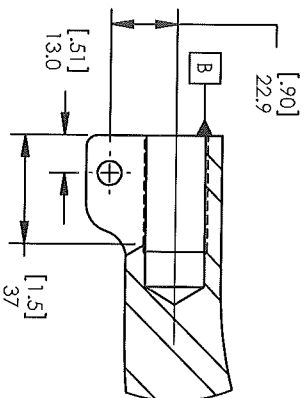
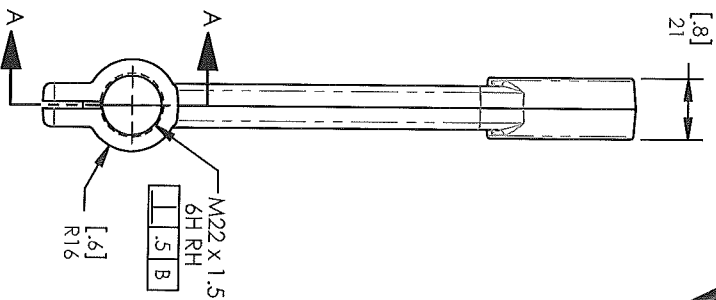
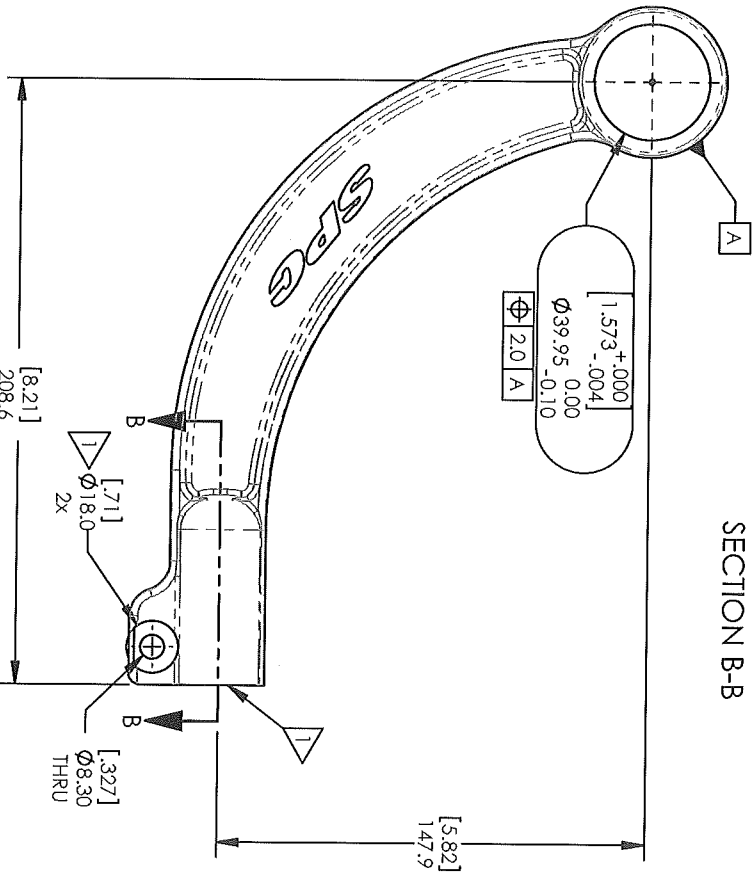
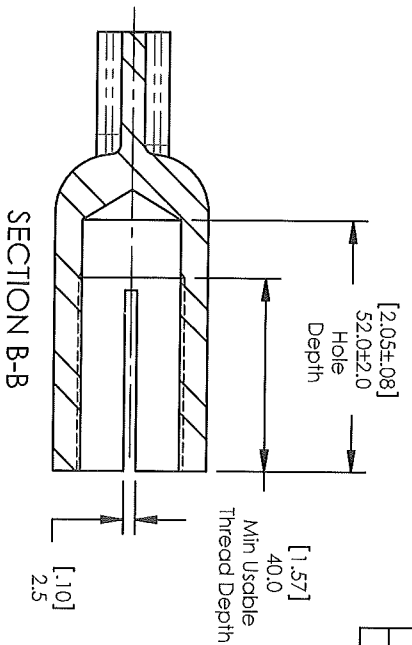


NOTES:  
1. Machine casting square to bore at end of part and spot-face bolt through-hole on both sides.

6746613 Forging, Control Arm Body			
DATE	REV	BY	ECN
			0
REVISION COMMENTS			
			0
30 Sep 13	A	Production release.	
		CDH	1521



## 6746613 Forging, Control Arm Body

INTERPRET & PROCESS  
per MSS-4.000

**DO NOT SCALE DRAWING**  
UNDIMENSIONED FEATURES  
ARE CONSIDERED NOMINAL.  
3D MODEL SURFACES WITH  
TOLERANCE ±0.50mm(0.020")

CONFORMS TO  
ASME Y 14.5M 1984  
ANGLES (deg)  
None ±1.00 [X ±0.040] None ±2.00 [X ±1.0]  
XX ±0.25 [XXX ±0.010] XX ±0.5

DRAWN: CDH  
DATE: 13 Jun 13  
CHECKED:

