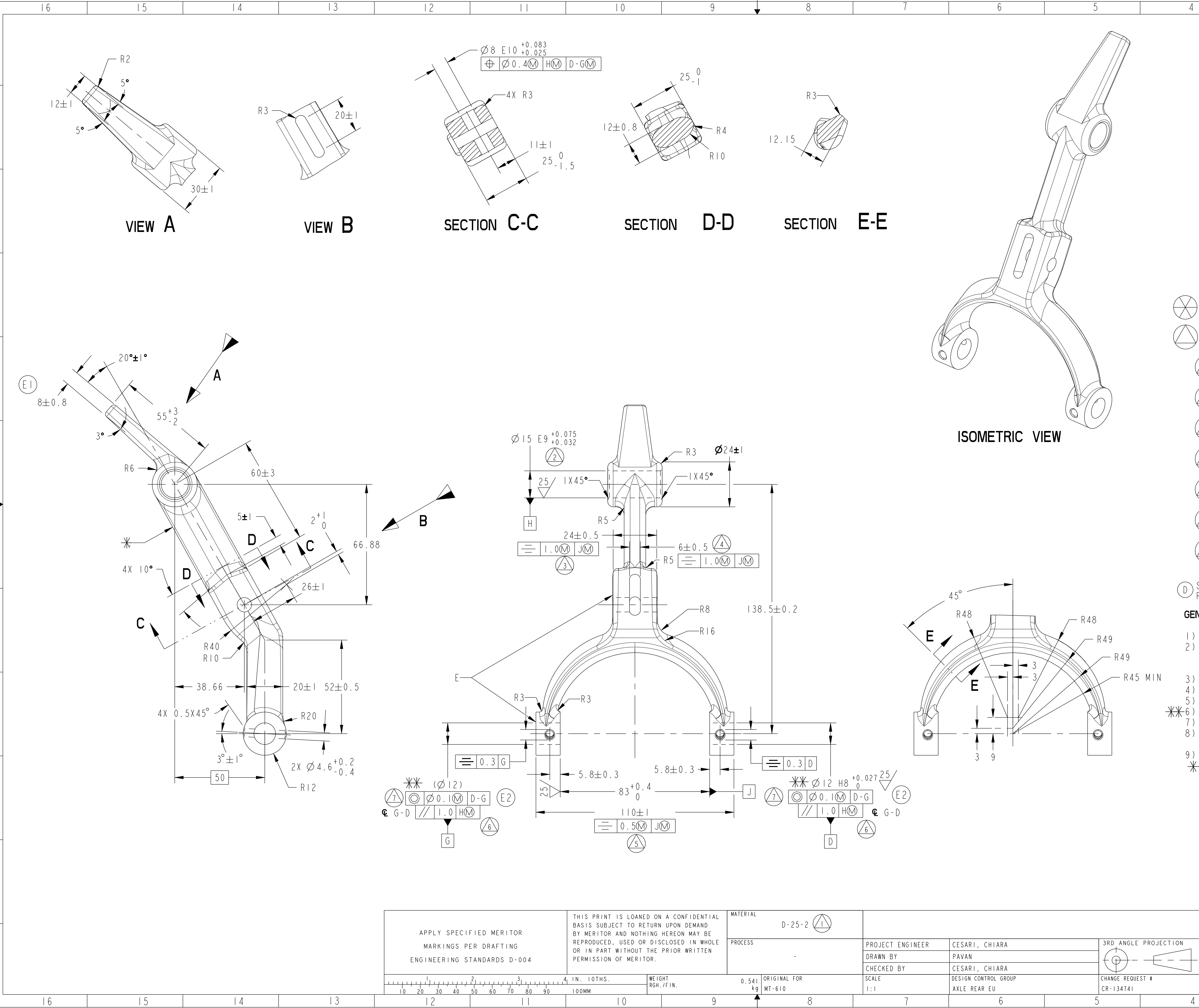


Revision: E.6

STATE: Engineering Released

EXPORT_CONTROL: HARD_WARE=EAR - EAR99,EXPORT_CONTROL=EAR - EAR99

Revision: E.6



		3			2			1
LAYOUT NO.		-						
SIM. PARTS		-						
UNLESS OTHERWISE SPECIFIED								
INTERPRET DRAWING PER ASME Y14.5M-1994 ALL DIMENSIONS IN MILLIMETERS. ALL OTHER TOLERANCES: ±0.40 ON 2-PLACE DECIMALS ±0.8 ON 1-PLACE DECIMALS ±1° ON ANGULAR DIMENSIONS				8.9/√ ALL MACHINED SURFACE FINISHES ALL MACHINED INSIDE CORNERS 0.80 RADIUS. BREAK ALL SHARP EDGES. REMOVE ALL BURRS, FINIS, FLASH & PROJECTIONS CASTING TOLERANCES PER STD ISO 8062-3 FORGING TOLERANCES +1.6-0.8; DRAFTS 7°±1°				
REVISIONS								
D	BUMPED TO 'D' REVISION TO MATCH WITH WT PART REVISION AND REDRAW THE DRAWING. ADDED NOTE.					ECN-161591 19-NOV-19	PH CC	
E	E1-DIM. WAS 5; E2-GD&T WAS DⓂ & GⓂ DATUM.					ECN-168849 18-JUN-20	EV CC	

QUALITY CONTROL CHARACTERISTICS

- ⊗ DENOTES SAFETY RELATED CHARACTERISTIC
- ⊕ DENOTES MAJOR CHARACTERISTIC
- ① MATERIAL
- ② MACHINE BORE SIZE
- ③ BOSS SYMMETRICITY
- ④ SLOT SYMMETRICITY
- ⑤ OVERALL WIDTH SYMMETRICITY
- ⑥ HOLE AXIS PARALLELISM
- ⑦ BORE CONCENTRICITY

Ⓜ SOUNDNESS REQUIREMENTS APPLIES TO THIS DRAWING. REFER SHOP CHART NUMBER 4-71480.

