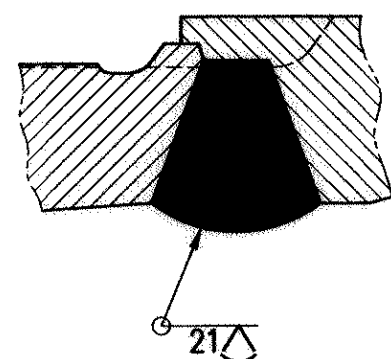
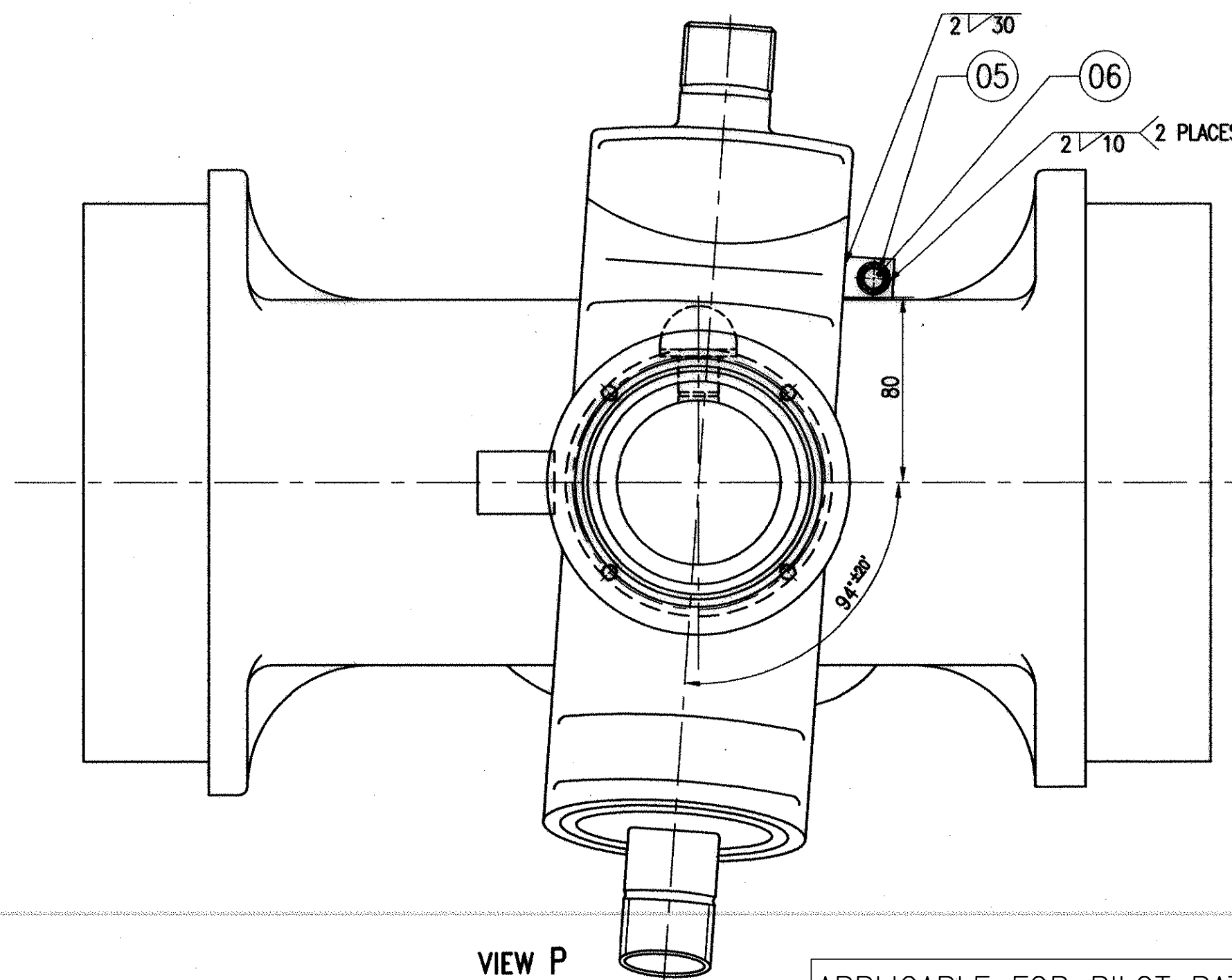


