

Revision: Q.4

STATE: Design

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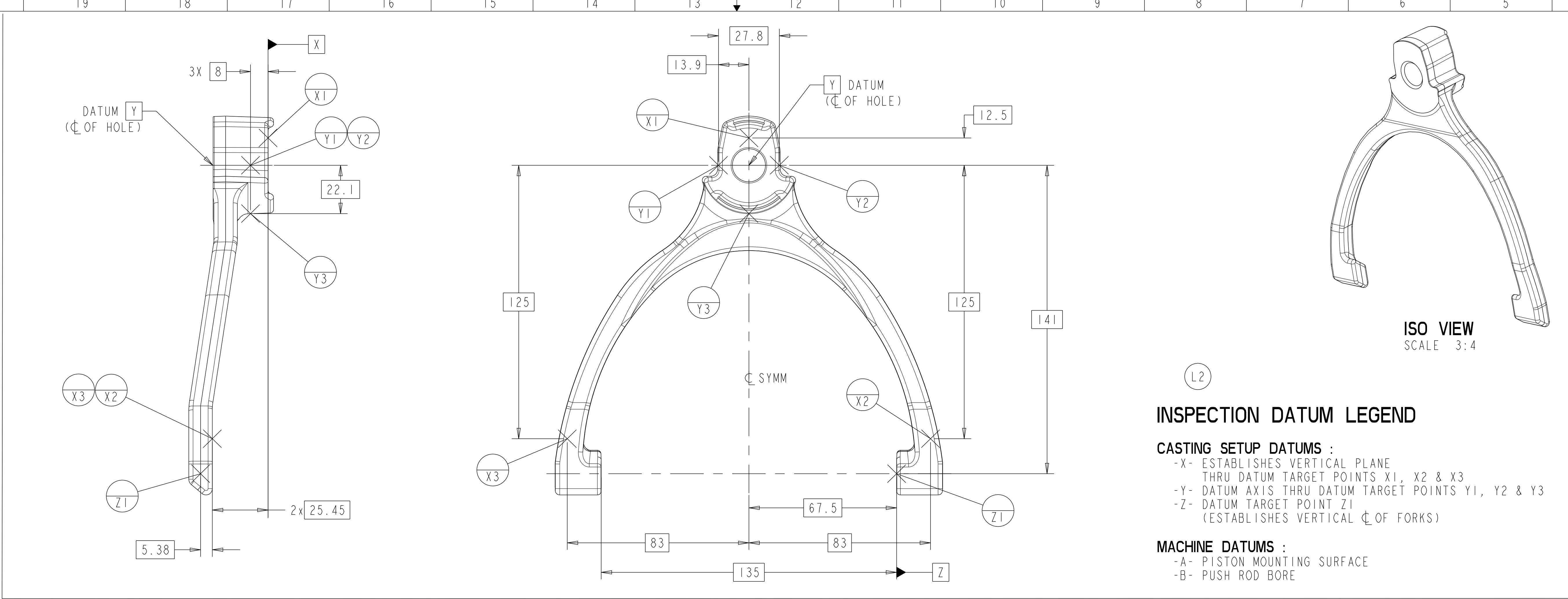
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INSPECTION DATUM LEGEND