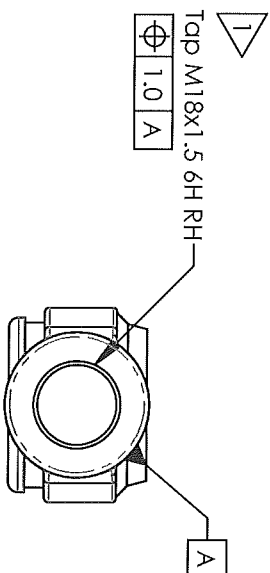
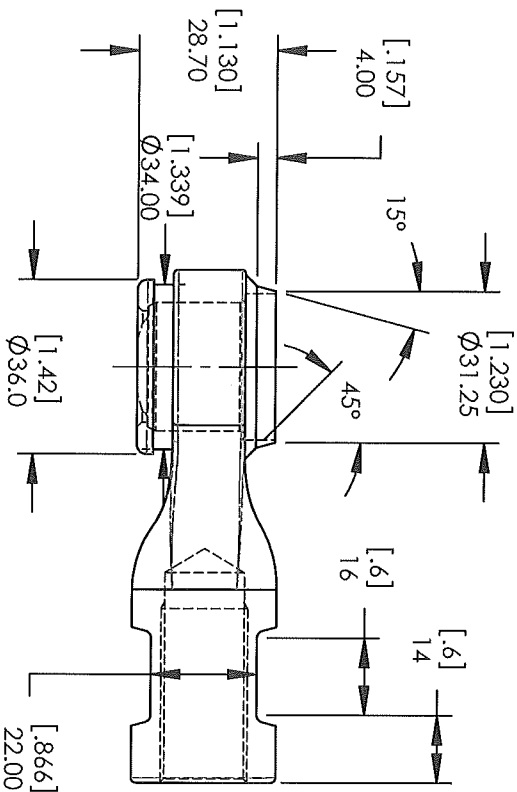
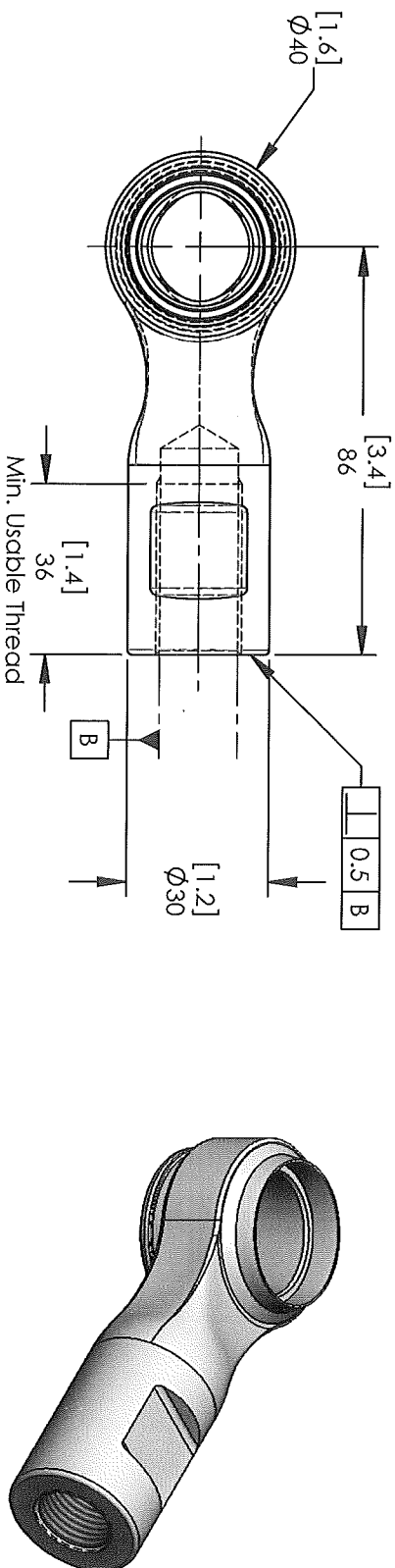
MATERIAL: Forged Alloy Steel per ASTM A668 Class H  
Min Yield 414MPa [60ksi]  
FINISH: E-Coat Black per MSS 2.003

Rev. A  
SHEET 1 of 1

## Housing, Ball Joint

DATE	REV	REVISION COMMENTS	BY	ECN
9/22/10	A	Initial Release.	CDH	991
10/25/11	B	Changed thread size to M18 x 1.5, 36mm usable. Changed wrench flat to 22mm (7/8"). Changed OD to 30mm. Shortened thread tube 3mm.	CDH	1050
28 Mar '11	C	Updated sheet format. Added 15 deg. taper for swage lip. Relaxed non-critical tolerances. Changed max flash width from 2.5 to 3mm.	CDH	1096

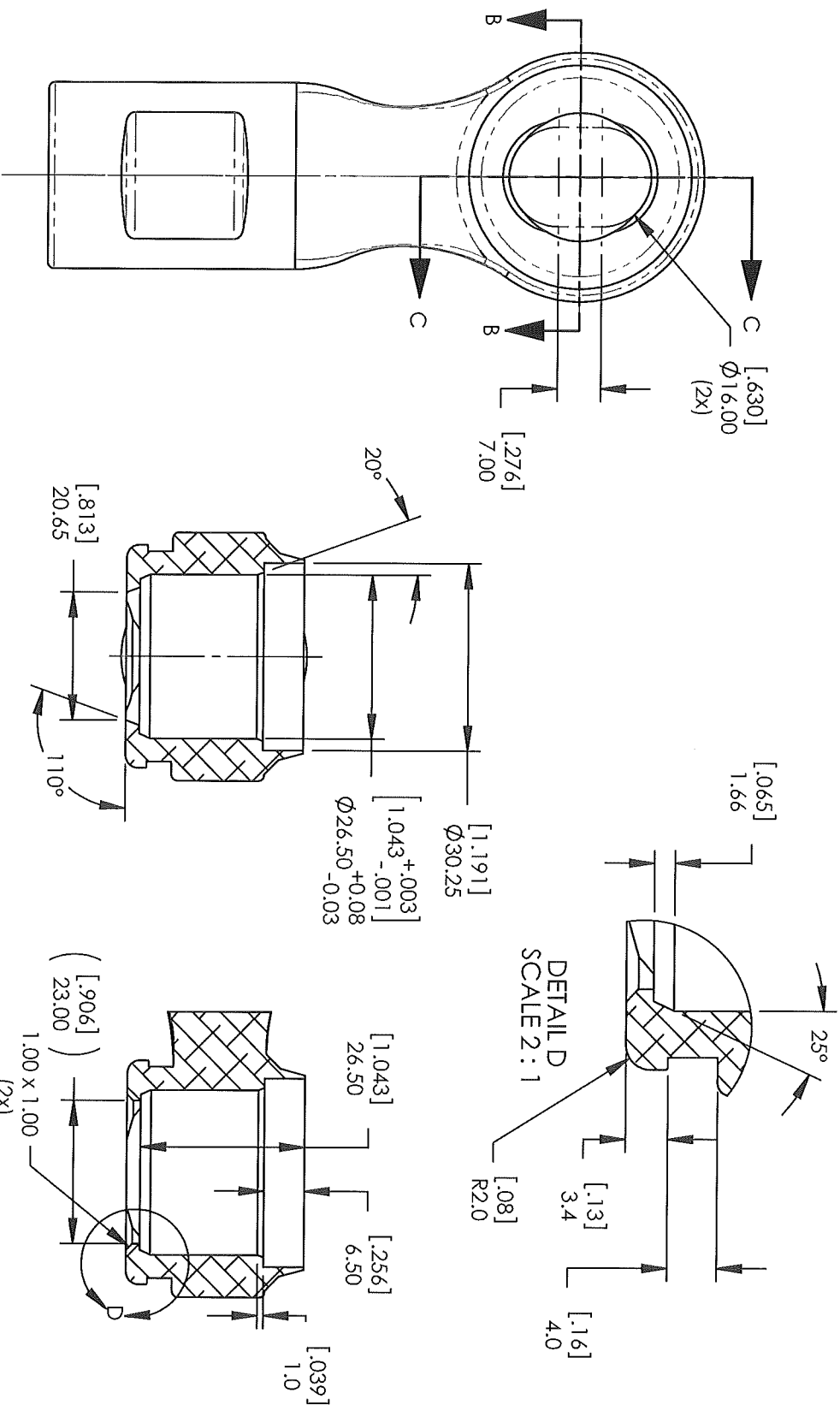
- Thread Class 6H per ASME B1.13M.  
All dimensions are excluding flash, undimensioned features as forged.  
Use Trim Die to remove flash; trim width to be less than 3mm.  
All surfaces to be no more than 1/8" after anodize.  
After forging, heat treat to T6 Temper.  
Test per MSS-4.011 to the following material specifications:  
- Yield Strength > 35Ksi Min.  
- Brinell hardness 90-100.



