

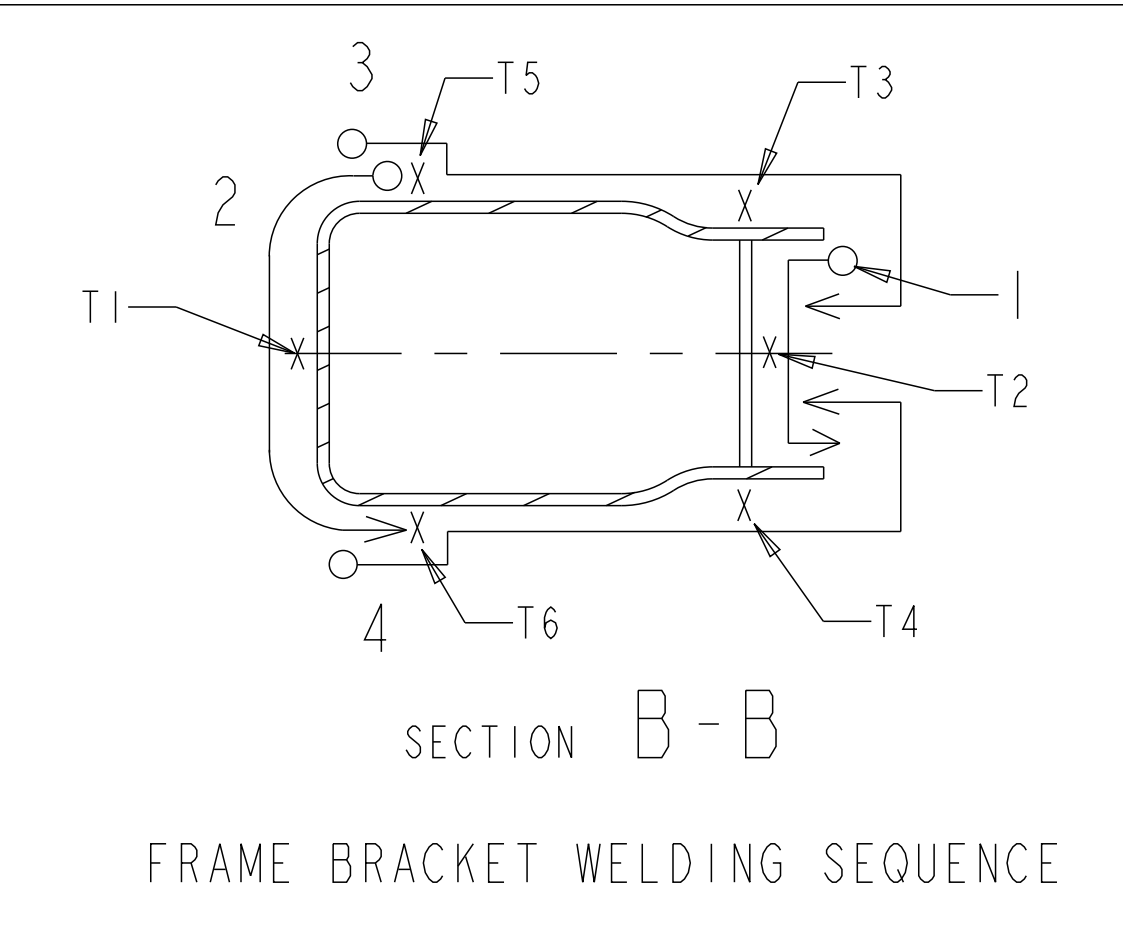
X = TACK WELD

T1 FIRST
