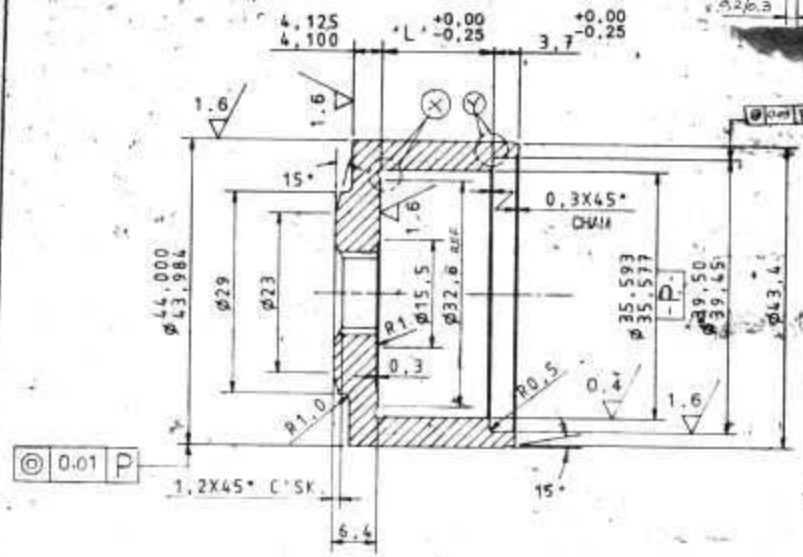
ASHOK LEYLAND

FIRST ANGLE PROJECTION

SURFACE FINISH AS PER IS 3073 (CLA VALUE)

MICRONCHES	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

PART NO	DIMN. 'L'
X1802115	16.2
X1802215	18.2



SECTION–AA

PART NO. X1802115 #

PART NO X1802115 & X1802215 WAS D90453 & D90454 15; ALTERNATE PROFILE UNDER CUT DETAIL 'X' & 'Y' ADDED

NOTE

MATERIAL:
BS 970-EN 353 (OR) EN 352 (OR) BS M13

HEAT TREATMENT
CARBURIZED HARDENED & TEMPERED TO A CASE DEPTH OF 0.4 MM TO 0.6 MM AFTER GRINDING
CASE HARDNESS 58-62 HRc
CASE TO BE TEMPERED MARTENSITE & TO BE FREE FROM CARBIDES & RETAINED AUSTENITE

MACHINE ALL OVER 3.2/ UNLESS OTHERWISE SPECIFIED

ASHOK LEYLAND LTD.
ENNORE MADRAS

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STAGE	CHECKED	SIGN	DATE
I			
II			
III			

DRAWN			
CHECKED			
APPROVED			

MATERIAL: SEE NOTE

HEAT TREATMENT: SEE NOTE

REMARKS: FOR DOUBLE U.J. SHAFT

DESCRIPTION: NEEDLE HOUSING

PART NO: X1802115 #

UNLESS OTHERWISE SPECIFIED

SURFACE PROTECTION: FABRICATED COMPONENTS TO BE PHOSPHATED TO GRADE 'D' 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 1194

MACHINING TOLERANCE FOR OPEN DIMENSIONS WILL BE AS PER IS 2102

DIMN.	OVER	0	30	120	315	1000	2000	>4000
	UPTO/INCLUDING	30	120	315	1000	2000	4000	
	TOLERANCE	±0.1	±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

SPECIAL INSTRUCTIONS / NOTE

BILL OF MATERIALS

S.No	PART NO	DESCRIPTION	SIZE	MATERIAL	QTY.

REF. PT. NO	—	ISSUED UNDER		MICRO FILMED	
SUPERSEDES	—	ECNO/DN	DATE	BY	—
SA. PT. NO.	B152601	19661	12.1.95	DATE	—
WEIGHT	ROUGH — / FINISH —	SUPPLIER'S DRAWING APPROVAL REQUIRED		YES	NO
SCALE	2:1	APPROVAL NO.	—		
SPEC NO.	HAA49	TESTING STD.	—		