**INTERPRET & PROCESS  
per MSS-4.000**

8135219 Housing, Ball Joint

DO NOT SCALE DRAWING		CONFORMS TO ASME Y 14.5M-1984
UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AT 3D MODEL SURFACES WITH TOLERANCE $\pm 0.50\text{mm}(\pm 0.020")$	LINEAR (mm/in) None: 1.00 X $\pm 0.040"$ X $\pm 0.50$ XX $\pm 0.020"$ XX $\pm 0.25$ XXX $\pm 0.015"$	ANGLE (deg) None: 2.0° X $\pm 1.0°$ XX $\pm 0.5°$
DRAWN: CDH	DATE: 9/22/10	
MATERIAL: Forged 6061 Aluminum	OPT. MAT'L: None	
FINISH: Clear Matte Anodize per MIL-A-8625 T-2 CL-1	CHECKED: JRF	
Rev. C	SHEET 1 of 2	

SECTION B-B  
SCALE 1 : 1SECTION C-C  
SCALE 1 : 1INTERPRET & PROCESS  
per MSS-4.000

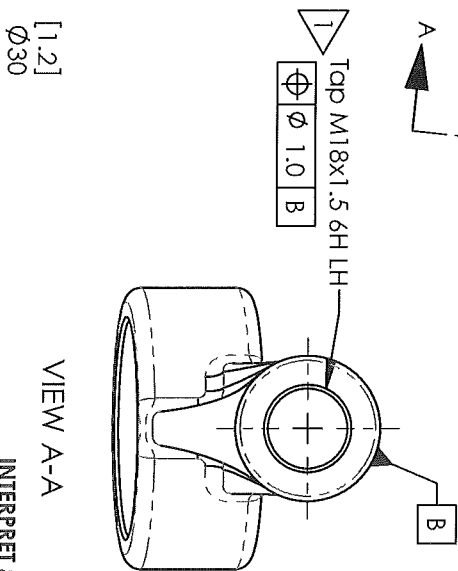
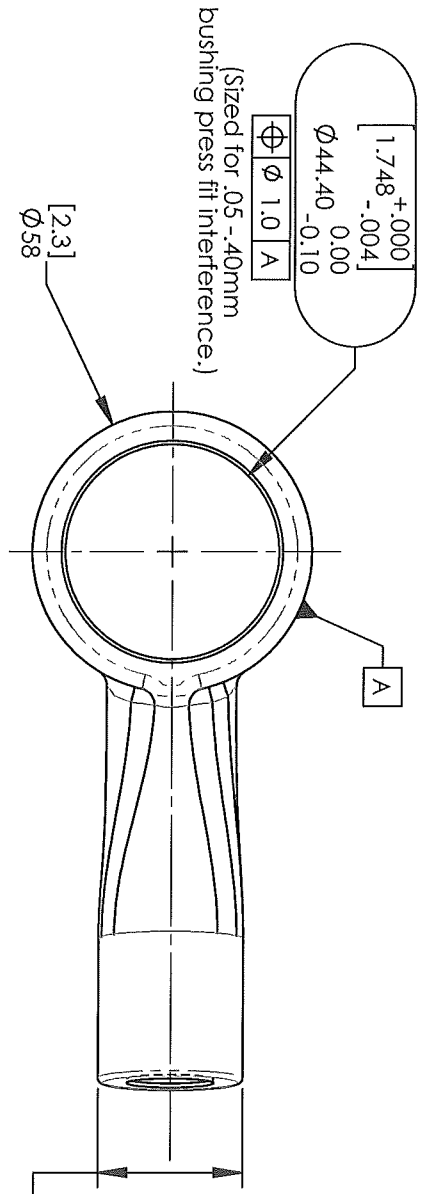
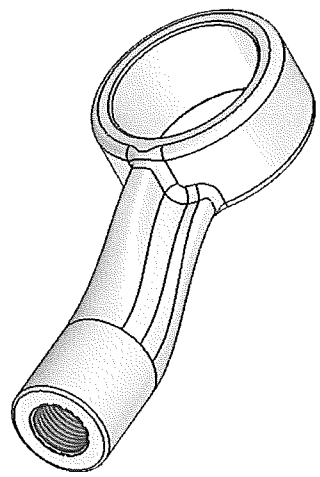
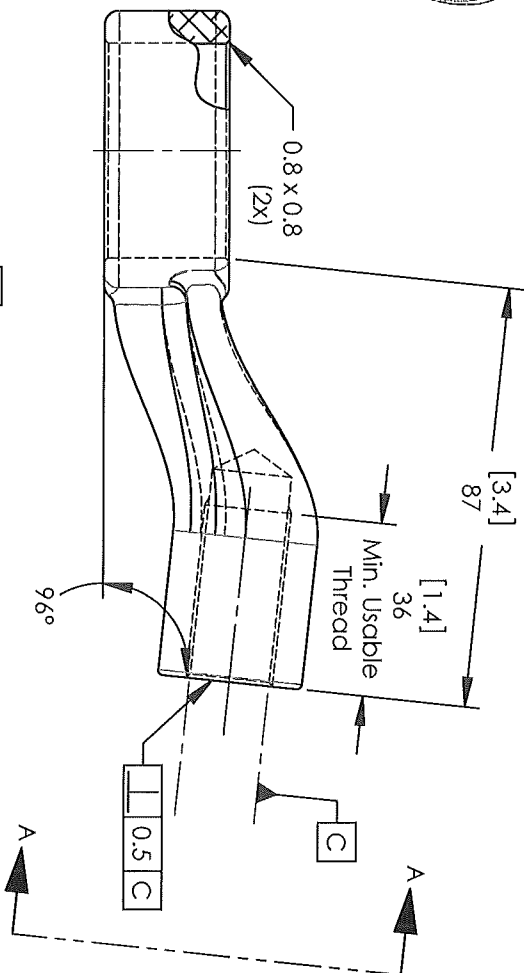
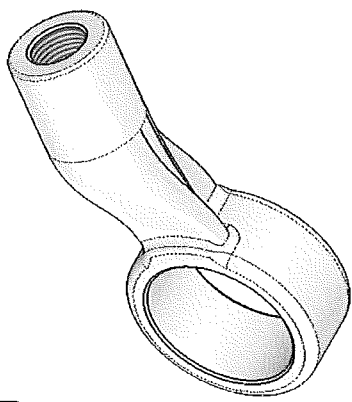
## 8135219 Housing, Ball Joint

