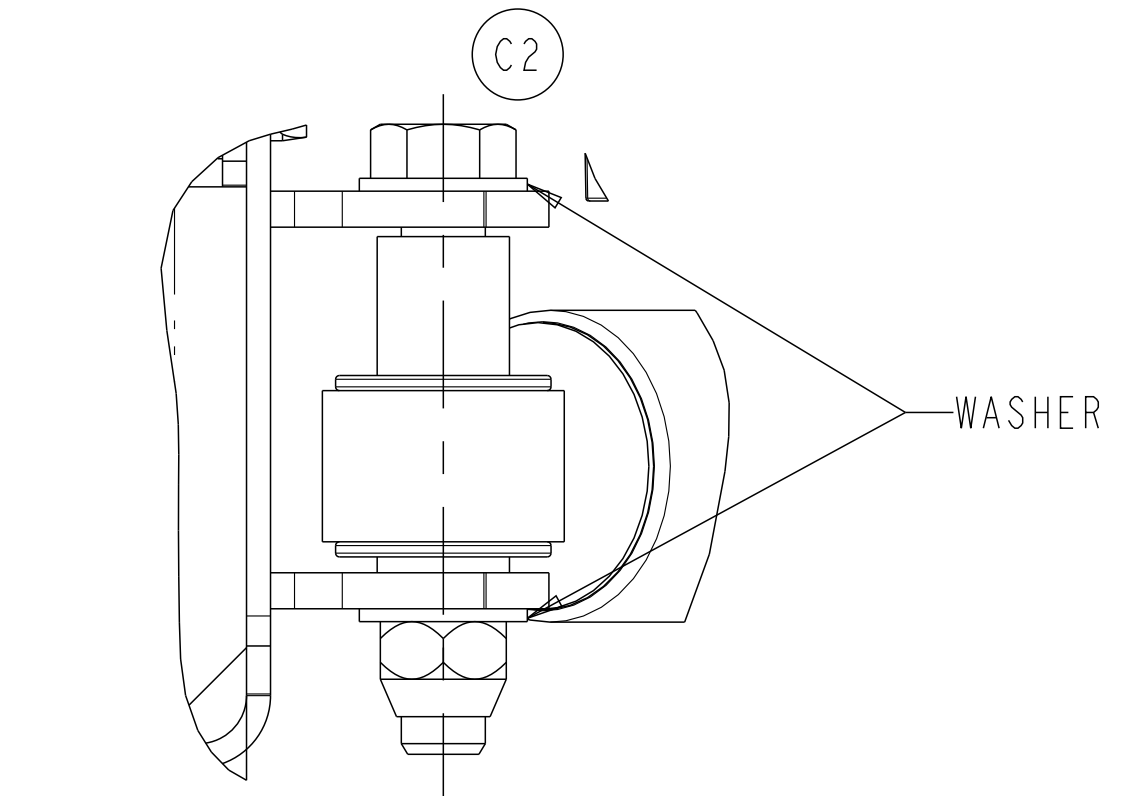
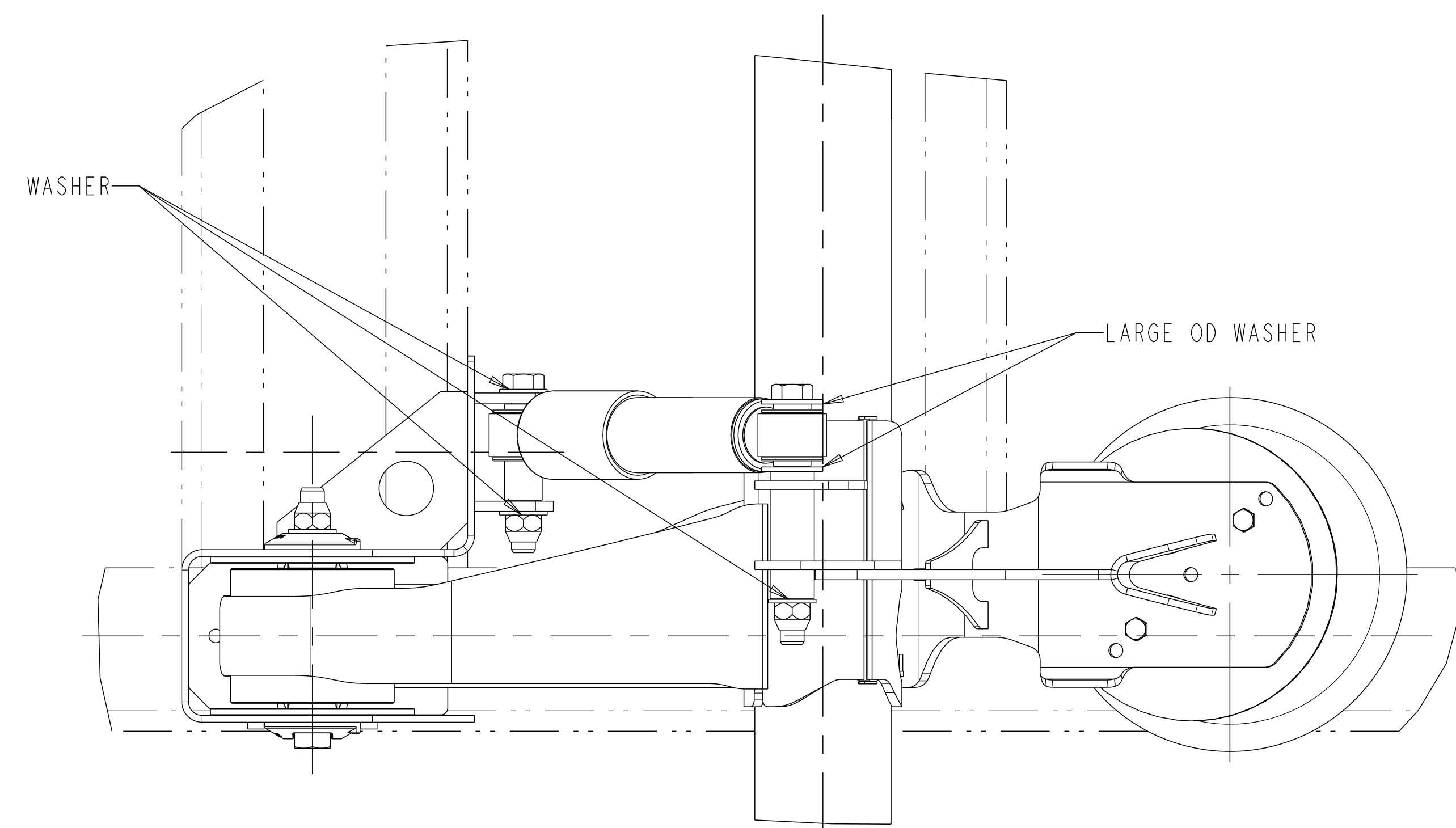
