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HBNR 1280

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PRODUCTION ENGINEERING & PROJECTS ASHOK LEYLAND LTD. HO-SUR

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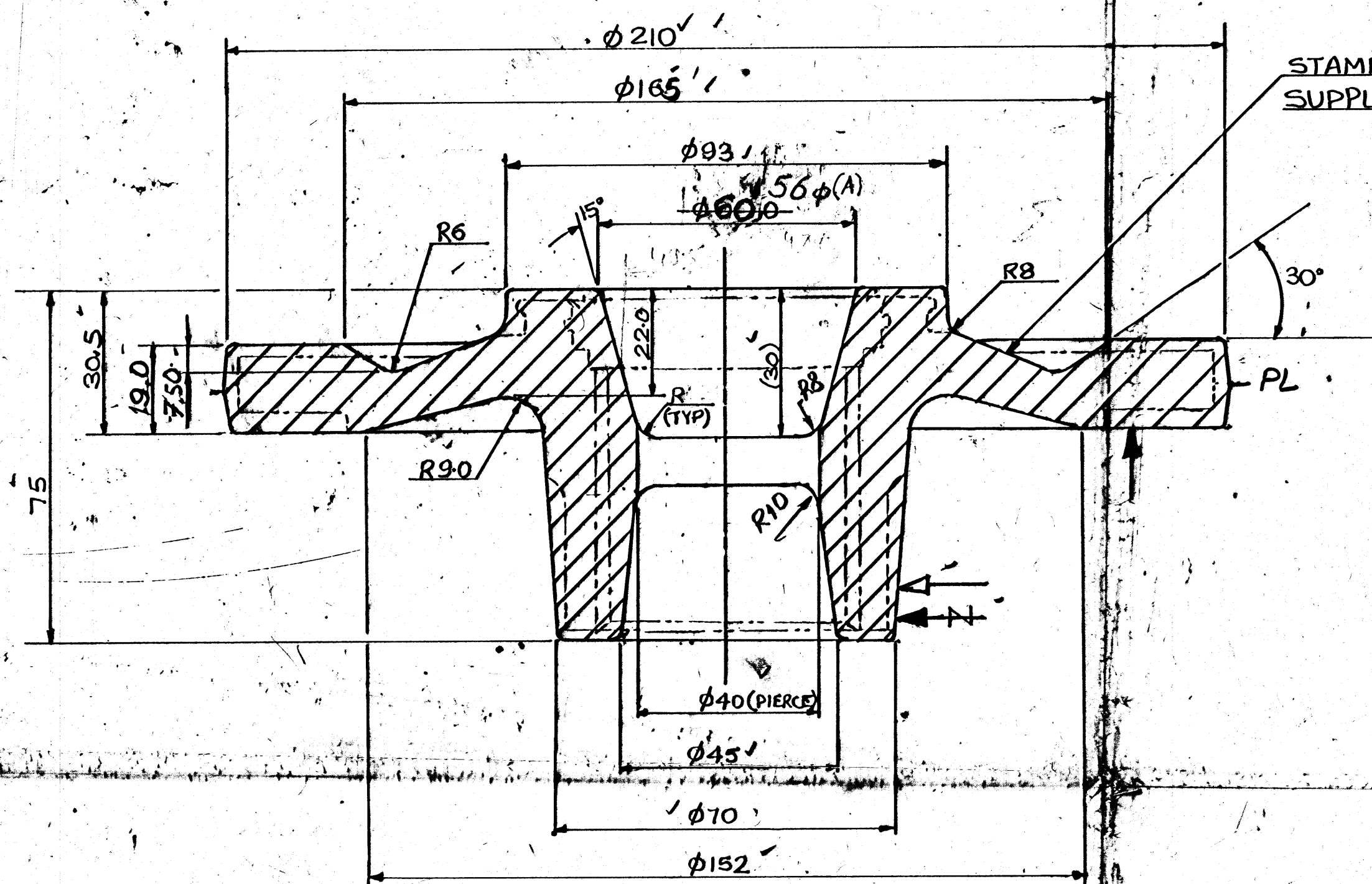
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IF IN DOUBT ASK.

ORG. NO.

Z1802911

ALTERATIONS



STAMP PART NO. & HEATCODE
SUPPLIER'S CODE HERE

NOTE:

- (1) ALL DIMENSIONS ARE IN MM
- (2) ALL TOLERANCES TO BE AS PER IS: 3469 (PART I TO III) - 1974
- (3) DIMENSIONS TO BE TAKEN TO THE POINTS OF INTERSECTION
- (4) 100% CRACK DETECTION
- (5) FOR INTERNAL DIMENSIONAL TOLERANCES REVERSE + & - SIGN
- (6) ALL LOCATING, RESTING & CLAMPING SURFACES TO BE CLEAN, SMOOTH & CYLINDRICAL
- (7) SURFACE DEFECTS: PERMISSIBLE PITS INCLUDING SCALES LAPS AND OTHER SURFACE DEFECTS ON MACHINED SURFACES UPTO 50% OF MACHINING ALLOWANCE AND ON OTHER SURFACES UPTO 1/3 OF FORGING TOLERANCES
- (8) SUPPLY CONDITION: SHOT BLASTED

MATERIAL: C45	TOLERANCES	PART NO.	X 18 029 11
HEAT-TREATMENT: HARDENED & TEMPERED	DRAFT ANGLE: +2°, -1°	DESCRIPTION	FRONT WHEEL DRIVE
HARDNESS: 244-285 HB	RADI (C & F): 2.0 50% - 25%	REPLACES ORG. NO.	
DRAFT ANGLE: INNER 7°, OUTER 5°	THICKNESS: +1.5, -0.7	DRAWN	V. P. Jain
RADI: CORNER R2, FILLET R3	MISMATCH: 0.8	CHECKED	Shankar
	FLASH EXT.: 1.0	APPROVED	P. S. Sankar
	STRAIGHTNESS: 1.2	TITLE	(ACTUATOR)
	LENGTH, WIDTH, HEIGHT DIA	FRONT WHEEL DRIVE	

Matl. Specn-15: 4517 added & Matl. 45Cg was C45 change as per JBGM/TS LINA. 4556/Fur-Veh/AL/AGB/ CDO-W, dt. 13-11-03 & JWM/ROT LINO. 461/ROT/Policy/03, dt. 15-11-03. K. P. Chel.

Dim 56+ was 60 φ, change to accommodate sufficient mach. Allow. (Ref. JWM/GS 4th GSN/7/03, dt. 6-3-2001). K. P. Chel.

Symbol	~	▽	W	W	W	W	W	W	W
Description	Raw	Roughing	Smoothing	Finishing	Pipe Finishing	Ground	HAD	GD	
Ra Value in um	50	12.5-25	0.8-0.3	0.4-0.2	0.2-0.012	0.4-0.2	0.4-0.2	0.4-0.2	

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PROJECT
MAGIRUS



THIRD ANGLE PROJECTION

REFER IS 2102 - 1969 FOR ALLOWABLE DEVIATION FOR DIMENSIONS SPECIFIED TOLERANCES

SHARP EDGES TO BE REMOVED DO NOT SCALE DRAWING

DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE STATED

SURFACE FINISH SYMBOLS

ORG. NO.

Z1802911

13/1-11192A/CAB/1/1 P1034/17A2