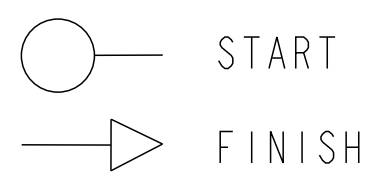


Revision: D.6
STATE: Engineering Released
EXPORT_CONTROL: HARD_WARE=EAR - EAR99, EXPORT_CONTROL=EAR - EAR99

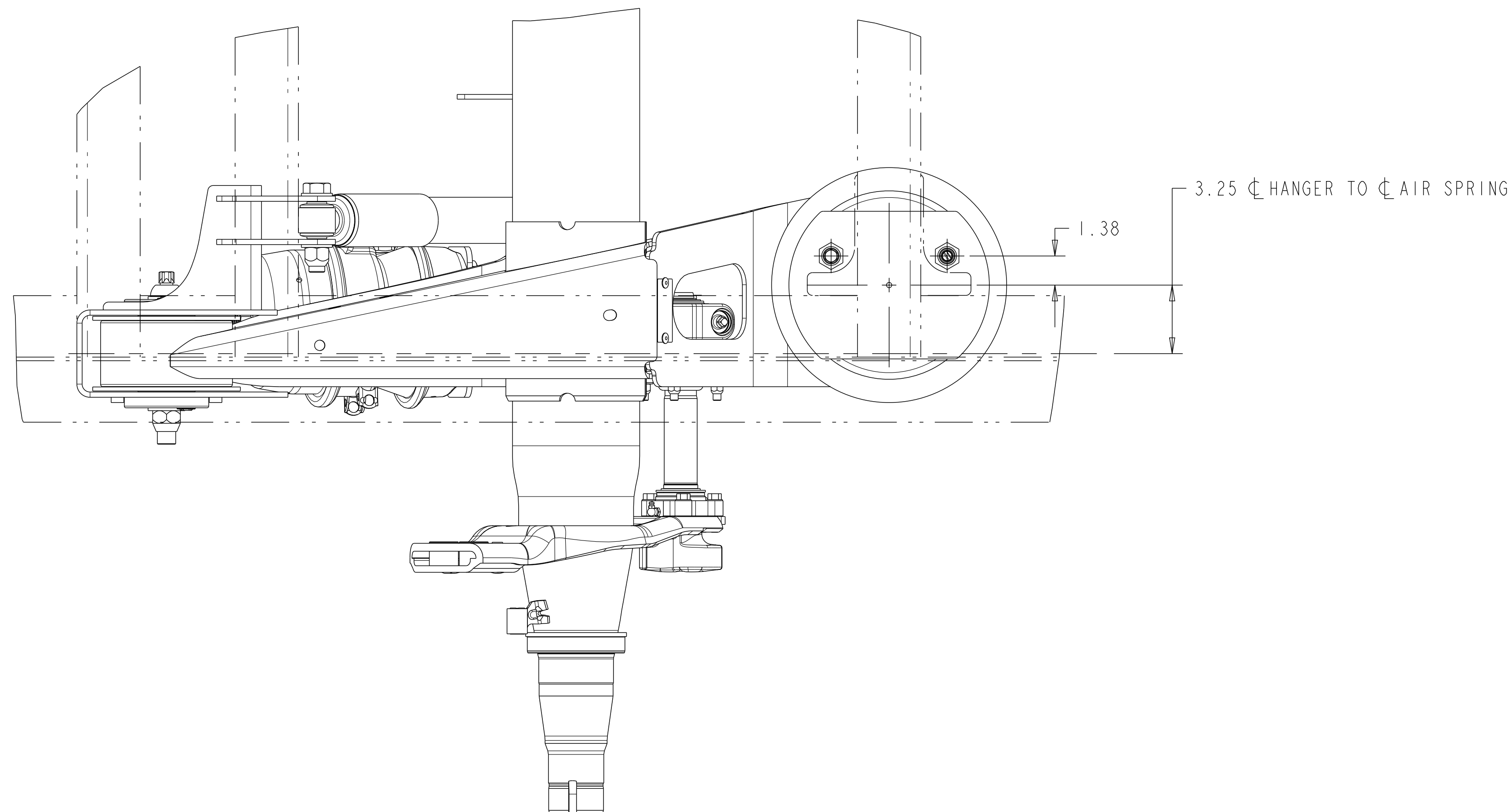
NOTE:
 PROPER VEHICLE FRAME DESIGN IN THE AREA OF SUSPENSION ATTACHMENT IS THE RESPONSIBILITY OF THE INSTALLER.
 ALL WELDING TO COMPLY WITH AWS STANDARDS 70 KSI MIN. WELD WIRE TENSILE STRENGTH.
 NO WELDING OR DRILLING ALLOWED ON TRAILING ARMS. NO WELD WITHIN .25" OF FRAME BRACKET TOOLING HOLES.
 FOR GENERAL ARRANGEMENT INFORMATION SEE DRAWING:
 5-70010E (DRUM BRAKE)
 5-70010F (DISC BRAKE)
 REFER TO SHOP CHART 4-60559_43 FOR TORQUE INFORMATION.
 ALL INFORMATION SHOWN APPLIES TO BOTH DRUM AND DISC BRAKE APPLICATIONS (DRUM APPLICATION SHOWN)