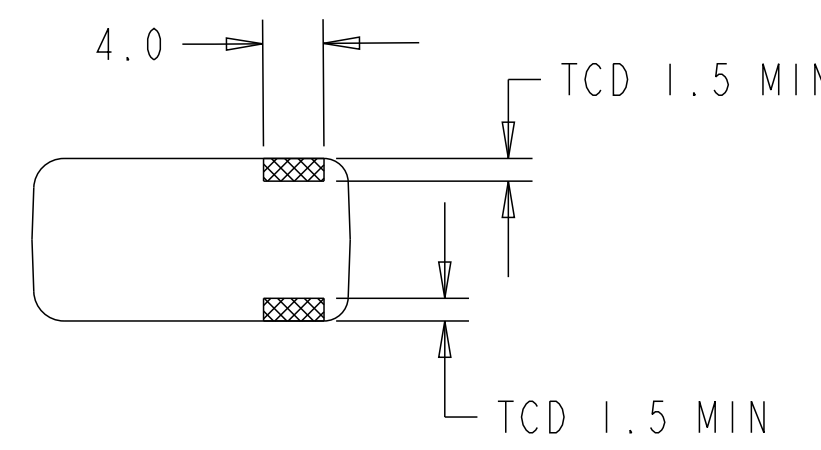