GENERAL NOTES :

- MACHINING ANGLE TOLERANCES UNLESS OTHERWISE STATED: ±5°
- THE PRESENCE OF DROSS/SLAG INCLUSIONS IS PERMITTED TO A MAXIMUM DEPTH OF 1.27 (.050 Inch) FROM THE AS CAST SURFACE.
- ALL SMALL RADII NON-SPECIFIED TO BE 3±1.
- NON-SPECIFIED DRAFT ANGLES 4° MAX.
- NON-SPECIFIED SURFACE ROUGHNESS: 25
- Ⓜ CHECKED WITH FUNCTIONAL GAUGE.
- HARDNESS MEASURED ON "E".
- OPTIONAL HEAT TREATMENT (NORMALISING) TO ACHIEVE FREE FROM CARBIDE.
- PART ID INFORMATION:
- Ⓜ RECESS MERITOR CORPORATE IDENTITY STYLE D-1 PER LAYOUT 4-34573.
- RECESS MERITOR CASTING PART NUMBER AND LATEST CASTING CHANGE LETTER 0.8 X 5.0
- RAISE VENDOR TRADE MARK AND/OR OTHER SPECIAL MARKINGS.
- RAISE MATERIAL HEAT OR DATE CODE 0.8 X 5.0 ON CASTINGS.

APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-004		THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.		MATERIAL D-25-2		PROCESS -		PROJECT ENGINEER CESARI, CHIARA		3RD ANGLE PROJECTION		DRAWING SIZE D		DRAWING 1523080_01 E.4		MODEL 1523080 E.4		SHEET 1 OF 1	
WEIGHT RGH./FIN.		ORIGINAL FOR MT-610		SCALE 1:1		CHANGE REQUEST # CR-134741		DESIGN CONTROL GROUP AXLE REAR EU		DRAWING 1523080_01 E.4		MODEL 1523080 E.4		SHEET 1 OF 1		DRAWING 1523080_01 E.4		MODEL 1523080 E.4	