T2 SECOND
T3 THIRD
T4 FOURTH
T5 FIFTH
T6 SIXTH

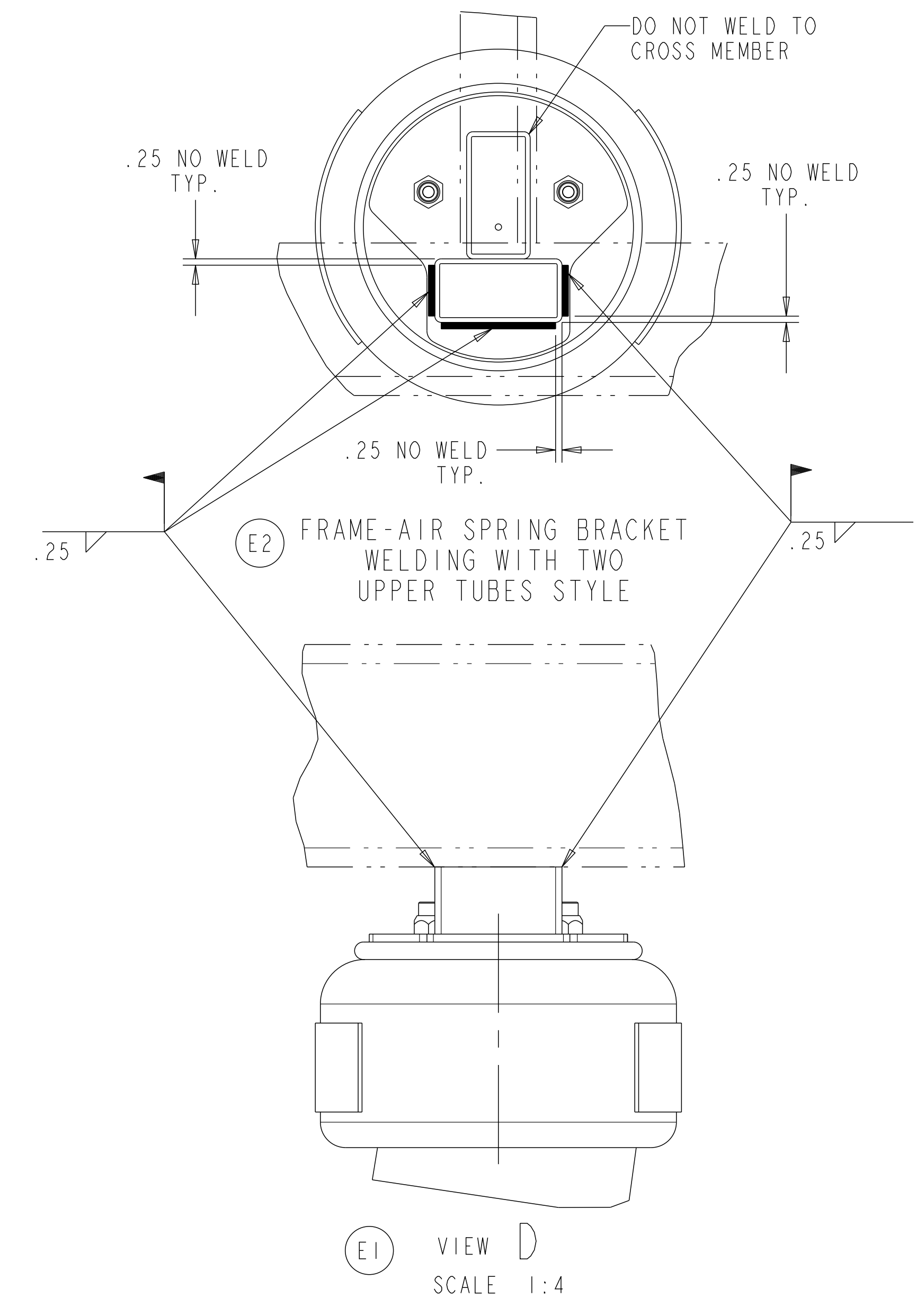
