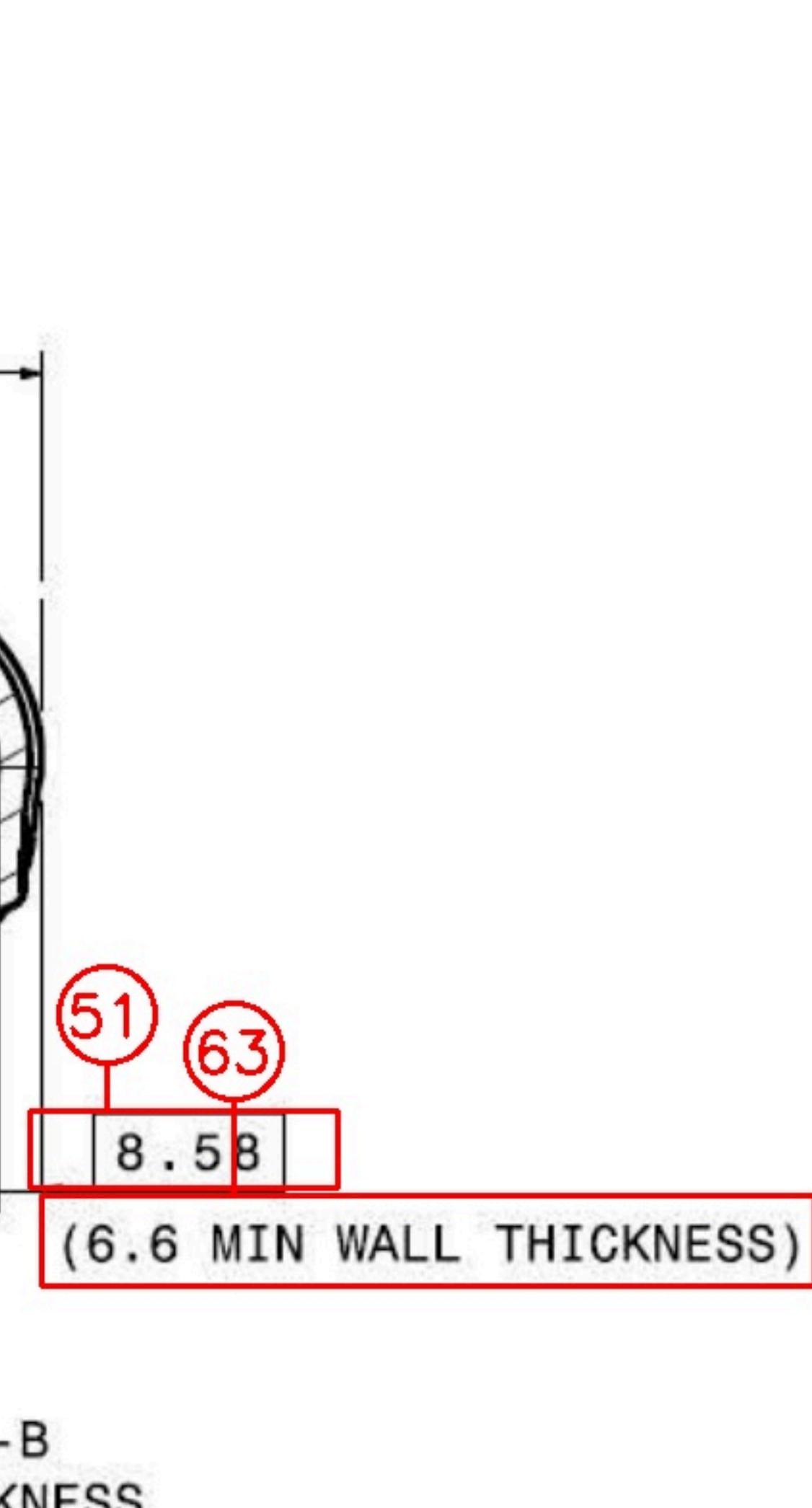


FRONT VIEW