WELD SEQUENCE

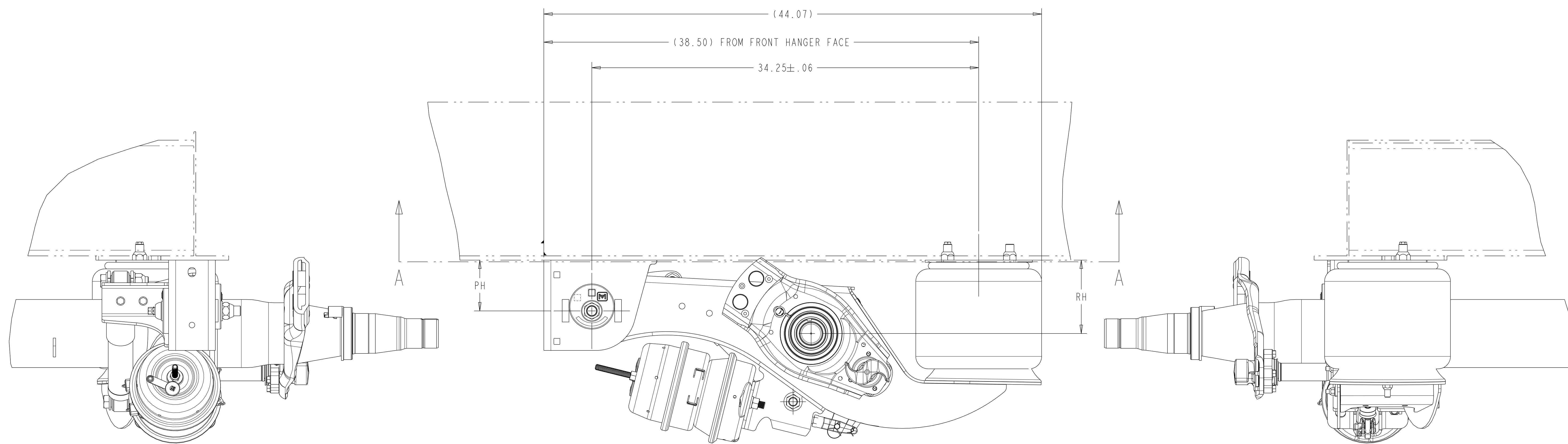


SEE WELD SEQUENCE NUMBERS ON ARROWS

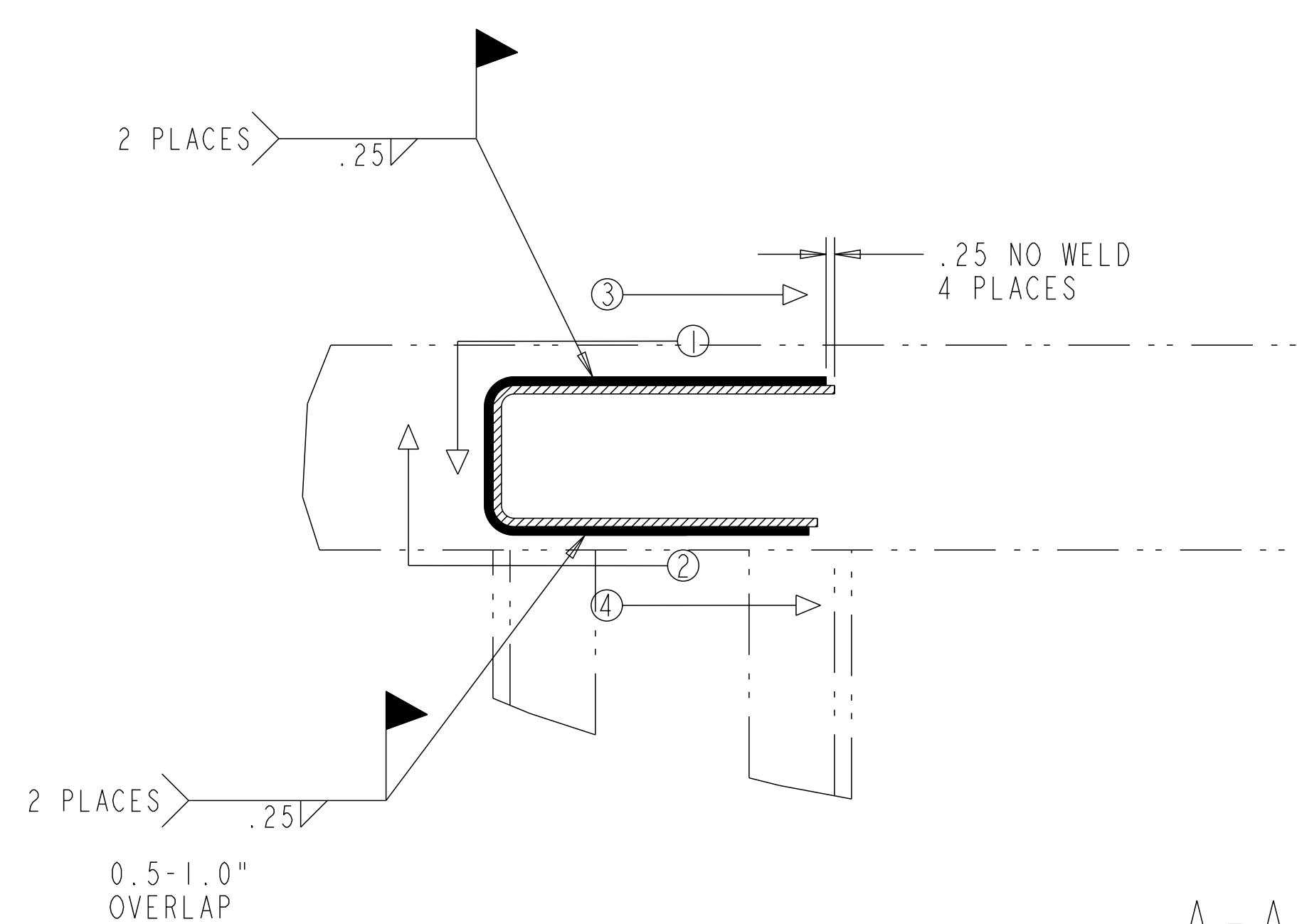
(D1)	RIDE HEIGHT	PH
	6.5, 7.5, 8 & 9	4.5
	12.0	8.0
	14 & 15	10.0
	16 & 17	12.0