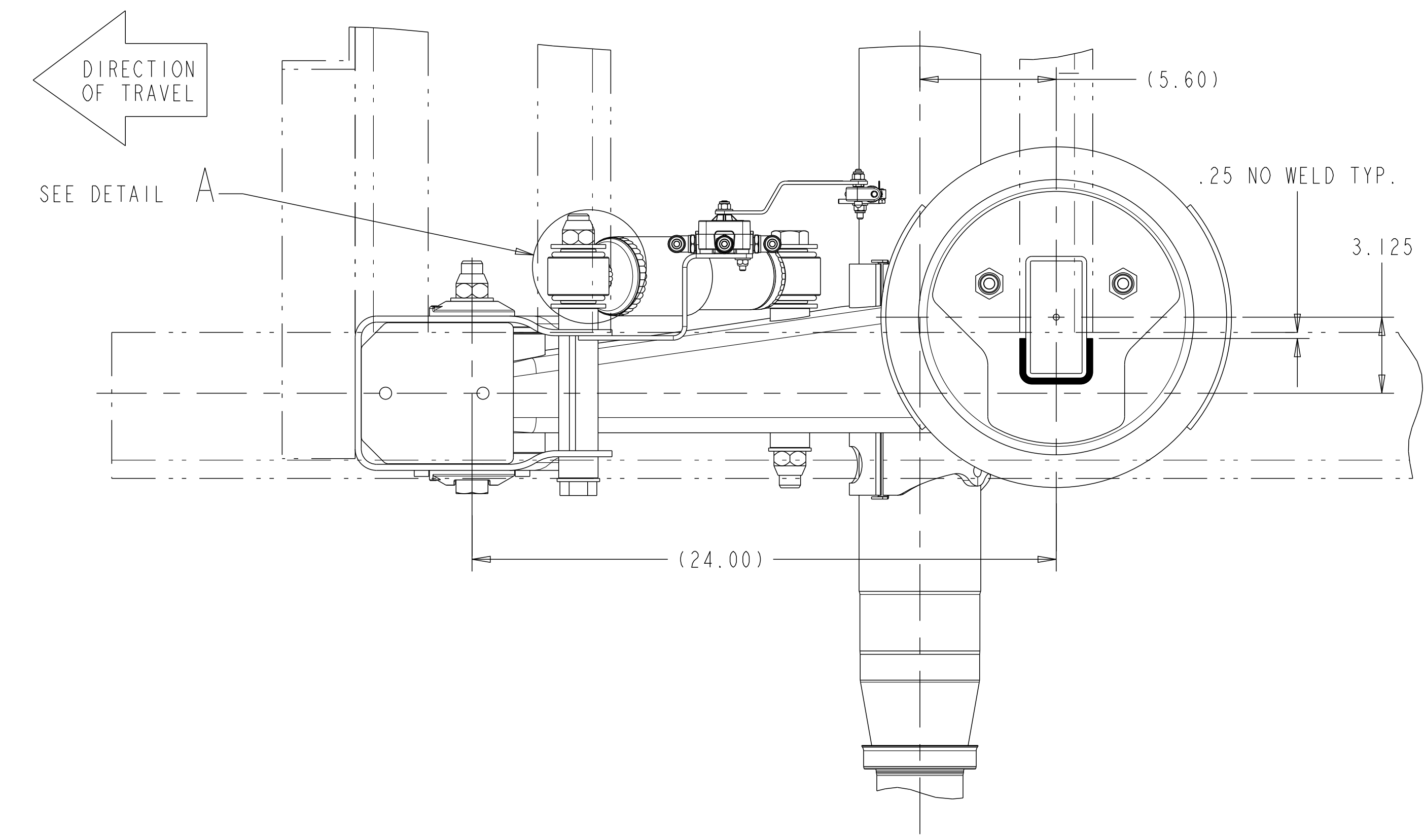