SECTION VIEW B-B  
EP3 MTN WALL THICKNESS

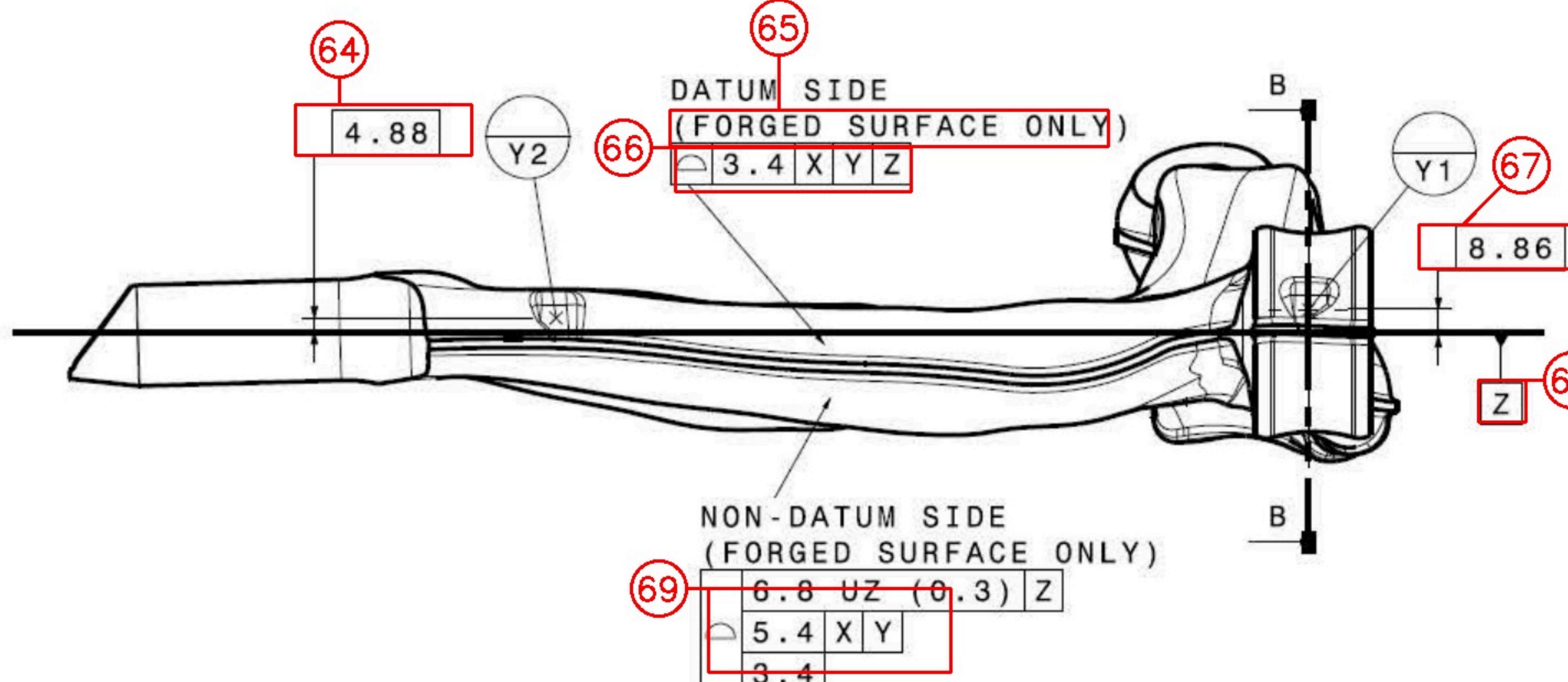
