

This design is strictly private and confidential. It is the exclusive property of Ashok Leyland Ltd. and must not be used, copied or reproduced in part or whole without the company's written permission.

Q-CRITICAL Q-SAFETY Q-IMPORTANT. THIS DRG. CONTAINS SAFETY CHARACTERISTICS UNLESS OTHERWISE SPECIFIED

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

ASHOK LEYLAND

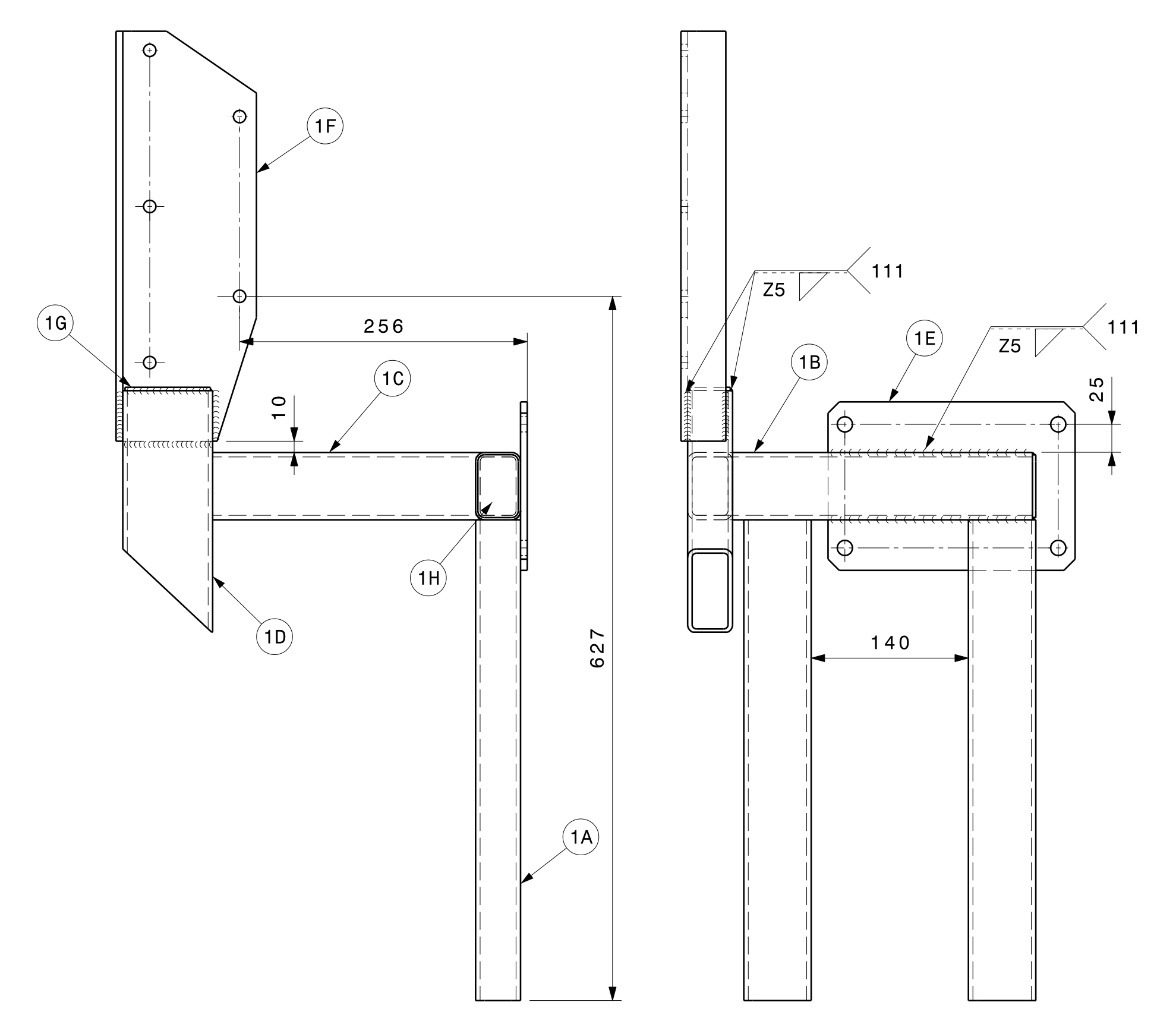