## DO NOT SCALE DRAWING

UNDIMENSIONED FEATURES		CONFORMS TO		DRAWN: CDH		MATERIAL: Forged 6061 Aluminum		Rev. C
ARE CONSIDERED NOMINAL	LINEAR (mm/in)	ANGLE (deg)	SCALE 1:1	DATE: 9/22/10	OPT. MATL: None			
AND MODE SURFACES WITH X	Nominal $\pm 1.00$ [X $\pm 0.040$ ] X $\pm 1.0$	Nominal $\pm 2.0$		CHECKED: JRF	FINISH: Clear Matte Anodize per MIL-A-8625 T-2 CL-1			SHEET 2 of 2
TOLERANCE $\pm 0.50$ mm (0.020")	[X $\pm 0.25$ ] [XX $\pm 0.07$ ] [X $\pm 0.5$ ]							

- Notes:
1. Thread Class 6H per ASME B1.13M.
  2. All dimensions are excluding flash; undimensioned features as forged.
  3. Use Trim Die to remove flash; trim width to be less than 2.5mm.
  4. All surfaces to be no more than  $\frac{1}{8}$ " after anodize.
  5. Test per MSS-4.011 to the following material specifications:  
 -Yield Strength > 35Ksi Min.  
 - Brinell hardness 90-100.

8136218 Housing, Bushing Arm			
DATE	REV	REVISION COMMENTS	BY ECN
12 Apr 11	d1	Created new part from 8135218	CDH 0
17 May 11	A	Production Release.	CDH 1110



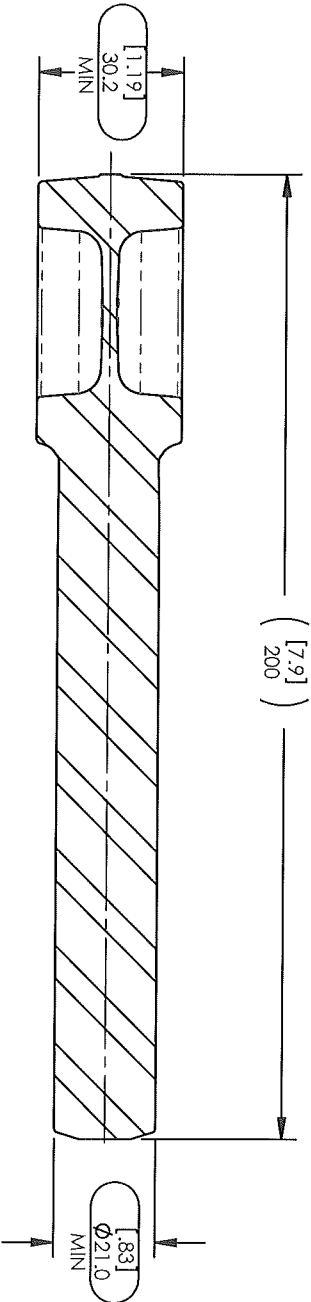
VIEW A-A  
 INTERPRET & PROCESS  
 per MSS-4.000