LAYOUT NO.		
SIM. PARTS		
UNLESS OTHERWISE SPECIFIED		
INTERPRET DRAWING PER ASME Y14.5M-1994 ALL DIMENSIONS IN INCHES: ±.015 ON 3-PLACE DECIMALS ±.03 ON 2-PLACE DECIMALS ±.1° ON ANGULAR DIMENSIONS	ALL MACHINED SURFACE FINISHES 350/▽ BREAK ALL SHARP EDGES REMOVE ALL BURRS, FLASH & PROJECTIONS CASTING TOLERANCES PER STD. ISO 8062-3 "P.1" FORGING TOLERANCES ±.00 - .03; DRAFTS "P.1"	
REVISIONS		
A	RELEASE FOR PROTOTYPE	15/SEP/17 MDM
B	ADDED SHEET-02 TO SHOW REINFORCEMENT WELDING DETAILS. B1-ADDED VIEW TO SHOW PEDESTAL WELDING DETAILS B2-B3-ADDED NOTE	ECN-143354 LGS 23-Oct-17 SKS
C	RELEASE 5-70009B FOR PRODUCTION	ECN-151590 CH 17-AUG-18 MS
D	UPDATE TO LATEST PARTS 1-ADD RH/PH CHART SHT 1 2-ADD DIM CHART AND ASSOCIATED DIMS SHT 2 3-REVISE INSTRUCTIONS SHT 2 4-UPDATE PART# TABLE SHT 2 5-ADD VIEW FOR KNEE BRACE SHT 2 6-REVISE RECOMMENDATIONS SHT 2 7-ADDED C-CHANNEL VIEWS SHT 2	ECN-166379 MDM 17-JUN-20 SS

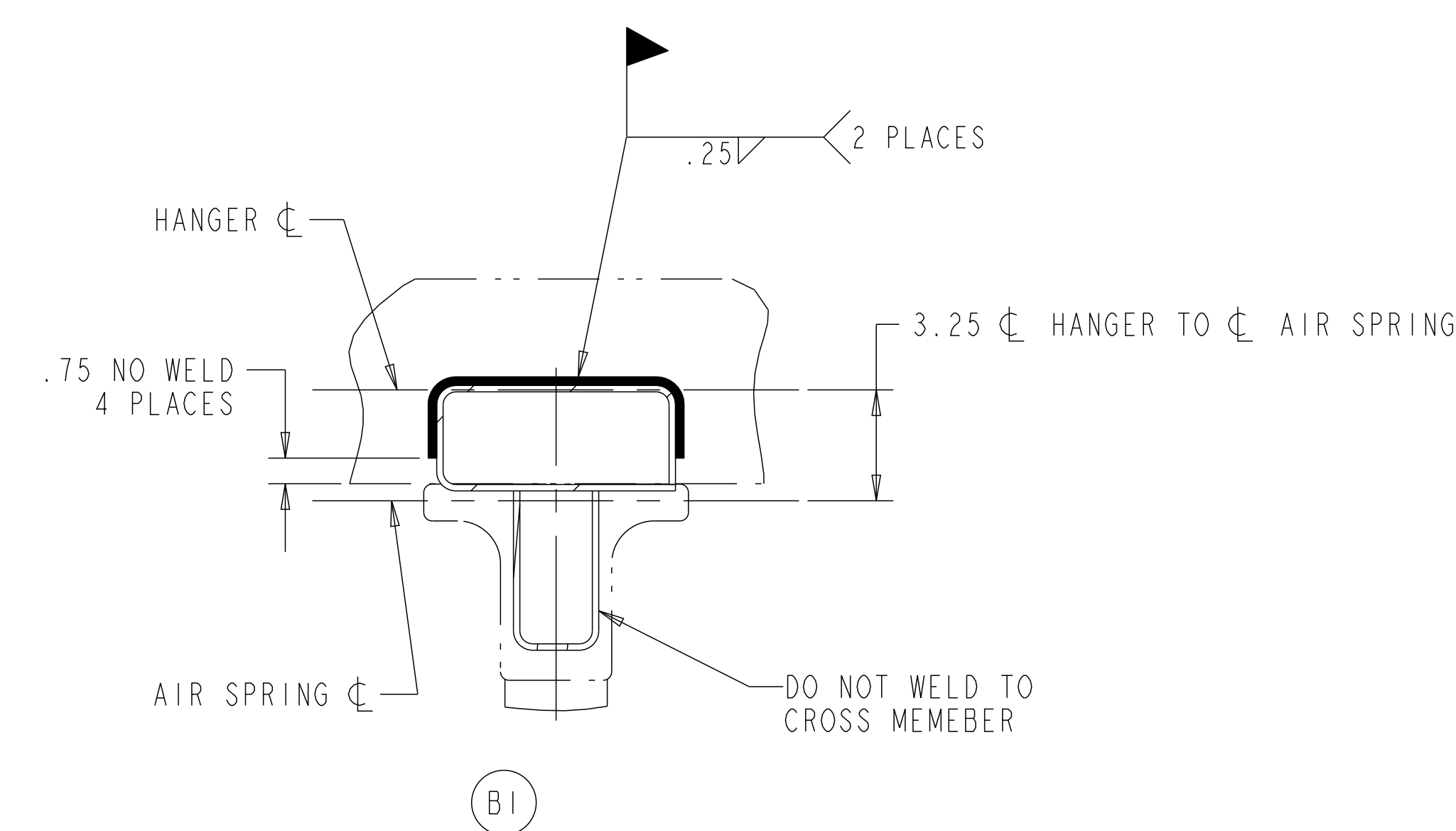


SCALE 1:4



SECTION A-A

(B2) PEDESTAL WELDING DETAILS FOR 6.5", 7.5", 8", 9" & 12" RIDE HEIGHT



PEDESTAL WELDING DETAILS FOR 14", 15", 16" & 17" RIDE HEIGHT

(B3) REFER TO SHEET-02 FOR REINFORCEMENT WELDING DETAILS

APPLY SPECIFIED MERITOR MARKINGS-SEE 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 LBS MTA-TEC6-23L	PROCESS ORIGINAL FOR	PROJECT ENGINEER SCHUCK	3RD ANGLE PROJECTION	DRAWING SIZE E	RELEASE ECN-141605 ECN-151590	PART/DWG NO. 5-70009B	00050
4 IN. 10THS. 1:10MM		WEIGHT RGR./FIN.	SCALE 1:4	DRAWN BY MARCETTI	CHANGE REQUEST # CR-133500	DRAWING 5-70009B D.6	NAME WELD TO FRAME	ENG. DESC. CODE INCH	SHEET 1 OF 2
DESIGN CONTROL GROUP TRAILERS N/A		DESIGNER SCHUCK	CHECKED BY SCHUCK	TRAILERS N/A	MODEL 5-70009B D.3	MERITOR			