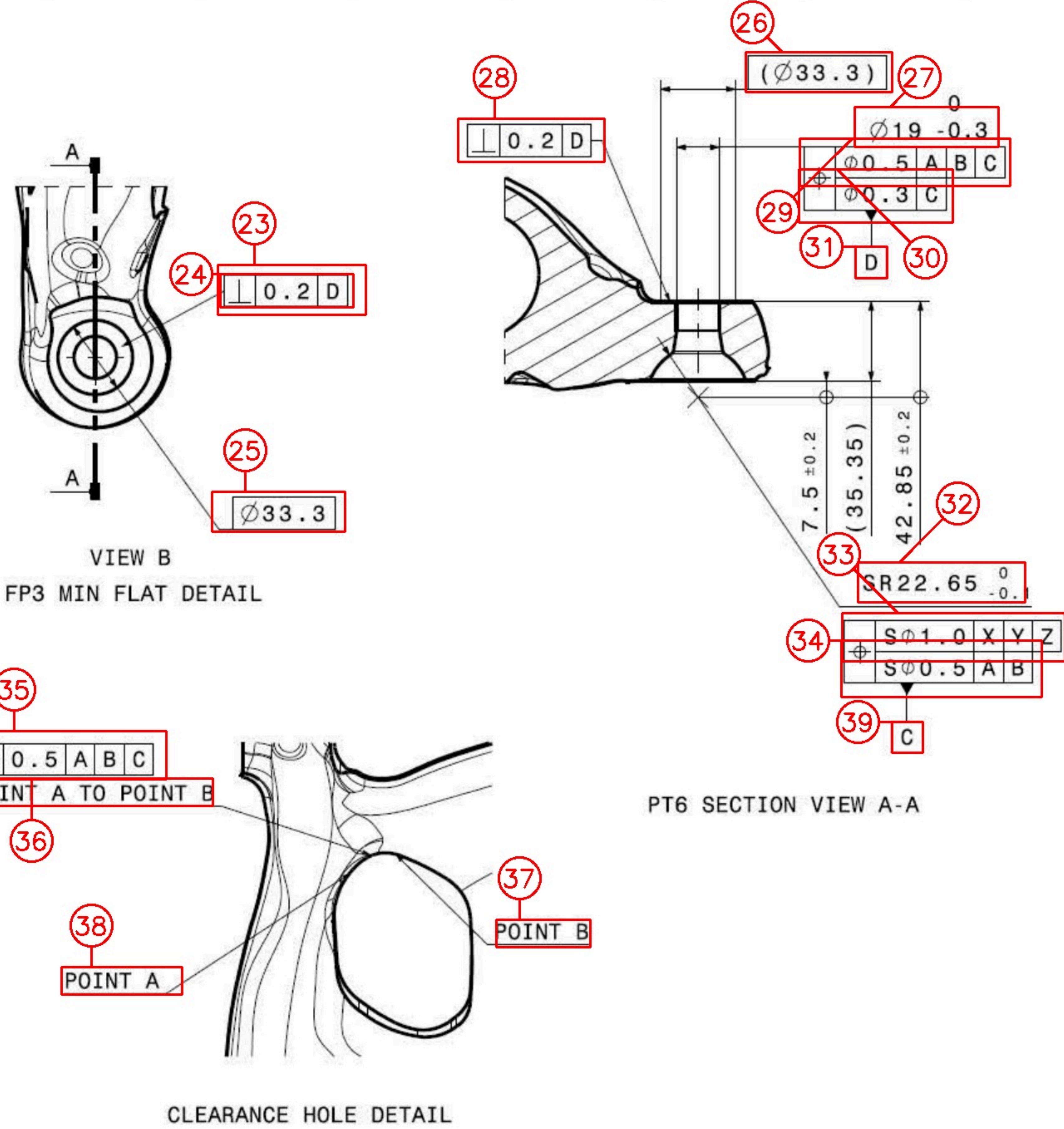