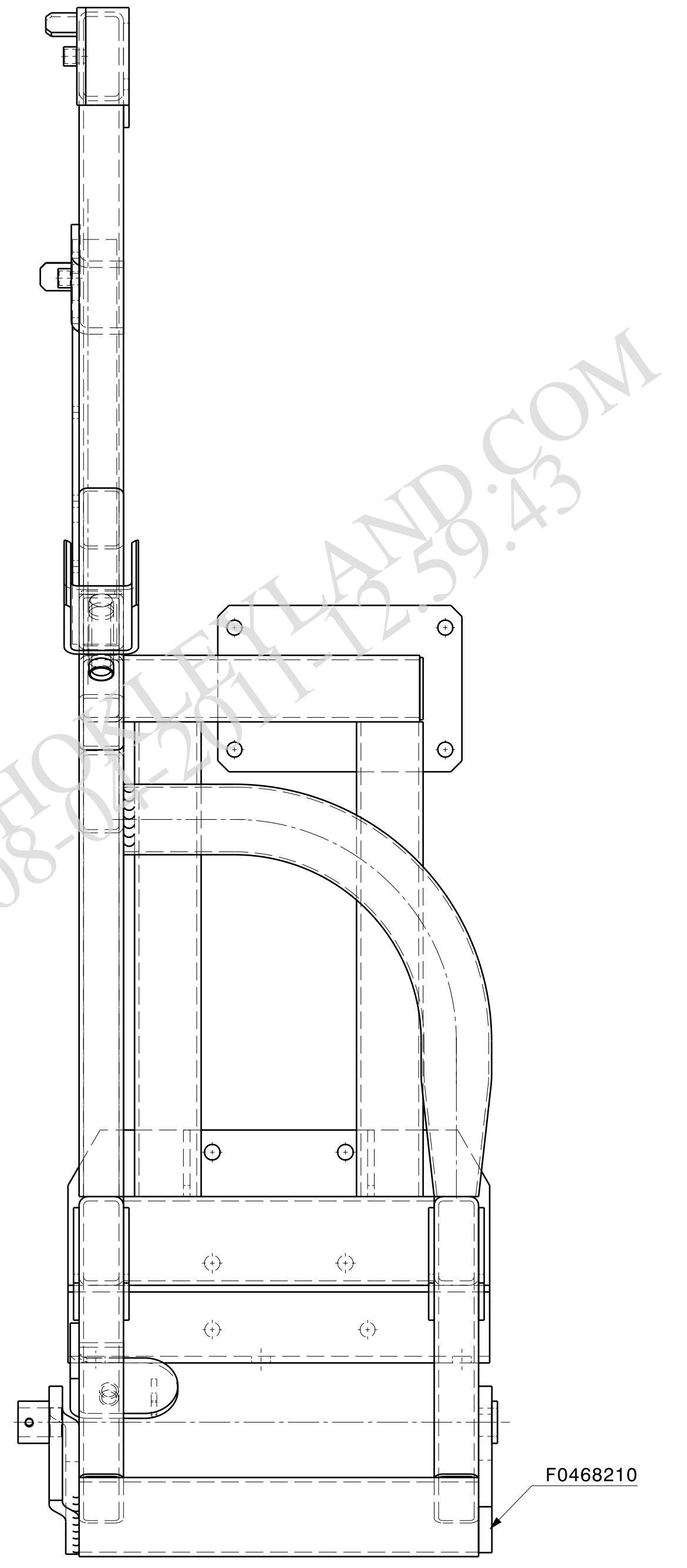
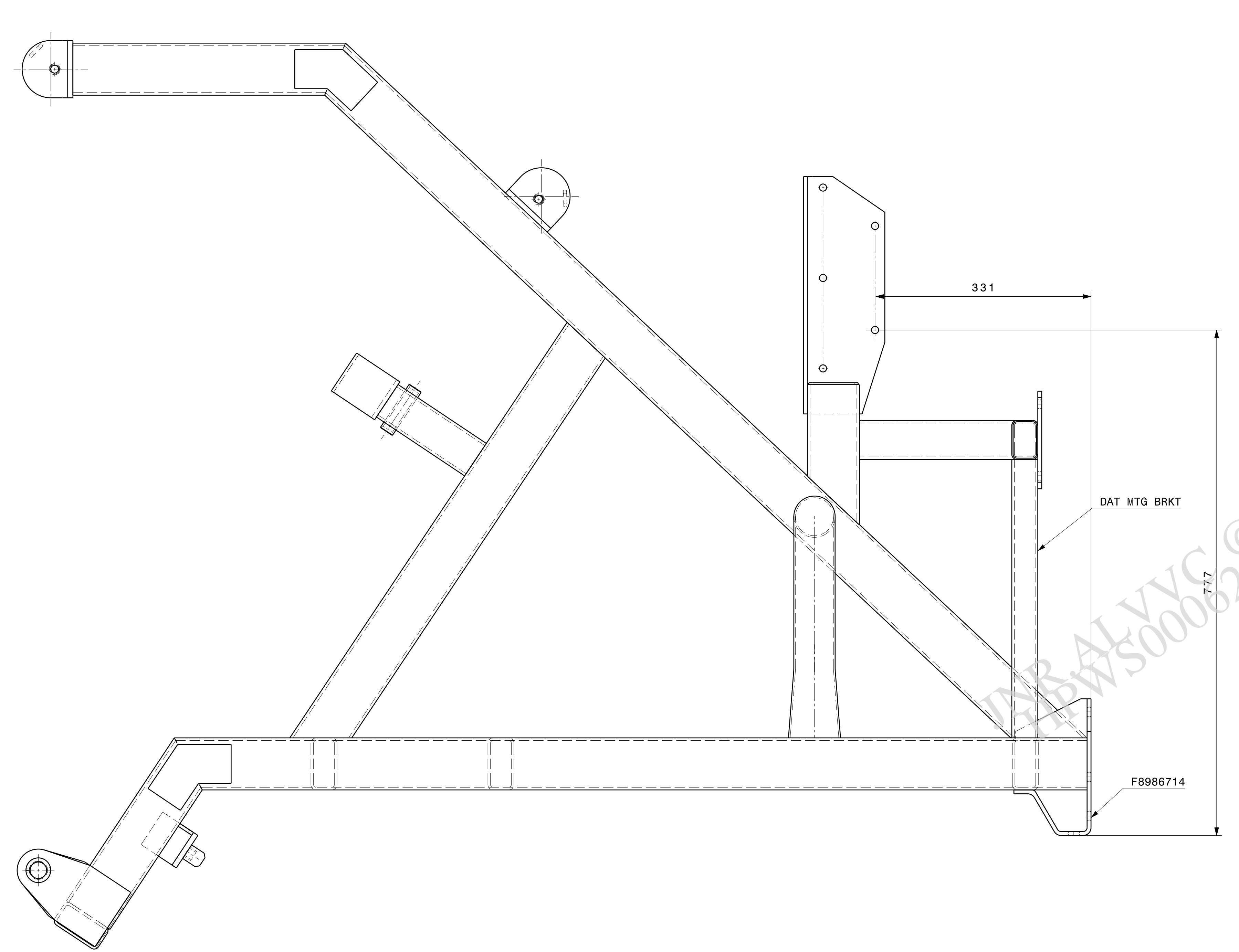