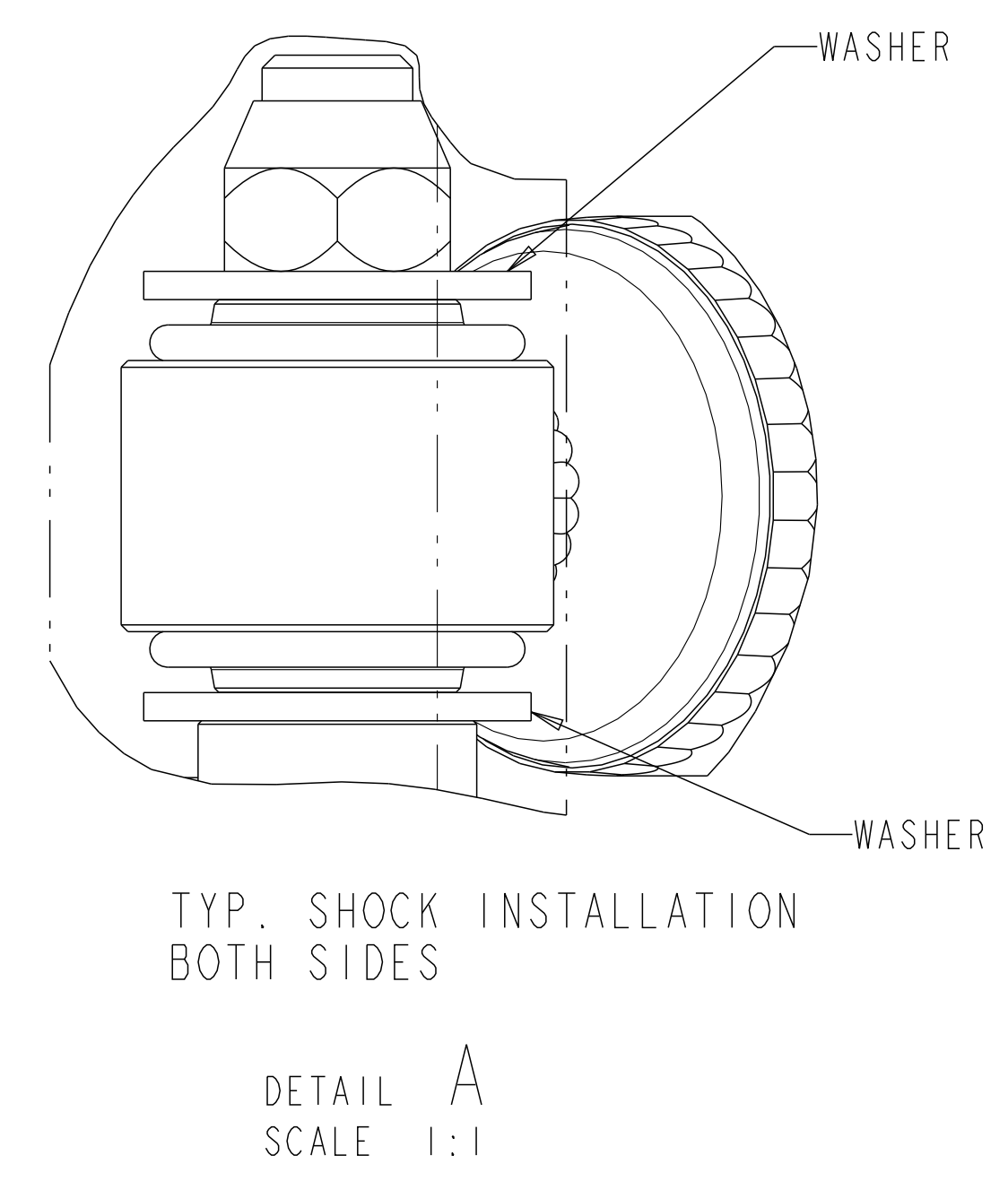
WELD RUN PROCEDURE AFTER TACK WELDING

