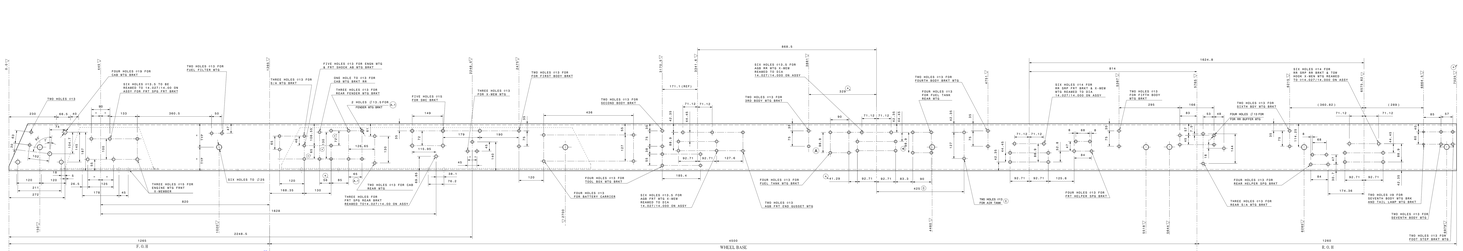
ASHOK LEYLAND

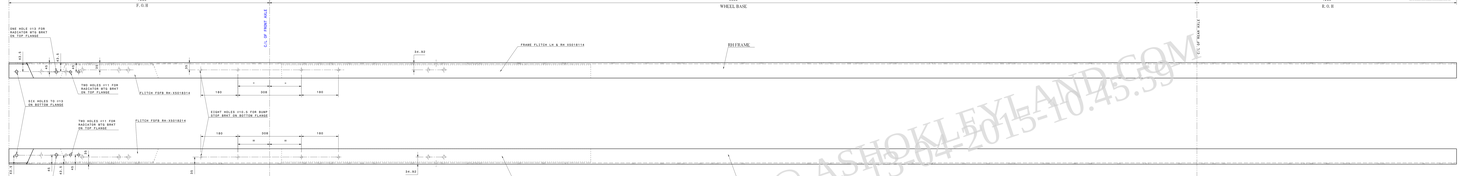
FIRST ANGLE PROJECTION

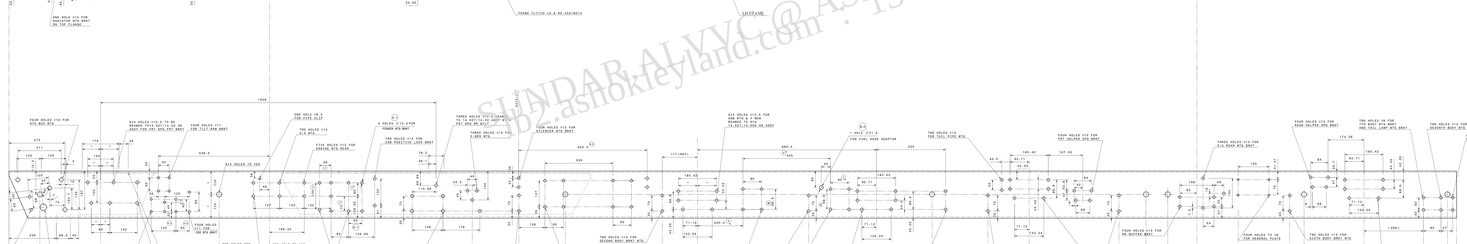
COMPUTERIZED DRAWING
DO NOT CHANGE MANUALLY

This drawing is property of ASHOK LEYLAND LTD. It is the confidential information of ASHOK LEYLAND LTD. Recipient shall not use it for any purpose other than that for which it is expressly provided by ASHOK LEYLAND LTD. Recipient shall not reproduce, copy, or disclose to others in whole or in part without the express written consent of ASHOK LEYLAND LTD.

