

P3

DATUM LEGEND

INSPECTION SETUP DATUMS:

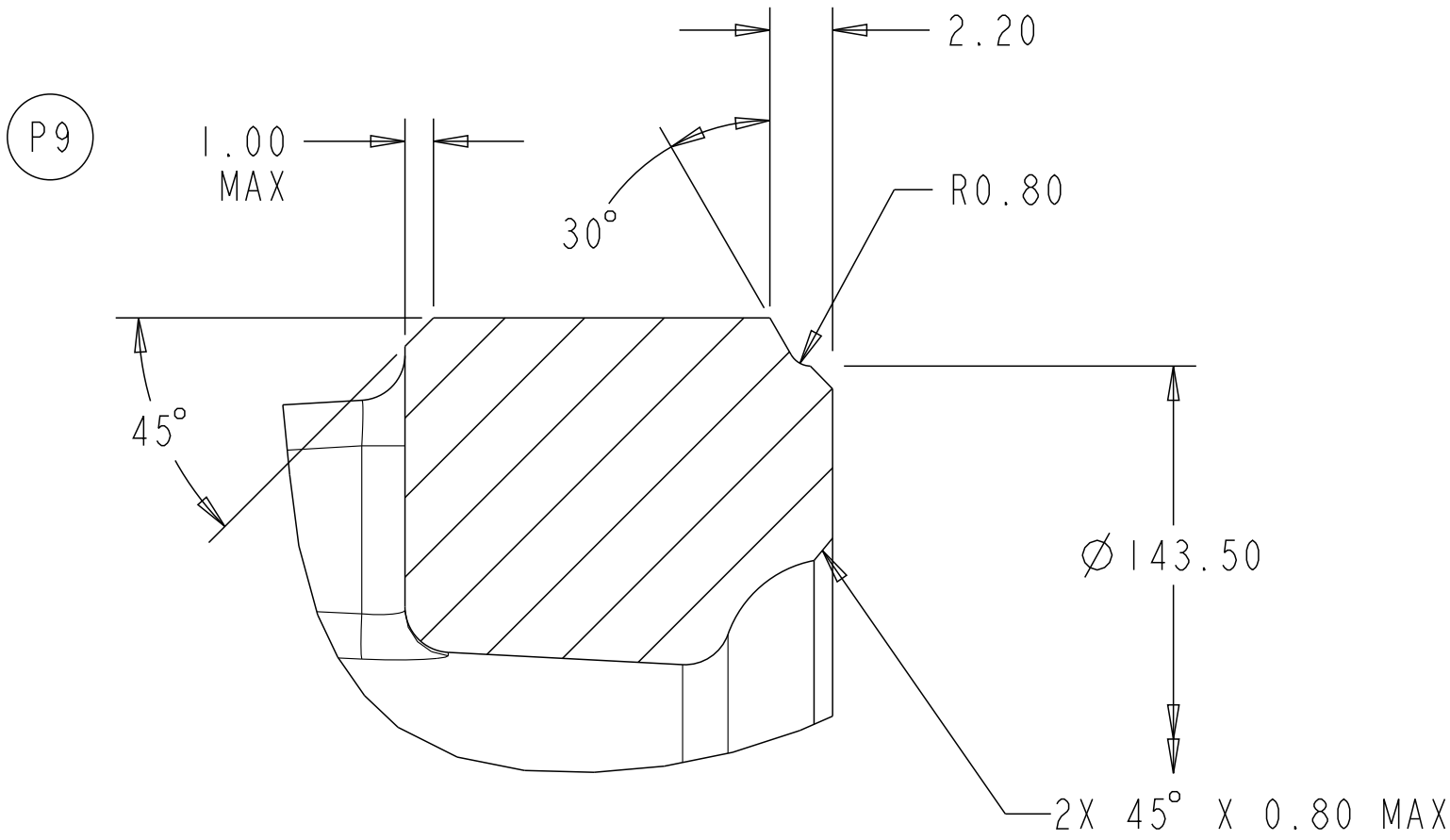