○ START
→ STOP

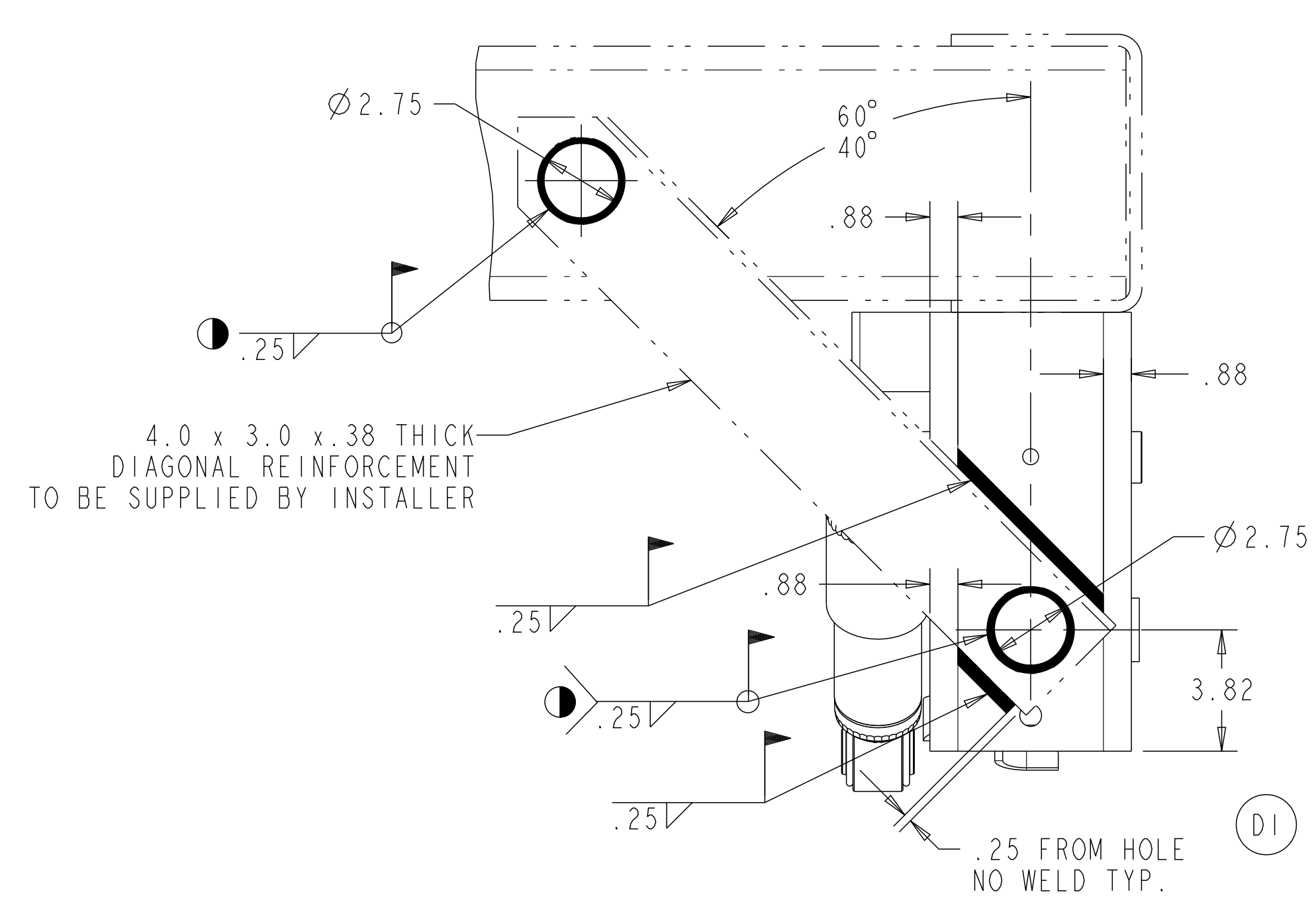
1 FIRST RUN
2 SECOND RUN
3 THIRD RUN
4 FOURTH RUN



SIM. PARTS			5-66240A_01		
REVISIONS					
A	RELEASED 5-66733E_01 FOR PRODUCTION.	109888	09/24/10	CH	HN
B	ADDED TACK WELDS AND REVISED WELDING SEQUENCE	115034	02/23/11	CH	SS
C	SHOP CHART WAS 4-60559_09	115433	04/27/11	CH	SS
D	1) WAS .25 FROM EDGE, 2) WAS 1/2" FROM TOOLING HOLE	116459	10/10/11	CH	SS
E	1-UPDATED VIEW TO REMOVE SECTION C-C AND ADDED TOP VIEW 2-UPDATED NOTE	ECN-132874	30-May-16	OL	SD
F	UPDATED RHC REPRESENTATION	ECN-165357	30-JUL-20	EN	SD

