSOLUTELY NO SHARP EDGES

- WELDING NOTES:**
1. WELDING SYMBOLS AS PER IS 813
 2. WELDING TO BE CO2 ONLY
 3. WELDING ELECTODE TO CONFORM TO ER 70-S6 OF AWS A5.18

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
SURFACE TREATMENT NOTE MODIFIED FOR ADDITION 0 G PAINT TO SHADE NO.294-IS,5 INPLACE OF BLACK PAINT AND ENAMAL REQUIREMENT TO IS 8982 ADDED DRN NO:-H0601/7.12.02/ABM	07 12 02	-	A
-ITEM NO. 2 ADDED -BOM ADDED -DRG. REDRAWN IN CATIA & RE-RELEASED -WELDING & PAINTING NOTES UPDATED	03 08 09	-	B

AL PLM VAULT
 REVISION: B | DATE: 7-8-2009 | STATUS: RELEASE
 STAGE: III | ER-DIN NO/DATE: ER-DIN-0003572 / 7-8-2009
 ALTERED BY: sundar.alvvc | CHECKED: venkatesh.s.alvvc
 MED APPROVAL: anantha.almdch | APPROVED: snagarajan.alvvc
 DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
SA 28.08.95	THOMAS 28.08.95			

S. NO.	PART NO	DESCRIPTION	MATERIAL	QTY
2	----	L BRKT	STEEL PLATE 5 THK TO IS:2062 Gr 'B'	1
1	----	PLATE	STEEL PLATE 2.64 THK TO IS:1079 Gr 'D'	1

(B)

(C) -CRITICAL (S) -SAFETY (I) -IMPORTANT. THIS DRAWING CONTAINS SAFETY CHARACTERISTICS

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:

NOTE:

(B) *SCAMIC GREEN PAINTING TO BE DONE INLINE WITH DRG PART NO:X9715000

BILL OF MATERIALS		
APPEARANCE ITEM	ER-DIN	DATE
<input checked="" type="checkbox"/> YES	NO	ER-DIN-XXXXXX XX/XX/XX
FINISHED WEIGHT (APPROX)	REF PART NO:	---
XXX.XXX Kgs	S/A PART NO:	---
SCALE	SUPERSEDES	---
1:2	SPEC NO:	---

MATERIAL	SEE BOM
HEAT TREATMENT	
REMARKS	F23-6X6 FCT
DESCRIPTION	WHEEL SCOTCHE
PART NO.	X 4 7 0 0 3 1 4 B
SHEET No1..... OF1..... A2