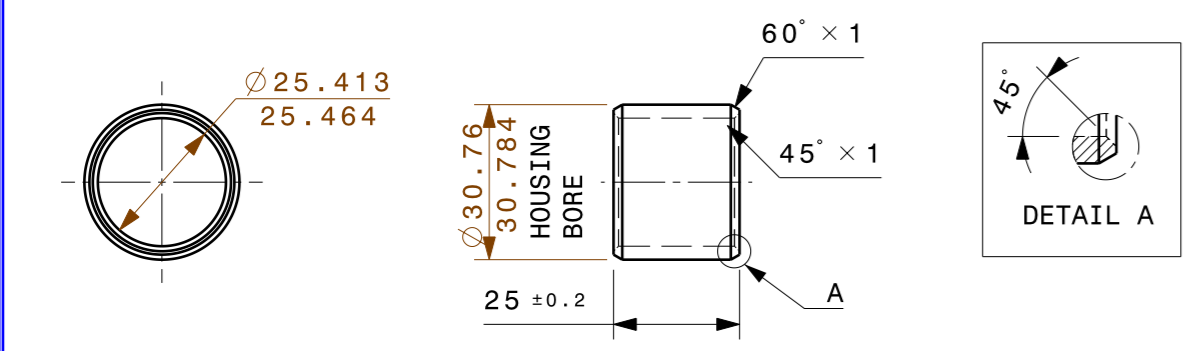
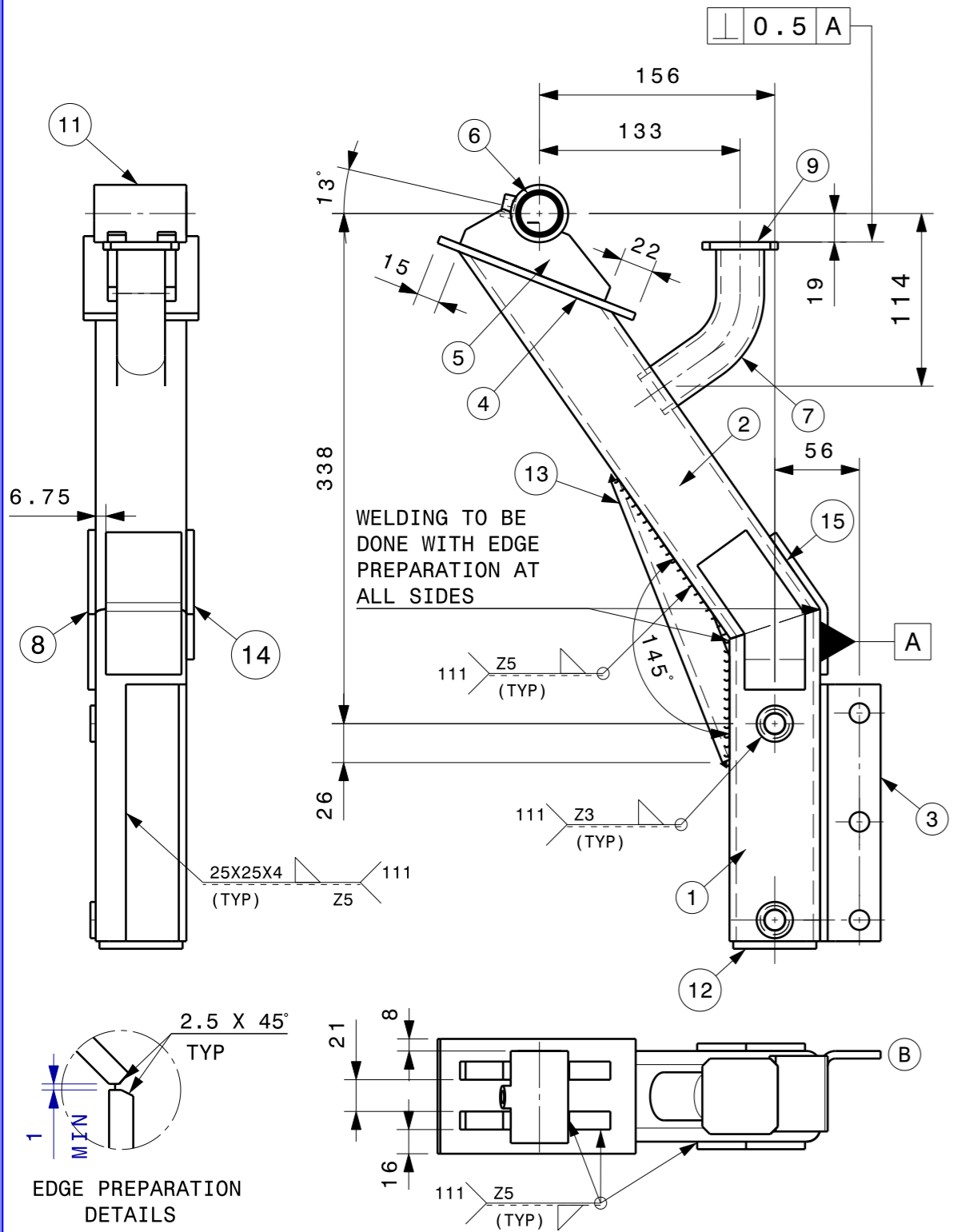


