DRG. NO. 160 0 7253 165 4

MACHINING DEVIATIONS FOR LINEAR DIMENSIONS									
ABOVE UP TO AND INCLUDING	–	6	30	120	315	1000	2000	4000	THE REST
	6	30	120	315	1000	2000	4000	–	
VALUE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	---

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PLACE FOR THE CHECK MARK AND PUNCH MARK

PUNCH THE WELDER'S MARK

DEBURR THE CHAMFERED EDGES

4 PLACES EQUISPACED

AFTER MACHINING DIA $132^{+0.5}_{0}$ THE AREA OF THE WELD ROOT MUST BE FREE OF DEFECTS

PRESERVE HORIZONTAL POSITION OF HOLE DIA 6

VIEW P

2 PLACES EQUISPACED

SECTION B–B

DETAIL A
SCALE 1:1
BEFORE MACHINING

NOTE:

1. DP TEST AFTER ROOT PASS WELDING AT DETAIL 'A' SHALL CONFORM TO RADIOGRAPHY Gr. 1 OF ASTM E 1955–1998
2. FILLET WELD SHALL BE DP TESTED.
3. USE WELD WIRE CONFORMING TO AWS–E 80T5–G USING FCAW PROCESS, PRE HEAT–200°C, POST HEAT–300°C
4. THE ITEM NO. 8 TO BE TIGHTENED WITH THE HERMETIC (LOCTITE 648).
5. WELDS 21 ▽ AND 10 ◺ – (S3–CSN 05 5373), (VUS–34 Mn, CSN 05 5712).
6. WELD ROOT 21 ▽ AND 10 ◺ MUST BE WELDED WELL, IT MUST NOT CONTAIN ANY INCLUSIONS AND OTHER RESIDUAL AFTER FLUX. FINISHED WELD MUST NOT BE ARRANGED (OTHER THAN HAMMERING AND THE LIKE) WHEN IT IS IN THE STATE OF SOLIDIFICATION.
7. WELDS MARKED ✱ ARE MADE WITH AWS A5.18 CLASS ER 70S–6 (C4002)
8. SURFACE FINISH OF OUTER NON–MACHINED SURFACES: BASIC OIL RESISTANT PAINT 20μ AT MIN.
9. WELD 2 ▽ WITH ELECTRODE P52.15 (CSN 05 5390)
10. WELDING SHALL BE DONE AS PER PR1004–C.
11. QUALITY OF WELDING SHALL CONFORM TO QY1027–C.
12. DIMENSIONAL TOLERANCE FOR FABRICATED PARTS SHALL CONFORM TO KES–04.052.3.

SL NO	DRG/STD NO	DESCRIPTION	QTY	MATERIAL	UNIT WT IN Kg	TOTAL WT IN Kg	REMARKS	LOC
08	160 0 5023 011 4	SUPPORTING PIN	01	15NiSCr4Mo1 IS:4432–1988	0.24	0.24	A4	G–8
07	160 0 7863 039 4	REAR COVERING SHEET ASSY	01	–	1.81	1.81	A3	D–3
06	160 0 2896 223 4	STRUT	02	E 410C △2011 IS:2062–2006	0.60	1.20	A4	E–7
05	160 0 2568 030 4	BRAKE CYLINDER BRACKET	01	E 410C △2011 IS:2062–2006	0.84	0.84	A4	E–6
04	160 0 5001 095 4	BRAKE SHOE PIN	02	40Cr1 IS:1570 (PART 2/SEC 1)–1979	0.66	1.32	A4	G–3
03	160 0 2401 021 4	BRAKE GIRDER	01	Gr. 3 △1 IS:2707–1996	12.0	12.0	A0	E–3
02	160 0 2007 018 4	SWINGING FORK	01	Gr. 1, Gr–2 IS:2707–1996	33.10	33.10	A0	E–10
01	160 0 2006 044 4	REAR SEMI AXLE	01	20C15, IS:1570 (PART–IV)–1988	49.90	49.90	A1	F–3

△1 15Cr3 TO IS:4432–88

NEXT ASSY. 160 0 7250 110 4, 160 0 7250 115 4

PRODUCT BEML HDT 8X8 — DESIGN REF. ---

USED ON: ET 02, ER 02 — QTY — MATL: --- — H.T. --- — S.T. SEE NOTE: 8

TECHNICO	△ 07			27/02/2016
160DRA0010	AMEND	NO.	SIGNATURE	DATE
DRA/ECN	NAME			
APPROVED	KRISHNA.K			27/8/13
REVIEWED	KRISHNA.K			
CHECKED	D S RAO			27.08.2013
DRAWN	SURENDRA			26/08/2013
STDS.	SHANKAR S			26/08/2013

TITLE: REAR SEMI AXLE ASSY

Wt. in kg 100.4 — SCALE 1:2 — SHEET NO. 1 — NO. OF SHEETS 1

BEML LIMITED KGF — DRG. NO. 160 0 7253 165 4

APPLICABLE FOR PILOT BATCH(93 SETS)