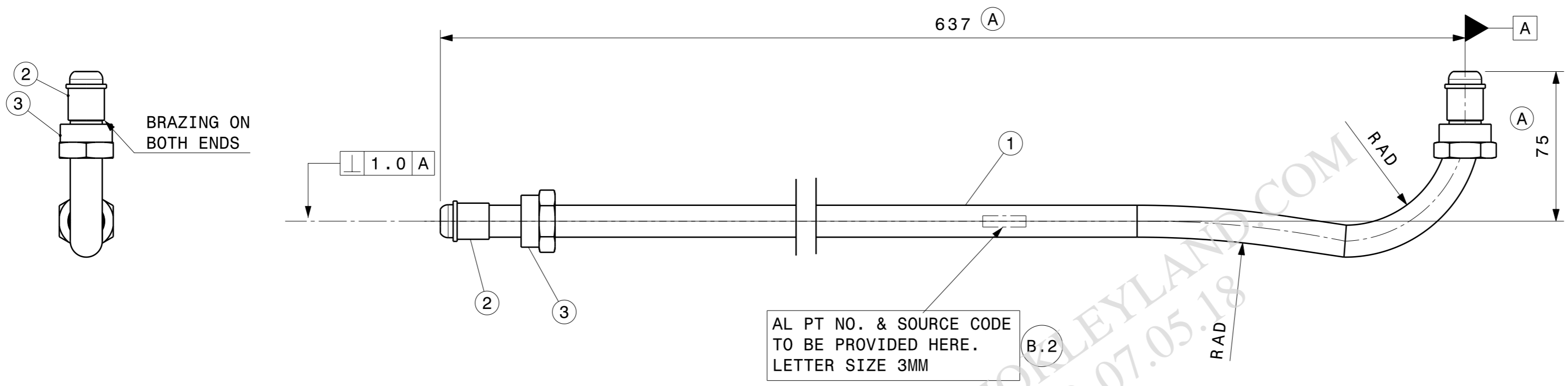




ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVoyalCHAVADI

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NOTE: -
 * THIS DRG FOR REFERENCE PURPOSE ONLY
 * FOR BULK PRODUCTION MASTER SAMPLE TO BE GIVEN BY P.D.

NOTE: -
 * HYDRAULIC TEST TO BE DONE AS PER IS-3074
 * FOR PLATING DETAILS REFER DRG:-F9615000
 * LIMIT OF DEVIATION FROM ROUNDNESS AFTER FORMING SHOULD NOT BE MORE THAN 10% OF NOMINAL OUTER DIA OF TUBE (AS PER IVECO STD 10.4418 CLASS 4.1.2)
 (B.1) * BRAZING TO BE LEAK PROOF AT A PRESSURE OF 105 BAR. (AS PER ALS 276.01)

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:

SNO	PART NO	DESCRIPTION	QTY
(B) 3	F2935015	NUT	2
(B) 2	F2901615	NIPPLE	2
(B.1) 1	---	STEEL TUBE TO IS 3074 - CEW 1, SIZE 16 OD, 2 THICK	1

BILL OF MATERIALS			
APPEARANCE ITEM	ER-DIN	DATE	
<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	023273	19/05/06	
FINISHED WEIGHT (APPROX)	REF PART NO:	B2205401	
	S/A PART NO:	---	
SCALE	SUPERSEDES	---	
1:2	SPEC NO:	ALSG19	

ALTERATIONS	DATE	ER-DIN DATE	GRADE	SUFFIX
MATL. UPDATED FOR ITEM1 DISCRPTION CHANGED DIN:023739 EA/SN		26/08/06	-	A
IN ITEM NO. 2: - PT.NO.F2901615 WAS F2939815 IN ITEM NO. 3: - PT.NO.F2935015 WAS F2940015 DIN:023855 EA/SN		25/09/06	-	B
SL.NO.1 MATERIAL CEW 1 WAS CDS 1, BRAZING NOTE:LEAK PROOF PRESSURE 105 BAR WAS 150 BAR. SRR/EAK		10/11/06	-	B.1
IN ITEM 1, AL PT NO & SOURCE CODE NOTE ADDED. SG/BSV		20/07/10	-	B.2

AL PLM VAULT
 REVISION : B.2 DATE : 3/12/2010 STATUS : RELEASE
 STAGE : III ER-DIN NO : ER-DIN-0006139 DATE : 3/12/2010
 ALTERED BY : sundar.alvvc CHECKED BY : jnr.alvvc
 MED APPROVAL : visu.alvvc APPROVED BY : snagarajan.alvvc

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
A.A 19/05/05	SN 19/05/05	PRAKASH SHAH 22/05/06	SN 19/05/05	---

MATERIAL SEE B.O.M
 HEAT TREATMENT ---

REMARKS FOR STALLION MARK IV
 DESCRIPTION STEERING PIPE-RETURN LINE
 PART NO. **B 2 2 3 8 2 1 0 B.2**
 SHEET No1..... OF1..... A2