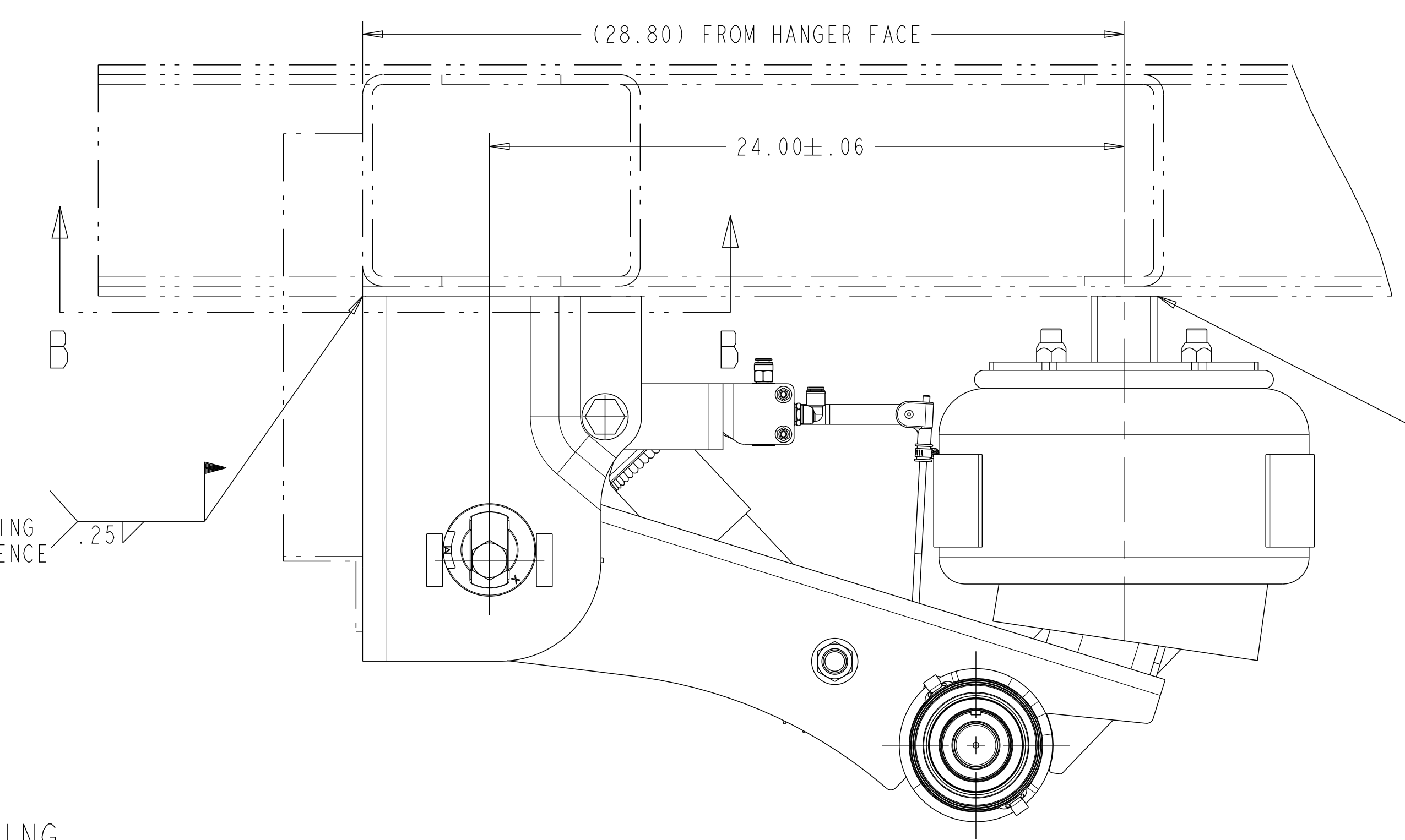


CAD FILES	
NAME	TYPE
5-66733E F.11	DRAWING
5-66733E F.6	MODEL



RECOMMENDED KNEE BRACING AND WELDING

WELD ON INSIDE OF HOLE TO PRODUCE PLUG WELD AS SHOWN



NOTE:

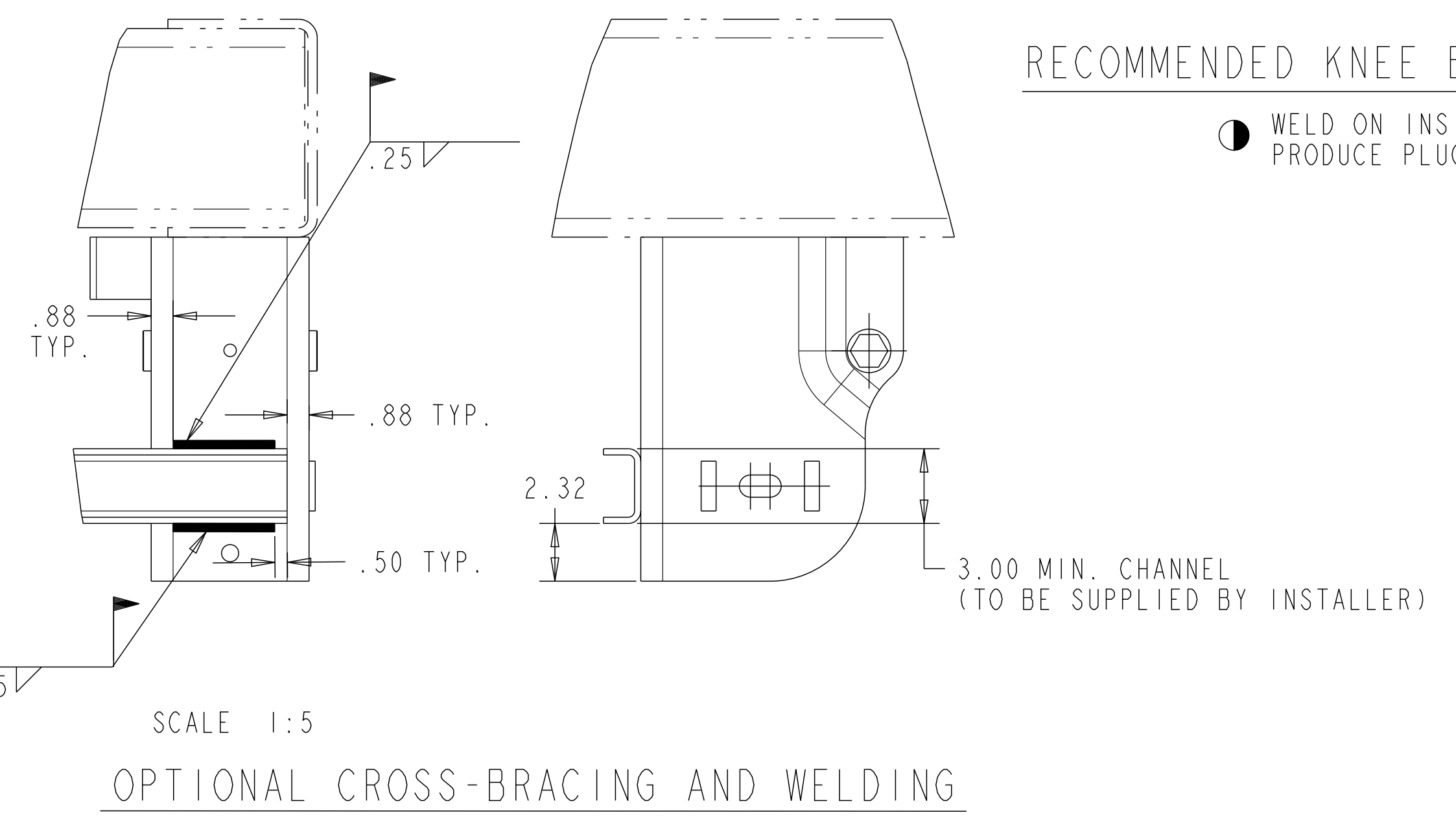
PROPER VEHICLE FRAME DESIGN IN THE AREA OF SUSPENSION ATTACHMENT IS THE RESPONSIBILITY OF THE INSTALLER.

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

D2 NO WELDING OR DRILLING ALLOWED ON TRAILING ARMS NO WELD WITHIN .25" OF FRAME BRACKET TOOLING HOLES

FOR GENERAL ARRANGEMENT INFORMATION SEE DRAWING 5-66734M_01 & 5-66734N_01

C REFER TO SHOP CHART 4-60559_36 FOR TORQUE INFORMATION



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	SEE BILL OF MATERIAL FOR SPECIFIC INDIVIDUAL MODEL INFORMATION				RELEASE	PART/DWG NO. 5-66733E-01	EDC 00050
			PROCESS	APPROVED PROJ. ENG. SAIEG	MATERIAL	SPECIAL			
4 IN. 10THS. 100MM		WEIGHT RGR. /FIN.	INQUIRY NO.	C. H. /T. E. NO. APP. NO.	PCCR 117265	ORIGINAL FOR MTA25T	SCALE 1:4	DESIGN CONTROL GROUP N. A. TRAILER PRODUCTS	PART NO.