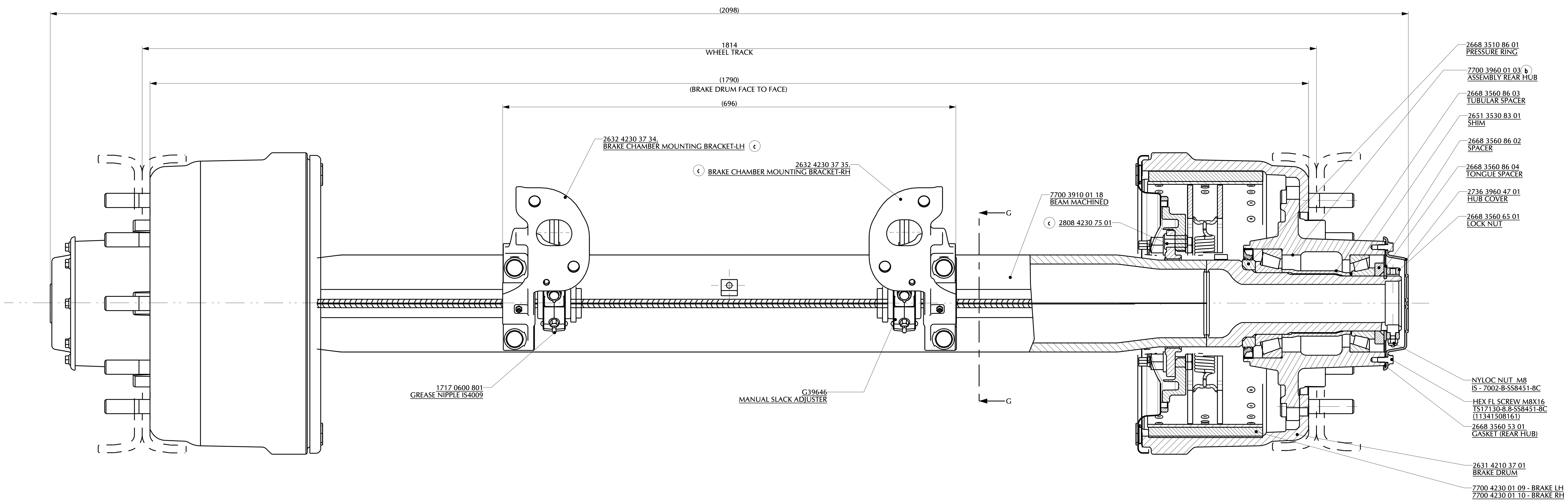
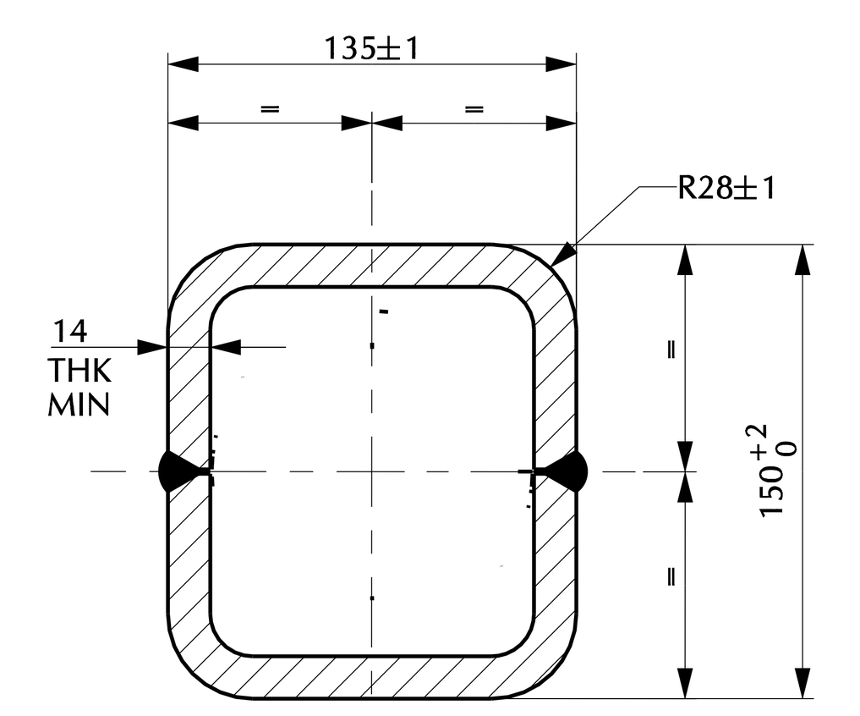
Do not scale the drawing.	Unless otherwise stated. 1) All dimensions in mm. 2) Drawing drawn to first angle projection	Nominal Dimension	Tolerance in μ m(microns) Refer IS919-2
If in doubt, ask.			