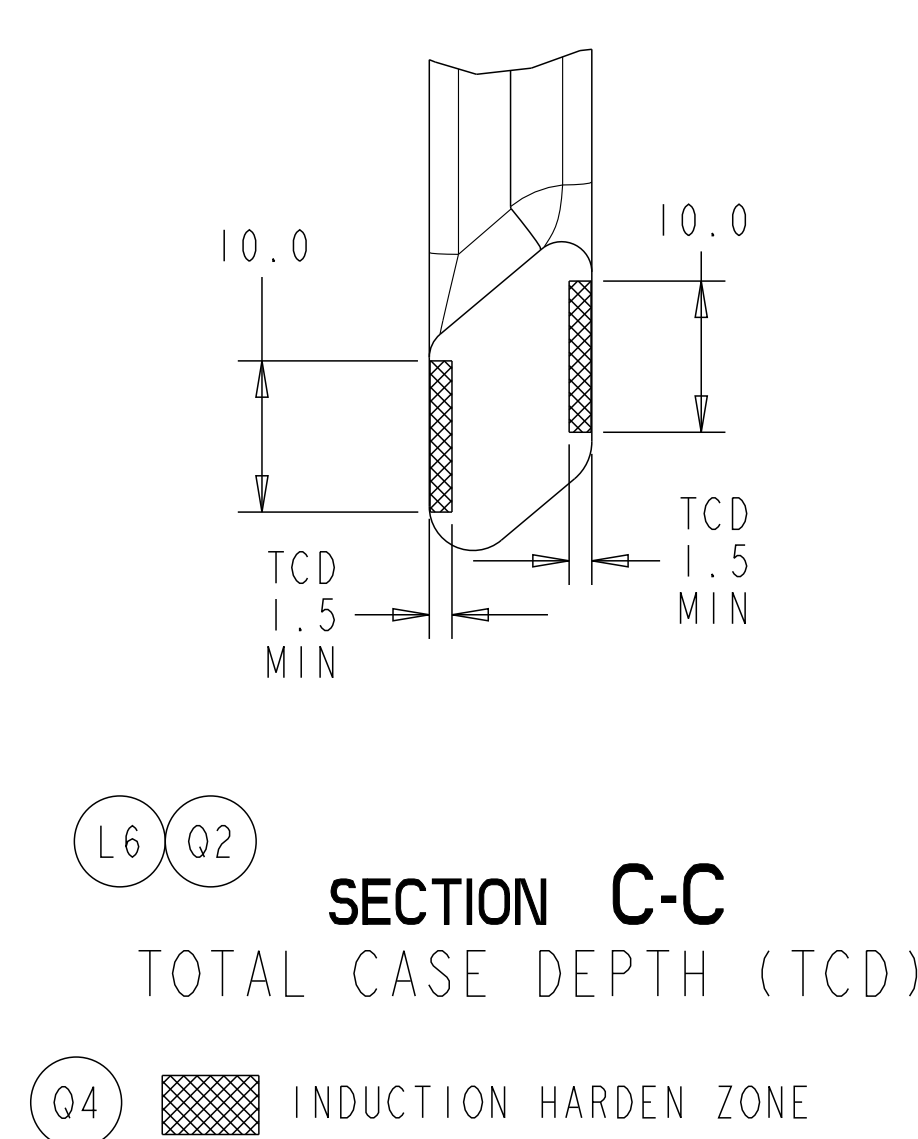
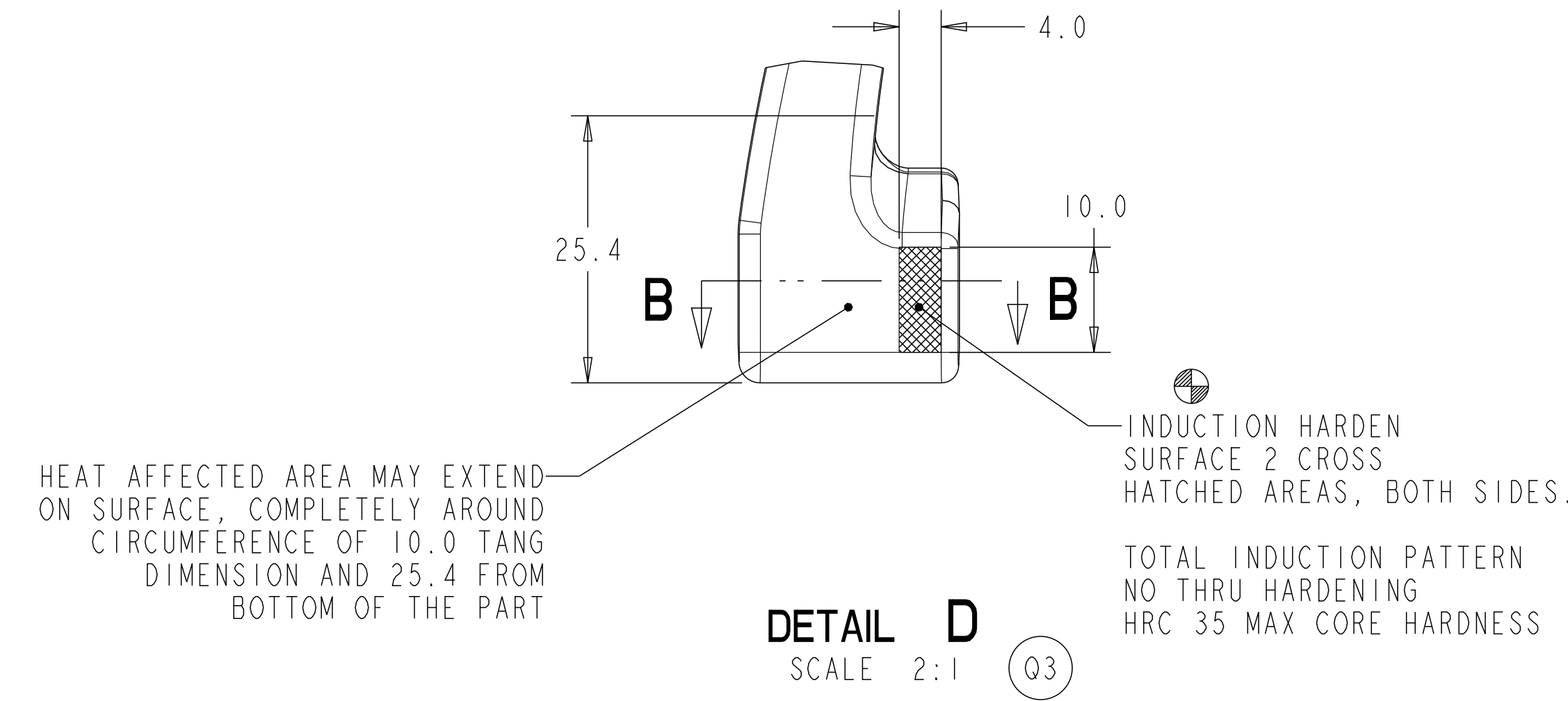