DO NOT CHANGE MANUALLY

Revision: D.6

STATE: Engineering Released

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

EXPORT_CONTROL=EAR - EAR99

D4 MTA-TEC6-23L WELD-ON HANGERS WITH GUSSET PLATE P/N'S

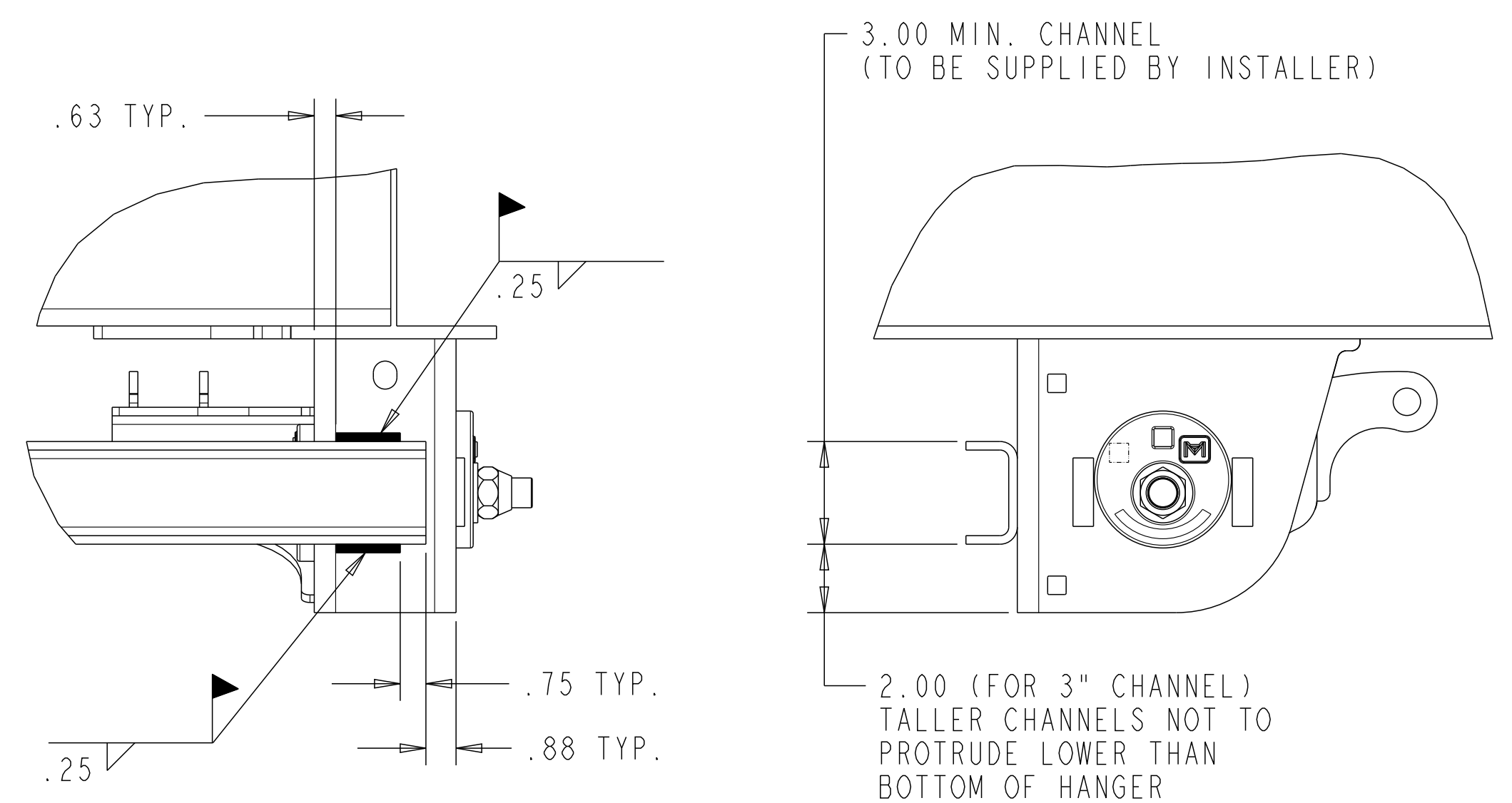
ITEM #	PART NAME	PART NUMBER	QTY
1	FRAME BRKT ASSY (ROADSIDE)	SEE B.O.M.	1
2	FRAME BRKT ASSY (CURBSIDE)	SEE B.O.M.	1
3	GUSSET PLATE	SEE TABLE	2
4	WASHER-FLAT	1229N1326	2
5	SCREW-CAP	S-21016-M-2	1
6	NUT-LOCK, FIN.	NL-210-M-2	1

GUSSET PLATE INFO.

