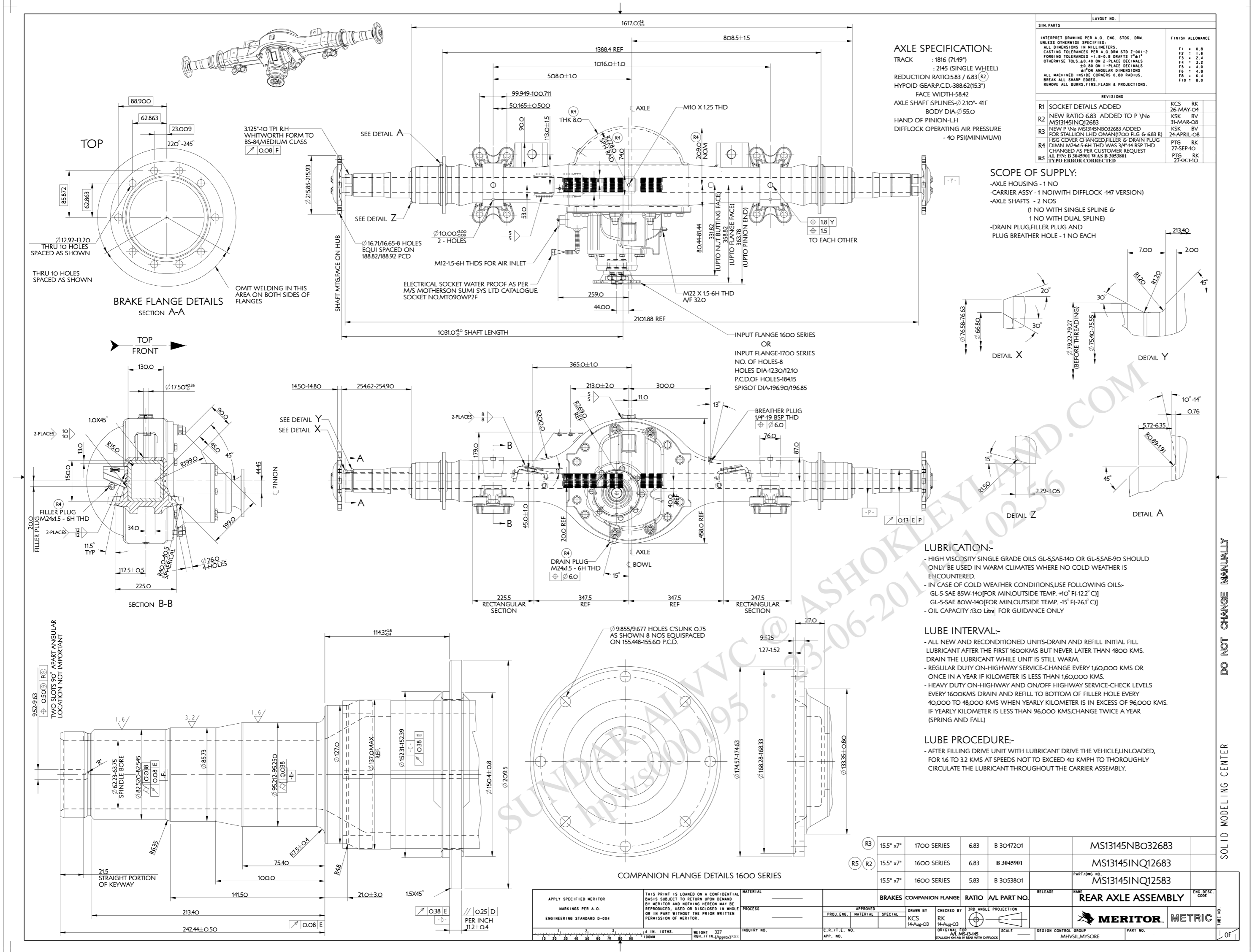




ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVOLCHAVADI



ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
SUPPLIER DRAWING RE-APPROVED FOR FILLER AND DRAIN PLUG MODIFICATION.	28.10.10		#.1
KV/BSV			



**AXLE SPECIFICATION:**  
 TRACK : 1816 (71.49")  
 : 2145 (SINGLE WHEEL)  
 REDUCTION RATIO: 5.83 / 6.83 (R2)  
 HYPOID GEAR P.C.D.: 388.62 (15.3")  
 FACE WIDTH: 58.42  
 AXLE SHAFT SPLINES: 23\*10 - 41T  
 BODY DIA: 55.0  
 HAND OF PINION: LH  
 DIFFLOCK OPERATING AIR PRESSURE : 40 PSI (MINIMUM)