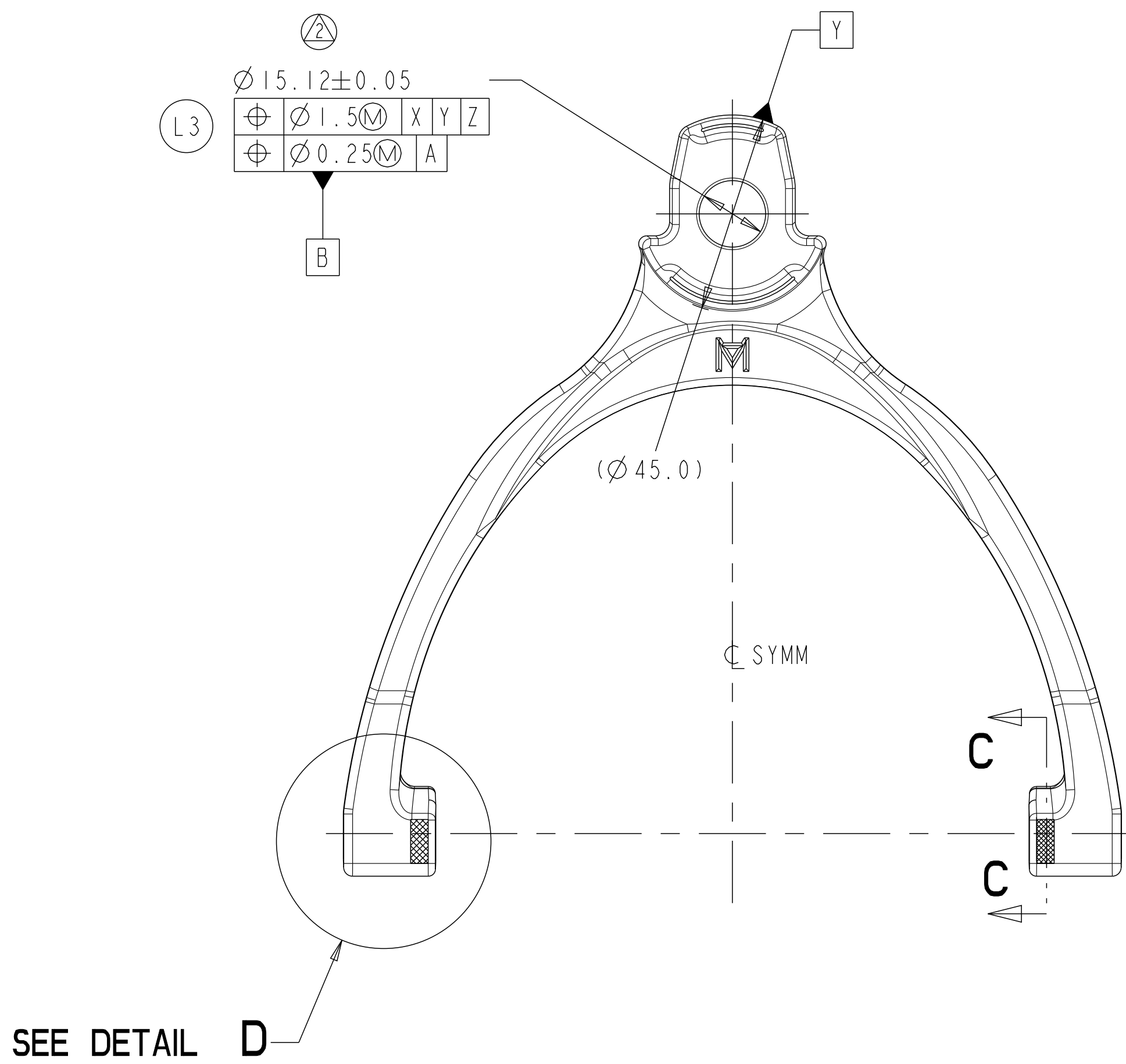