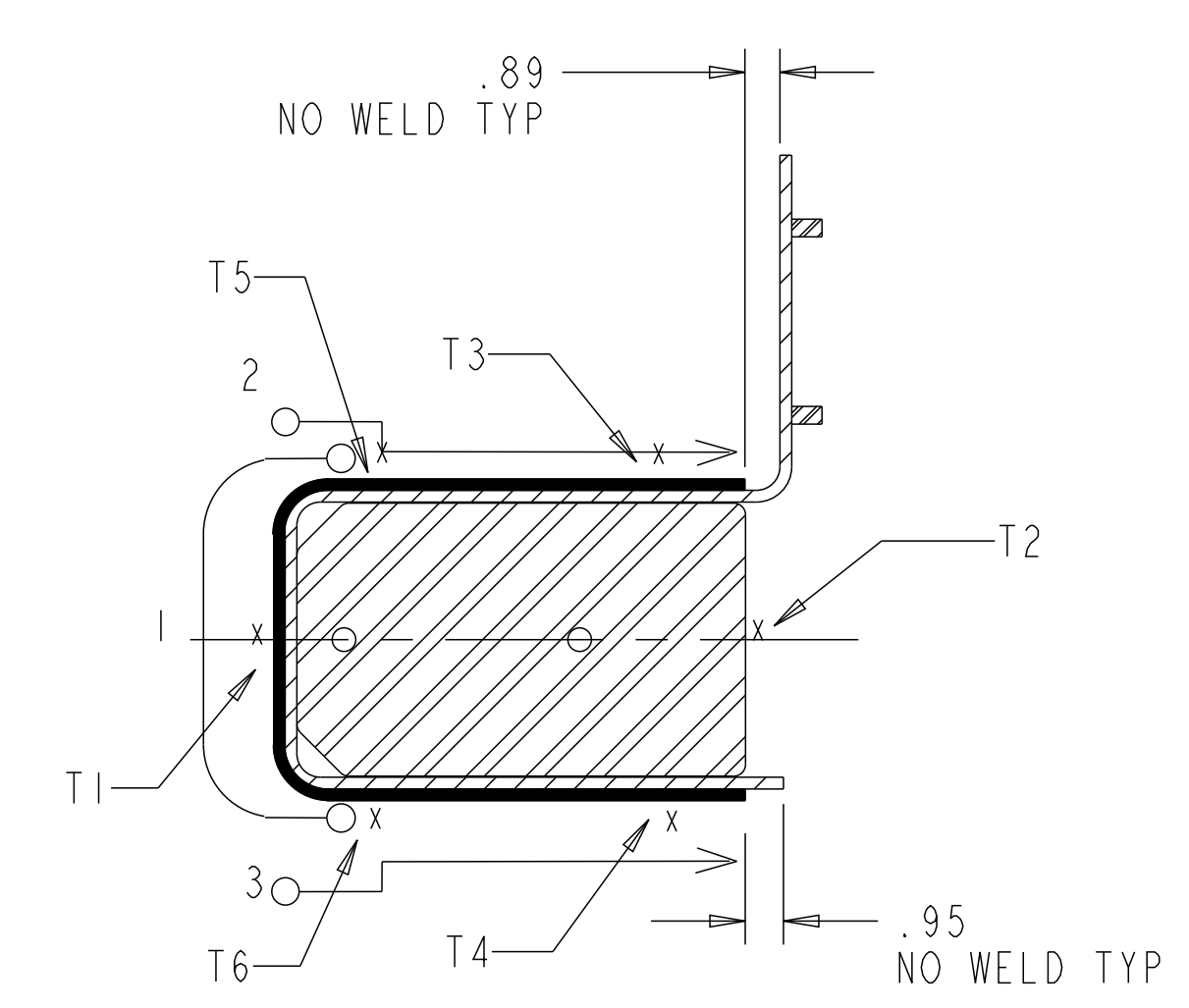