SIM PARTS	LAYOUT NO.	FINISH ALLOWANCE
INTERPRET DRAWING PER A.O. ENG. STDS. DIM. UNLESS OTHERWISE SPECIFIED		F1 : 0.8
ALL DIMENSIONS IN MILLIMETERS.		F2 : 0.4
CAD FILE TOLERANCES PER A.O. DIM STD 3-01-2		F3 : 0.2
FORMING TOLERANCES ± 0.3 DRAFTS 7°-1°		F4 : 0.2
OTHERWISE 10% OF DIM ON 2-PLACE DECIMALS		F5 : 0.2
± 0.30 ON 1-PLACE DECIMALS		F6 : 0.2
± 0.75 ANGULAR DIMENSIONS		F7 : 0.2
ALL MACHINED INSIDE CORNERS 0.40 RADIUS		F8 : 0.2
BREAK ALL SHARP EDGES		F9 : 0.2
REMOVE ALL BURRS, FILLS, FLASH & PROJECTIONS.		F10 : 0.2

**SCOPE OF SUPPLY:**  
 - AXLE HOUSING - 1 NO  
 - CARRIER ASSY - 1 NO (WITH DIFFLOCK -17 VERSION)  
 - AXLE SHAFTS - 2 NOS  
 (1 NO WITH SINGLE SPLINE & 1 NO WITH DUAL SPLINE)  
 - DRAIN PLUG, FILLER PLUG AND PLUG BREATHER HOLE - 1 NO EACH

**LUBRICATION:-**  
 - HIGH VISCOSITY SINGLE GRADE OILS GL-5SAE-90 OR GL-5SAE-85 SHOULD ONLY BE USED IN WARM CLIMATES WHERE NO COLD WEATHER IS ENCOUNTERED.  
 - IN CASE OF COLD WEATHER CONDITIONS, USE FOLLOWING OILS:-  
 GL-5SAE 85W-140 (FOR MIN OUTSIDE TEMP. -10° F/-12.2° C)  
 GL-5SAE 80W-90 (FOR MIN OUTSIDE TEMP. -15° F/-16.1° C)  
 - OIL CAPACITY: 13.0 Litre FOR GUIDANCE ONLY

**LUBE INTERVAL:-**  
 - ALL NEW AND RECONDITIONED UNITS DRAIN AND REFILL INITIAL FILL LUBRICANT AFTER THE FIRST 1600KMS BUT NEVER LATER THAN 4800 KMS. DRAIN THE LUBRICANT WHILE UNIT IS STILL WARM.  
 - REGULAR DUTY ON-HIGHWAY SERVICE-CHANGE EVERY 160,000 KMS OR ONCE IN A YEAR IF KILOMETER IS LESS THAN 160,000 KMS.  
 - HEAVY DUTY ON-HIGHWAY AND ON/OFF HIGHWAY SERVICE-CHECK LEVELS EVERY 1600KMS DRAIN AND REFILL TO BOTTOM OF FILLER HOLE EVERY 40000 TO 48000 KMS WHEN YEARLY KILOMETER IS IN EXCESS OF 96,000 KMS. IF YEARLY KILOMETER IS LESS THAN 96,000 KMS, CHANGE TWICE A YEAR (SPRING AND FALL)

**LUBE PROCEDURE:-**  
 - AFTER FILLING DRIVE UNIT WITH LUBRICANT DRIVE THE VEHICLE UNLOADED, FOR 1.6 TO 3.2 KMS AT SPEEDS NOT TO EXCEED 40 KM/PH TO THOROUGHLY CIRCULATE THE LUBRICANT THROUGHOUT THE CARRIER ASSEMBLY.

BR	QTY	DESCRIPTION	REMARKS
R1	155" x 7"	1700 SERIES	6.83 B 3047201
R2	155" x 7"	1600 SERIES	6.83 B 3045901
R3	155" x 7"	1600 SERIES	5.83 B 3053801

APPLY SPECIFIED MERITOR MARKINGS PER A.O. ENGINEERING STANDARD D-004	MATERIAL	PROCESS	APPROVED	DESIGNED BY	CHECKED BY	DATE	SCALE	DESIGN CONTROL GROUP	PART NO.

MS13145ING12683	B3045901	Qty : -	Qty : -	-
Supplier Part No	AL Part No	Sample	Pilot	<input checked="" type="checkbox"/> Production

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:

BILL OF MATERIALS		
APPEARANCE ITEM	ER-DIN	DATE
YES	NO	ER-DIN----
FINISHED WEIGHT (APPROX)	REF PART NO:	-----
___ Kgs	S/A PART NO:	-----
SCALE	SUPERSEDES	-----
NTS	SPEC NO:	-----

AL PLM VAULT		
REVISION : #1	DATE : 10/12/2010	STATUS : RELEASE
STAGE : III	ER-DIN NO : ER-DIN-0006051	DATE : 10/12/2010
ALTERED BY : sundar.alv	CHECKED BY : jnr.alv	
MED APPROVAL : N/A	APPROVED BY : snagarajan.alv	

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
KV 28.10.10	BSV 28.10.10		SN 28.10.10	
MATERIAL				
HEAT TREATMENT				
REMARKS				
FOR STALLION MK-IV BSIII				
DESCRIPTION				
REAR AXLE ASSEMBLY				
PART NO.	B 3 0 4 5 9 0 1			#.1
SHEET No .....1..... OF .....1.....				A2