TABLE NO

ITEM	PART NO	DESCRIPTION	MATERAIL	COATING	WEIGHT
71	1 548232103803	LOWER CONTROL ARM LH	A1Si1MgMn - T6 TS > 400 MPA YS > 380 MPA E% > 8% HARDNESS > 85HB	N/A	4.348 kg
	2 548232103801	LOWER CONTROL ARM RH			4.348 kg

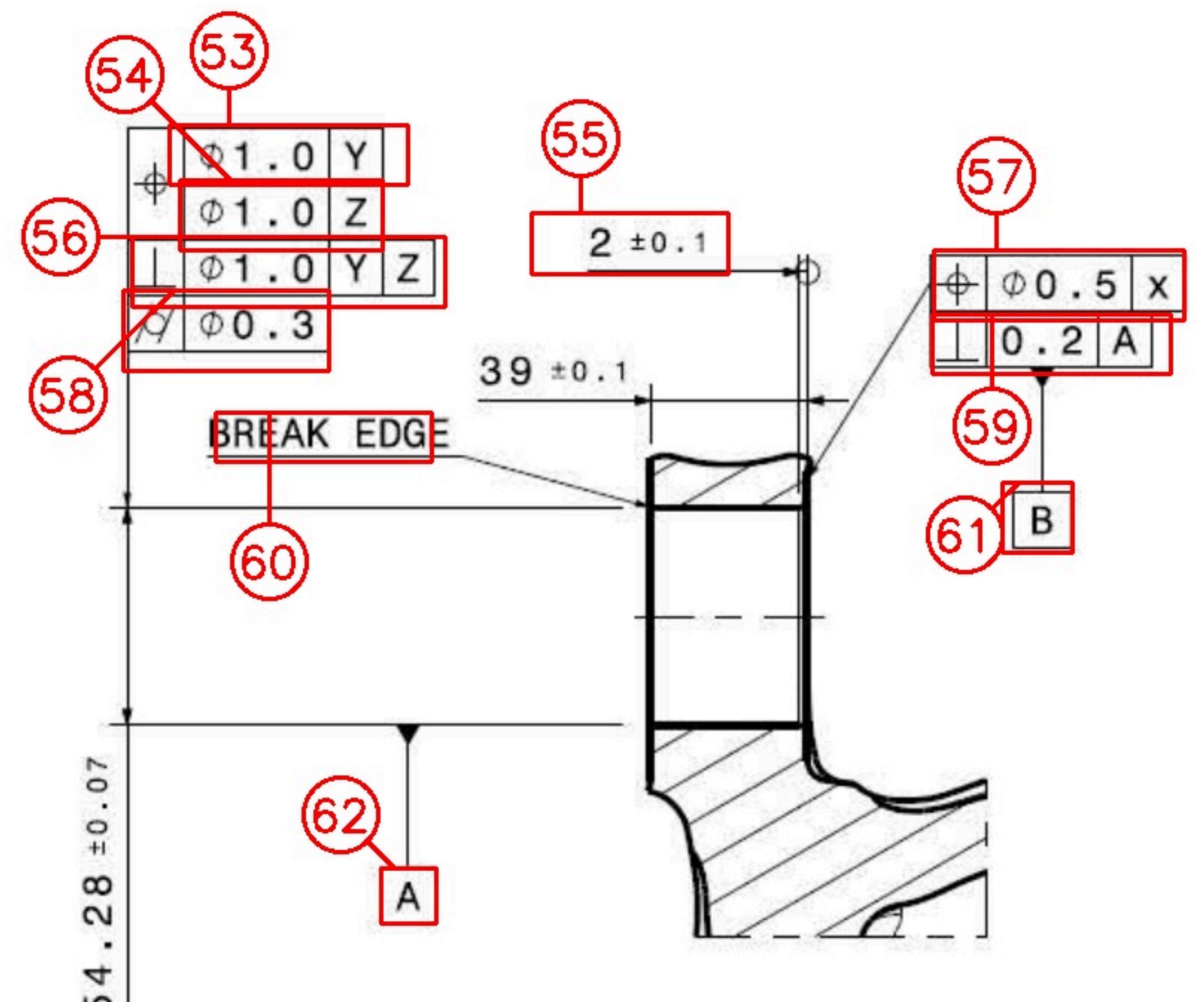
FOR ADDITIONAL DETAILS REFER CAD DATA



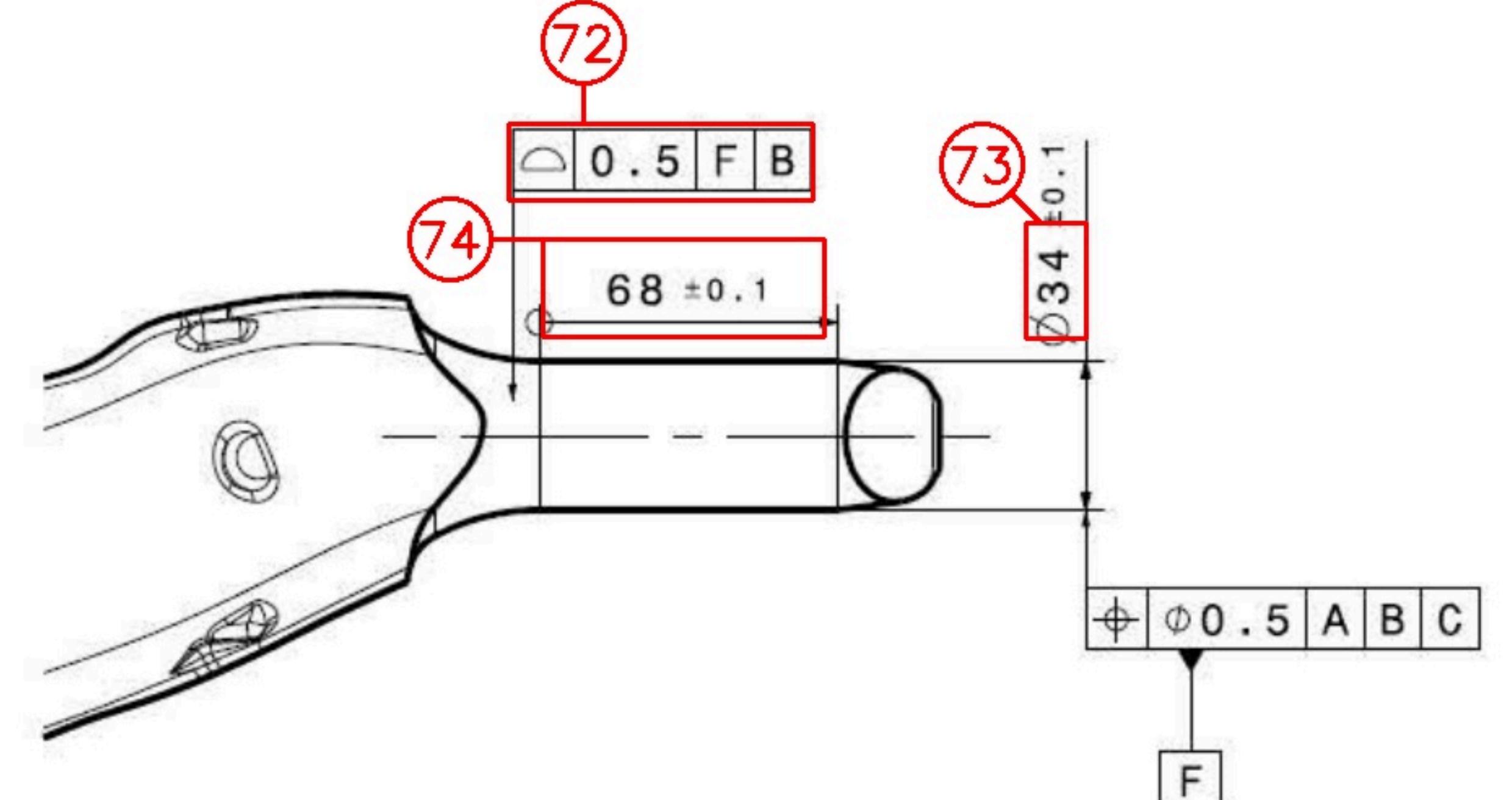
VIEW B

PT6 SECTION VIEW A-A

#### CLEARANCE HOLE DETAIL

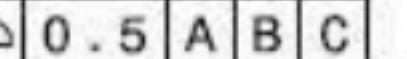


PT3 SECTION VIEW C-C



FP4 DETAIL VIEW

## NOTES

- PART MUST CONFORM TO 548232103801/548232103803 LATEST REVISION.
  - ALL DIMENSIONS ARE IN FINISHED CONDITION UNLESS OTHERWISE STATED
  - UNDIMENSIONED MACHINED FEATURES TO COMPLY WITH GENERAL TOLERANCES ISO 22081 UNLESS OTHERWISE SPECIFIED 
  - DIMENSIONED MACHINED FEATURES WITHOUT INDIVIDUAL TOLERANCE INDICATIONS TO COMPLY WITH ISO 2768-mK UNLESS OTHERWISE SPECIFIED
  - THE MACHINED PART SHALL CONFORM TO THE FOLLOWING:
    - COMPLETELY FREE FROM HAZARDOUS BURRS & SHARP EDGES (SEE ES FOR MORE INFO)
    - WASHED, FREE FROM GREASE, OIL, LUBRICANT, SWarf & DEBRIS
    - THREADS DEBURRED IN ACCORDANCE WITH DIN 76-1
    - MAXIMUM MACHINING ROUGHNESS ( $R_a$ ) 3.2 UNLESS OTHERWISE STATED
    - MAXIMUM DEPTH OF ALL INDENTED CHARACTERS AND MANUFACTURING SYMBOLS 1MM
