

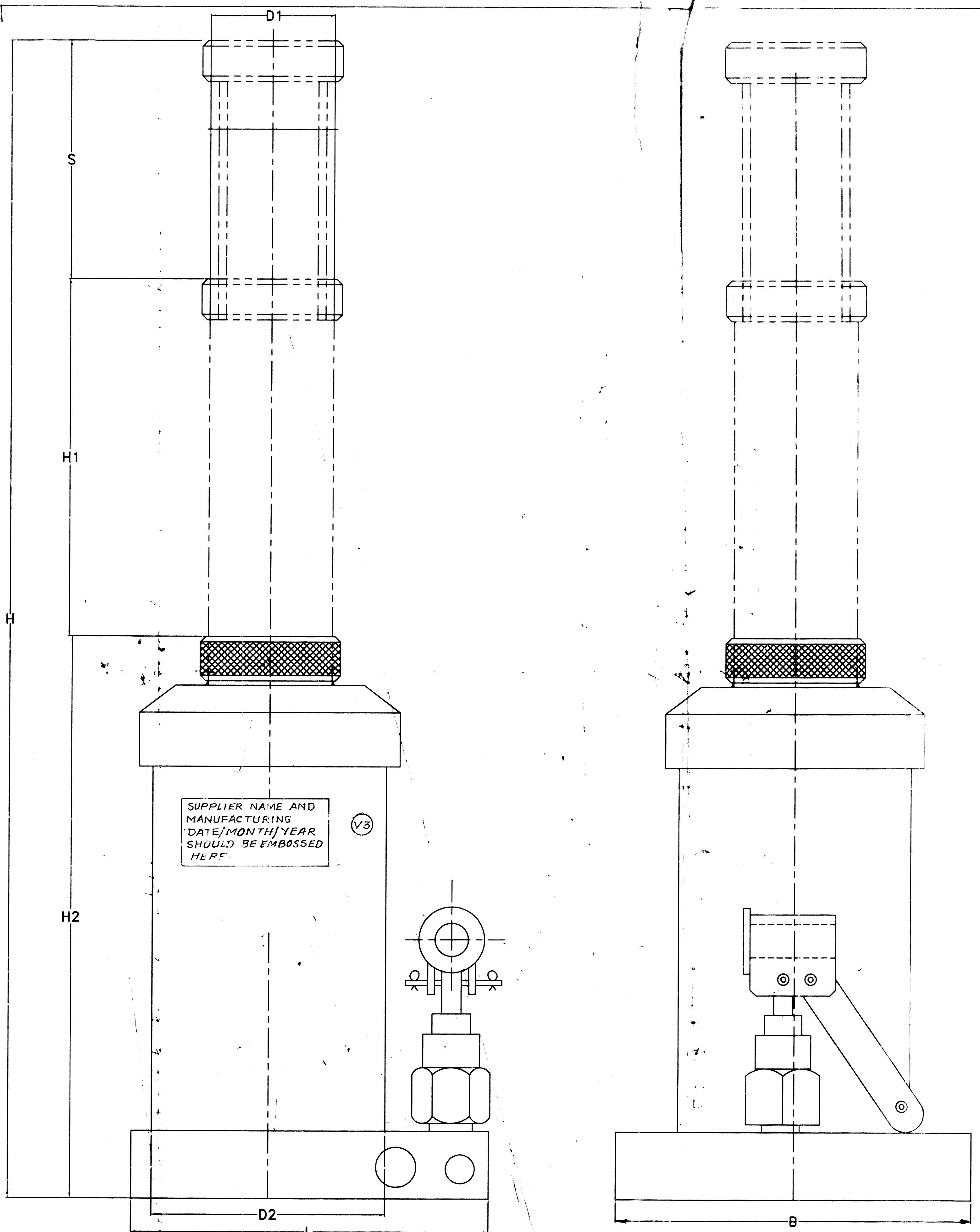
**ASHOK LEYLAND**

FIRST ANGLE PROJECTION

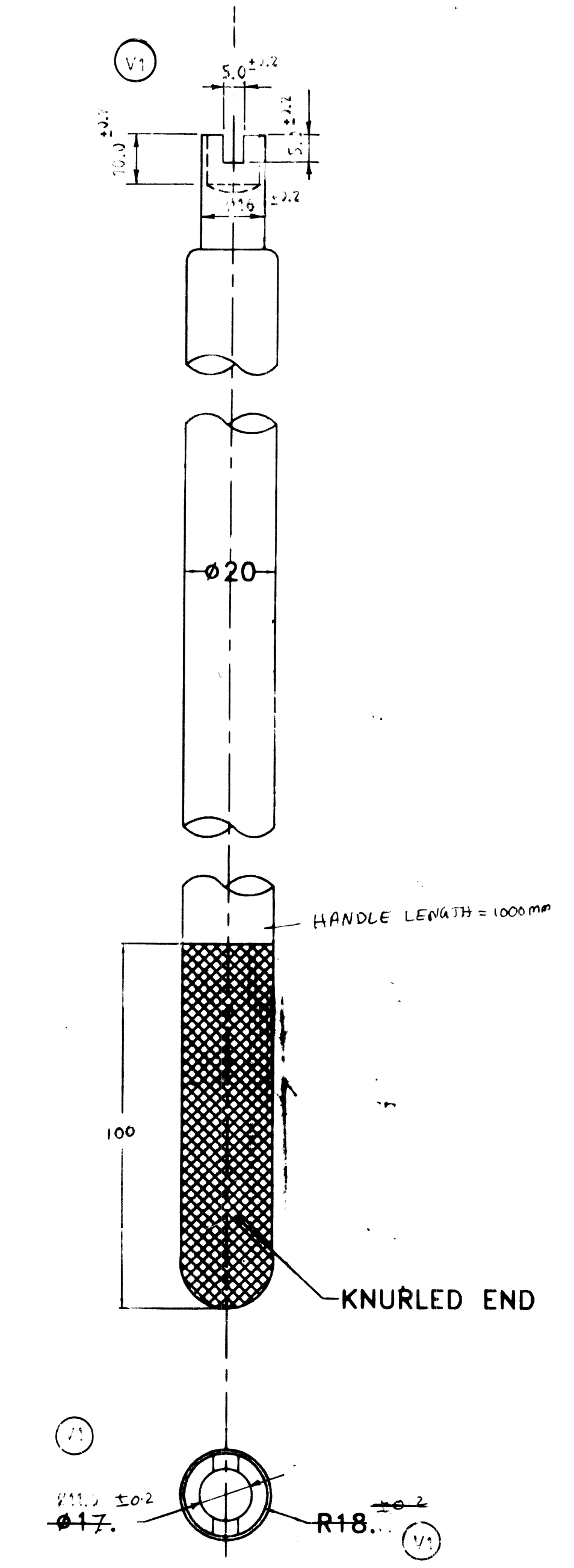
SURFACE FINISH AS PER IS:2073 (CLA VALUE)

MICRO INCHES	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

ASHOK LEYLAND LTD., HOOSUR



- CAPACITY = 8 TONNES
- RAM DIA D1 = 43
- BODY DIA D2 = 86
- TOTAL EXT. HT H = 486
- HYD. LIFT H1 = 150
- CLOSED HT H2 = 236
- BASE LENGTH L = 150
- BASE WIDTH B = 140
- SCREW EXT. S = 100



**VFJ** PART NO. X7451300 #

ALTERATIONS	DATE	BY	APPROVED	REASON
1) DIM. 110 WAS 117 & 110 WAS 117 R15 WAS DELETED	02/21/93	AWH	CSG	
2) DIM. 110 WAS 117 & 110 WAS 117 R15 WAS DELETED	04/04/93	AWH	CSG	
3) SLOT WIDTH 5 <sup>±0.2</sup> & DEPTH 5 <sup>±0.2</sup> ADDED				

CH. NO. - 50221 DATE - 03-03-98 (V2)  
MANUFACTURERS NAME AND MFG. DATE/MONTH/YEAR TO BE EMBOSSED ADDED.

CH. NO. - 50209 DATE - 04-08-2003 (V2)  
NOTE:- APPLICABILITY OF THIS DR. NO. - X7451300 ALSO EXTENDED FOR LPTA 2.5 TON VEHICLES.

STAGE	CHECKED	DATE	APPROVED	DATE	ALTERATION LEVEL
I					
II					
III					

8T JACK TO IS 4552-(PART 2):1993. DESIGNATION: H1B1-B 150IS

UNLESS OTHERWISE SPECIFIED