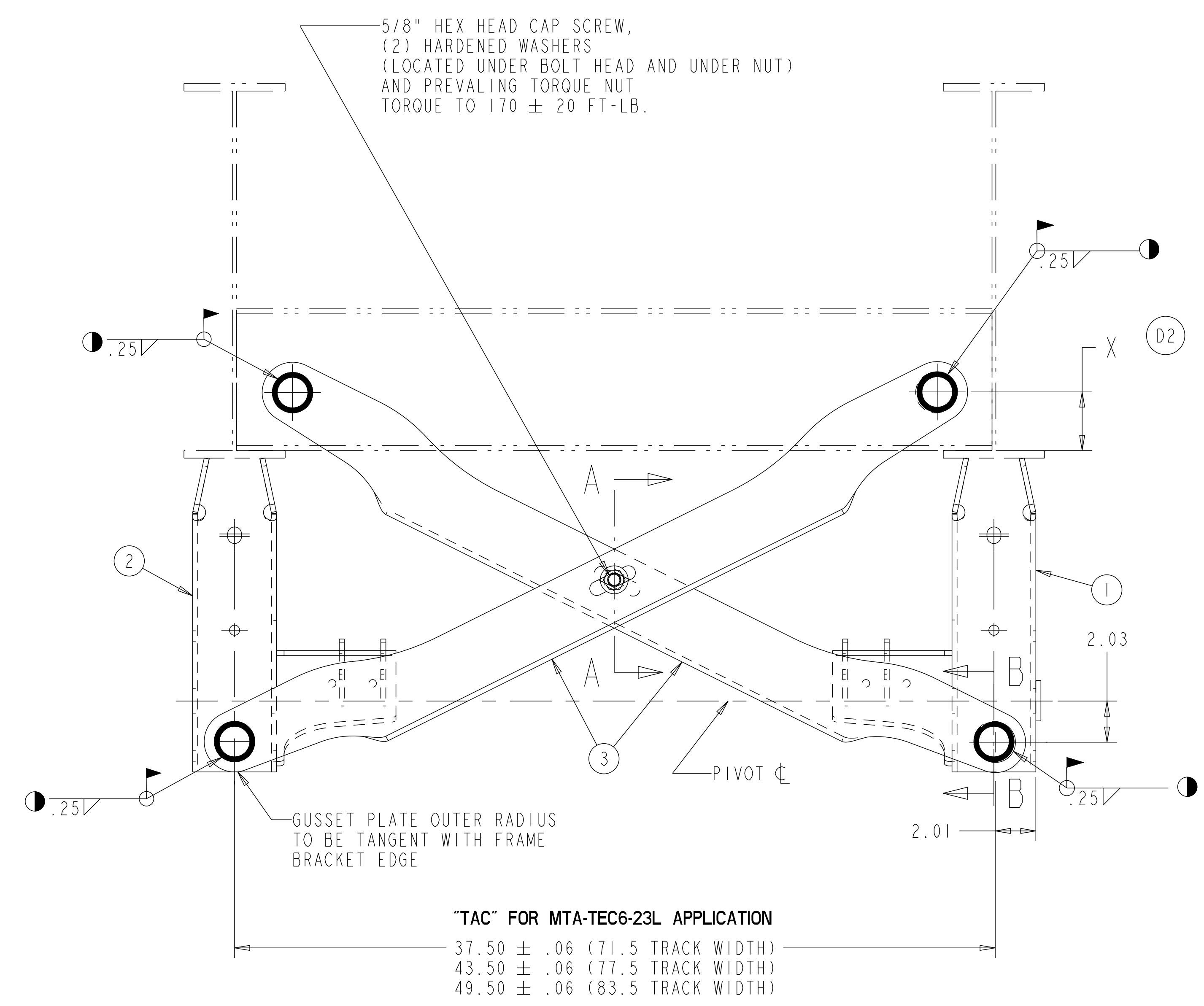
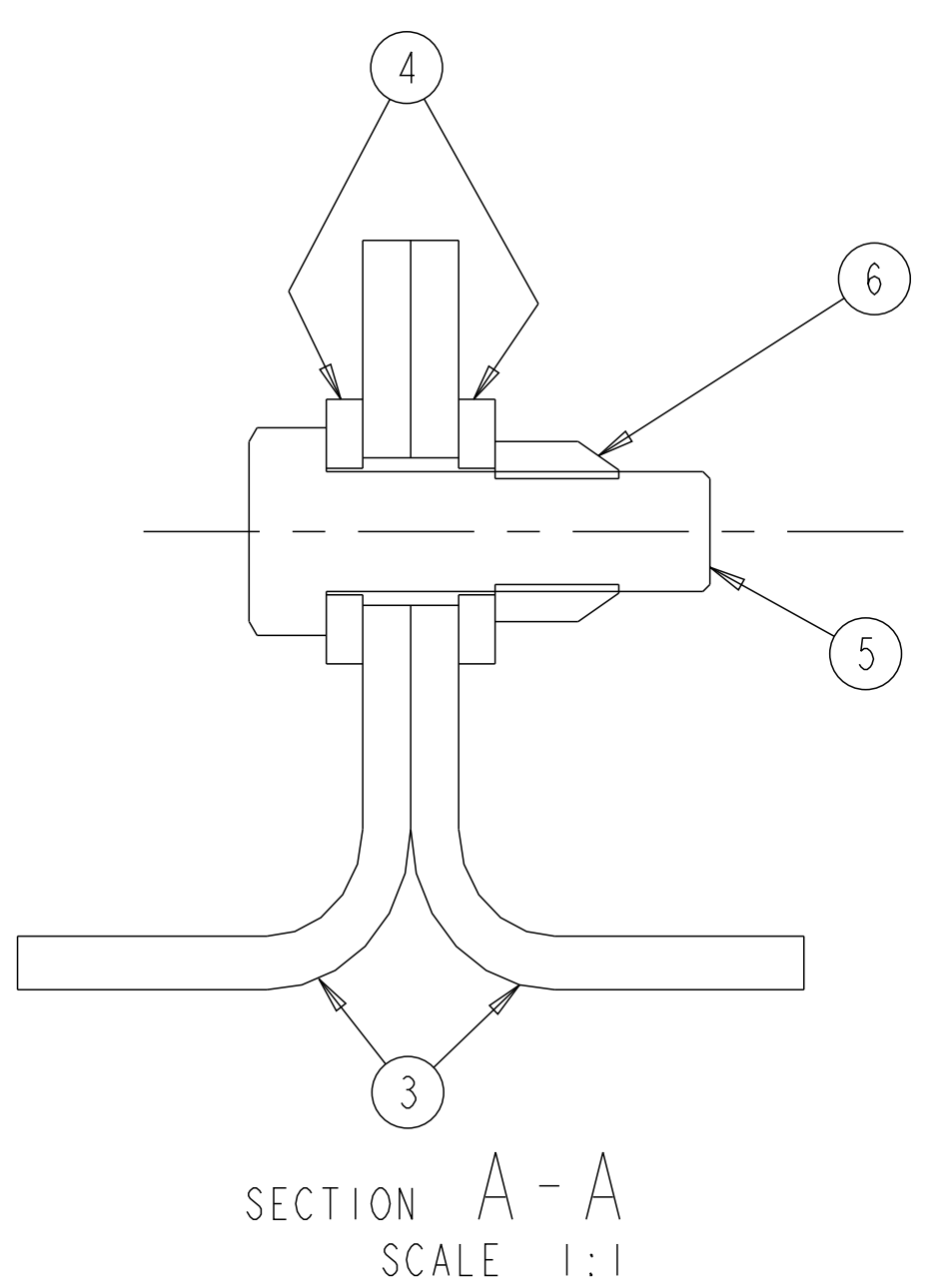
TAC	GUSSET PLATE
49.5	3305C4631
43.5	3305B4630
37.5	3305A4629