  - FORGED RAW PART TOLERANCE TO BS EN 586-3 UNLESS OTHERWISE SPECIFIED, SEE THE FOLLOWING FOR DEFINED VALUES FROM THE STANDARD:
    - DIE CLOSURE TOLERANCE +2.0/-1.4mm
    - DIE MISMATCH TOLERANCE +1.0mm
    - SHAPE TOLERANCE:
      - CRITICAL DIMENSIONS DEFINED ON THE DRAWING
      - REFER TO THE STANDARD FOR NON DIMENSIONED SURFACES (MAXIMUM  $\pm 1.7\text{mm}$  CONSIDERED FOR TMPV DESIGN PURPOSES ONLY)SEE 'GENERAL PROFILE TOLERANCE VIEW' FOR MORE DETAILS
  - THE RAW PART SHALL CONFORM TO THE FOLLOWING:
    - MAXIMUM ALLOWABLE FLASH 1.5MM - NOT SHARP
    - MAXIMUM ROUGHNESS ( $R_z$ ) 35
    - MAXIMUM HEIGHT OF ALL EMBOSSED CHARACTERS AND MANUFACTURING SYMBOLS 1.5MM
  - NO ADDITIONAL MARKINGS SHALL BE PRESENT ON THE PART OTHER THAN WHAT'S SPECIFIED ON THE DRAWING
  - MATERIAL: SPECIFIED IN TABLE 1 (SEE ES FOR MORE DETAILS)
  - WEIGHT: SPECIFIED IN TABLE 1 (INFORMATION PURPOSES ONLY, CAD APPROXIMATE)
  - CORROSION PROTECTION: SPECIFIED IN TABLE 1 (SEE ES FOR MORE DETAILS)
  - LH AS DRAWN, RH SYMMETRICALLY OPPOSITE UNLESS OTHERWISE STATED (EXCEPT FOR PART MARKINGS).
  - MATERIAL FOR BLACK BOX ("OFF THE SHELF") OR GREY BOX (JOINTLY DESIGN BY THE SUPPLIER & TMPV) ITEMS SHALL CONFORM TO TMPV MATERIAL CONTROL SPECIFICATION STJLR.51.5227