# 8136218 Housing, Bushing Arm

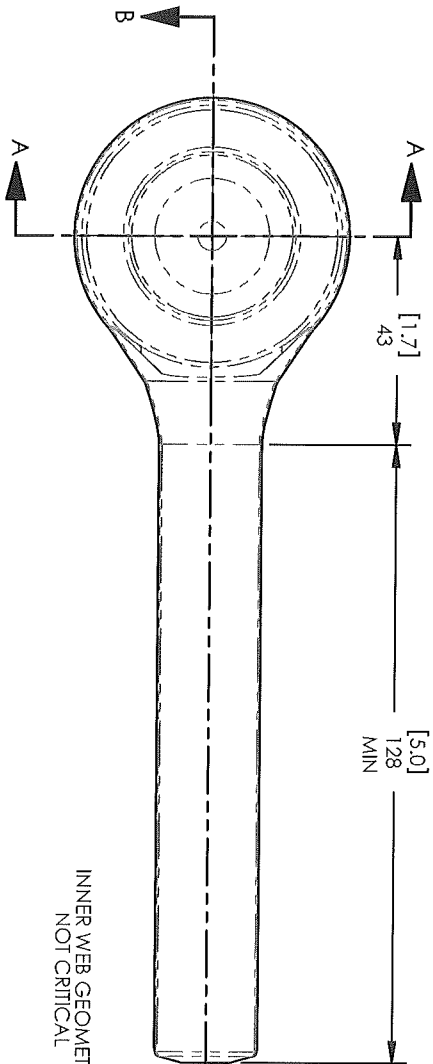
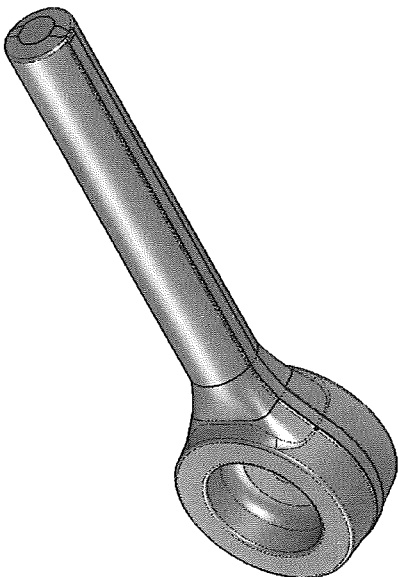
DO NOT SCALE DRAWING		CONFORMS TO		DRAWN: CDH		MATERIAL: Forged 6061, T6 Temper		Rev. A	
UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AT 3D MODEL SURFACES WITH TOLERANCE ±0.50mm(0.020")	LINEAR mm(in)	ANGLE (deg)	DATE: 11 Apr 11	CHECKED: CTV	FINISH: Clear Matte Anodize per MIL-A-8625 T-2 Cl-1	SHEET 1 of 1			

NOTES:  
1. Overall forging geometry per 3D model with tolerance +/- 1.0 mm except where specifically dimensioned.

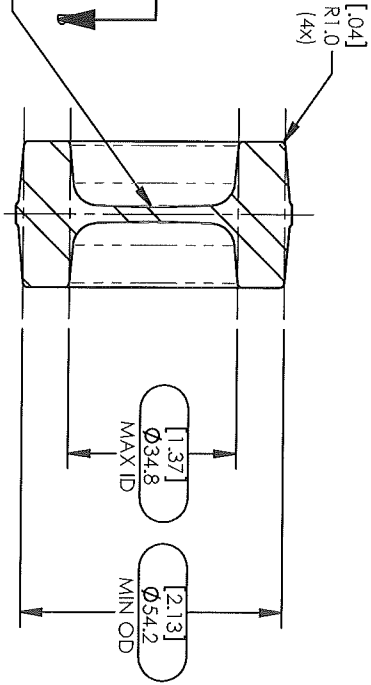
50007103 Receiver, XAxis - Forging, Blank			
DATE	REV	REVISION COMMENTS	BY ECN
			0
			0
02 Dec 13	A	Production release.	JW 1548



SECTION B-B



INNER WEB GEOMETRY  
NOT CRITICAL



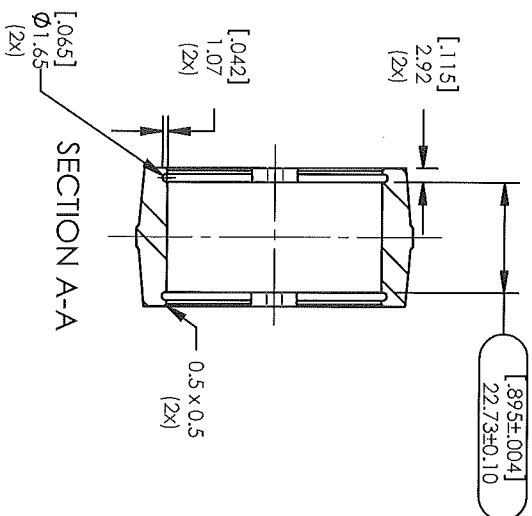
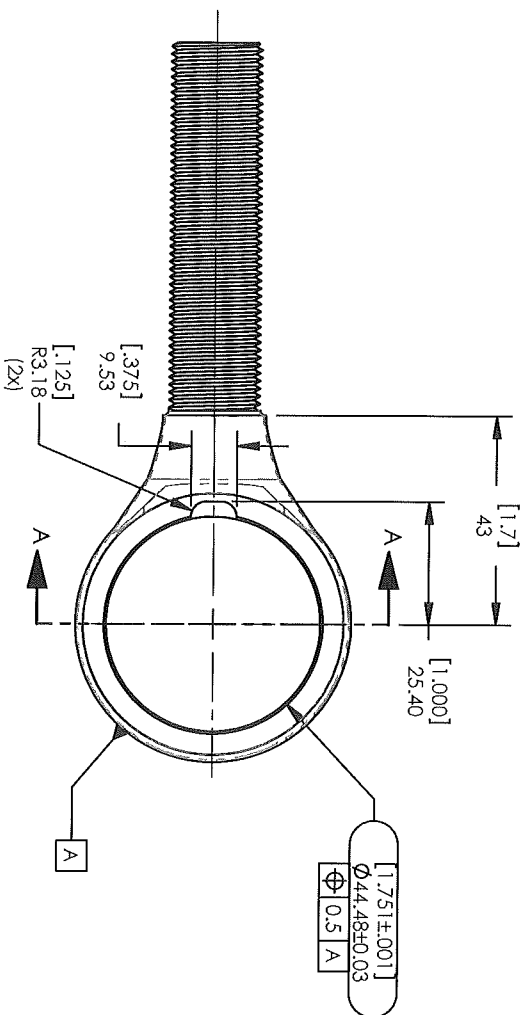
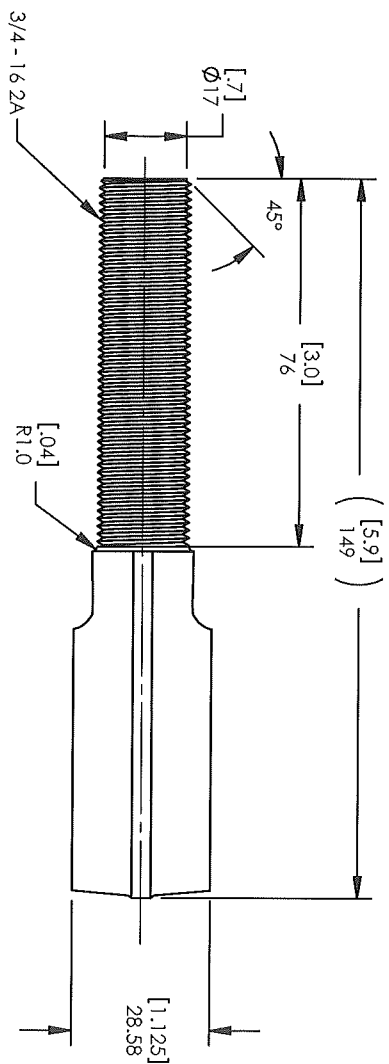
SECTION A-A