SECTION G-G
SCALE 2:5

AXLE SPECIFICATION

1. RATED AXLE LOAD = 10, 000 kgs
2. WEIGHT OF AXLE WITH BRAKES = 320 kgs (TO BE CONFORMED)
3. BRAKE SIZE = Ø 408.0 X180 WIDE

NOTE :

WEIGHT OF GREASE IN EACH HUB ASSY :- 650 grms
REAR HUB WHEEL BEARING GREASE CONSISTENSY -3 SS : 6808

HUB BEARING ASSY ADJUSTMENT

MEASURE THE GAP BETWEEN THE INNER RACES OF HUB INNER & OUTER BEARINGS. SAY 'X' (THIS CAN BE DONE EITHER WITH THE FIXTURE PRIOR TO ASSY OR BY TRIAL & ERROR INSERSTION OF THE SPACER & SHIM PACKAGES BETWEEN THE BEARING IN THE AXLE ASSY
TAKE THE TUBULAR SPACER (2668 3560 86 03) & INSERT SHIMS (2651 3560 83 01) SUCH THAT THE TOTAL THICKNESS OF THE PACKAGE IS MORE THAN 'X' BY ANY VALUE BETWEEN 0.02 & 0.12 .PRESS THE INNER RACE OF THE OUTER BEARING WITHOUT DAMAGING THE THREADS ON THE AXLE BEAM. THEN ASSEMBLE THE TOUNGE SPACER (2668 3560 86 04) TO BUTT AGAINST THE BEARING FACE
SCREW THE HUB LOCKNUT ON THE BEAM & TIGHTEN IT APLLYING OF 30-40 MKg.
HAMMER THE HUB FRONT FACE GENTLY SO THAT WHEEL BEARINGS SET & RUN FREELY.
ASSY THE TOUNGE WASHER (2668 3560 86 04) BY ALIGNING THE TOUNGE INTO BEAM SLOT.
AND CHECK FOR THE ALIGNMENT WITH CLEARANCE HOLE OF TOUNGE WASHER TO TAPPED HOLES ON NUT.
IF THERE IS A MISMATCH, THEN TIGHTEN THE NUT FURTHER SO AS TO ALIGN THE IMMEDIATE NEXT HOLES THE NUT AND LOCK IN POSITION
ENSURE THE AXLE PLAY TO BE WITHIN 0.02 TO 0.12.

Date	Mod. No.	Sl No.	Zone	Modification	Chkd	Appd
24/02/17	12JM034 001	c		PART 280842307501 WAS 770039106301 SPRING WASHER REMOVED. 263242303735 WAS 263242303709 & 263242303734 WAS 263242303708.	AKR	AKS
06/02/2016	11JP009 061	b		PART NO.7700 3960 01 03 WAS 7700 3960 01 17. VIEW UPDATED.	MKS	AKS
28/04/12	11JP009 019	a		ASSY REVISED TO MODIFY BRAKE TC PART IN PLM E-BOM STRUCTURE.	RGC	AKS
23/03/12	11JP009 007	NR		NEW RELEASE	GSS	AKS

For all Vehicle Components & Assemblies.
Tata Group Mark & Part No. to be marked as per TS 11806

For M1 & N1 class of vehicles. applicable standards are: TS11414, TS11418, TS11419 & TS11420

Material description.size.spec.std No.

Classification of characteristics:
● Critical. ▲ Key Instruction
◐ Major. (None) Minor
Applies to upper limit
Applies to lower limit

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TML DRIVELINES LIMITED

2016	SIGN	DATE
Drawn	RISHABH	22/1
Chkd	MKS	22/1
Appd	AKS	22/1

Scale: 1:1

Envelope Dimensions: 2098.35 x 466.00 x 541.65

Final mass in kg.: 28.543

Surface protection as per standard: SEE NOTE

Tolerance as per standard

Product/Group No.: RA-909 RR

Replaces Drg

Reference Drg No.: 2736 3900 01 23

Opposite Hand Drg/Part No.

Drg/Part Designation: INFO DRAWING REAR AXLE ASSEMBLY (SEC-135X150X14 : TRACK-1814)

Drg/Part No.: 7700 3900 01 16

Sheet No.....1.... of ....1.... Sheets

Unless otherwise stated.general tolerance on geometrical characteristics as per ISO 2768-2-K (medium class)/TS12114

Unless otherwise stated.general tolerance on angular dimensions.radii and chamfers as per ISO 2768-1-m (medium class)/TS12115

Unless otherwise stated.general tolerance on machining as per ISO 2768-1-m (medium class)/TS12115

General tolerance on machining as per ISO 2768-1m(medium class)/TS12115								
Dimension	Over	-	6	30	120	400	1000	2000
	Upto & incl.	6	30	120	400	1000	2000	4000
Tolerance		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2

SURFACE ROUGHNESS SYMBOLS / VALUES IN μm Ra								
Symbol	N12	N11	N9	N7	N6	N3	N6 GRD	N6 HRD & GRD
Value	50	25	6.3	1.6	0.8	0.1	0.8	0.8
FOR OTHER ROUGHNESS SYMBOLS & VALUES, SEE IS 10719								

FOR FORGE AND FOUNDRY DIVISIONS ONLY										
Customer	Die-wear (surface)	Mis-match	Thickness	Flash thickness	Clip	Pierce	Restrike	Draft	Contraction	Minimum radius

For explanation of drawing format contents, refer to TS11103
0045 4130 70 66 PCF- 071(R4) 6/2011

Original drawing size A0