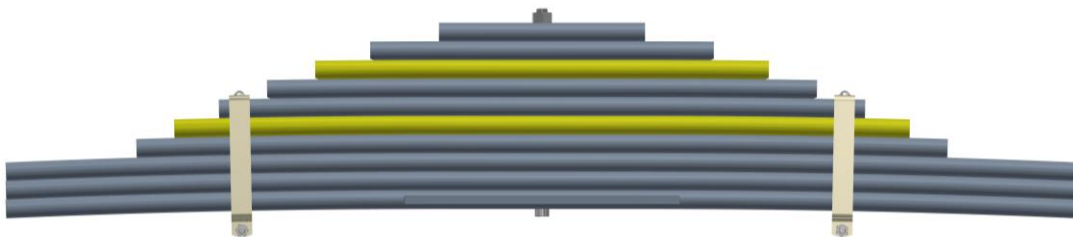


JAMNA AUTO INDUSTRIES LIMITED

Owner's Manual

**Retro fitment kit for MBP 38Ton
Conventional Bogie Spring
assembly.**

PART No: FTW00199



Works :-

Jamna Auto Industries Limited
Plot No.22~25, Sengundram Village
Maraimalai Nagar Industrial Complex,
Melrosapuram, Singaperumal Koil Post,
Pin – 603 204.

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LEAF SPRING IDENTIFICATION: JAMNA AUTO leaf spring assembly & Retro fitment kit are identified by a JAI Logo, Part no stenciled on tension side of leaf spring.

Pre-Installation Notes:

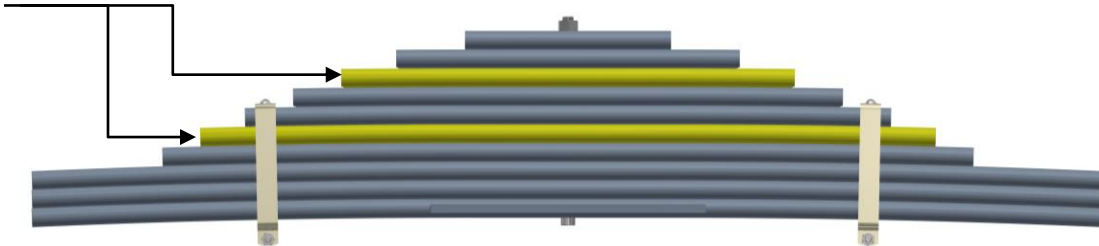
1. Suspension is designed to operate within specific parameters. Operating the suspension outside the design parameters may result in improper performance.
2. Improper locating of leaves on a spring assy. can affect the supporting component. The installer is responsible for correct location.
3. Welding and hammering are not permitted on the Leaves.
4. Use fasteners (i.e. Center Bolt, Clamp Bolt, Clamps) as mentioned in the field kit.
5. Ensure that all fasteners including center bolt, U Bolt, clamp bolt are tightened to the proper torque values.

**Field Kit Specification Chart: -
(for OEM Part No.: FTW00199)**

SECTION	90 x 27 (T/2)
MATERIAL GRADE	SUP 11A
LEAF LENGTH	300mm
PAINTING	To Withstand 300Hrs SSR

Before Retro-fitment

Leaf to be removed
5th & 8th



Configuration & Work Instruction:

Scope: To remove 2 leaves in MBP-38Ton Bogie spring & Add two Bottom pack plate on OEM Part No.: FTW00199.

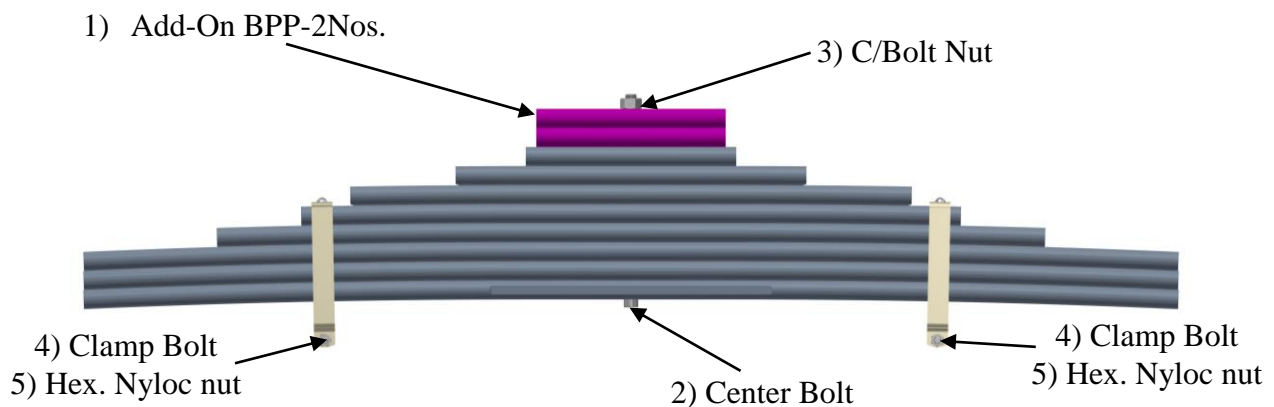
Purpose: To reduce spring stiffness.

Tools Required: Spanner, Torque wrench, Tongs, Hammer etc.

Steps:

1. Dismantle the assembly by loosening the centre bolt nut & clamp bolt nuts.
2. Remove 5th and 8th leaf from the assembly.
3. Add two bottom packing plate (90x27x300mm-2Nos), next to 10th leaf.
4. Place the other leaves in the same manner.
6. Don't assemble the used fasteners,
Discard the removed Center bolt, Nut & Clamp- bolt & Nut.
7. Assemble the spring assembly by tightening the New Center bolt & Nut (M16x290mm & Nut M16), also tight the Clamp bolt Nuts. (M10x90 & Nut M10)
8. Center bolt Nut "M16" Torque: 250±20Nm
9. Clamp bolt Nut "M10" Torque: 60Nm.

After Retro-fitment the spring assy.



Use the following components,

S.No.	Components	Item Code	Details	Qty.
1	Add-On BPP		90x27x300mm	02
2	Center Bolt	(COCB06242)	M16x290mm	01
3	C/Bolt Nut	(COMT00505)	M16	01
4	Clamp bolt	(CMP00122)	M10x1.25x90mm	02
5	Hex. Nyloc Nut	(CONT00507)	M10x1.25	02

Do's

1. Add the add-on pack plate to the spring assembly.
2. Torque the center bolt nut with specified torque.
3. Always use proper torque for U-bolts.

Dont's

1. Never hammering on leafs.
2. Don't heat the leaves with gas welding torch or with any other means.

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