



- 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 $\pm 0.5 A B C$
 - 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 (Ra) 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 ±1.7mm CONSIDERED FOR TMPV DESIGN PURPOSES ONLY)
 - THE RAW PART SHALL CONFORM TO THE FOLLOWING:
 - MAXIMUM ALLOWABLE FLASH 1.5MM NOT SHARP
 - MAXIMUM ROUGHNESS (Rz) 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
 - EXTERNAL THREADS
 - FOR A COATING THICKNESS ≤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 ISO 6157
- | 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 |
- ALL DIMENSIONS ARE IN THE PRE-COATED CONDITION UNLESS OTHERWISE STATED
 - QR CODE REFER STD STJLR.AD.5005, SIZE 15X15mm.
 - BAR CODE LABEL AS PER TATA MOTORS STANDARD (TS11879).
 - TATA LOGO AS PER TATA MOTORS STANDARD (TS11234).

TABLE NO 01					
ITEM	PART NO	DESCRIPTION	MATERAIL	COATING	WEIGHT
1	548232103803	LOWER CONTROL ARM LH	AlSi1MgMn-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.

Design Yield:
-- %

For Bar Codes System of Supplier Parts, refer TS 11879
For Marking of Apparatus Manufactured in-house, refer TS 11840
For List of Parts Having Heat & Treatment Requirements, refer TS 10844
For All Vehicle Components & Assemblies
Tata Group Mark & Part No. to be marked as per TS10806
For M1 & M2 class of vehicles, applicable standards are:
TS11414, TS11418, TS11419 & TS11420
Material Description, Size, Spec, Std. No.
REFER TABLE NO 01

Classification of characteristic:
● Critical ▲ Key Instruction
● Major (None) Minor
● Applies to upper limit
● Applies to lower limit

Date: 23/02/2024
Mod No: M04
S.No: 01
Zone: 01

Envelope Dimensions (L x W x H): 602x382x102
Fin pass surface protection as per Std. Refer Notes:
4.348 Tol. as per std.

Replaces Drg. No.:
Reference Drg. No.: SEMA-3A053-A
Qsp. Hand Drg. /Prt. No.: 5482 3210 38 01
Drg. /Part Designation:
LOWER CONTROL ARM LH

Sheet No: 1 of 1 Sheets