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Process Specification

Specification: 7-H

Revision Date: 10/05/2011

CYCLE ANNEAL

1. General Specification:

Process Specification 1. All the requirements for the general specification apply unless superseded by the requirements within this specification.

2. SCOPE

This process specification is a recommended guideline only. Its purpose is to improve machinability, and is used at the option of the machining facility.

PROCESS	DESCRIPTION
Cycle-Anneal	Heat to 1450°F for 1½ to 2 hours. Cool rapidly to 1200°F (1/2 hour). Hold at 1200°F for 4 to 5 hours. Cool slowly to 500°F (200°F per hour), then cool in air. Application: Used for SAE 4340, 1350, 1345, and similar steels.

Date	Change
10/05/2011 Level G Request 30272-149	Title was NORMALIZING - ANNEALING. Added general specification note to section 1.
10/05/2008 Level F Request 30272-58	Added General Specification PS 1
6/15/2001 Level E Request 21206-3	Created an individual document for process specification 7-H. It was originally included on P.S. 7.

Approved By: S. Foster
Vice President - Quality