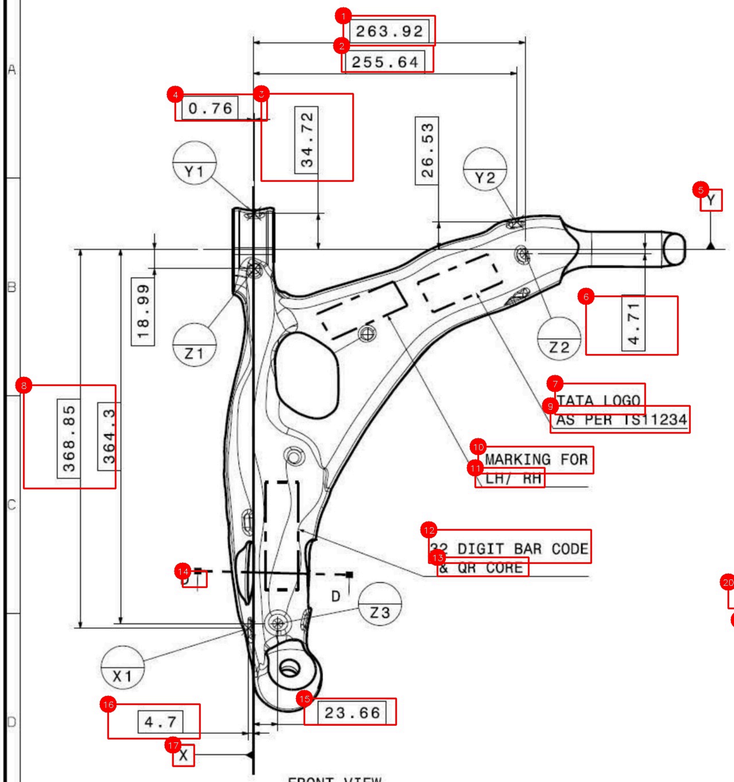
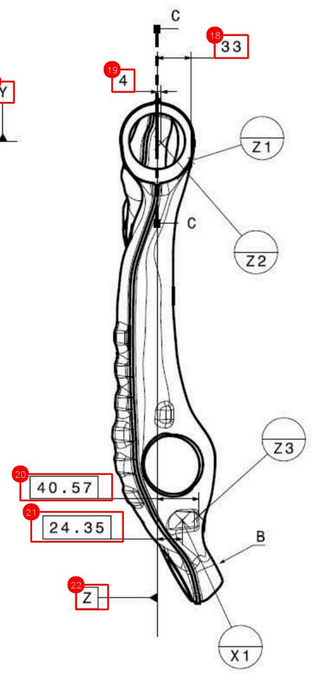
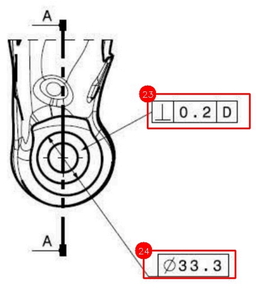
5482 3210 38 03