SIM. PARTS		
REVISIONS		
A	RELEASED 5-66733G_01 FOR PRODUCTION.	117163 AJ GS
B	ADDED PEDESTAL WELDING DETAILS FOR 14", 15", 16", 17", 19" RIDE HEIGHTS.	117478 AJ SJP
C	1-UPDATED VIEWS TO REFLECT THE CHANGES IN RHCY DESIGN. 2-CHANGED UPPER SHOCK BOLT ORIENTATION. 3-SIDE WALL FUSION WAS 0.018	118970 LGS SJP
D	UPDATED VIEWS TO REFLECT THE CHANGES IN RHCY DESIGN.	119841 LGS SVM
E	ADDED REF. DIMENSION.	122694 KHK SKS
F	UPDATED VIEWS TO REFLECT THE CHANGES IN SHOCK ABSORBER BRACKET. 1-ADDED SHOCK INSTALLATION VIEW FOR DISC BRAKE APPLICATION. 2-UPDATED NOTE.	124403 SD ARS
G	ADDED MTA23L INFO.	ECN-143200 LGS SKS
H	UPDATED RHCY REPRESENTATION	ECN-165357 EN SD



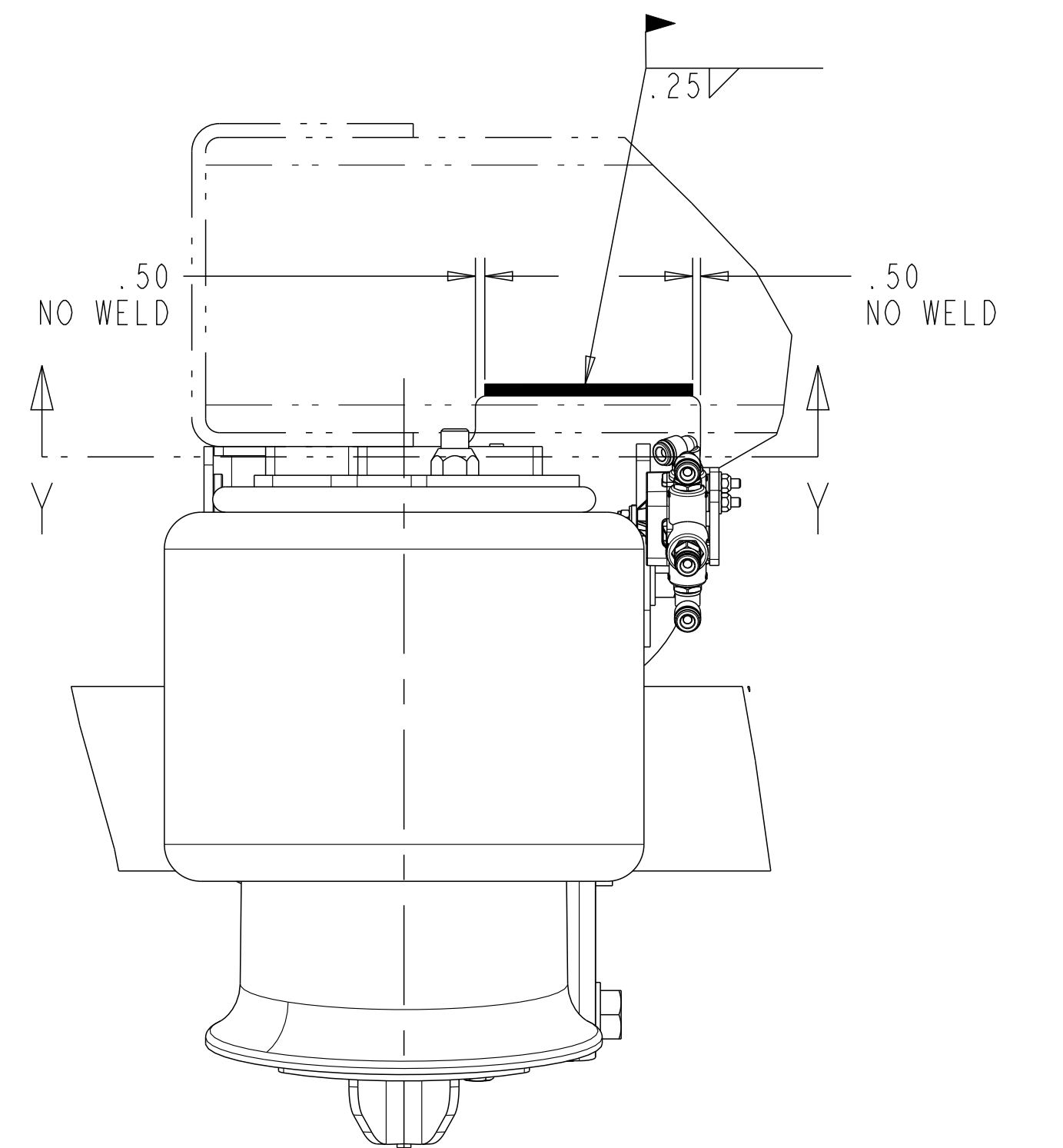
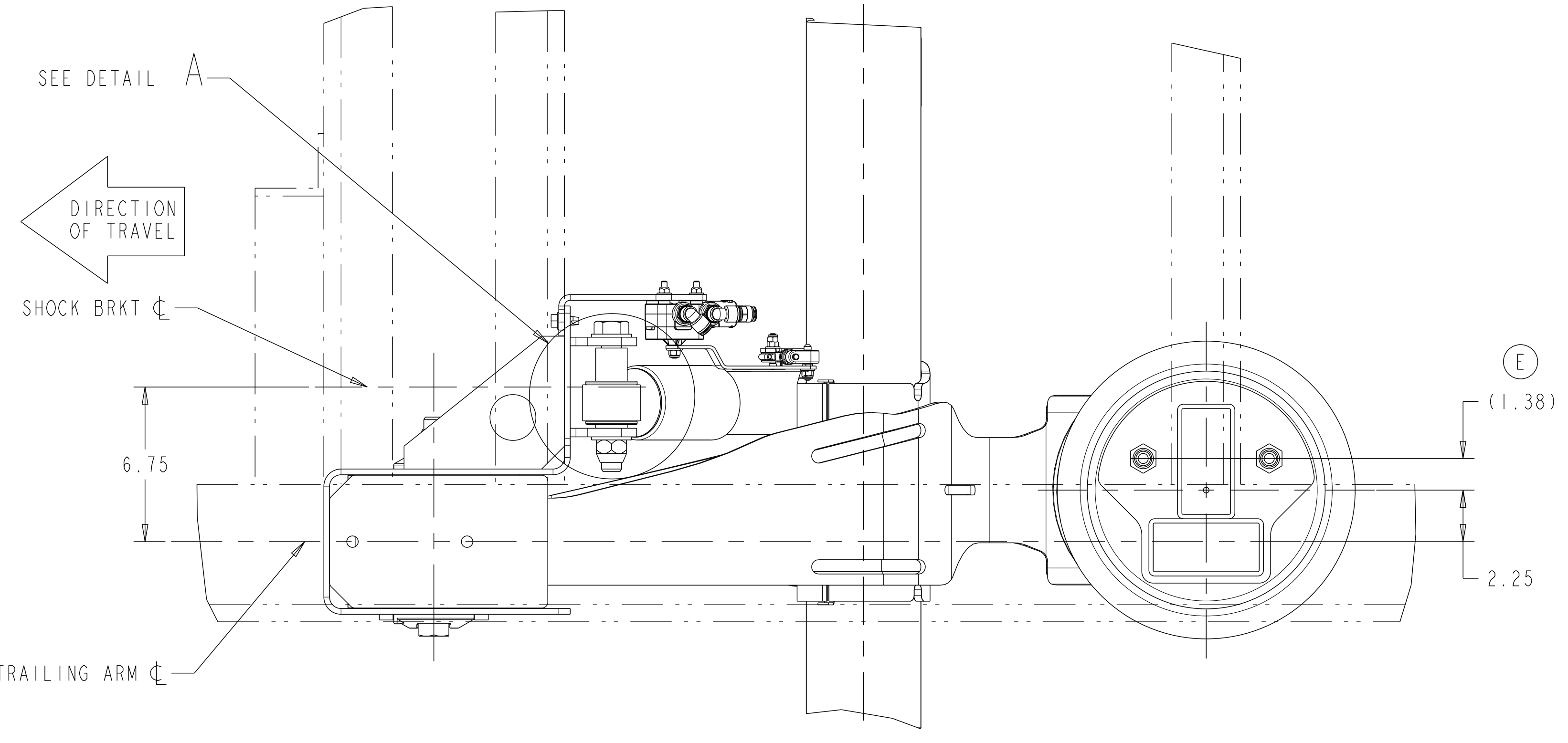
DETAIL A  
SCALE 1:2  
TYP SHOCK INSTALLATION  
BOTH SIDES  
FOR DRUM BRAKE APPLICATION