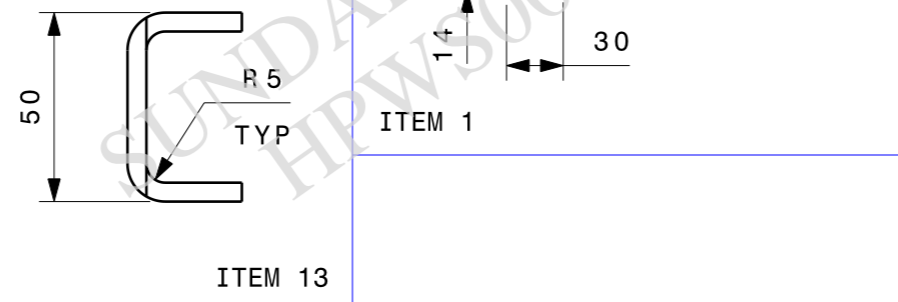
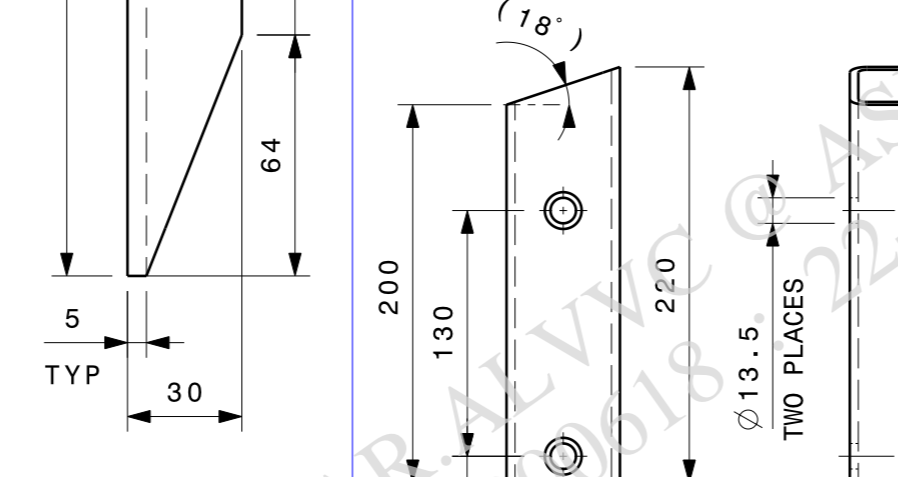