INTERPRET & PROCESS  
per MSS-4.000

## 50007103 Receiver, XAxis - Forging, Blank

DO NOT SCALE DRAWING			
UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AND MODEL SURFACES WITH TOLERANCE ±0.50mm(0.020")	LINEAR mm(in) None±1.00 (X ±0.040) X ±0.50 (XX ±0.020) XX ±0.25 (XXX±0.010)	ANGLE (deg) None±2.0° X ±1.0° EngCode: CABJ-DO	Drawn: JW Date: 21 May 13 MATERIAL: Forged Alloy Steel per ASTM A668 Class H Min Yield 414MPa [60 ksi] FINISH: As Forged
			Rev. A SHEET 1 of 1

50007206 Receiver, XAxis - Forged, 3/4"-16RH x 1.751" ID			
DATE	REV	REVISION COMMENTS	BY ECN
			0
			0
02 Dec 13	A	Production release.	JW 1548



INTERPRET & PROCESS  
per MSS-4.000

## 50007206 Receiver, XAxis - Forged, 3/4"-16RH x 1.751" ID

### DO NOT SCALE DRAWING

UNDIMENSIONED FEATURES  
ARE CONSIDERED NOMINAL  
AT 3D MODEL SURFACES WITH  
TOLERANCE  $\pm 0.50$  mm (0.020")

LINEAR mm (in) ANGLE (deg)  
None  $\pm 1.00$  (X  $\pm 0.040$ ) None  $\pm 2.0^\circ$   
X  $\pm 0.50$  (XX  $\pm 0.020$ ) X  $\pm 1.0^\circ$   
XX  $\pm 0.25$  (XXX  $\pm 0.010$ ) XX  $\pm 0.5^\circ$

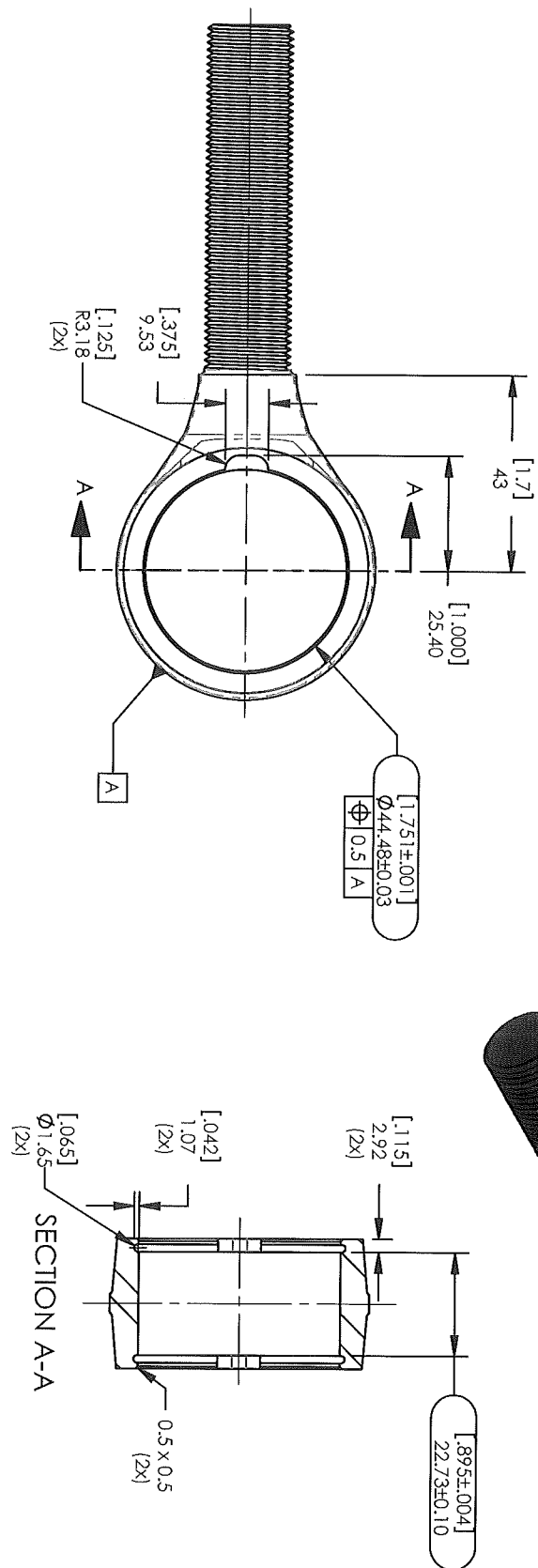
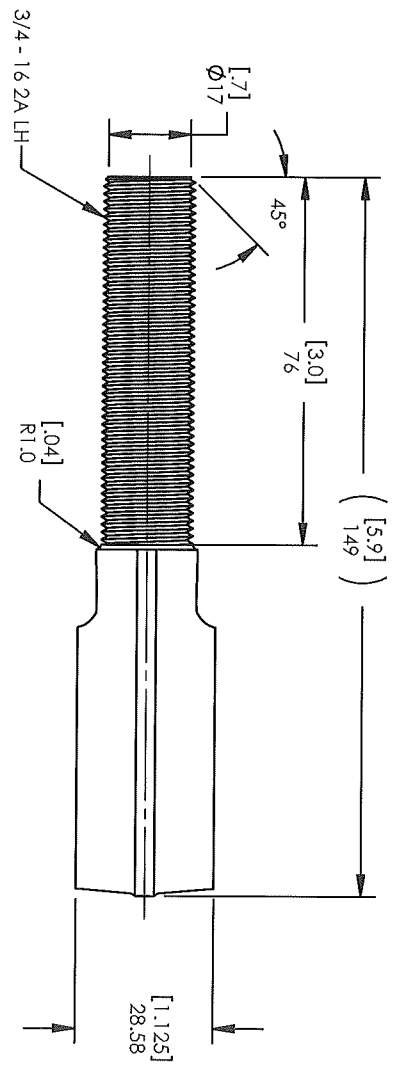
Drawn: JW  
Date: 21 May 13  
EngCode: CABJDI

