



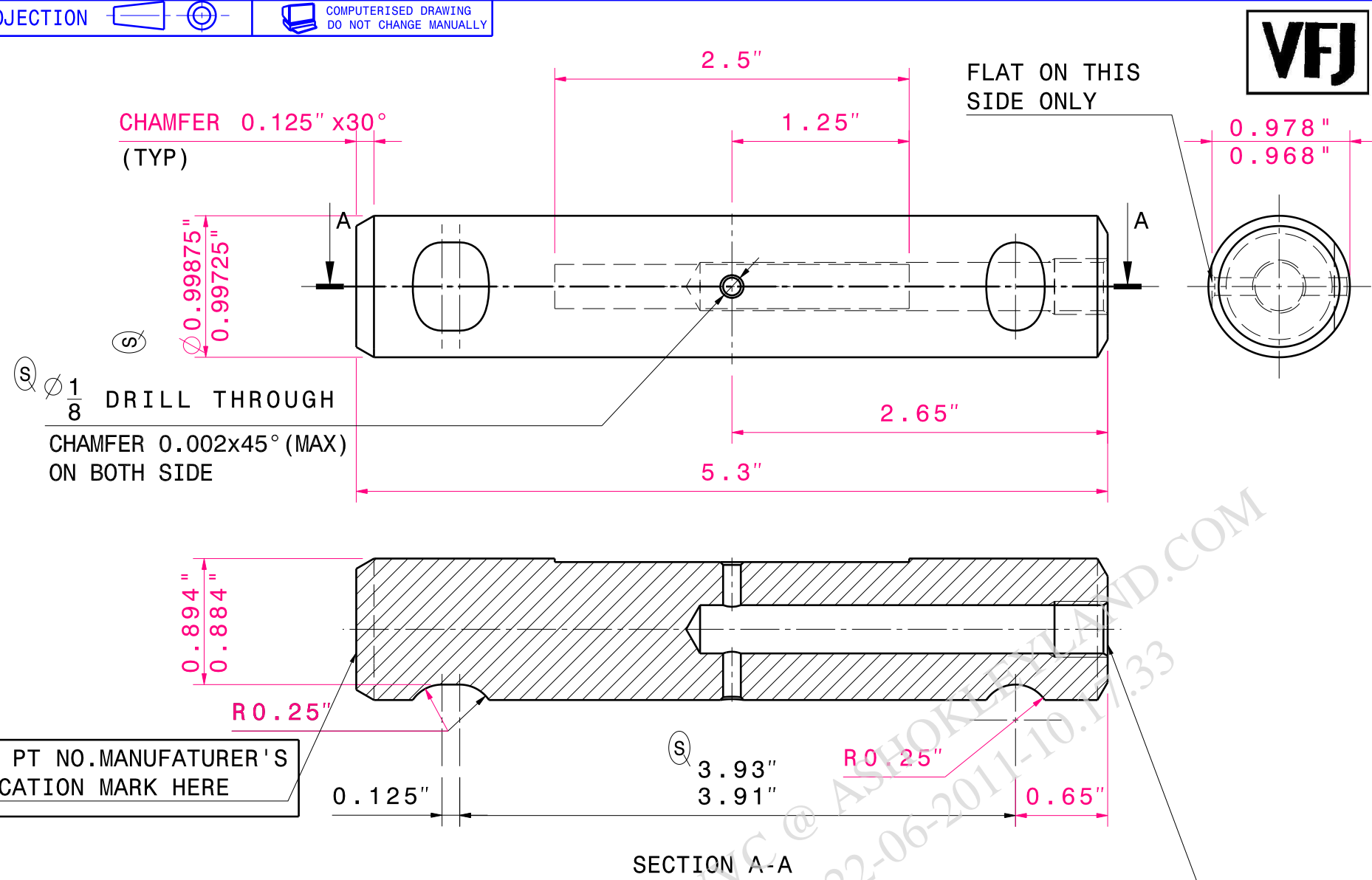
LEYLAND

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ASHOK LEYLAND LTD.
TECHNICAL CENTRE, VELLIVoyalCHAVADI



LEYLAND



Material and Heat treatment

- Steel to DIN17200 CK45 cold drawn bright bar
- Core Hardness: - 210 to 250 BHN
- Induction hardened. Case depth 0.05" to 0.07"
- Surface hardness 55 – 61 HRC
- Surface to be completely free from decarburization
- To be applied with temporary rust preventive oil to IS 1154

DRILL 2.875" DEEP AND
TAP M10x1.0 - 0.375" DEEP
0.030"x30° CHAMFER
BEFORE TAPPING; THREADS
TO MEDIUM CLASS AS PER
IS:4218-1967

NOTE: THROUGH HARDENING AND TEMPERING PROCESS ELIMINATED

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX

AL PLM VAULT
REVISION:#.0 | DATE:10-06-2009 | STATUS:RELEASE
STAGE:III | ER-DIN NO/DATE: ER-DIN-0003185 / 11-06-2009
ALTERED BY:babud.aie | CHECKED:vmg.aie
MED APPROVAL:kanhaiya.alvvc | APPROVED:vmg.aie
DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL /DATE	APPROVED/ DATE	STDS APP/ DATE
D.BABU 05.06.2009	V.MURUGAN 05.06.2009	KANAIYAKUMAR 05.06.2009	V.MURUGAN 05.06.2009	

MATERIAL SEE DRG.

HEAT TREATMENT SEE DRG.

REMARKS
ALL BUS AND TRUCKS MODELS

DESCRIPTION	PART NO.	SHEET NO.
SHACKLE PIN	FF6001101..... OF... 1.....
		A3

SL No	PART NO:	DESCRIPTION	SIZE	MATERIAL	QTY
BILL OF MATERIALS					
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				
METRIC THREADS	METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4218 CLASS 6g EXTERNAL OR 5H INTERNAL				
		SURFACE FINISH AS PER IS:3073(CLA VALUE)	APPEARANCE ITEM	ER-DIN	DATE
			YES NO		
		SHARP EDGES TO BE REMOVED	FINISHED WEIGHT (APPROX):	REF PT NO:	F0977815
		DIMENSIONS ARE IN MM	SUPERSEDES:	S/A PT NO:	
		DO NOT SCALE DRAWING	SCALE	SPEC NO:	
			1:1		