- X = TACK WELD
- T1 FIRST  
T2 SECOND  
T3 THIRD  
T4 FOURTH  
T5 FIFTH  
T6 SIXTH
- WELD RUN PROCEDURE  
AFTER TACK WELDING
- START  
→ STOP
- 1 FIRST RUN  
2 SECOND RUN  
3 THIRD RUN



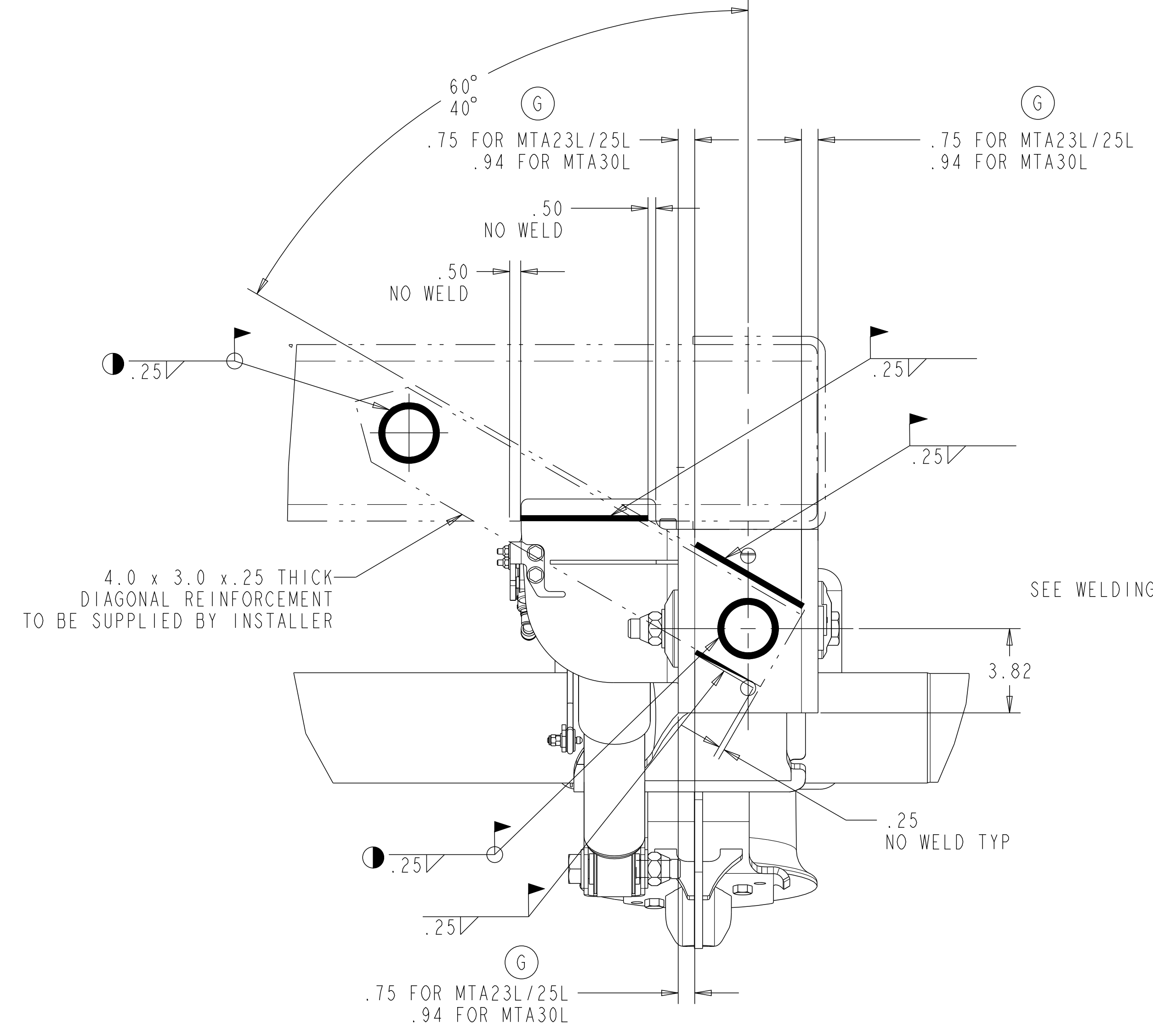
SECTION X-X  
HANGER BRACKET WELDING DETAILS