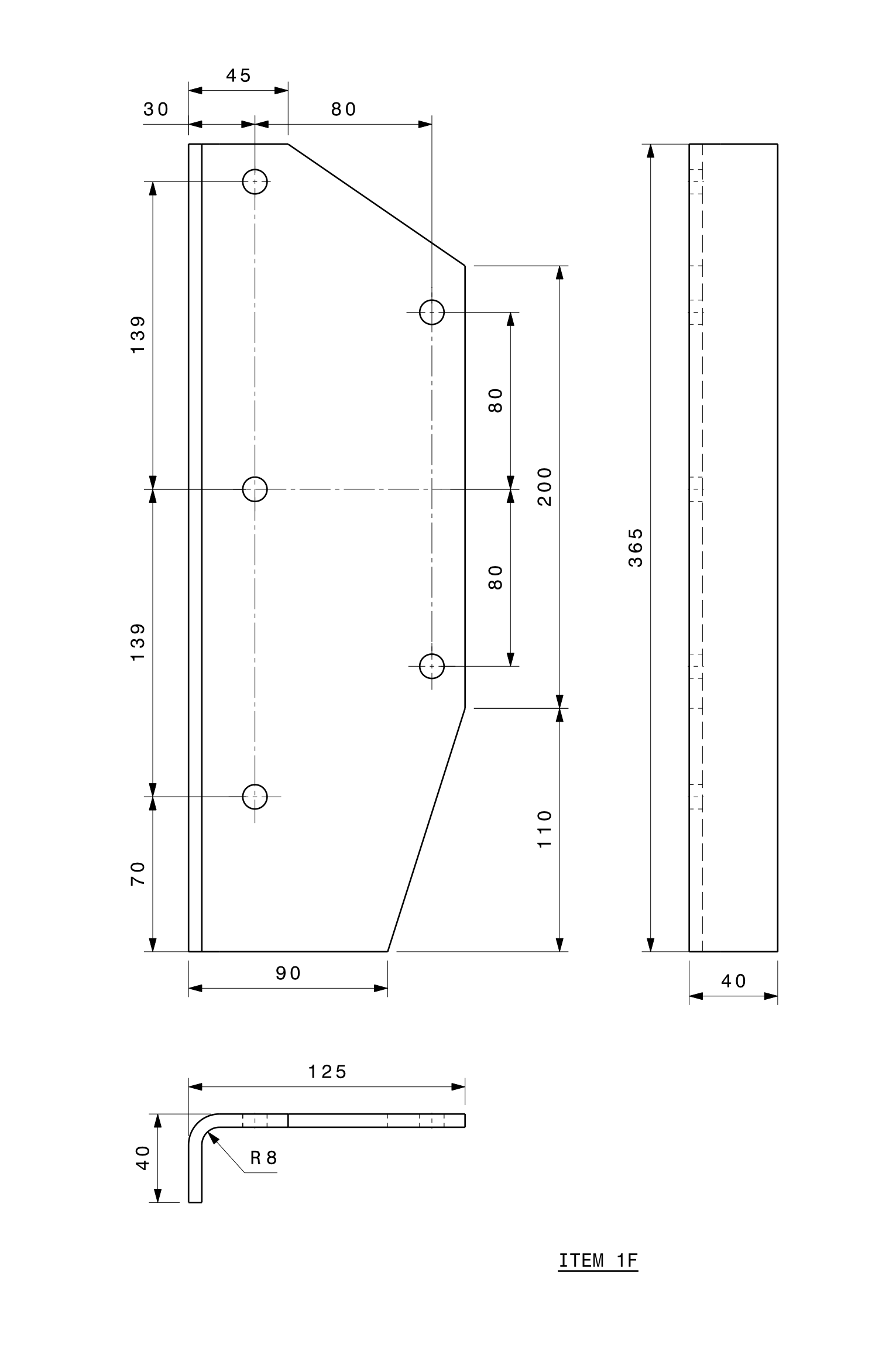
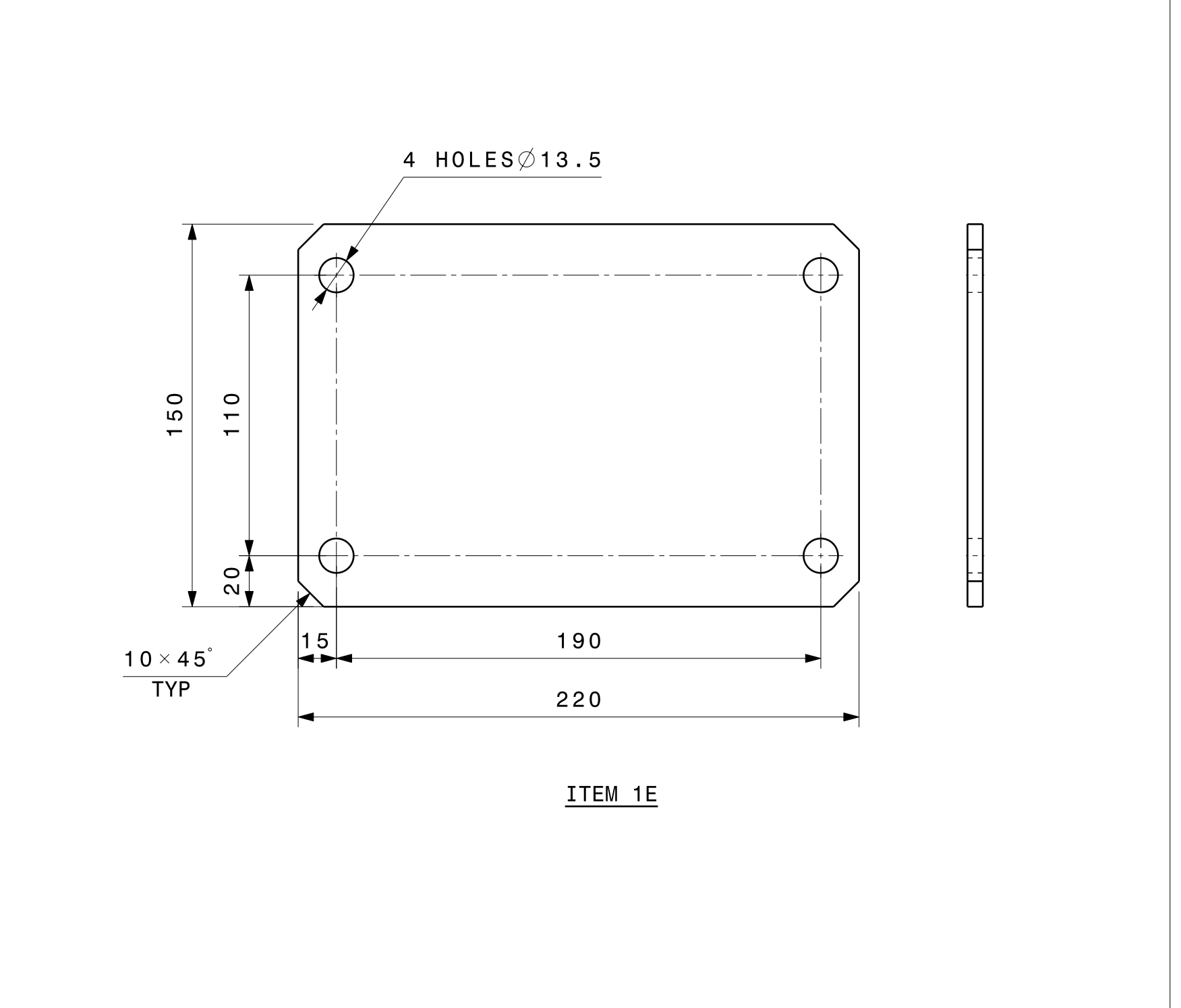
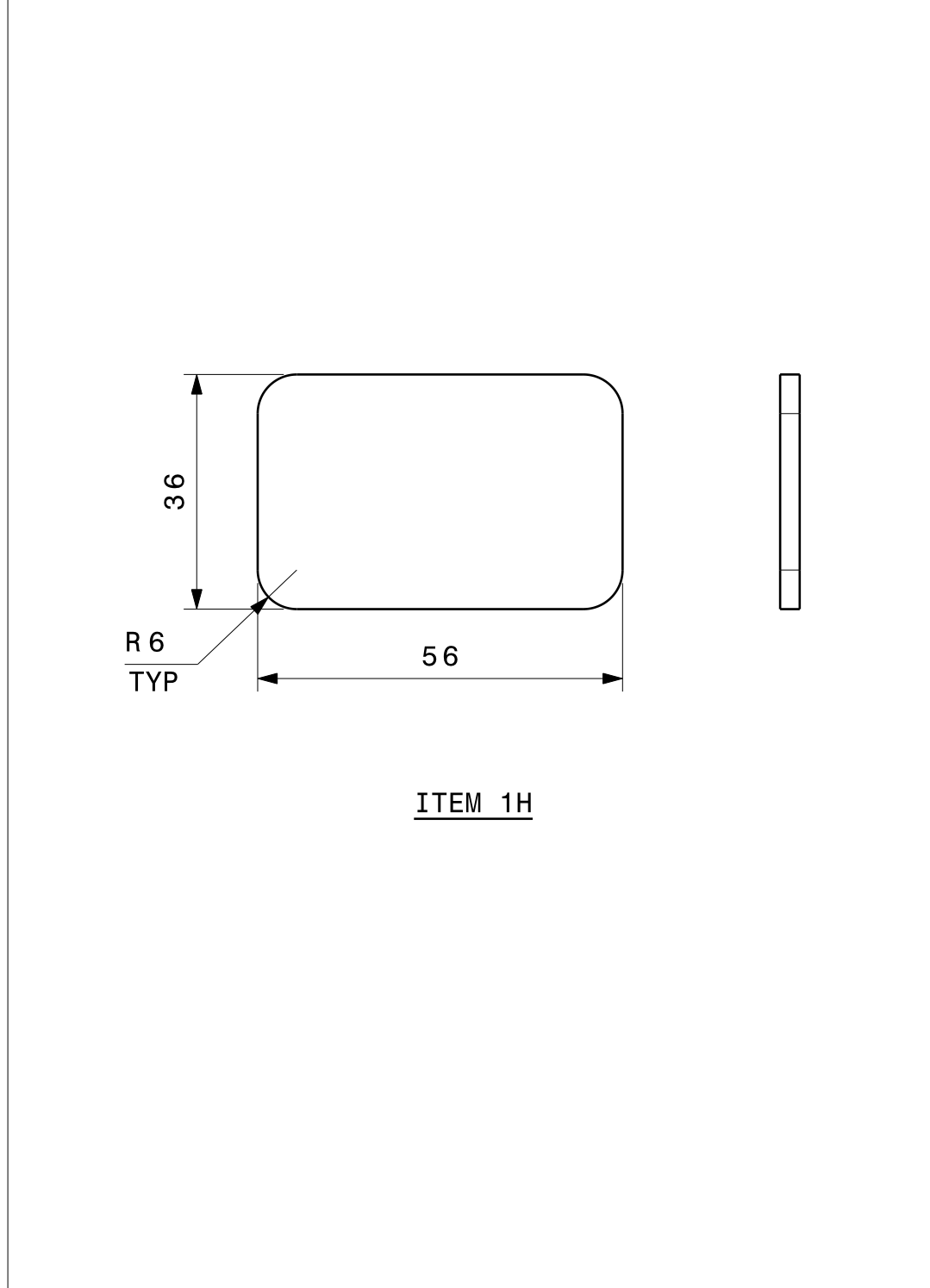
