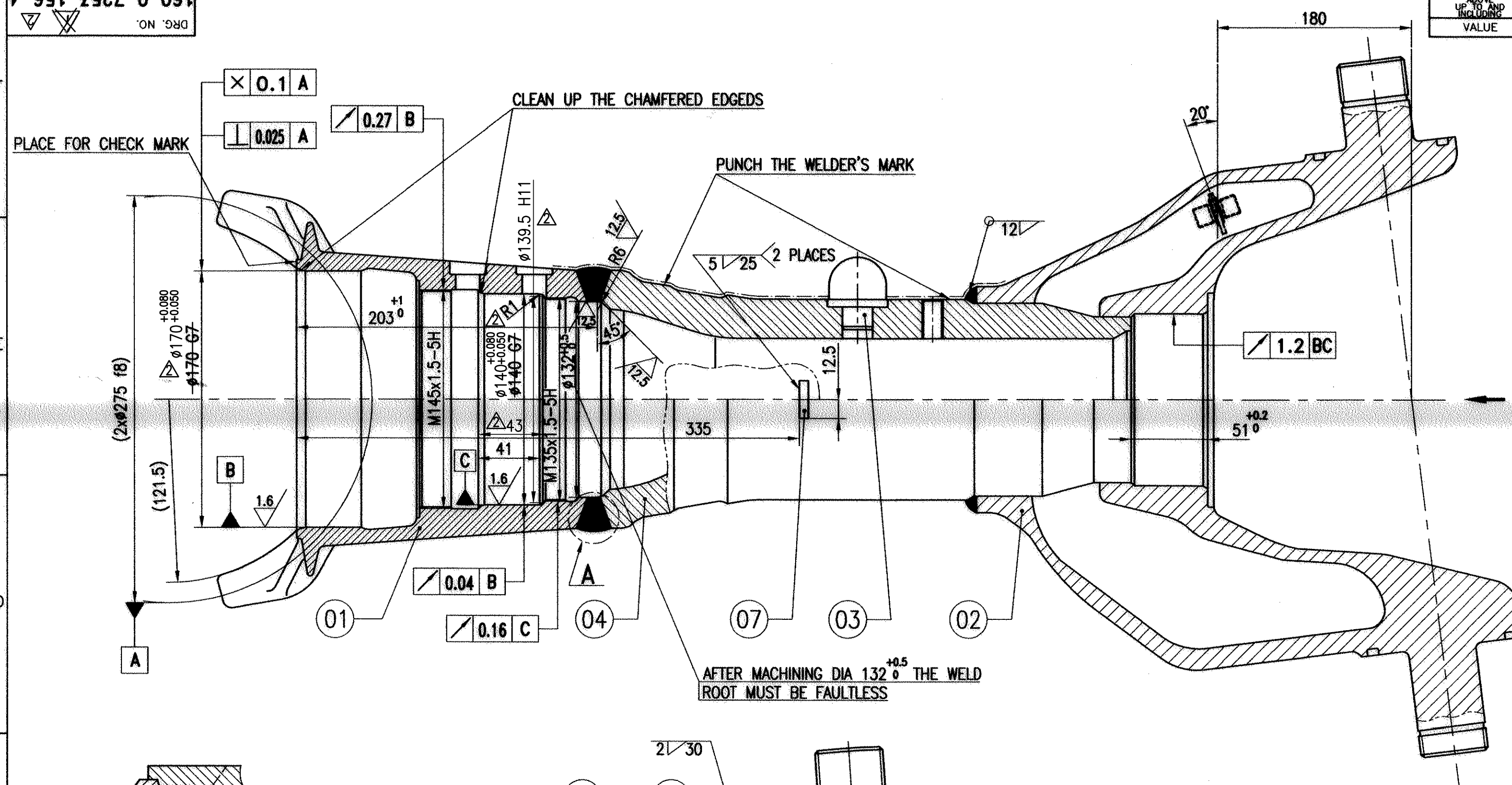
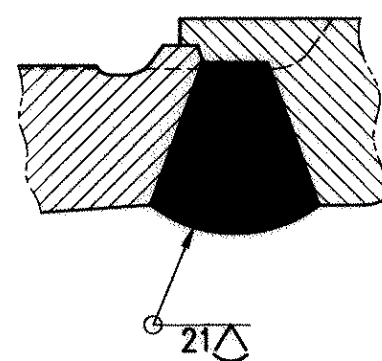


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS									THE REST	---
ABOVE UP TO AND INCLUDING	— 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 —		
VALUE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3		