(F1) TYP SHOCK INSTALLATION  
FOR DISC BRAKE APPLICATION



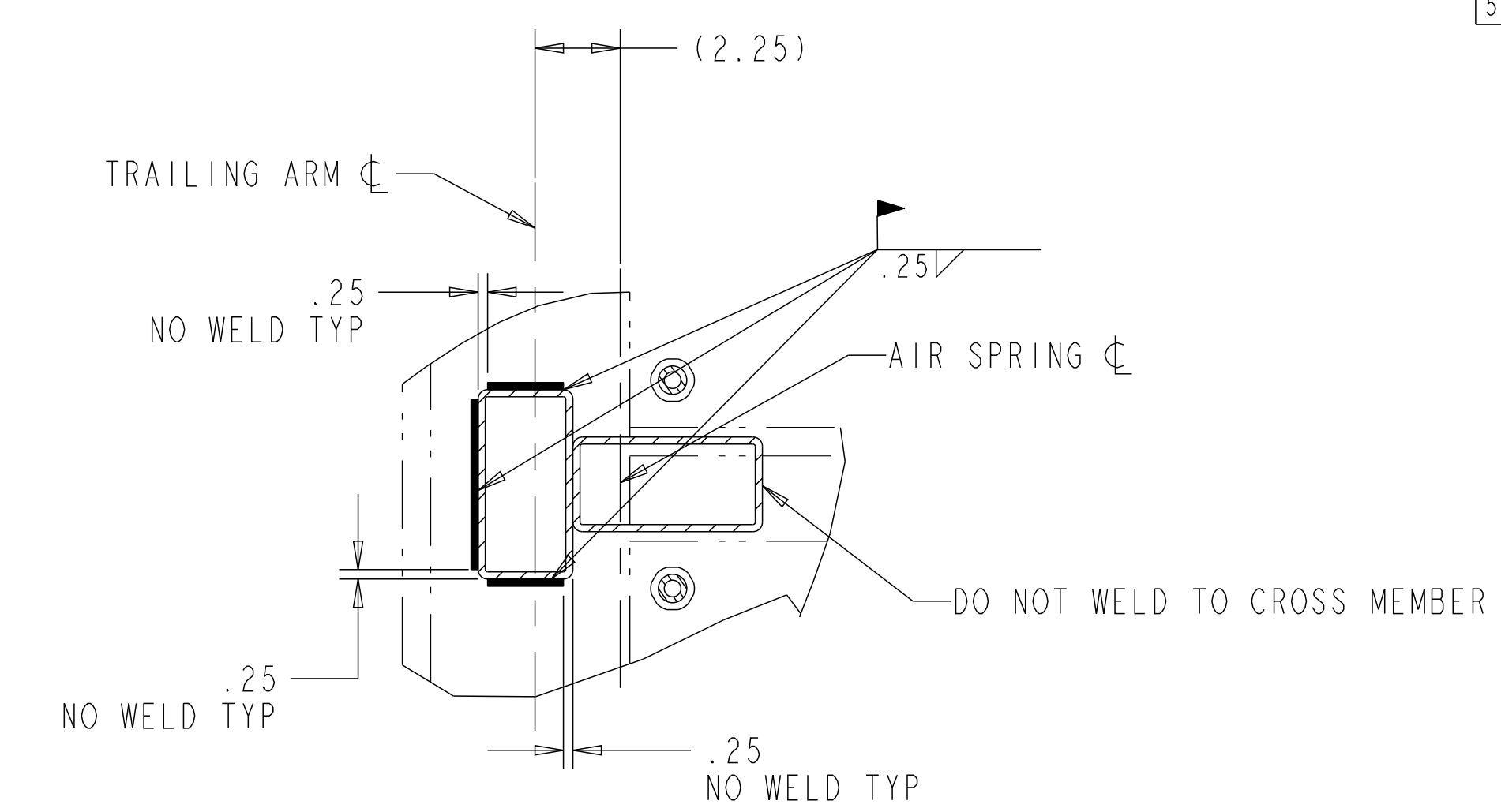
