

beml

UNIT STANDARDS

KGF COMPLEX - B

TITLE: HOT ROLLED LOW ALLOY STEEL
FOR TRACK SHOES
(B1201)

DATE: 1992-11-19

INFORMATION SHEET -01

IMPORTANT NOTE:

1. INFORMATION IN THIS SHALL BE FOR INTERNAL USE ONLY.
2. REMOVE THIS PAGE BEFORE ISSUE TO THE SUPPLIER.

ADDITIONAL INFORMATION.

FOR PLACEMENT OF ORDER, YOU ARE REQUESTED TO SEND THIS STANDARD ALONG WITH APPLICABLE DRAWING/DRAWINGS MENTIONED BELOW TO THE VENDORS :

<u>SLNO</u>	<u>EQUIPMENT</u>	<u>PART NUMBER</u>
1	D31A-17	105 CT 11007/1
2	D50A-15	110 CT 11005/1
3	D80A-12	116 CT 11002/1
4	5013 - SHOVEL	205 CT 11003/1
5	8023 - SHOVEL	210 CT 11001/1
6	PC220-3	155 CT 11001/1
7	PC300-3	160 CT 11008/1
8	PC650-3	171 CT 11003
9	D65E-8	113 CT 11016

This standard is replacement for the following EM standards :

1	01.04.03
2	01.04.09
3	01.04.10

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1. SCOPE :

This specification covers the requirements of hot rolled low alloy steel for track shoes of dozers, shovels and excavators.

2. CHEMICAL COMPOSITION, PERCENTAGE :

Carbon	: 0.28 ~ 0.34	Sulphur	: 0.03 max.
Manganese	: 1.00 ~ 1.30	Phosphorus	: 0.03 max.
Silicon	: 0.15 ~ 0.35	Titanium	: 0.025min.
Chromium	: 0.25 max.	Boron	: 0.0005 ~ 0.003

3. ALLOWABLE VARIATION IN CHEMICAL COMPOSITION :

C = ± 0.02 , Si = ± 0.02 , Mn = ± 0.04 .

Chemical analysis shall be performed in accordance with IS:228.

4. NOTE :

- a) One sample track shoe per heat shall be selected at random and tested for chemical composition. When the chemical composition is within the allowable limits as specified in clause-2, the entire lot with same heat number shall be accepted. In case the chemical composition is not within the allowable limits as specified in clause-2, one more Track shoe shall be tested for chemical composition. If the result of retest for chemical composition is within the allowable variation as mentioned in clause-3, the batch shall be accepted.

POSITION TO EXTRACT SAMPLE FOR CHEMICAL ANALYSIS :

FOR D50A-15, D80A-12,
D120A-18 & D56E-8

FOR D31A-17 ONLY

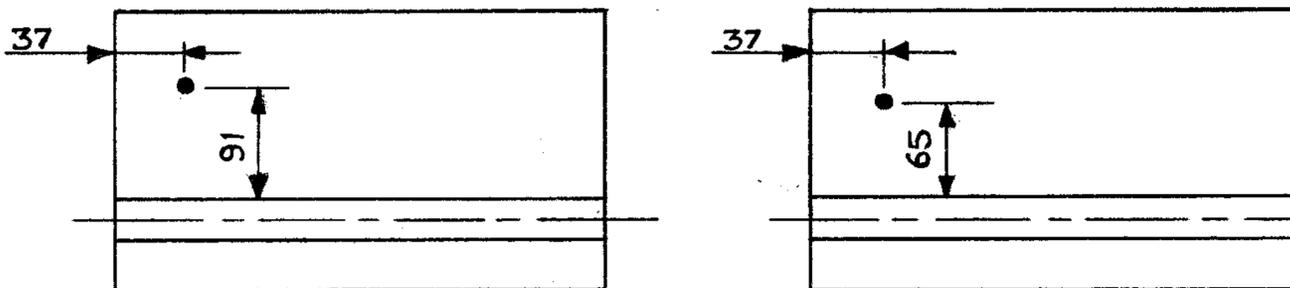


Fig-1 (Dimensions in mm.)

PREPARED BY:

ISSUE NO:

TWO

REPLACEMENT FOR:

EM STANDARDS :

01-04-03

01-04-09

01-04-10

REF:

APPROVED BY:

ALTERED BY:

B1201

UNIT STANDARDS



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KGF COMPLEX - B

DATE: 1992-11-19

TITLE: HOT ROLLED LOW ALLOY STEEL
FOR TRACK SHOES

FOR 5013, 8023, PC220,
PC300

FOR PC650 ONLY

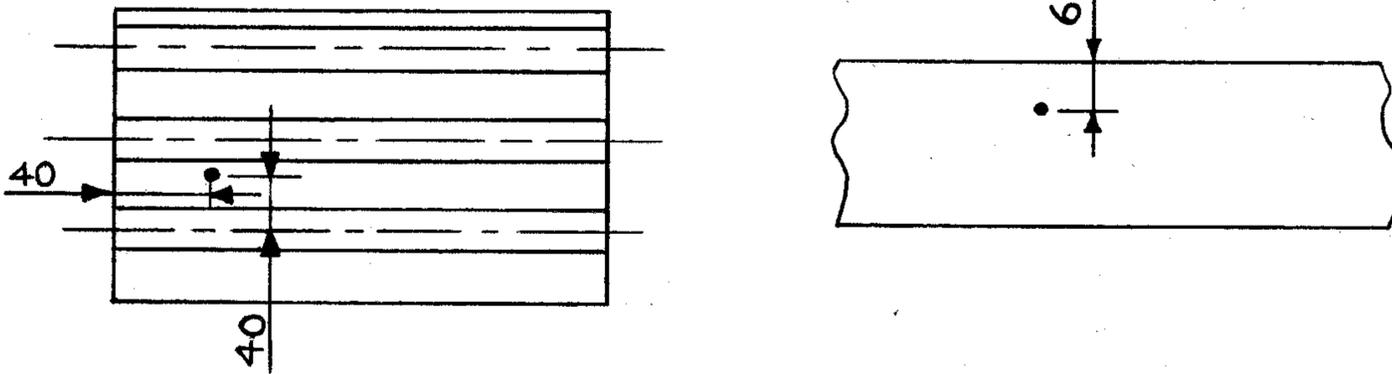


Fig-2 (Dimensions in mm)

- b) If a lot is rejected based on the result of retest for chemical analysis, joint analysis may be made only once, if requested by the supplier. On such occasions one more additional Track shoe (on third sample) shall be tested and if the result of joint analysis (on third sample) is within allowable limits as specified clause-2, the lot shall be accepted.

5. GRAIN SIZE :

Grain size shall be ASTM No : 5 ~ 8.

6. INCLUSION CONTENT :

Test in accordance with as per clause-2 of IS:4163-1982 - "Method for determination of inclusion content steel by Macroscopic method"

7. HARDENABILITY :

- a) Hardenability shall be determined in accordance with IS:3848.
- b) Requirement : Distance in mm from quenched end

<u>Distance (mm)</u>	<u>Hardness (HRC)</u>
1.5	49 ~ 55
7.5	38 ~ 44
15	28 min.

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FOR TRACK SHOES

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8. SUPPLY CONDITION :

Track shoes shall be supplied in normalised condition.

9. DIMENSIONAL REQUIREMENT AND TOLERANCES :

- a) The track shoe section must conform to the dimensions/tolerances specified in the drawing(s).
- b) Straightness shall be within 6 mm in 1500 mm to permit shearing.

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