

ASHOK

LEYLAND

ASHOK LEYLAND LTD.  
TECHNICAL CENTRE, VELLIVOLCHAVADI

First Angle Projection

Computerised Drawing  
Do not change manually

90°

0.25 Y

ENLARGED VIEW OF SERRATIONS

12 15 11 14 4

2 x 45°

6.3

3.2

21.8 +0.1 -0.2

22.00 +0.01 -0.10 OPTIONAL

CHAMFER THREAD DOWN TO THREAD CORE DIA

R 1 (MAX)

6 ± 1

90.0° 89.5°

M22X2.5-6g TO IS:4218

3

45°

6.3

3.2

B ± 0.3

A +2 0

L ± 0.5

0.05 Z

0.25 Y

FRONT VIEW

DETAIL X

R 1 +0.5 0

22 +0.01 -0.10

22.55 0 -0.2

KNURL OD

KNURL PITCH 1.4

LEFT VIEW

32 +1.5 0

13.5 0.0 -0.2

10.9

6.3

XXX

STAMP SUPPLIER NAME & GRADE FOR IDENTIFICATION

NOTE:  
PROPERTY CLASS 10.9 TO IS : 1367 - PART - III  
SURFACE: CARBURISED 0.1±0.05MM 350-450 HV-1  
SURFACE PROTECTION: PHOSPHATE TO IS : 1367 - PART - XII  
TO AVOID HYDROGEN EMBRITTLEMENT  
TEMPER 2 HR/190°C  
DIP IN OIL AFTER TEMPERING

S - SAFETY

2

+ - IMPORTANT

-

C - CRITICAL

-

SL NO

PART NO

L

A

B

Wt (Kg)

1

F3569310

A 88 C

A 43 C

23

0.33

2

F3569410

A 98 C

A 38 C

23

0.36

SL No

PART NO:

DESCRIPTION

SIZE

MATERIAL

QTY

UNLESS OTHERWISE SPECIFIED

TOLERANCES

REFER IS:2102 ; MEDIUM FOR MACHINING AND COARSE FOR FABRICATION

SURFACE FINISH AS PER IS:3073(CLA VALUE)

APPEARANCE ITEM

YES

NO

7793

18.03.1995

FINISHED WEIGHT (APPROX):

REFER TABLE

REF PT NO:

F3580311 F3580411

SHARP EDGES TO BE REMOVED

DIMENSIONS ARE IN MM

DO NOT SCALE DRAWING

SUPERSEDES:

SCALE

1:1

SPEC NO:

ALFA,BA

ASHOK

LEYLAND

ASHOK LEYLAND LTD.  
TECHNICAL CENTRE, VELLIVOLCHAVADI

ALTERATIONS

ER-DIN DATE

GRADE

SUFFIX

DIMN 83 WAS 88 AND 38 WAS 43 FOR F3569310;  
DIMN 98 WAS 103 AND 38 WAS 43 FOR F3569410.

7858  
30.12.95

1

A

RVN/RRGM

KEY CHARACTERISTICS ADDED.

8529  
28.03.01

1

B

KSP/MMN

DIMN 88 WAS 83 AND 43 WAS 38 FOR F3569310;  
NOTE FOR IDENTIFICATION ADDED.  
WEIGHTS UPDATED.

18043  
07.10.13

2

C

BDN/KRK/VRJ

AL PLM VAULT

REVISION : C

DATE : 1/10/2013

STATUS : RELEASE

STAGE : III

ER-DIN NO : ER-DIN-0018043

DATE : 8/10/2013

ALTERED BY : Dhamodharan.B

CHECKED BY : RAMAKRISHNAN.K2

MED APPROVAL : SIVAKUMAR.GK

APPROVED BY : jensi.alvvc

DIGITALLY SIGNED . PHYSICAL SIGNATURE NOT REQUIRED

DRAWN/ DATE

CHECKED/ DATE

MED APPROVAL /DATE

APPROVED/ DATE

STDS APP/ DATE

RVN

RRGM

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RRGM

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21.03.1995

28.03.1995

28.03.1995

MATERIAL

SEE NOTE

HEAT TREATMENT

SEE NOTE

REMARKS

FOR SPIGOTTED WHEELS

DESCRIPTION

WHEEL BOLT-M22X2.5

PART NO.

F3569310

C

SHEET NO: 1 OF 1

A3