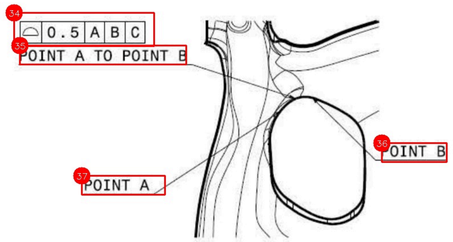
FRONT VIEW



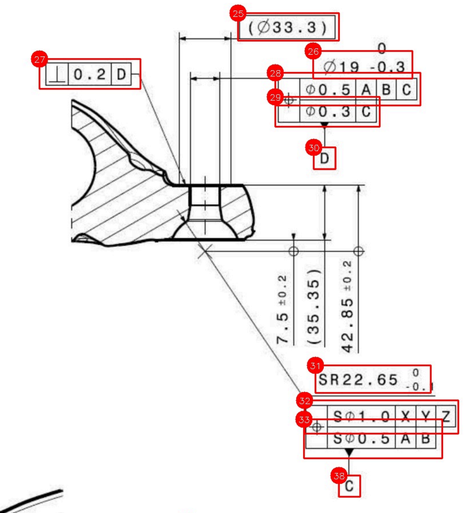
SIDE VIEW



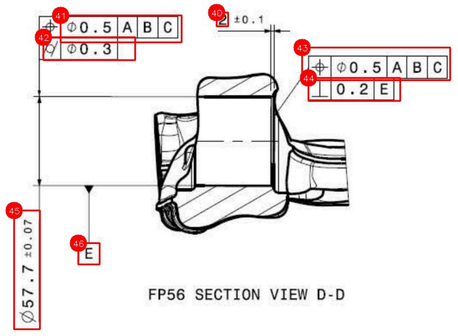
VIEW B
FP3 MIN FLAT DETAIL



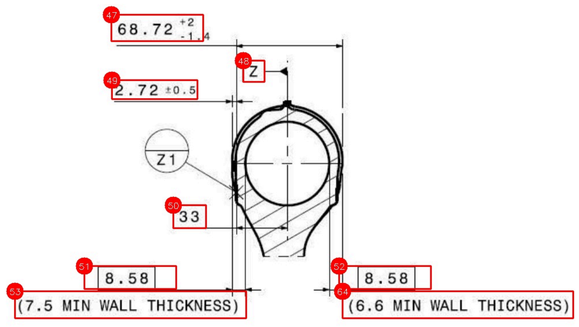
CLEARANCE HOLE DETAIL



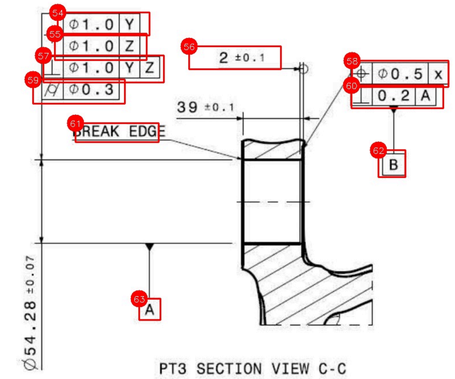
PT3 SECTION VIEW A-A



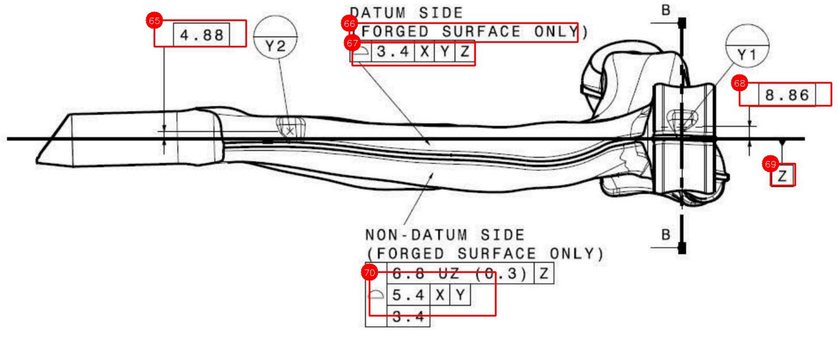
FP56 SECTION VIEW D-D

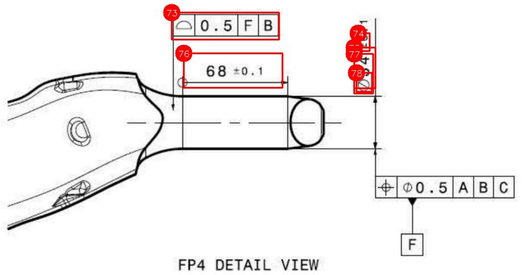


SECTION VIEW B-B
FP3 MIN WALL THICKNESS



PT3 SECTION VIEW C-C





FP4 DETAIL VIEW

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.

Do not scale the drg	Unless otherwise stated 1. All diams. in mm. 2. Drg drawn to first angle projection 3. For supplier drg release,refer angle of projection on supplier drg	Nominal dim	Tolerances in µ m
If in doubt. Ask		----	--

NOTES

1. PART MUST CONFORM TO 548232103801/548232103803 LATEST REVISION.
2. ALL DIMENSIONS ARE IN FINISHED CONDITION UNLESS OTHERWISE STATED
3. UNDIMENSIONED MACHINED FEATURES TO COMPLY WITH GENERAL TOLERANCES ISO 22081 UNLESS OTHERWISE SPECIFIED ⌓ 0.5 A B C
4. DIMENSIONED MACHINED FEATURES WITHOUT INDIVIDUAL TOLERANCE INDICATIONS TO COMPLY WITH
ISO 2768-mK UNLESS OTHERWISE SPECIFIED
5. 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
6. 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)
SEE 'GENERAL PROFILE TOLERANCE VIEW' FOR MORE DETAILS
7. 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
8. NO ADDITIONAL MARKINGS SHALL BE PRESENT ON THE PART OTHER THAN WHAT'S SPECIFIED ON THE DRAWING
9. MATERIAL: SPECIFIED IN TABLE 1 (SEE ES FOR MORE DETAILS)
10. WEIGHT: SPECIFIED IN TABLE 1 (INFORMATION PURPOSES ONLY, CAD APPROXIMATE)
11. CORROSION PROTECTION: SPECIFIED IN TABLE 1 (SEE ES FOR MORE DETAILS)
12. LH AS DRAWN, RH SYMMETRICALLY OPPOSITE UNLESS OTHERWISE STATED (EXCEPT FOR PART MARKINGS).
13. 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 ≤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

TABLE 2 - EXTERNAL THREADS	
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: -- %

For Bar Codes System of Supplier Parts, refer TS 11879
For Numbering of Aggregates Manufactured in-house, refer TS 11847
For List of Parts having Recall & Traceability Requirements, refer TS 15814
For all Vehicle Components & Assemblies,
Tata Group Mark & Part No. to be marked as per TS10805
For M1 & N1 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	Mod No	S. No	Zone	Modification	CHKD	APPD

2024	SIGN	DATE	
DRN	MDA	23/02	
CHKD	PRG	23/02	
APPD	NOD	23/02	
Scale 1:2			

Envelope Dimensions (L x W x H): 602x382x102
Fin mass in kg: 4.348
Surface protection as per Std. Refer Notes.
Tol. as per std.
Product/Group No.:
Replaces Drg. No.: –
Reference Drg. No.: SEMA-3A053-A
Opp. Hand Drg. /Pt. No.: 5482 3210 38 01
Drg. /Part Designation: LOWER CONTROL ARM LH
Drg. /Part No.: 5482 3210 38 03
Sheet No 1 of 1 Sheets

A1