D2 DIMENSION "X"

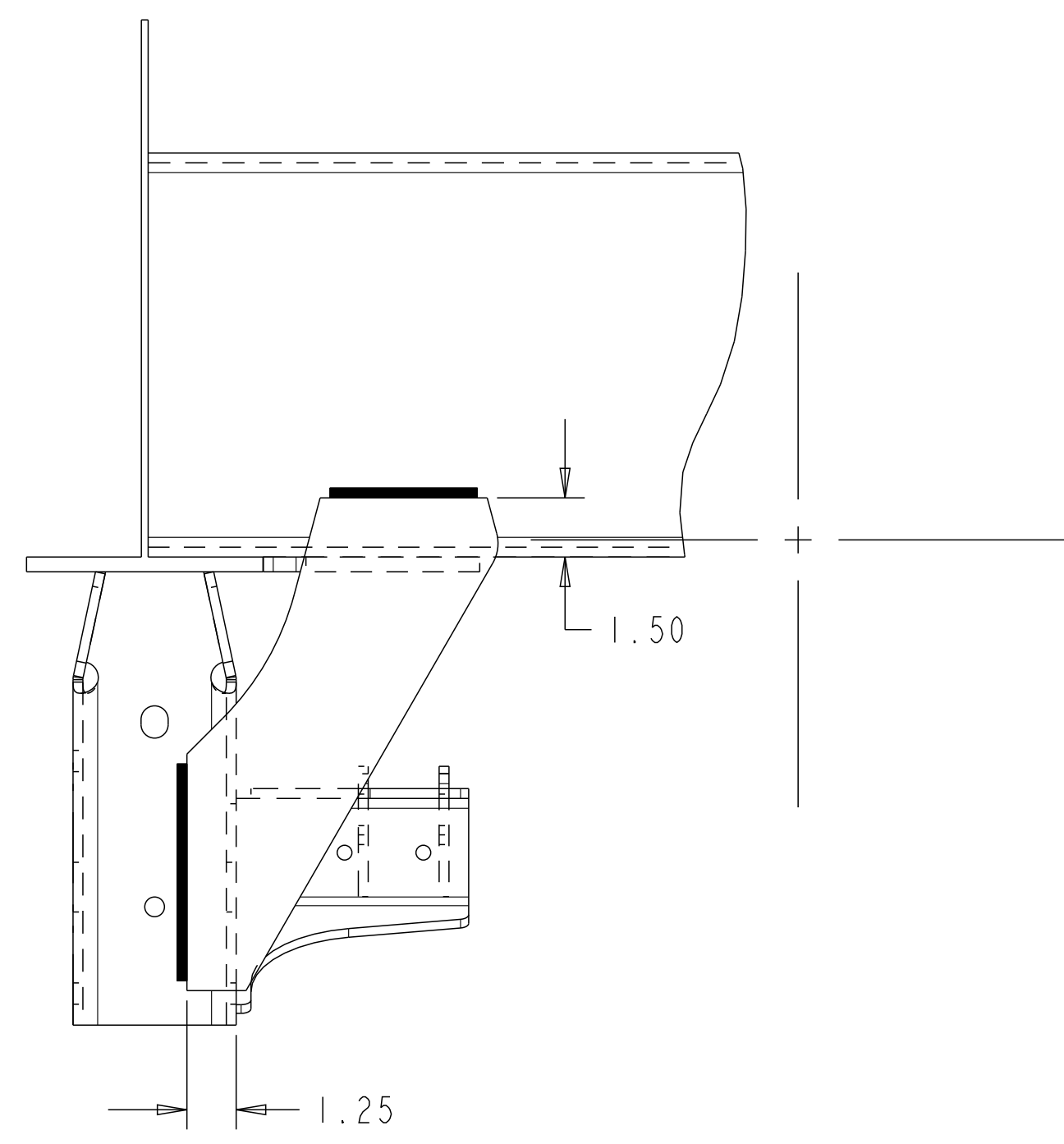
RIDE HEIGHT	PIVOT HEIGHT	TAC		
		37.5	43.5	49.5
6.5, 7.5, 8 & 9	4.5	9.32	9.09	8.89
12.0	8.0	5.15	4.79	4.47
14 & 15	10.0	3.82	3.59	3.39
16 & 17	12.0	2.86	2.82	2.82