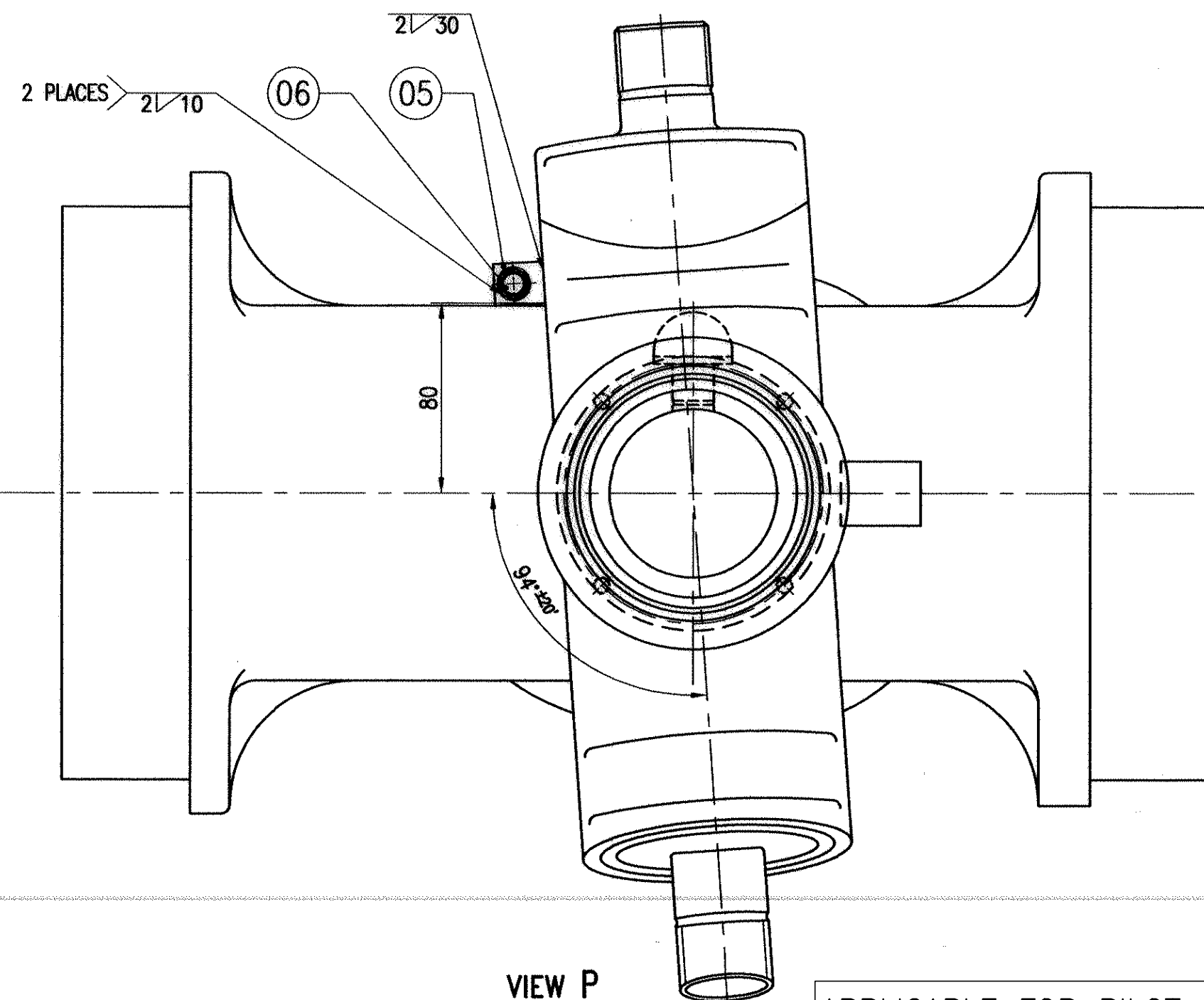


NOTE:

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 ③ 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)

E250

IS:2062-2011

07	160 0 2940 145 4	GUIDE SHIM	01	E-250 C- IS:2062-2006	0.040	0.040	A4	D-
06	109 411 040 000	SOCKET Js6	01	e-410 WC IS:2062-1984	0.022	0.022	A4	C-
05	160 0 2603 055 4	BRACKET	01	e-410 IS:5986-2002	0.012	0.012	A4	C-
04	160 0 2101 021 4	FRONT HALF-AXLES	01	20C15, IS:1570 (PART-IV)-1988	21.80	21.80	A2	D-
03	160 0 5023 011 4	SUPPORTING PIN	01	15N15Cr4Mo IS:4432-1988	0.242	0.242	A4	D-
02	160 0 2109 024 4	FORKED KING PIN RH	01	Gr-1, Gr-2 IS:2707-96	34.50	34.50	A0	D-
01	160 0 2007 018 4	SWINGING FORK	01	Gr-1, Gr-2 IS:2707-96	33.10	33.10	A0	D-
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**

	<div style="display: flex; justify-content: space-between;"> <div> <div style="width: 100%; border-bottom: 1px solid black; margin-bottom: 5px;">PRODUCT BEML HDT 8x8</div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>USED ON</div> <div>QTY</div> <div>MATL: ---</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>ET</div> <div>01</div> <div>H.T. ---</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>ER</div> <div>01</div> <div>S.T. SEE NOTE: 08</div> </div> </div> <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="width: 80%;"> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>ISOHADDI</div> <div>2</div> <div>27/02/2016</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>160DRA0010</div> <div>AMEND NO.</div> <div>SIGNATURE</div> <div>DATE</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>DRA/ECN</div> <div>NAME</div> <div>TITLE</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>APPROVED</div> <div>KRISHNA.K</div> <div>29/8/13</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>REVIEWED</div> <div>KRISHNA.K</div> <div></div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>CHECKED</div> <div>D S RAO</div> <div>29/08/2013</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>DRAWN</div> <div>ANIL</div> <div>28/08/2013</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>STDN</div> <div>SHANKAR S</div> <div>28/08/2013</div> </div> </div> <div style="width: 20%; text-align: center;"> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> </div> </div></div>
<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="width: 80%;"> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>DESIGN REF.</div> <div>---</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>Wt. in kg</div> <div>SCALE</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>89.72</div> <div>1:2.5</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>SHEET NO.</div> <div>1</div> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; margin-bottom: 5px;"> <div>NO. OF SHEETS</div> <div>1</div> </div> </div> <div style="width: 20%; text-align: center;"> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> <div style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 5px;"></div> </div> </div>	

TITLE

SWING HALF-AXLE ASSY, LH

DRG. NO.