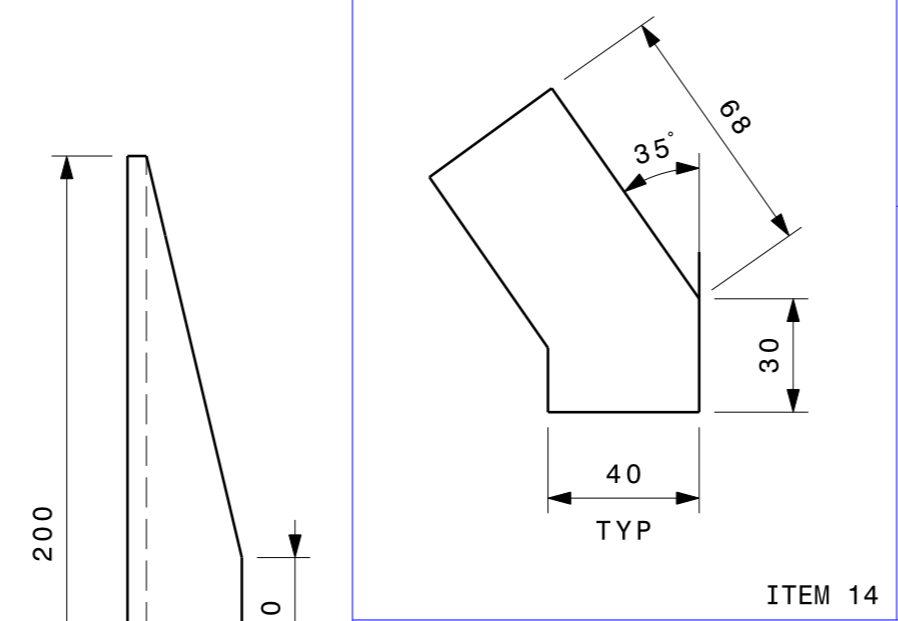
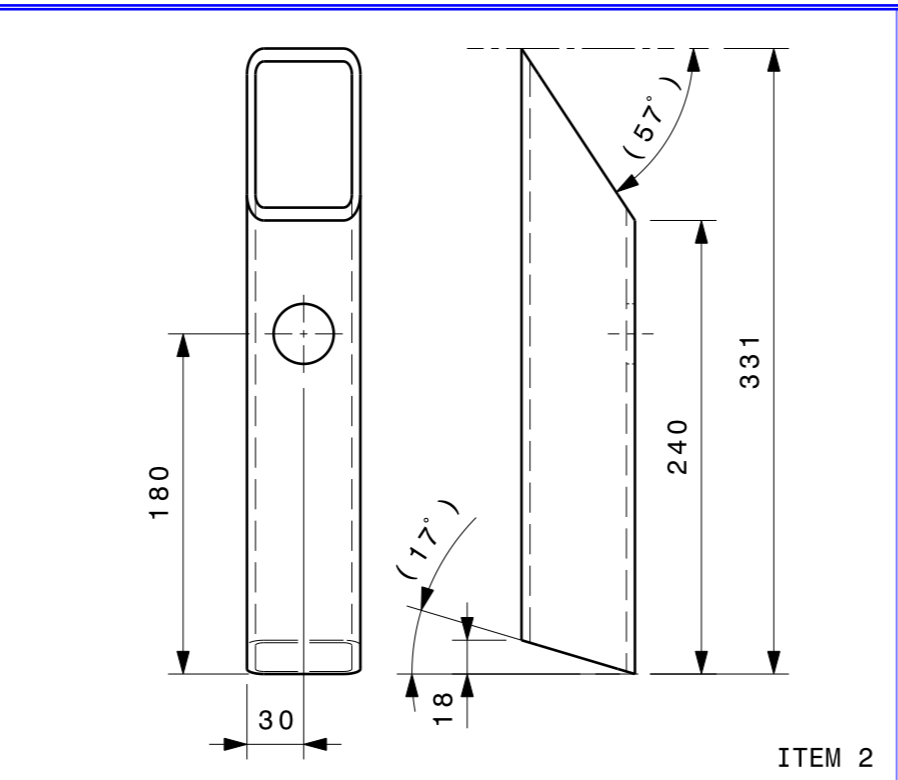