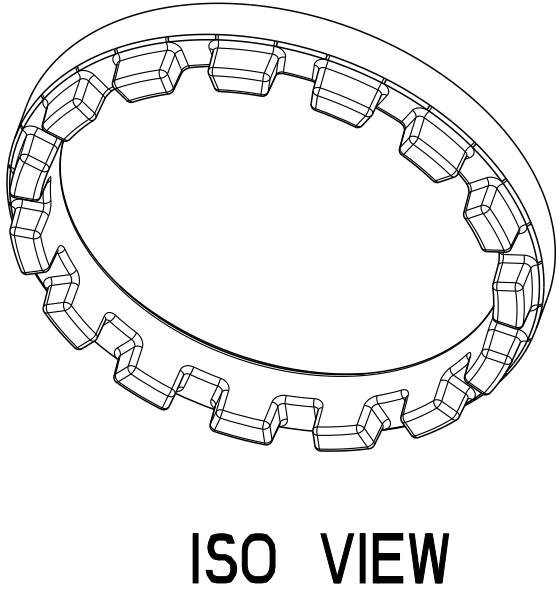
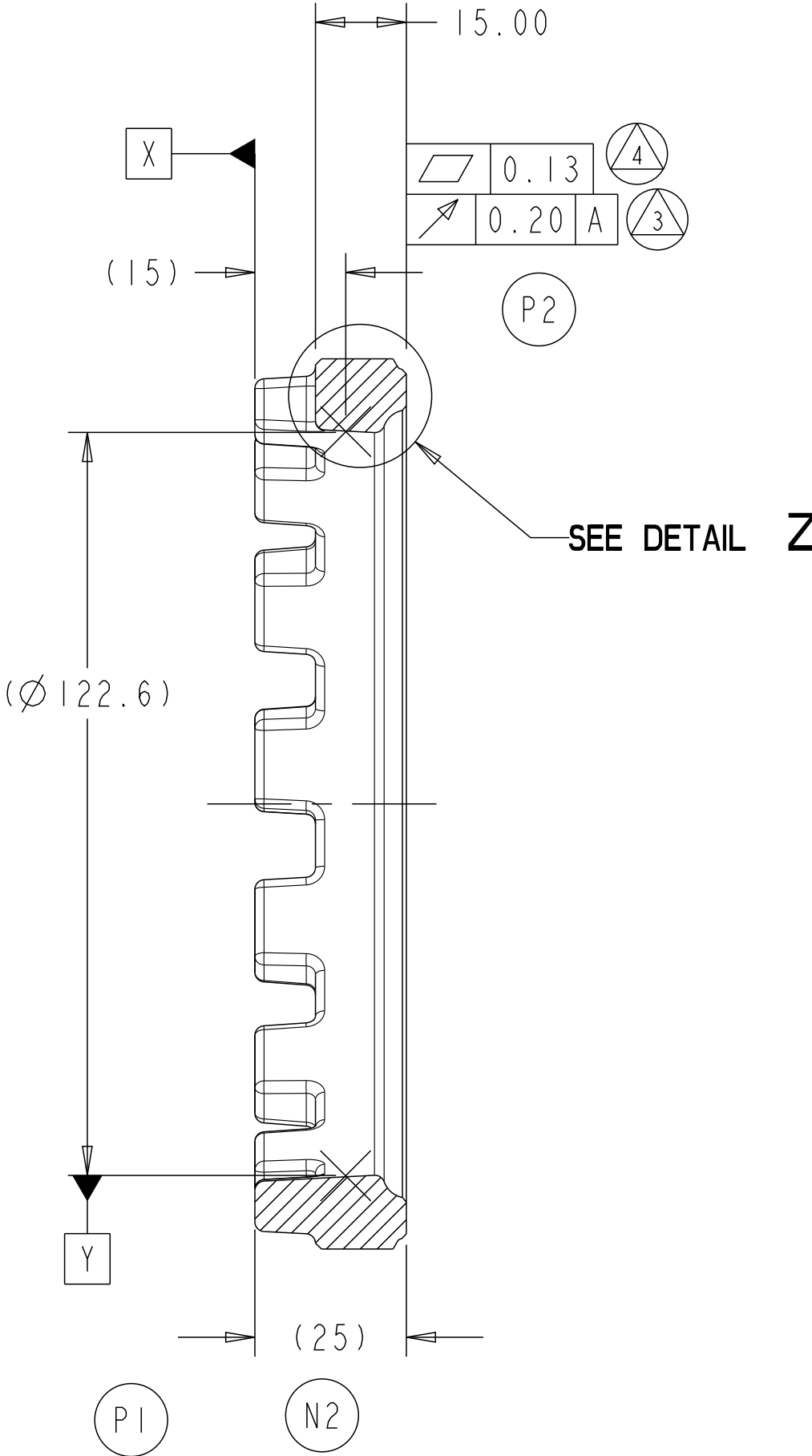
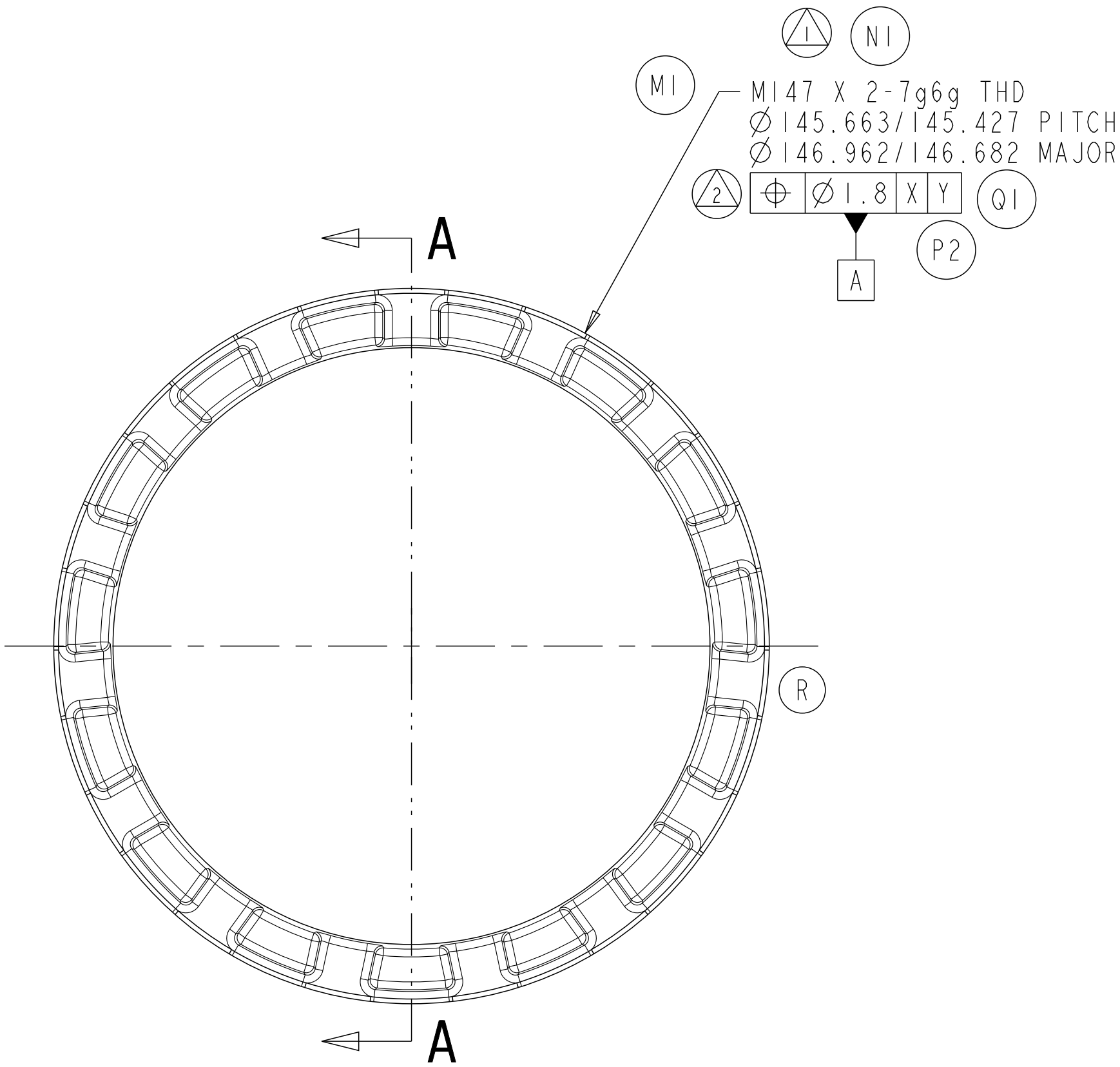
- X- DATUM PLANE LOCATED ON UPPER SURFACE
- Y- DATUM AXIS LOCATED AT INNER DIAMETER