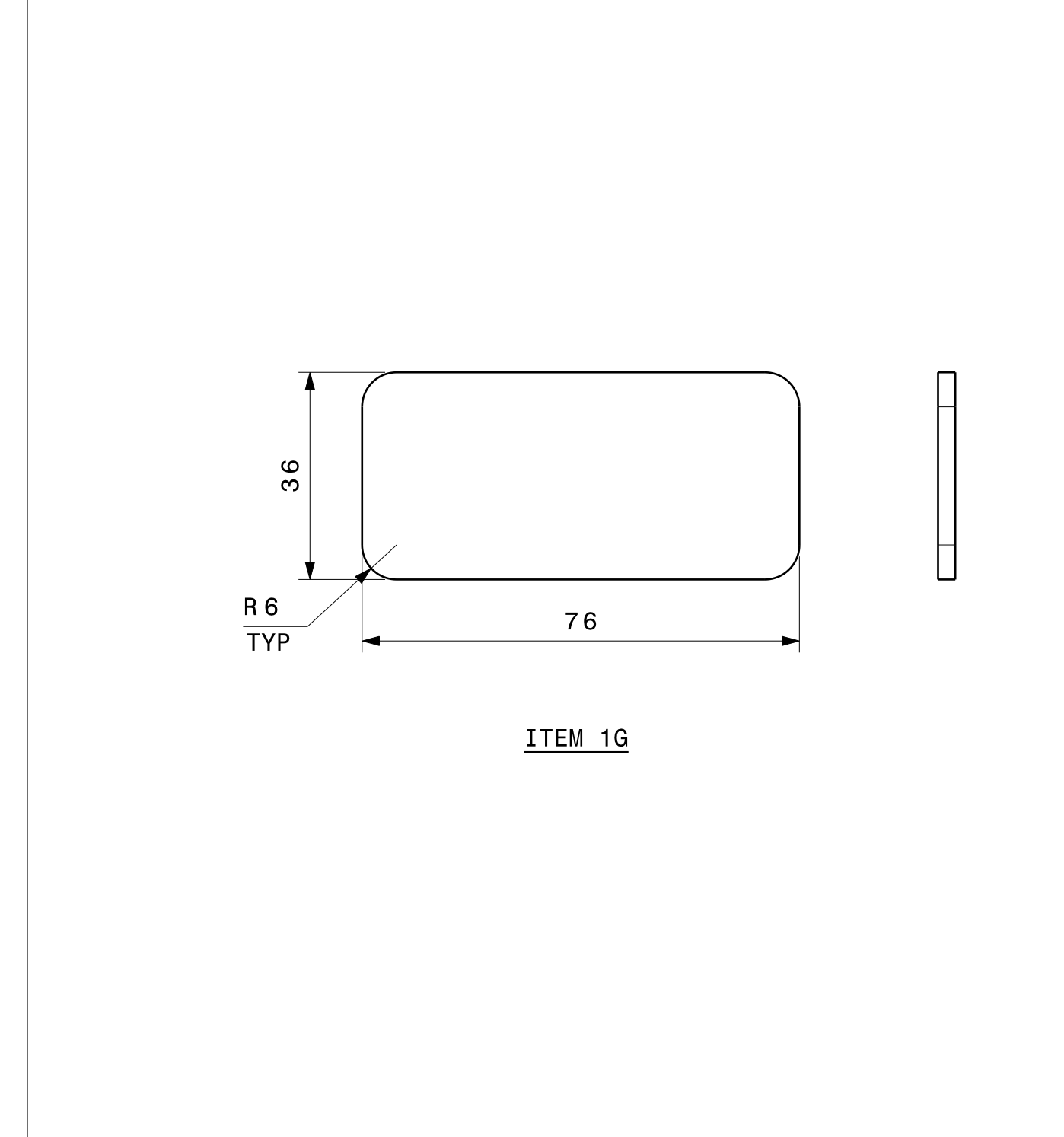
SURFACE FINISH AS PER IS:3073 (CLA VALUE)

METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE CURRENT IS:4216 CLASS 6g EXTERNAL OR 6h INTERNAL.

SHARP EDGES TO BE REMOVED DIMENSIONS ARE IN MM DO NOT SCALE DRAWING

SPECIAL INSTRUCTIONS/NOTE:

ALL JOINTS TO BE CONTINUOUS WELDED
 MAX PERMISSIBLE BOW & TWIST TO BE 3 mm
 WELDING SYMBOL AS PER IS 813
 ELECTRODES EQUIVALENT TO AWS E6012 OR E6013
 SCAMIC GREEN PAINT TO BE APPLIED ,AS PER AL RECOMMENDATION INLINE WITH DRG TO PTNO: X9715000



SL NO	PART NO	DESCRIPTION	MATERIAL	QTY
8	ITEM 1H	CLOSURE PLATE	STEEL PLATE 3THK TO IS 1079 Gr 'Q'	1
7	ITEM 1G	CLOSURE PLATE	STEEL PLATE 3THK TO IS 1079 Gr 'Q'	1
6	ITEM 1F	L BRACKET	STEEL PLATE 6THK TO IS 2062 Gr 'B'	1
5	ITEM 1E	PLATE	STEEL PLATE 6THK TO IS 2062 Gr 'B'	1
4	ITEM 1D	TUBE	80X40X4THK 200 LONG HFS TUBE IS:4923 Gr YST 240	1
3	ITEM 1C	TUBE	60X40X4THK 274 LONG HFS TUBE IS:4923 Gr YST 240	1
2	ITEM 1B	TUBE	60X40X4THK 307 LONG HFS TUBE IS:4923 Gr YST 240	1
1	ITEM 1A	TUBE	60X40X4THK 427 LONG HFS TUBE IS:4923 Gr YST 240	2

NOTE:
 THIS PART TO BE MADE FROM DRG B0993602 WITH FOLLOWING CHANGES

- ITEM NO 6 DELETED
- ITEM NO 7 DELETED
- PIVOT BRACKET X0439110 TO BE REMOVED AND F0468210 TO BE ADDED
- IN PLACE OF X0450010 PART NO F8986714 TO BE USED
- FOOT STEP SWC X0485010 DELETED.
- DAT MTG BRKT ADDED.

BILL OF MATERIALS

APPEARANCE	ITEM	ER-DIN	DATE
YES	NO	ER-DIN-XXXXXXX	XX.XX.XXXX
FINISHED WEIGHT (APPROX)	REF.PT.NO.		
XXX.XXX Kgs	S/A.PT.NO.		
SCALE	SUPERSEDES		
1:4	SPEC.NO.		

ALTERATIONS		PLANNED DATE	ISSUED BY
DRG.REDRAWN	SS/SV	07/08/09	#.1
ITEM 1A- DIM 427 WAS 340 AND		12	#.2
ITEM 1C- DIM 274 WAS 284 ADDED	SG/SV	12 09	
FOR STAG E III RELEASE	SS/SV	09/12/10	#.3

REVISION	DATE	STATUS
REVISION : R3	DATE : 10/12/2010	STATUS : RELEASE
STAGE : III	ER-DIN NO : ER-DIN-0006051	DATE : 10/12/2010
ALTERED BY : jnr.alvvc	CHECKED BY : sundar.alvvc	
MED APPROVAL : fanish.alvvc	APPROVED BY : sngarajan.alvvc	

DATE	CHECKED/DATE	MED APPROVAL/DATE	APPROVED/DATE	STDS APP/DATE
SS 19.06.08	EA 19.06.08		SN 19.06.08	

AL PLM VAULT

DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED

REMARKS
FOR STALLION MK IV-BS3
DESCRIPTION
S/A FRAME SWC
PART NO. B 0 9 0 9 1 0 2 #.3
SHEET NO 1 OF 1