



DATUM LEGEND

CASTING INSPECTION DATUMS:

- X- DATUM AXIS THRU DATUM TARGETS X1, X2, & X3
- Z- DATUM PLANE

MACHINE INSPECTION DATUMS:

- A- INPUT BEARING SURFACE
- B- SEAL BORE

LAYOUT NO.		5-68217 & 5-68218	
SIM. PARTS		2214Y1325 & 2214W1271	
UNLESS OTHERWISE SPECIFIED			
INTERPRET DRAWING PER ASME Y14.5M-1994 ALL DIMENSIONS IN MILLIMETERS: ±.01 ON 2-PLACE DECIMALS ±.005 ON 1-PLACE DECIMALS ±.1° ON ANGULAR DIMENSIONS		ALL MACHINED SURFACE FINISHES ALL MACHINED INSIDE CORNERS R.80 RADIUS, BREAK ALL SHARP EDGES. REMOVE ALL BURRS, FLASH & PROJECTIONS CASTING TOLERANCES PER STD ISO 8062-3 FORMING TOLERANCES ±1.6-12.5 DRAFTS 1°-1.5°	
REVISIONS			
C	RELEASE 2214-Q-1343 FOR PRODUCTION	124323 06-06-14	JLB VRH
D	1) RESIZED O-RING GLAND & PILOT DIA 2) SHIFTED ITS POSITION 3) TP OF THREADS, GLAND ID AND PILOT OD 4) GENERAL NOTES 3 & 4	124379 6-17-14	RDV VH
E	1) WAS 472 2) ADD DETAIL G, INDUCTION HARDEN PATTERN 3) REVISED DWG FORMAT FROM D SIZE 4) WAS [A][B]	124532 07-16-14	KGB VRH
F	1) CATING PRO-E MODEL REVISED, MACHINE MODEL UPDATED 2) WAS Ø129.89 3) WAS Ø0.08 4) WAS Ø126.265	124826 08-27-14	KGB VRH
G	1) WAS 112.867 2) WAS 3.0	125578 12-01-14	VRH SC
H	1) WAS 1.85	127063 05-06-15	VRH MJC
J	1) CASTING CREO MODEL REVISED; FINISH CREO MODEL UPDATED 2) REVISED GENERAL NOTES	129184 03-08-16	VRH KGB
K	UPDATED TO LATEST FORMAT. REMOVED MERITOR SYMBOL AND PART IDENTIFICATION MARKINGS FROM CAST MODEL	165777 22-JAN-20	VKH PG

QUALITY CONTROL CHARACTERISTICS	
Ⓐ	DENOTES MAJOR CHARACTERISTIC
Ⓐ	THREAD SIZE
Ⓐ	THREAD TRUE POSITION
Ⓐ	DIAMETER - SEAL BORE
Ⓐ	RUNOUT - SEAL BORE
Ⓐ	SURFACE FLATNESS
Ⓐ	SURFACE PERPENDICULARITY
Ⓐ	HARDNESS - PATTERN
Ⓐ	COVER PILOT DIAMETER
Ⓐ	COVER PILOT TRUE POSITION
Ⓐ	GLAND DIAMETER
Ⓐ	GLAND TRUE POSITION

GENERAL NOTES:

- 1) THIS DRAWING IS FOR INSPECTION PURPOSES ONLY
- 2) QCC ITEM #7 TO BE APPLIED ONLY ALONG [A]- SURFACE ACCORDING TO MERITOR SPECIFICATION 404-D
- 3) ALL THREAD DIMENSIONS APPLY TO PART AFTER HEAT TREATMENT
- 4) THREAD, PILOT AND GLAND FEATURES ARE TO BE MACHINED IN ONE SET UP WITH DIRECT REFERENCE TO SEAL BORE
- 5) MACHINED SURFACES MUST MEET REQUIREMENTS IN SECTION 2.4 OF D-1 PER SOUNDNESS LOCATIONS SHOWN ON 2214P1342
- 6) VENDOR IDENTIFICATION REQUIRED, METHOD AND LOCATION MUST BE APPROVED IN WRITING BY MERITOR ENGINEERING. DETAILS TO BE SUBMITTED AND STORED WITH PPAP DOCUMENTATION.

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 SEE MAKE FROM		PROCESS 404-D		PROJECT ENGINEER DRAWN BY CHECKED BY		V HICKS KGB VRH		3RD ANGLE PROJECTION		DRAWING SIZE E		CHANGE REQUEST # PROJ496		DRAWING 2214Q1343 K.4		MODEL 2214Q1343 K.3		SHEET 1 OF 1	
WEIGHT 0.92 ORIGINAL FOR kg WT 14X		SCALE 1:1		DESIGN CONTROL GROUP AXLE REAR NA		MAKE FROM		RELEASE		NAME RING-BRG ADJ. FIN.		PART/DWG NO. 2214Q1343		03200		2214P1342		127063		2214Q1342		03200	