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ASHOK LEYLAND LTD. TECHNICAL CENTRE VELLIVOLCHAVADI

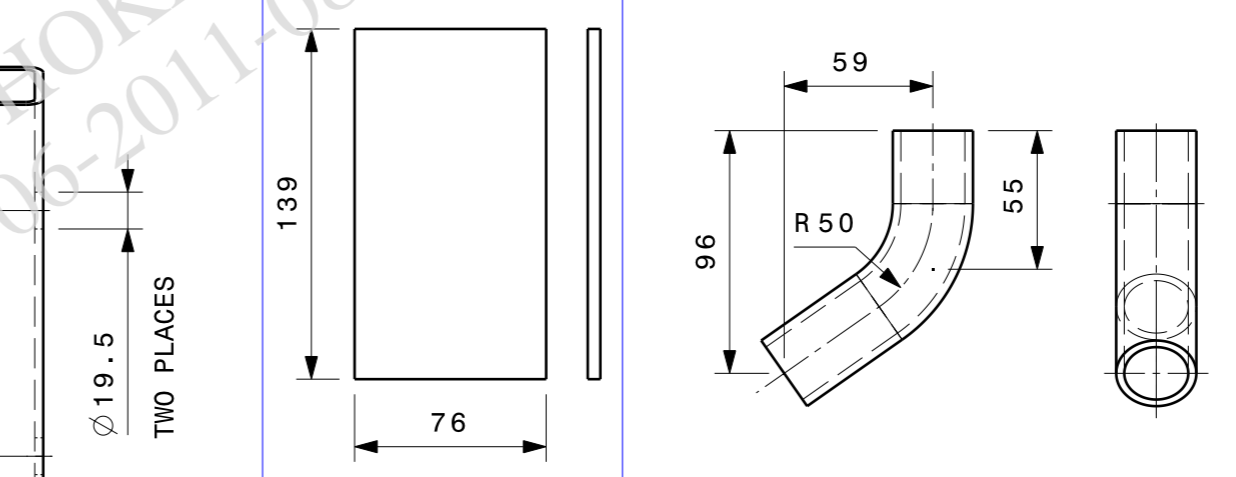