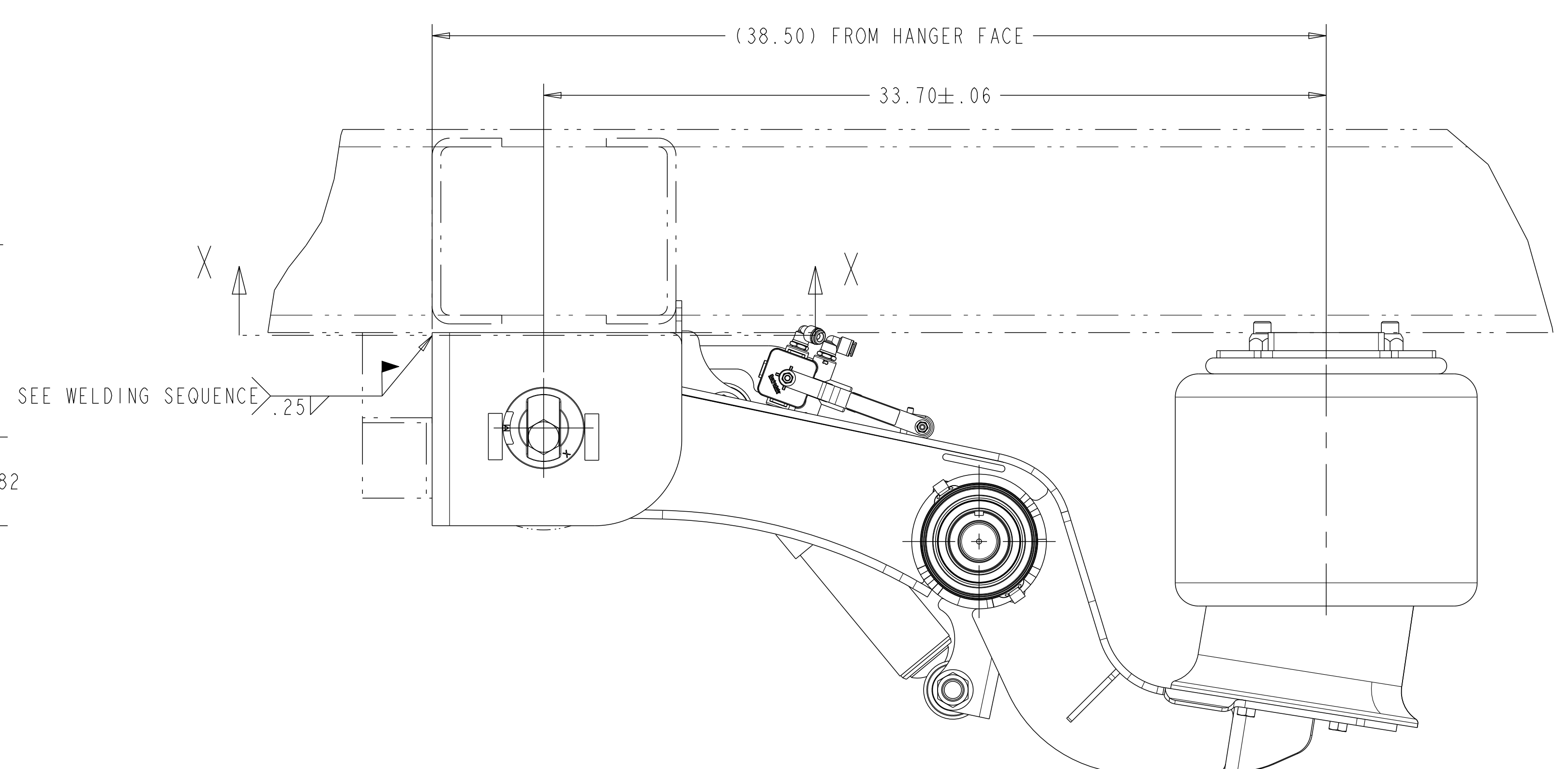
HANGER BRACKET WELDING DETAIL TO VEHICLE FRAME