NOTE:

01. DP TEST AFTER ROOT PASS WELDING AT DETAIL 'A' SHALL CONFORM TO RADIOGRAPHY Gr-1 OF ASTM E 1955-98.
02. FILLET WELD SHALL BE DP TESTED.
03. USE WELD WIRE CONFORMING TO AWS-E80T5-G USING FCAW PROCESS. PRE HEAT-200°C, POST HEAT-300°C TO BE MAINTAINED.
04. WELD 2 ▽ WITH AWS A5.18 CLASS ER 70S-6 (C4002).
05. WELDS 21 ▽ AND 12 ▽ -(S3-CSN 05 5373), (VUS-34 Mn, CSN 05 5712).
06. WELD ROOT 21 ▽ AND 12 ▽ MUST BE WELDED WELL, IT MUST NOT CONTAIN ANY INCLUSIONS AND OTHER TRACES OF FLUX. FINISHED WELD MUST NOT BE ARRANGED IN ADDITION (BY HAMMERING AND THE LIKE) WHEN IT IS IN THE STATE OF SOLIDIFICATION.
07. SEAL POSITION PART ⑬ WITH HERMETIC PASTE (LOCTITE-648).
08. SURFACE PROTECTION OF OUTER NON-MACHINED SURFACE MARKED '-----' WITH OIL RESISTANT PRIMER MIN. 20 μm.
09. WELDING SHALL BE DONE AS PER PR1004-C.
10. QUALITY OF WELDING SHALL CONFORM TO QY1027-C.
11. DIMENSIONAL TOLERANCE FOR FABRICATED PARTS SHALL CONFORM TO KES-04.052.3.
12. WELD 5 ▽ 25 WITH ELECTRODE 'P 52.15 C' (CSN 05 5390).



DETAIL A
SCALE 1:1
BEFORE MACHINING



VIEW P

APPLICABLE FOR PILOT BATCH(93 SETS)

△ E 250,
IS:2062-2011

07	160 0 2940 145 4	GUIDE SHIM	01	E-250 C, IS:2062-2011	0.040	0.040	A4	D-6
06	109 411 040 000	SOCKET Js6	01	E-410 WC, IS:2062-1984	0.022	0.022	A4	C-4
05	160 0 2603 055 4	BRACKET	01	E-410, IS:5986-2002	0.012	0.012	A4	C-4
04	160 0 2101 021 4	FRONT HALF-AXLE	01	20C15, IS:1570 (PART-IV)-1988	21.80	21.80	A2	D-6
03	160 0 5023 011 4	SUPPORTING PIN	01	15Ni5Cr4Mo1 IS:4432-1988	0.242	0.242	A4	D-5
02	160 0 2109 025 4	FORKED KING PIN LH	01	Gr-1, Gr-2 IS:2707-96	34.50	34.50	A0	D-5
01	160 0 2007 018 4	SWINGING FORK	01	Gr-1, Gr-2 IS:2707-96	33.10	33.10	A0	D-7
SL NO	DRG/STD NO	DESCRIPTION	QTY	MATERIAL	UNIT WT IN Kg	TOTAL WT IN Kg	REMARKS	LOC

NEXT ASSY. 160 0 7300 063 4

				PRODUCT BEML HDT 8x8	DESIGN REF. ----
				USED ON QTY	
				ET 01	
				ER 01	
				MATL: ----	
				H.T. ----	
				S.T. ----	
				SEE NOTE: 08	
				Wt. in kg SCALE 89.72 1:2.5	
160HADDI △ 06 27/02/2016 160DRA0010 △ 2 AMEND NO. 12/9/14 DRA/ECN NAME SIGNATURE DATE				TITLE SWING HALF-AXLE ASSY, RH	
APPROVED: KRISHNA.K 28/8/12					
REVIEWED: KRISHNA.K					
CHECKED: D S RAO 28/8/2013					
DRAWN: ANIL 27/08/2013					
STDS. SHANKAR S 27/08/2013				DRG. NO. 160 0 7253 155 4	

BEM LIMITED
 KGF