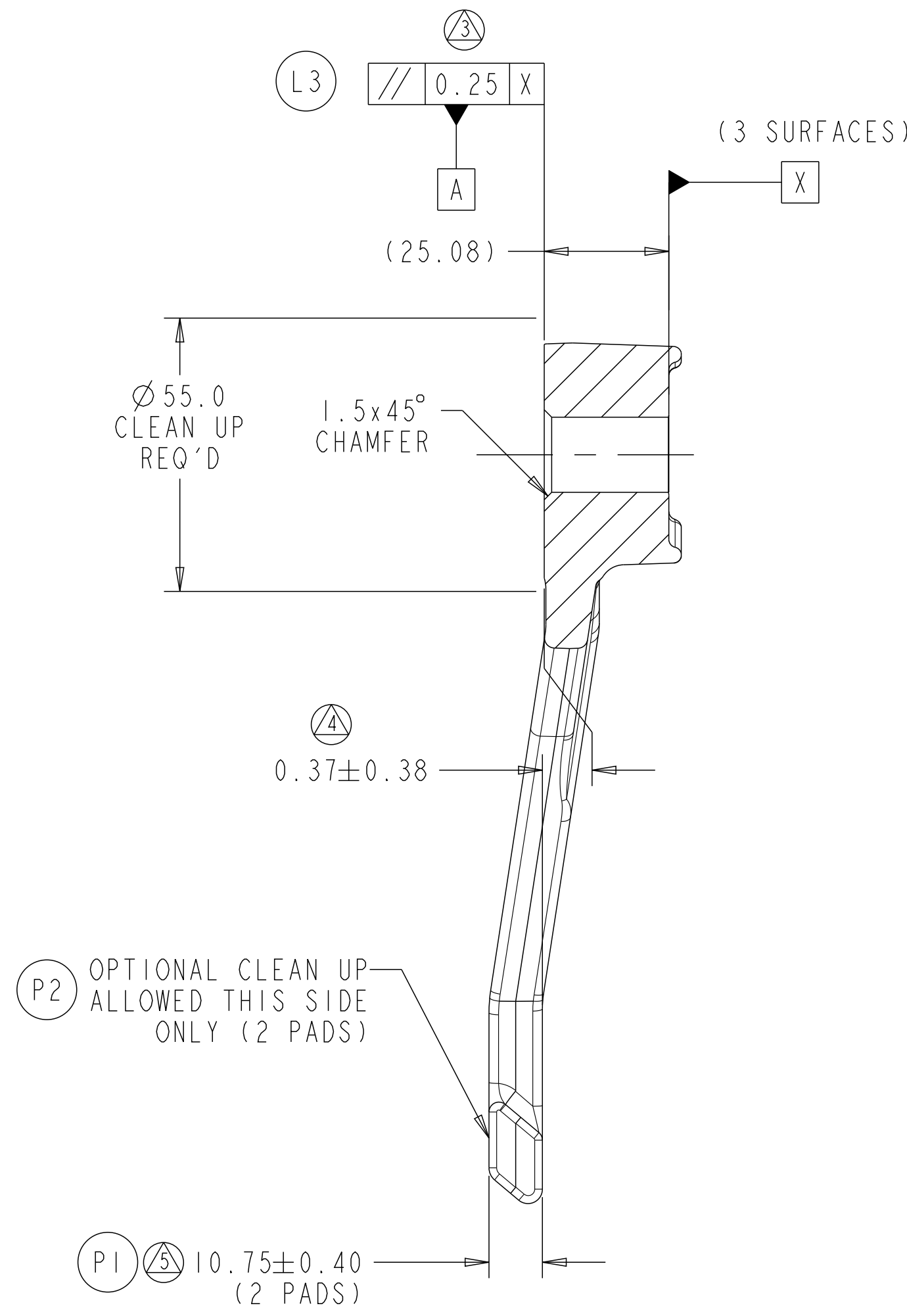
