



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

**ALTERNATE DESIGN FOR AXLE RING FORGING**  
(TO PART NO.: 992 AX 50066)

**RAW MATERIAL RING FORGING DIMENSIONS**

OUTER DIAMETER : <sup>1865</sup>~~1850~~ mm }   
 INNER DIAMETER : <sup>1480</sup>~~1500~~ mm }  
 THICKNESS : <sup>600</sup>~~580~~ mm }

**PROOF MACHINED FORGING DIMENSIONS**

OUTER DIAMETER : <sup>1835</sup>~~1820~~ mm }   
 INNER DIAMETER : ~~1500~~ mm }  
 THICKNESS : <sup>580</sup>~~571~~ mm }

**TECHNICAL REQUIREMENTS:**

1. QUALITY OF THE FORGING SHALL CONFORM TO QTY1019-C & QY1020-C

2. MATERIAL : BEML C1204-98 EQUIVALENT TO SAE8620H

HEAT TREATMENT : NORMALIZING CONDITION

FINAL HARDNESS : 180 TO 229 BHN



MINIMUM YIELD STRENGTH : 360 MPa

3. REDUCTION RATIO SHALL BE 6:1

4. INCLUSION RATING TYPE A-B-C-D OF IS4163 -2 MAX.

5. REFER TO AXLE RING LH MACHINED DRG.992 AX 50074  
RH MACHINED DRG.992 AX 50082

NEXT ASSY. 992 AX 50074 & 992 AX 50082

				PRODUCT <b>REAR DUMPER</b>		DESIGN REF. ---	
				USED ON	QTY	MATL: SEE NOTE	
				BH205E	02	H.T. SEE NOTE	
						S.T. ---  4745	
AMEND NO.		SIGNATURE		DATE		Wt. in kg SCALE	
DRA/ECN		NAME		TITLE		SHEET NO. 1	
APPROVED		SUDARSHAN.K.S.		24/9/19		NO. OF SHEETS 1	
REVIEWED		MAHADEVAN B		24/9/19			
CHECKED		H D SATYANARAYANA		24/9/19			
DRAWN		SUTHAKAR.S		24/9/19		DRG. NO.	
STDS.						992 AX 53711 	



BEML LIMITED  
MYSORE

DRG. NO.

992 AX 53711 