


This document is the exclusive property of BEML and contains confidential information. This document or its contents shall not be used, reproduced or disclosed in whole or in part, without prior written permission of BEML. This document and all its copies shall be returned to BEML on demand.


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS									THE REST	—
ABOVE UP TO AND INCLUDING	6	30	120	315	1000	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

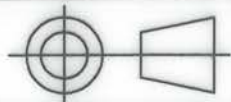


OUTER DIAMETER : ~~1850~~¹⁸⁶⁵ mm } 
 INNER DIAMETER : ~~1500~~¹⁴⁹⁰ mm }
 THICKNESS : ~~580~~⁶⁰⁰ mm }

PROOF MACHINED FORGING DIMENSIONS

OUTER DIAMETER : ~~1820~~¹⁸³⁵ mm } 
 INNER DIAMETER : ~~1500~~ mm }
 THICKNESS : ~~571~~⁵⁸⁰ 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 REAR DUMPER		DESIGN REF. ---	
USED ON		QTY		MATL: SEE NOTE			
BH205E		02		H.T. SEE NOTE			
S.T. ---		---		---		Wt. in kg 4745 4176.0	
SCALE ---		---		---		---	
AMEND NO.	SIGNATURE	DATE	TITLE		SHEET NO. 1		NO. OF SHEETS 1
DRA/ECN	NAME	DATE	AXLE RING FORGING (ALTERNATE DESIGN)		1		
APPROVED	SUDARSHAN.K.S	24/9/19	 BEML LIMITED MYSORE		DRG. NO.		
REVIEWED	MAHADEVAN B	24/9/19			992 AX 53711 		
CHECKED	H D SATYANARAYANA	24/9/19					
DRAWN	SUTHAKAR.S	24/9/19					
STDS.							