MATERIAL: Made from P/N 50007103  
Min Yield 414MPa [60 ksi]  
FINISH: E-Coat Black per MSS 2.003 Type 1

Rev. A  
SHEET 1 of 1

**50007207 Receiver, XAxis - Forged, 3/4"-16LH x 1.751" ID**

DATE	REV	REVISION COMMENTS	BY	ECN
				0
				0
02 Dec 13	A	Production release.	JW	1548

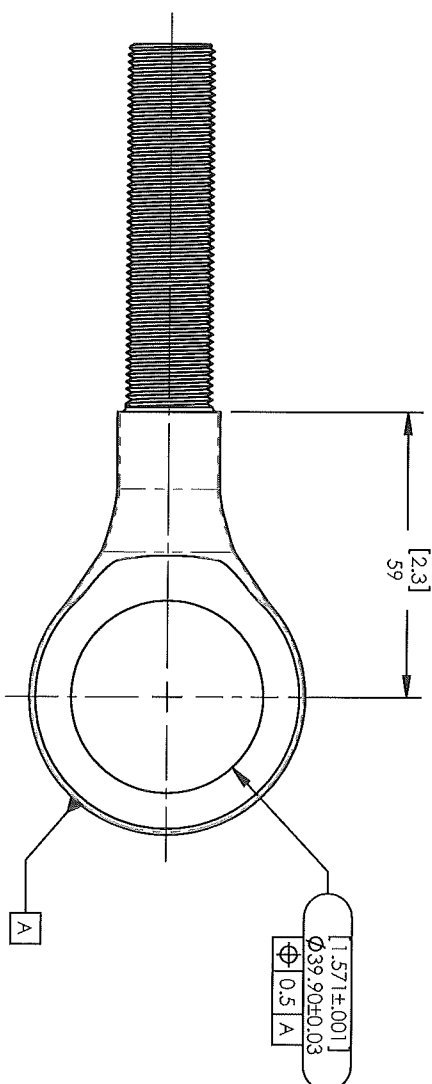


**50007207 Receiver, XAxis - Forged, 3/4"-16LH x 1.751" ID**

<b>DO NOT SCALE DRAWING</b>	<b>CONFORMING TO:</b> ASME Y14.5M 1994	<b>Drawn:</b> JW	<b>MATERIAL:</b> Made from P/N 50007103 Min Yield 414MPa [60 ksi]	<b>Rev. A</b>
<b>UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AT 3D MODEL SURFACES WITH TOLERANCE <math>\pm 0.50mm</math> [0.020"]</b>	<b>LINEAR mm [in]</b> None $\pm 1.00$ [X $\pm 0.040$ "] X $\pm 0.50$ [XX $\pm 0.020$ "] XX $\pm 0.25$ [XXX $\pm 0.010$ "]	<b>ANGLE (deg)</b> None $\pm 2.0^\circ$ X $\pm 1.0^\circ$ XX $\pm 0.5^\circ$	<b>Date:</b> 21 May 13 <b>EngCode:</b> CAB-J-D1	
			<b>FINISH:</b> E-Coat Black per MSS 2.003 Type 1	<b>SHEET 1 of 1</b>

**INTERPRET & PROCESS**  
per MSS-4.000

Technical drawing of a threaded rod. The drawing includes a side view with dimensions and a 3D perspective view. The side view shows a threaded section with a 45-degree thread angle, a pitch of 3.0mm, and a total length of 75mm. The thread is labeled M18x1.5 6G. The diameter is labeled Ø16. The thread is shown with a 45-degree angle. The 3D perspective view shows the threaded rod with a 45-degree thread angle and a 3.0mm pitch. The dimensions are: [6.4] (total length), [3.0] (pitch), 75 (total length), Ø16 (diameter), 45° (thread angle), M18x1.5 6G (thread specification), [0.4] (pitch), R1.0 (radius), [866] (pitch), 22.00 (pitch).