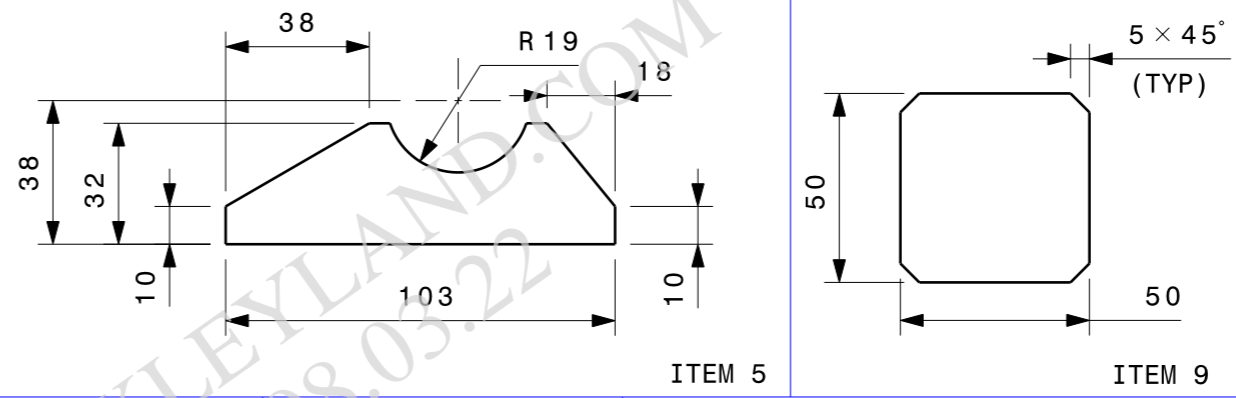
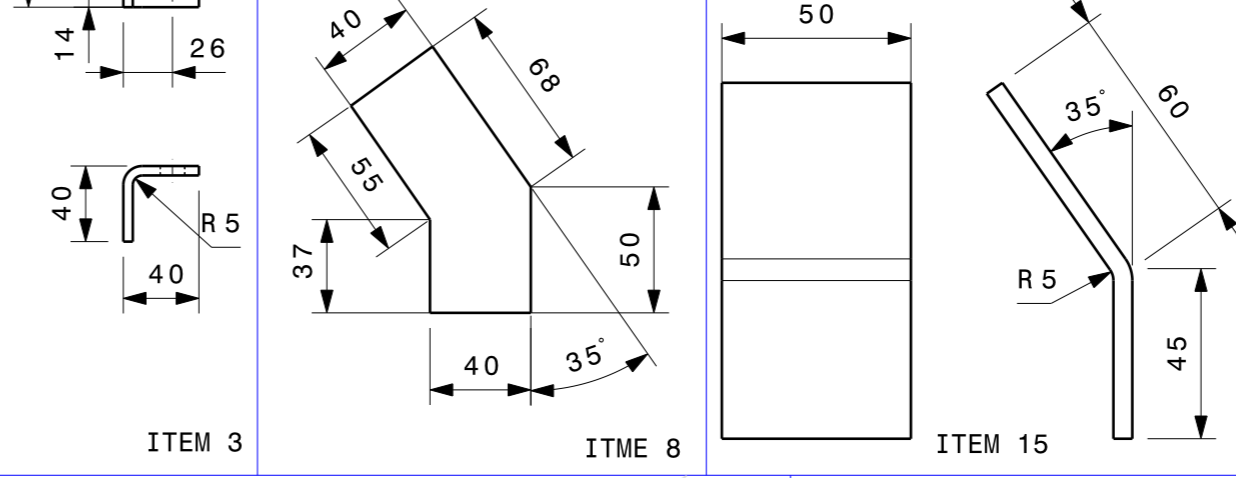
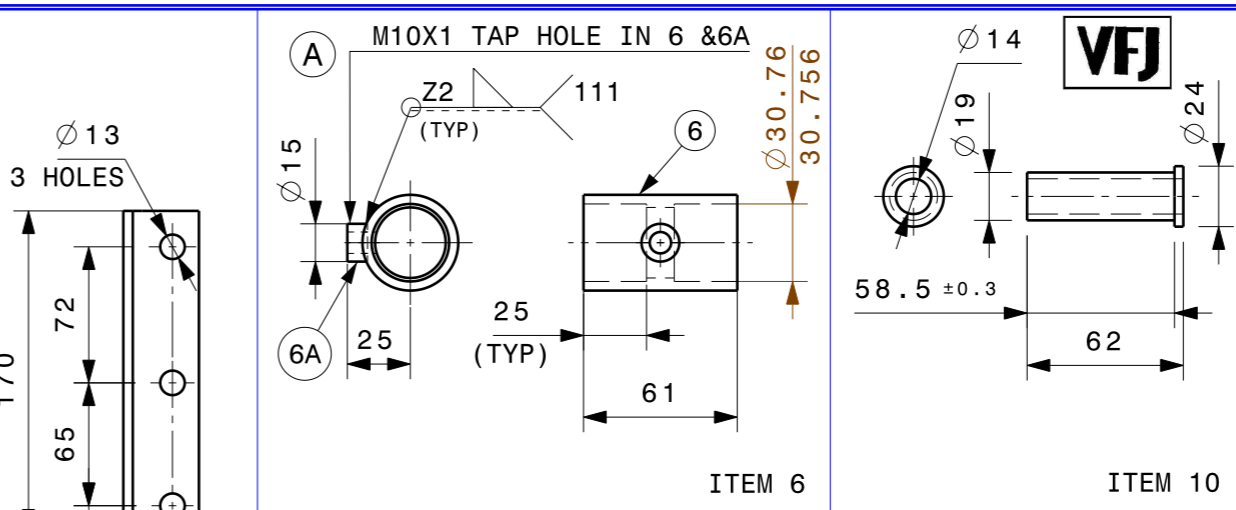