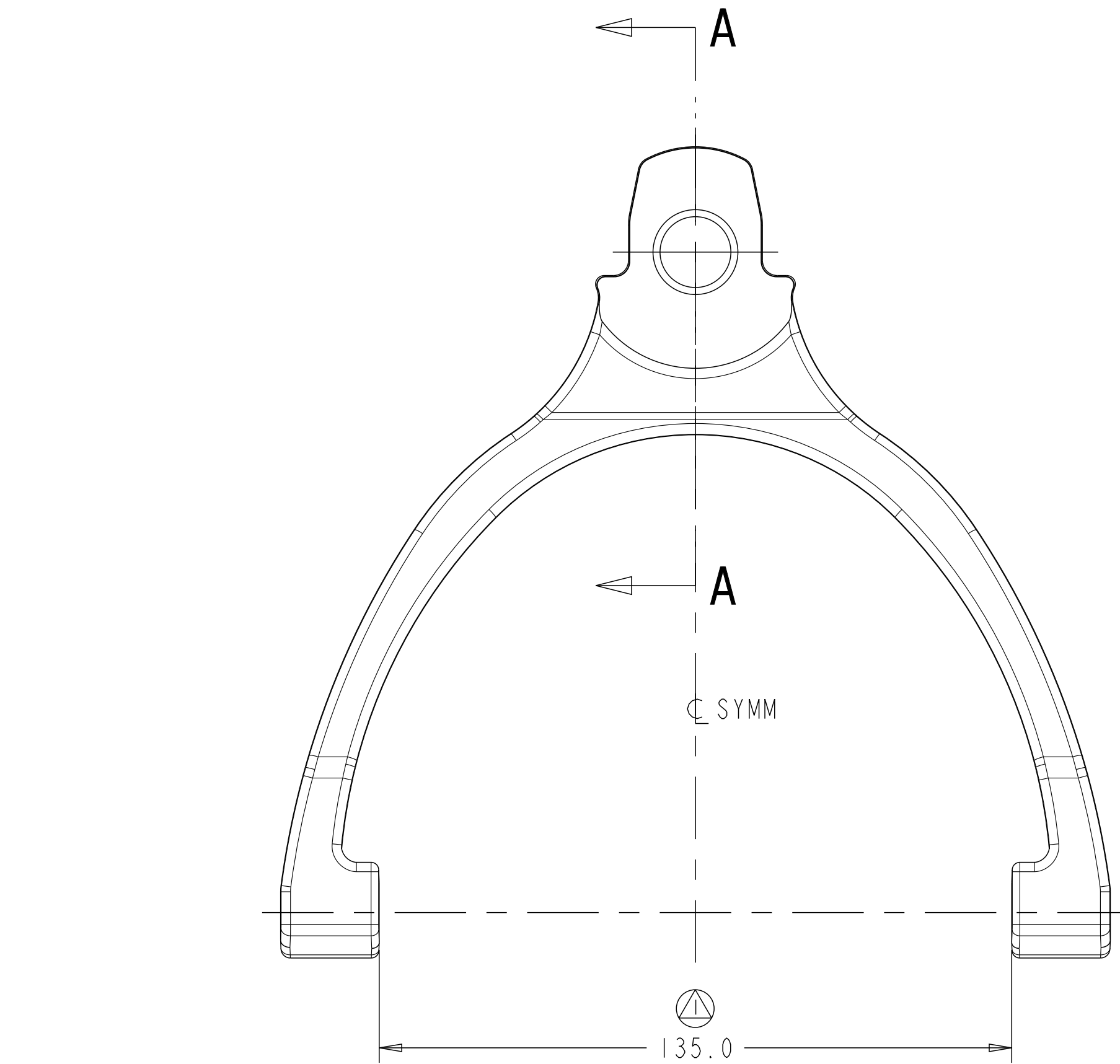
CASTING SETUP DATUMS :