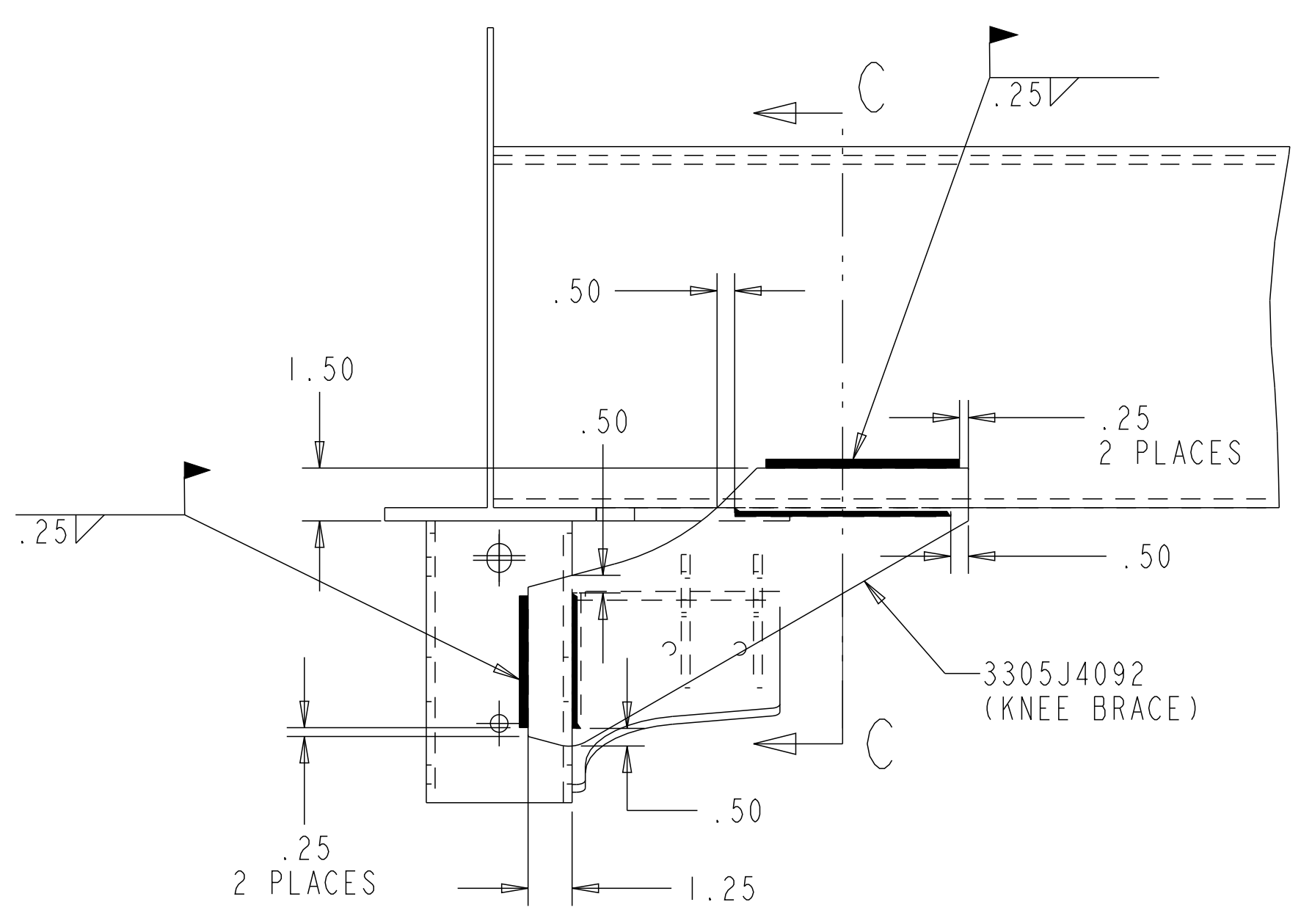
D7 OPTIONAL C-CHANNEL WELDING DETAILS FOR 4.5" PIVOT HEIGHT HANGER CONFIGURATION