NOTE:
TO BE MACHINED ALL OVER THE SURFACE
SURFACE ROUGHNESS 3.2 MICRONS
NOT TO SCALE



BRACKET CAB MOUNTING REAR LH - B0122906 - DRAWN
BRACKET CAB MOUNTING REAR RH - B0122907 - MIRROR IMAGE

NOTE:
DESCALE DERUST DEGREASE APPLY ZINC PHOSPHATE APPLY EPOXY PRIMER APPLY SCAMIC GREEN ENAMEL TO CONFORM TO SHADE NO 294 IS:5 TO MEET 300 HRS SALT SPRAY LIFE WILL TESTED AS PER ASTM B117 UNDER PELLICULAR CORROSION ≤2MM NO BLASTERING IS ALLOWED



SL No	PART NO:	MATERIAL DESCRIPTION	QTY
16	ITEM15	PLATE 5 THICK IS:2062 Gr 'A'	1
15	ITEM14	PLATE 5 THICK IS:2062 Gr 'A'	1
14	ITEM13	PLATE 5 THICK IS:2062 Gr 'A'	1
13	ITEM12	PLATE 55 X 55 X 5 THICK IS:2062 Gr 'A'	1
12	ITEM11	AB1 TO BS 1400	2
11	ITEM10	EN 32B/080M15/EN3B 070M20 OF BS 970	2
10	ITEM 9	PLATE 5 THICK IS:2062 Gr 'A'	1
9	ITEM 8	PLATE 5 THICK IS:2062 Gr 'A'	1
8	ITEM 7	ERW 1 TUBE Ø31.8 3.2 THICK TO IS 3074	1
7	ITEM 6A	EN 32B/080M15/EN3B 070M20 OF BS 970	1
6	ITEM 6	TUBE OD 38 4THICK ERW 1 TO IS 3074	1
5	ITEM 5	PLATE 12 THICK IS:2062 Gr 'A'	2
4	ITEM 4	PLATE 5 THICK IS:2062 Gr 'A'	1
3	ITEM 3	PLATE 5 THICK IS:2062 Gr 'B'	1
2	ITEM 2	60X60X4 SQUARE TUBE IS 4923 Gr YST 240	1
1	ITEM 1	60X60X4 SQUARE TUBE IS 4923 Gr YST 240	1

BILL OF MATERIALS			
APPEARANCE	ITEM	ER-DIN	DATE
YES	NO	ER-DIN-023205	05/05/06
FINISHED WEIGHT (APPROX)		REF PART NO:	-----
Kgs		S/A PART NO:	-----
SCALE		SUPERSEDES	-----
1:4		SPEC NO:	-----

ALTERATIONS	ER-DIN DATE	GRADE	SUFFIX
M10X1 TAP HOLE WAS M8X1 DIN: 023748 RP/EA	28 08 06	A	SN 28/ 08
-ITEM 1&2: SQ.TUBE SIZE 63.5X63.5X4.5THK CHANGED TO 60X60X4THK -ITEM 13,14&15 ADDED	14 06 07	A.1	M.R 14. 06. 07
ER-DIN-0000218 ANAND			
DIMENSION 8 DELETED ITEM 3 MTG FACE INLINE WITH ITEM 1 MTG FACE	23 07 09	B	RDN 24/ 07/ 09

REVISION	DATE	STATUS
AL PLM VAULT	6-8-2009	RELEASE
STAGE:III	ER-DIN NO/DATE: ER-DIN-0003572 / 7-8-2009	
ALTERED BY:sundar.alvvc CHECKED:venkateshs.alvvc MED APPROVAL:--NA-- APPROVED:snagarajan.alvvc DIGITALLY SIGNED. PHYSICAL SIGNATURE NOT REQUIRED		

DRAWN/ DATE	CHECKED/ DATE	MED APPROVAL/ DATE	APPROVED/ DATE	STDS APP/ DATE
AMOL 03/05/06	MRK 03/05/06	SURESH 12/05/06	MRK 08/05/06	

MATERIAL	REMARKS
-----	FOR HMV 6X6 J
HEAT TREATMENT	DESCRIPTION
-----	BRACKET CAB MTG REAR LH

PART NO.	SHEET No	OF	A2
B 0 1 2 2 9 0 6 B	1	1	

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:**
- GENERAL TOLERANCE TO BE ±0.5 MM.
 - TOLERANCE ON HOLE PITCHES & SIZES TO BE ±0.25MM.
 - TOLERANCE ON OVERALL DIMENSIONS TO BE ±1MM.
 - WELDING TO CONFORM TO ALS.276.02.
 - BEND LINE TO BE ⊥ TO GRAIN FLOW DIRECTION.