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		<div>8.9</div> <div>▽</div> <div>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°</div>	
REVISIONS			
L	TRANSFERRED 2214-Y-1039 FROM 2214-X-1038 SHT. 1. REDRAWN AS SOLID MODEL WAS 2D CAD. UPDATED AND REVISED PER LATEST ENGINEERING DESIGN REQUIREMENTS.	91490 11-10-03	KBR
M	M1-THREAD SIZE WAS IN ERROR. M2-ADDED QCC DECAL.	92414 01-19-04	KBR
N	N1-WAS M147.0 X 2.0-7g6g THD., N2-ADDED DIMENSION	102527 1-12-07	JGW
P	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) REMOVED SHT. NO. 1 OF 2 NOTE 9) ADDED CHAMFER AND DIMENSIONS	132171 06-08-16	TAD DAC
Q	1) 1.8 WAS 1	135794 12-20-16	TAD DAC
R	UPDATED TO LATEST FORMAT. REMOVED MERITOR SYMBOL AND PART IDENTIFICATION MARKINGS FROM CAST MODEL	165777 21-JAN-20	VKH PG

DO NOT CHANGE MANUALLY



DETAIL Z
SCALE 4:1

- P6 QUALITY CONTROL CHARACTERISTICS
- ⊕ DENOTES MAJOR CHARACTERISTIC
- ⊕ THREAD SIZE
 - ⊕ THREAD TRUE POSITION
 - ⊕ RUNOUT
 - ⊕ SURFACE FLATNESS
 - ⊕ HARDNESS - PATTERN

P7 GENERAL NOTES:

- 1) MACHINED SURFACES MUST MEET REQUIREMENTS IN SECTION 2.4 OF D-1 PER SOUNDNESS LOCATIONS CALLED OUT ON 2214X1038
- 2) VENDOR IDENTIFICATION REQUIRED. METHOD AND LOCATION MUST BE APPROVED IN WRITING BY MERITOR ENGINEERING. DETAILS TO BE SUBMITTED AND STORED WITH PPAP DOCUMENTATION.
- 3) ID MACHINING PERMISSIBLE FOR LOCATING PURPOSES

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		PROJECT ENGINEER MS		3RD ANGLE PROJECTION		DRAWING SIZE D		MERITOR		METRIC	
PROCESS ⊕ 472 & 703		CHECKED BY KBR		SCALE 1:1		DESIGN CONTROL GROUP AXLE REAR NA		CHANGE REQUEST # PNS-2172, PNS-2173		DRAWING 2214Y1039_01 R.6		MODEL 2214Y1039 R.4		SHEET 1 OF 1	