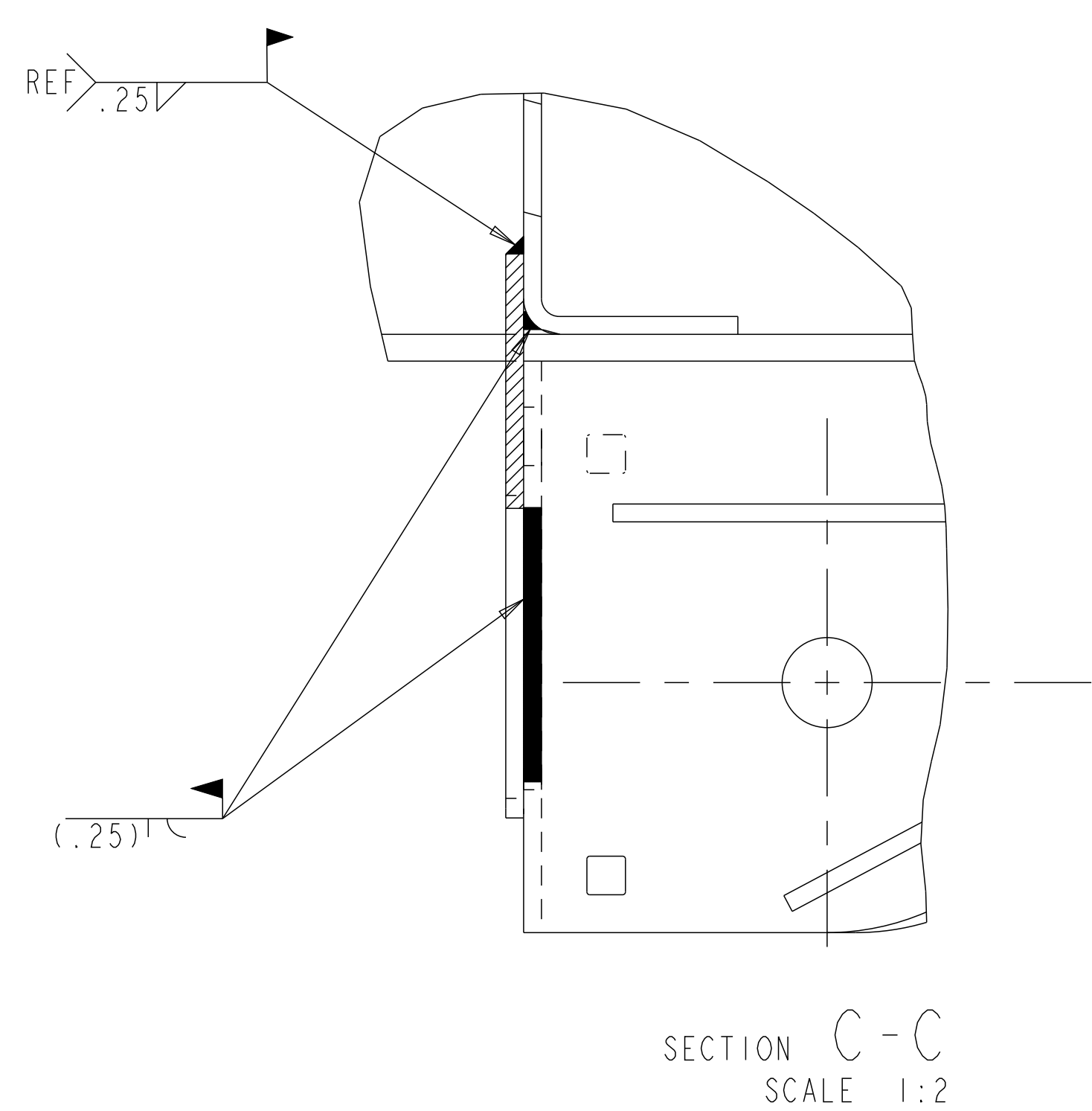
D6 RECOMMENDED X-BRACE WELDING DETAILS FOR 10" AND 12" PIVOT HEIGHT HANGER CONFIGURATIONS. (OPTIONAL FOR 8" PIVOT HEIGHT CONFIGURATIONS) (MTA-TEC6-23L 12" P.H SHOWN)



D5 RECOMMENDED KNEE BRACE POSITION FOR 8" PIVOT HEIGHT HANGER CONFIGURATION (SEE 4.5" CONFIGURATION FOR WELDING DETAILS)



D5 RECOMMENDED KNEE BRACE WELDING DETAILS FOR 4.5" PIVOT HEIGHT HANGER CONFIGURATION



WELD ON INSIDE OF HOLE TO PRODUCE PLUG WELD AS SHOWN

- D3 INSTALLATION INSTRUCTIONS
1. LOCATE AND WELD FIRST GUSSET PLATE WITH GUSSET FLANGE FACING DOWN AND REARWARD
 2. LOCATE SECOND GUSSET PLATE WITH GUSSET FLANGE FACING DOWN AND FORWARD
 3. ENSURE BOLT PASSES THROUGH THE SLOTS OF THE GUSSETS BEFORE WELDING THE SECOND GUSSET WELD SECOND GUSSET IN PLACE
 4. FASTEN THE GUSSET PLATES AT THE CENTER AS SHOWN

LAYOUT NO. 0

SIM. PARTS UNLESS OTHERWISE SPECIFIED

INTERPRET DRAWING PER ASME Y14.5M-1994
ALL DIMENSIONS IN INCHES
ALL OTHER TOLERANCES:
± .015 ON 3-PLACE DECIMALS
± .03 ON 2-PLACE DECIMALS
± .1" ON ANGULAR DIMENSIONS

ALL MACHINED SURFACE FINISHES: 320
BREAK ALL SHARP EDGES
REMOVE ALL BURRS, FLASH & PROJECTIONS
CASTING TOLERANCES PER STD. ISO 8062-3
FORMING TOLERANCES ± .06 - .03; DRAFTS "P" & "L"

REVISIONS

REV	DESCRIPTION	ECN	DATE	BY
B	ADDED VIEWS TO SHOW HANGER REINFORCEMENT OPTIONS.	ECN-143354	23-OCT-17	LGS
C	RELEASE 5-70009B FOR PRODUCTION	ECN-151590	17-AUG-18	CHMS
D	UPDATE TO LATEST PARTS 2-ADD DIM CHART AND ASSOCIATED DIMS SHT 2 3-REVISE INSTRUCTIONS SHT 2 4-UPDATE PART# TABLE SHT 2 5-ADD VIEW FOR KNEE BRACE SHT 2 6-REVISE RECOMMENDATIONS SHT 2 7-ADDED C-CHANNEL VIEWS SHT 2	ECN-166379	17-JUN-20	MDM/SS

MTA-TEC6-23L WELD-ON HANGER REINFORCEMENTS INSTALLATION

ECN-143354 ECN-151590	PART/DWG NO. 5-70009B	00050
RELEASE	NAME WELD TO FRAME	ENG. DESC. CODE
DRAWING SIZE E		INCH
DRAWING 5-70009B D.6	MODEL 5-70009B_X.BRACE D.3	SHEET 2 OF 2

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: --

PROJECT ENGINEER: L.G.S.

DRAWN BY: S.K.S.

CHECKED BY: L.G.S.

DESIGN CONTROL GROUP: TRAILER N.A.

CHANGE REQUEST #: CR-133500

SCALE: 1:4

WEIGHT: 4 IN. LOTS. 1.00MM

REGR./FIN. LBS

ORIGINAL FOR: --

3RD ANGLE PROJECTION

DO NOT CHANGE MANUALLY