**50007208** Receiver, xAxis - Forged, M18x1.5RH x 39.90mm ID

**DO NOT SCALE DRAWING**

UNDIMENSIONED FEATURES  
ARE CONSIDERED NOMINAL  
AT 3D MODEL SURFACES WITH  
TOLERANCE  $\pm 0.50\text{mm}$  [p.020]

CONFORMS TO  
ASME Y 14.5M 1994

Drawn: JW

MATERIAL: Made from P/N 50007103

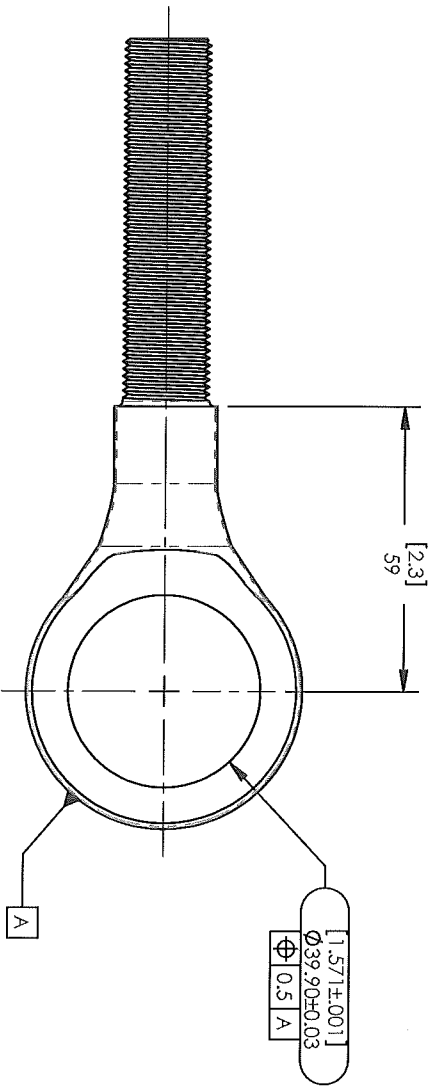
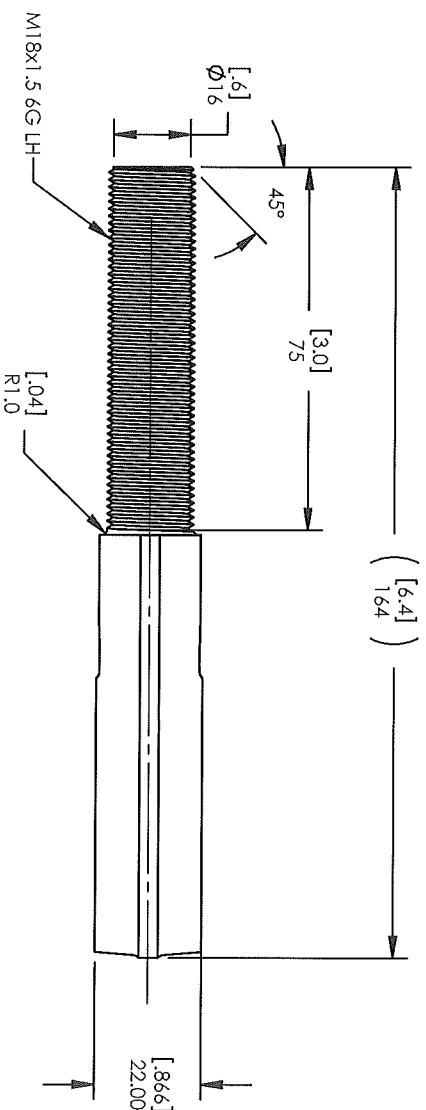
Min Yield 414MPa [60 ksi]

FINISH: E-Coat Black per MSS 2.003 Type 1

Rev. A  
SHEET 1 of 1



50007209 Receiver, XAxis - Forged, M18x1.5LH x 39.90mm ID			
DATE	REV	REVISION COMMENTS	BY ECN
			0
			0
02 Dec 13	A	Production release.	JW 1548



INTERPRET & PROCESS  
per MSS-4.000

# 50007209 Receiver, XAxis - Forged, M18x1.5LH x 39.90mm ID

DO NOT SCALE DRAWING			
UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AT 50 MOE UNLESS NOTED TOLERANCE ±0.50mm(0.020")	LINEAR mm(in) None±1.00 (X ±0.040") X ±0.50 (XX ±0.020") XX ±0.25 (XXX±0.010")		ANGLE (deg) None±2.0° X ±1.0° EngCode: CABJ-D1
	Drawn: JW Date: 21 May 13 EngCode: CABJ-D1		MATERIAL: Made from P/N 50007103 Min Yield 414MPa [60 ksi]
	FINISH: E-Coat Black per MSS 2.003 Type 1		Rev. A SHEET 1 of 1

80003100 Plate, Lock			
DATE	REV	REVISION COMMENTS	BY ECN
			0
			0
09 Dec 13	A	Production release.	JW 1548



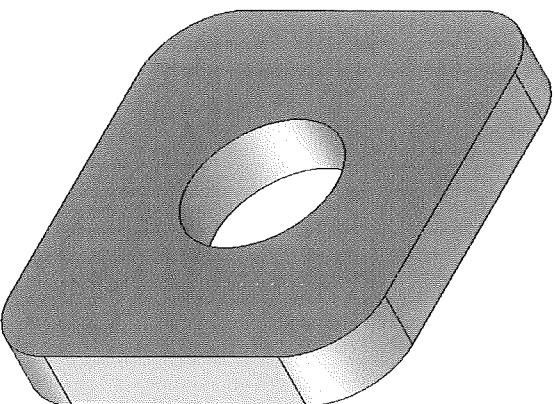
[.187]  
4.75

[1.329]  
33.75

[1.250]  
31.75

[.492]  
Ø 12.50

[.2]  
R6  
(4x)



INTERPRET & PROCESS  
per MSS-4.000

## 80003100 Plate, Lock

DO NOT SCALE DRAWING			
UNDIMENSIONED FEATURES ARE CONSIDERED NOMINAL AT 3D MODEL SURFACES WITH TOLERANCE ±0.50mm(0.020")	CONFORMS TO ASME Y 14.5M 1994	Drawn: JW	MATERIAL: Steel, Yield => 245MPa [36ksi]
LINEAR mm(in) None±1.00 [X ±.040"] X ±0.50 [XX ±.020"] XX ±0.25 [XXX±.010"]	ANGLE (deg) None±2.0° X ±1.0° XX ±0.5°	Date: 20 Nov 13	FINISH: Clear Zinc per ASTM B633-07 SC2, Type 3
EngCode: ECC1		Rev. A	
		SHEET 1 of 1	