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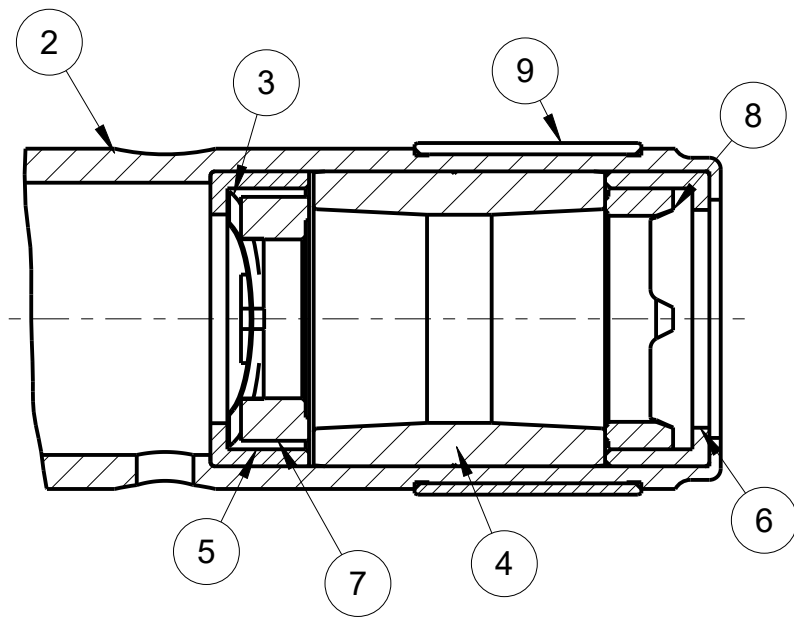
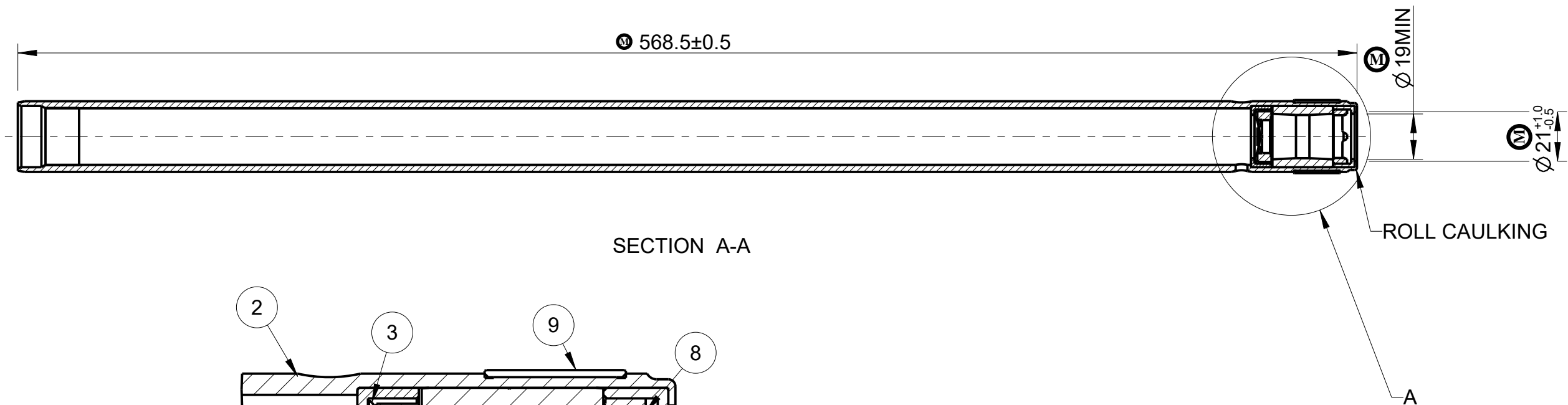
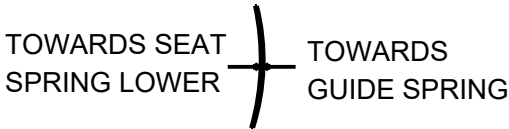


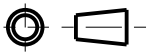
TABLE 1 : BILL OF MATERIALS

S.NO	PART NUMBER	PART DESCRIPTION	QTY
1	55050720	INNER TUBE RAW MATERIAL	1
2	55050728	INNER TUBE MACHINING & PLATING	1
3	5520011	SPRING WAVE WASHER	1
4	55060061	SPACER	1
5	55110011	SEAT SPRING LOWER	1
6	55110051-1	VALVE SEAT	1
7	55140031	GUIDE SPRING	1
8	55150051	FLOATING VALVE	1
9	55210041	DU BUSH INNER Ø 30	1

NOTES:-

- ▽ 1.TENSILE STRENGTH OF CAULKING PORTION TO BE 2500kgf MIN.
- Ⓜ 2.THE GUIDE SPRING SHOULD FLOAT FREE,NO DAMAGE TO GUIDE SPRING WHILE ASSEMBLING.
- Ⓜ 3.AFTER CAULKING THERE SHOULD BE NO DAMAGE TO VALVE SEAT.
- Ⓜ 4.AFTER CAULKING NO PLAY BETWEEN INNER TUBE, SEAT SPRING LOWER ,SPACER OIL LOCK & VALVE SEAT.
- Ⓜ 5.ROLL CAULKING AREA MUST BE FREE OF BURR.
- Ⓜ 6.SPINNING DEPTH SHALL BE : 1.8~2.5mm
- 7.NO DEFORMATION/ BULGING ON VALVE SEAT ID 19mm MIN.
8. FLOATING VALVE SHOULD FLOAT FREE.
- Ⓜ 9. WAVE WASHER ASSY:



				GABRIEL INDIA LTD.			
				SCALE	SHEETS	FINISH:	MASS:
				1:2	1 / 1		[.0] g
				DRAWN BY		NAME:-	
				DATE:		INNER TUBE ASSEMBLY	
				CHECKED BY			
DATE	REV	ALTERATION		E.C.N.NO	DATE:	MATERIAL:-	
SUPERSEDES :				APPROVED BY			
GENERAL TOLERANCE ASPER : -							
DESIGN SOURCE REF.				DATE:		PART NO:-	
RELEASE FOR						REV.	
<input type="checkbox"/> COSTING <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> OTS <input type="checkbox"/> PRE-PRODUCTION <input type="checkbox"/> PRODUCTION							
ALL DIMENSIONS ARE IN MM.		NO MANUAL ALTERATION		DO NOT SCALE		IF IN DOUBT PLEASE ASK	
						SIZE : A3	