- X- ESTABLISHES VERTICAL PLANE THRU DATUM TARGET POINTS X1, X2 & X3
- Y- DATUM AXIS THRU DATUM TARGET POINTS Y1, Y2 & Y3
- Z- DATUM TARGET POINT Z1 (ESTABLISHES VERTICAL ϕ OF FORKS)

MACHINE DATUMS :

- A- PISTON MOUNTING SURFACE
- B- PUSH ROD BORE

LAYOUT NO.	3296A1327, 3296B1328, & 3296B1380X		
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	ALL MACHINED SURFACE FINISHES ALL MACHINED INSIDE CORNERS 0.80 RADII. BREAK ALL SHARP EDGES REMOVE ALL BURRS, FINES, FLASH & PROJECTIONS CASTING TOLERANCES PER STD. ISO 8062-3 FORMING TOLERANCES ±1.6-0.8; DRAFTS 1°±1°		
REVISIONS			
L	L1-SEPARATED MACHINING DRAWING FROM CAST DRAWING 3296Z1378 AND UPDATED DATUM NAMINGS PER NEW STD	140921	AJB
	L2-REFORMATED DRAWING BY ADDING DATUM REFERENCE VIEWS	15-DEC-17	VMJ
	L3-UPDATED GD&T AND THE DATUM REFERENCE		
	L4-ADDED PROCESS SPEC 456-B & 703		
	L5-ADDED GENERAL NOTES L6-ADDED VIEW FOR INDUCTION HARDENING DETAILS		
M	MODEL UPDATE	ECN-158718 5-1-2019	RDK JO
N	ADDED NOTE #2	ECN-161140 11-26-2019	RDK JO
P	1-ADDED 10.75±0.40 DIM & OCC 5 2-ADDED OPTIONAL CLEAN UP NOTE 3-ADDED OCC 5:PAD WIDTH TO OCC NOTE	ECN-166184 31-JAN-20	PJG GS
	1-MOVED SECTION B-B & REMOVED CHAMFER REQUIREMENT, ADDED INDUCTION HARDENING ZONES 2-MOVED SECTION C-C & UPDATED INDUCTION HARDENING ZONES 3-MOVED DETAIL D 4-ADDED INDUCTION HARDENING ZONE LEGEND	ECN-185776 16-MAR-22	BWS GS



QUALITY CONTROL CHARACTERISTICS

- Ⓐ DENOTES MAJOR CHARACTERISTIC
- Ⓐ COLLAR OPENING
- Ⓐ MACHINED BORE
- Ⓐ MACHINE SURFACE FACE
- Ⓐ PAD LOCATION
- Ⓐ PAD WIDTH

GENERAL NOTES:

- 1) MACHINED SURFACES MUST MEET REQUIREMENTS IN SECTION 2.4 OF D-1 PER SOUNDNESS LOCATIONS CALLED OUT ON CASTING DRAWING 3296Z1378
- 2) NO TYPE 1 DECARBURIZATION PER SAE J419 IS ALLOWED ON INDUCTION HARDENED SURFACES.

3296Z1378	104553 106405	PART/DWG NO. 3296A1379	03190
MAKE FROM	RELEASE	NAME FORK-SHIFT, FIN.	ENG. DESC. CODE
PROJECT ENGINEER DRAWN BY/REDRAWN BY CHECKED BY/RECHECKED BY	PLATNER / BODARY, ANDREW KGB / JADHAV, VAIBHAV M. DP / BODARY, ANDREW	3RD ANGLE PROJECTION	DRAWING SIZE E
SCALE 1:1	DESIGN CONTROL GROUP AXLE REAR NA	CHANGE REQUEST # 111607-006	DRAWING 3296A1379 0.4
WEIGHT 0.519 ORIGINAL FOR kg MT-40-142	PROCESS 456-B & 703	MODEL 3296A1379 0.3	SHEET 1 OF 1