## 14. EXTERNAL THREADS FOR A COATING THICKNESS $\leq$ 15 MICROMETER (INCLUDING TOLERANCES):

- FOR A COATING THICKNESS  $\leq$  15 MICROMETER (INCLUDING TOLERANCES) :

  - THE THREAD PRECOATING TO CLASS 6g MIN TO ISO 965
  - THREAD POST COATING NOT TO TRANSGRESS THE MAX. MATERIAL LIMITS FOR POSITION h

FOR COATING THICKNESS > 15 MICROMETER (INCLUDING TOLERANCE) :

  - THREAD PRECOATING TO CLASS 6e MIN. TO ISO 965
  - THREAD POST COATING NOT TO TRANSGRESS THE MAX. MATERIAL LIMITS FOR POSITION h
  - CLASS 6H GO SCREW GAUGE ACCEPTANCE < TABLE 2 AS PER TSO 6157

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TABLE 2 - EXTERNAL THREADS

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STUD THREAD DIA (mm)	MAX THREAD TORQUE (Nm)
10	1
12	1.7
14	2.7
16	4.1
20	8.0
24	13.8

15. ALL DIMENSIONS ARE IN THE PRE-COATED CONDITION UNLESS OTHERWISE STATED
  16. QR CODE REFER STD STJLR.AD.5005, SIZE 15X15mm.
  17. BAR CODE LABEL AS PER TATA MOTORS STANDARD (TS11879).
  18. TATA LOGO AS PER TATA MOTORS STANDARD (TS11234).

Design Yield:  
-- %

or Bar Codes System of Supplier Parts, refer TS 11879  
or Numbering of Aggregates Manufactured in-house, refer TS 11842  
or List of Parts having Recall & Traceability Requirements, refer TS 10814  
or 811 Vehicle Components & Assemblies,  
data Group Mark & Part No. to be marked as per TS 10806