CAD FILES	
NAME	TYPE
5-66733G H.8	DRAWING
5-66733G H.5	MODEL

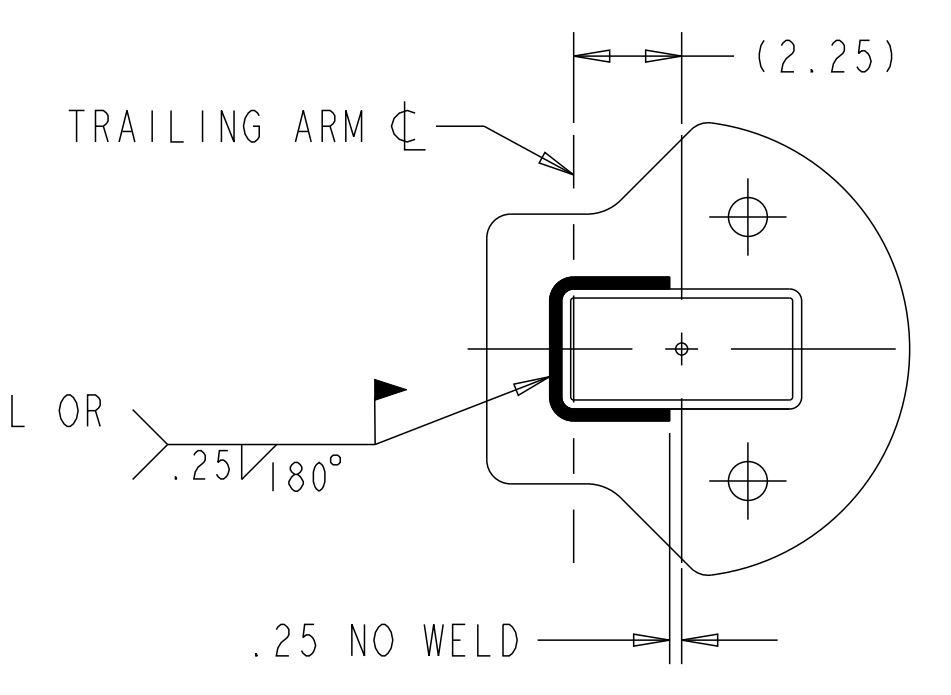


RECOMMENDED KNEE BRACING AND WELDING

● WELD ON INSIDE OF HOLE TO PRODUCE PLUG WELD AS SHOWN



SECTION Y-Y  
PEDESTAL WELDING  
DETAILS FOR 6.5", 7.5", 8.0", 9.0" RH



PEDESTAL WELDING  
DETAILS FOR 14", 15", 16", 17", 19" RH

NOTES:

PROPER VEHICLE FRAME DESIGN IN THE AREA OF SUSPENSION ATTACHMENT IS THE RESPONSIBILITY OF THE INSTALLER.

ALL WELDING TO COMPLY WITH AWS STANDARDS 70 KSI MIN WELD WIRE TENSILE STRENGTH.

NO WELDING OR DRILLING ALLOWED ON TRAILING ARMS

FOR GENERAL ARRANGEMENT INFORMATION SEE DRAWING 5-66734U\_01

WELD TO FRAME RAIL OR CROSS MEMBER BUT NOT BOTH

REFER TO SHOP CHART 4-60559\_38 FOR TORQUE INFORMATION

(F2) MTA23L/25L/30L  
WELD ON APPLICATION

WELD REQUIREMENTS (UNLESS OTHERWISE NOTED)	
CONCAVITY	0.25-INCH FILLET WELD
TOE RADIUS	MUST BE PRESENT AT TOE OF WELD
CONVEXITY	SMOOTH TOE ON THE PLATE SIDE
SURFACE POROSITY	NONE PERMITTED AT 1x MAGNIFICATION
INCLUSIONS	NONE PERMITTED AT 1x MAGNIFICATION
CRACKING	NONE PERMITTED
LEG LENGTH	0.25 INCH MINIMUM
SIDE WALL FUSION	0.013 INCH MINIMUM
EFFECTIVE THROAT	0.19 INCH MINIMUM
ROOT GAP	NOT TO EXCEED 0.060 INCH
WELD WIRE	70 KSI MINIMUM TENSILE STRENGTH

(C3)

APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-004		THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.		MATERIAL		PROCESS		APPROVED		DRAWN BY		CHECKED BY		3RD ANGLE PROJECTION		DRAWING SIZE		DESIGN CONTROL GROUP		PART NO.	
				WELD SPEC #804				A. J.		G. S.		A. J.		E		E		W W TRAILER PRODUCTS		5-66733G_01	
4 IN. 10THS. 100MM		WEIGHT RGH./FIN.		INQUIRY NO.		C.R./T.E. NO.		PCCR 119179 / 119183		ORIGINAL FOR		SCALE		1:4						117163	
										A. J.		03-Nov-11		E						11707	
										G. S.		03-Nov-11		E						PAGE 1 OF 1	

DO NOT CHANGE MANUALLY