ASHOK LEYLAND LTD.
TECHNICAL CENTRE, - HOSUR (INDIA)







SUNDAR ALLYC @ ASHOKLEYLAND.COM
ID: ashoklayland.com : 13-04-2015-10:45:59

FRAME PRESSING DETAIL:
FRAME PRESSING RH F8510213
FRAME PRESSING LH F8510313

ALTERATIONS

1) IN RH & LH FRAME PILOT HOLES DELETED AT DATUM 5644 & 6879 AND PILOT HOLES ADDED AT DATUM 4400 & 5974 2) IN RH & LH FRAME FUEL TANK MTG HOLE DIMENSION 96.9 WAS 68.9 DIN: 023215 AA/DN	06/05/06	A
2 HOLES (13.5 ADDED FOR FENDER MTG BRKT. LOCATION 328 WS ADDED FOR FENDER MTG BRKT. JR/EA	23/10/06	A-1
IN RH FRAME - 4 HOLES (11 ADDED FOR FUEL HOSE IN RH FRAME - SLINKER MTG BRKT HOLE DIMENSION 62.5 WAS 597 SS/SV	06.07.09	A-2
IN RH FOR FOR FUEL HOSE, 1 HOLE (27.5 WAS 119 SN/JRR	17.02.11	B-0
IN LH FBW, 113 TWO HOLES ADDED FOR AIR TANK. RK/SSV	25.01.12	C

SL PLM S MALLY
REVISION : C DATE : 25/1/2012 STATUS : RELEASE
STAGE : III EB-DIN NO : EB-DIN-000050 DATE : 31/1/2012
ALTERED BY : sundar.ptv CHECKED BY : jpr.ptv
MED APPROVAL : vkm.ptv APPROVED BY : rangarajan.ptv

DIGITALLY SIGNED , PHYSICAL SIGNATURE NOT REQUIRED

DRAWN DATE	CHECKED DATE	MED APPROVAL DATE	APPROVED DATE	STDS APP DATE
ASM 15/04/02	TN 15/04/02		MR 15/04/02	

MATERIAL
REF FRAME PRESSING DRG

HEAT TREATMENT
——

REMARKS FOR STALLION MK IV

DESCRIPTION FRAME DRILLING

APPEARANCE ITEM	ER-DIN	DATE
NIL	ER-DIN-003048	30/03/06
FINISHED WEIGHT(APPROX)	REF.PT.NO.	
XXX.XXX Kgs	D.G.PT.NO.	
	SUPERSEDES	
	SPEC.NO.	MAF 147

BILL OF MATERIALS

SCALE 1:5

PART NO. LH X 5 0 8 7 3 1 3 3 / RH X 5 0 8 7 2 1 3 3 — C

SHEET NO 1 OF 1 — EXP

G -CRITICAL S -SAFETY I -IMPORTANT. THIS DRG.CONTAINS SAFETY CHARACTERISTICS

UNLESS OTHERWISE SPECIFIED

TOLERANCES	REFER IS-2102 : MEDIUM FOR MACHCING AND COARSE FOR FABRICATION
SURFACE PROTECTION	FABRICATION COMPONENTS TO BE DEGREASED, DESCALED, APPLY ZINC PHOSPHATE, APPLY STOVE PRIMER COATING (ALKYD BASED) TO 25 MICRONS, APPLY STOVE ENAMEL TO 25 MICRONS AS PER ASTM B117 CORROSION PROTECTION CHAMBER (>1 YRS) NO ALLOTTERING TO ALLOWED.
SURFACE FINISH	SURFACE FINISH AS PER IS-3073(SLR VALUE) METRIC SCREW THREADS SHALL CONFORM TO THE LIMITS AND TOLERANCES SPECIFIED IN THE SUPPORT IS-1878 CLASS 6g EXTERNAL OR 7H INTERNAL.

SHARP EDGES TO BE REMOVED
DIMENSIONS AND IS NOT TO BE SCALE DRAWING
DO NOT CHANGE MANUALLY

SPECIAL INSTRUCTIONS:NOTE:

1) DIMENSIONS ARE SHOWN PARRALLEL TO THE DATUM LINE TO WHICH THEY PERTAIN
2) DIMENSIONS WITH ARROWHEADS DO NOT PERTAIN TO DATUM LINE
3) FOR LOCATING DIMENSIONS UNLESS OTHERWISE STATED
   UPTO 500 :0.3, 500 TO 1000 :0.5, 1000 TO 2000 :0.8,
   ADDITIONAL :0.1 FOR EVERY 600 OVER 2000
4) ALLOWABLE VARIATIONS TO DIMENSIONS UNLESS OTHERWISE STATED
   PUNCHED HOLES UPTO AND INCLUDING :10.7 PUNCHED HOLES :11.7 & UPWARDS +0.5
5) FORM AND FINISH TOLERANCING TO BS308 PART3

PAINTING DETAILS:
SURFACE PROTECTION:
CLASS 'C' AS PER ALS.268.03
COLOR:SCAMIC GREEN; SHADE NO.294 AS PER IS:5