

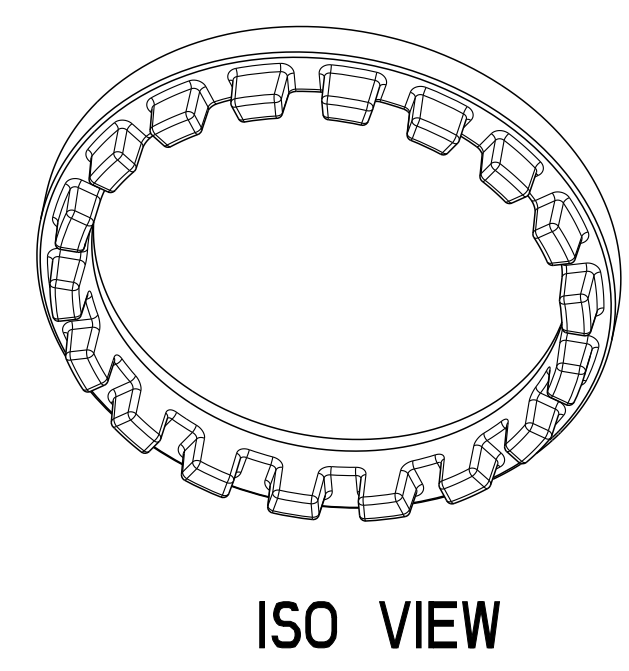
DATUM LEGEND

INSPECTION SETUP DATUMS:

- X- DATUM PLANE LOCATED ON UPPER SURFACE
- Y- DATUM AXIS LOCATED AT INNER DIAMETER

MACHINE DATUMS:

- A- DATUM PLANE LOCATED ON THREAD DIAMETER



LAYOUT NO.			
SIM. PARTS			
2214Z208 / L272			
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, FINES, FLASH & PROJECTIONS CASTING TOLERANCES PER STD ISO 8062-3. FORGING TOLERANCES +1.6-0.8; DRAFTS 7±1°	
REVISIONS			
D	ADDED QCC DECAL.	92414 01-15-04	KBR
E	D1-WAS M154.6 X 2.0-7g6g THD., D2-ADDED DIMENSION.	102527 1-12-07	JGW
F	F1- UPDATED ROUGH MODEL F2- REMOVED "SHT 1 OF 2" SHEET 2 WAS WITHDRAWN PREVIOUSLY	121476 5-9-13	RDK PJ
G	ADDED DIMENSIONS	125536 11-21-14	LW NM
H	1) REVISED DATUM AND DIMENSIONING SCHEME 2) REVISED PART GTOL CALLOUTS 3) ADDED DATUM LEGEND 4) DESIGN CONTROL GROUP WAS L.A.E. 5) ADDED PROCESS 703 6) ADDED QCC LIST 7) ADDED GENERAL NOTES 8) ADDED CHAMFERS AND DIMENSIONS 9) ADDED OPTIONAL CONSTRUCTION	132171 06-08-16	TAD DAC
J	1) 1.8 WAS 1	135794 12-20-16	TAD DAC
K	UPDATED TO LATEST FORMAT REMOVED MERITOR SYMBOL AND PART IDENTIFICATION MARKINGS	165279 02-JAN-19	VKH PG

- QUALITY CONTROL CHARACTERISTICS**
- THREAD SIZE
 - THREAD TRUE POSITION
 - RUNOUT
 - SURFACE FLATNESS
 - HARDNESS - PATTERN

- GENERAL NOTES:**
- MACHINED SURFACES MUST MEET REQUIREMENTS IN SECTION 2.4 OF D-1 PER SOUNDNESS LOCATIONS CALLED OUT ON 2214F1124
 - VENDOR IDENTIFICATION REQUIRED. METHOD AND LOCATION MUST BE APPROVED IN WRITING BY MERITOR ENGINEERING. DETAILS TO BE SUBMITTED AND STORED WITH PPAP DOCUMENTATION.
 - ID MACHINING PERMISSIBLE FOR LOCATING PURPOSES

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