FABRICATED COMPONENTS TO BE PHOSPHATED TO CLASS 'C' AS PER IS:3018 AND APPLIED IMMEDIATELY WITH RED OILS. ZINC-SHEMITE FINISH TO IS:2074.

WELDING TOLERANCES FOR OPEN DIMENSIONS WILL BE AS PER IS:2102

DIM. TOL. & INCL.	0-30	30-100	100-315	315-1000	1000-2000	> 2000
LINEAR	±0.1	±0.15	±0.2	±0.3	±0.4	±0.5
ANGULAR	±0.5	±0.5	±0.5	±0.5	±0.5	±0.5

SHARP EDGES ARE TO BE ROUNDED.

ANGULAR TOLERANCE AS PER IS:2102

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:2118. CLASS 6H EXTERNAL OR 6H INTERNAL.

ALL DIMENSIONS ARE IN MM

SPECIAL INSTRUCTION / NOTE:

- ANY SPL INSTRUCTION (OR) SUPPLIER RECOMMENDATION TO BE PROVIDED
- MFR DETAIL AND ALL PT NO TO BE PROVIDED.
- HYDRAULIC RAM TO LIFT 25mm IN MAX 18 STROKE OF PLUNGER.

SL. NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY
BILL OF MATERIALS				
NET PART NO.	F3955200	ISSUED UNDER		MICROFILMED
SUPERSEDES		EN / BRN	DATE	BY
S/A PART NO.		9.9.	31.7.92	
WEIGHT	ROUGH	FRESH	SUPPLIER'S DRAWING APPROVAL REQUIRED	YES
SCALE	1:1	APPROVAL NUMBER		
SPEC. NO.	HATS 4	TESTING SCL. IS: 4552		

HEAT TREATMENT: V2 APPLICABILITY STALLION 4x4 AND LPTA 2.5 TON VEHICLES

REMARKS: STALLION 4X4

DESCRIPTION: HYDRAULIC JACK

PART NO. X7451300 #

SHEET 1 OF 1

V3  
V2  
V1