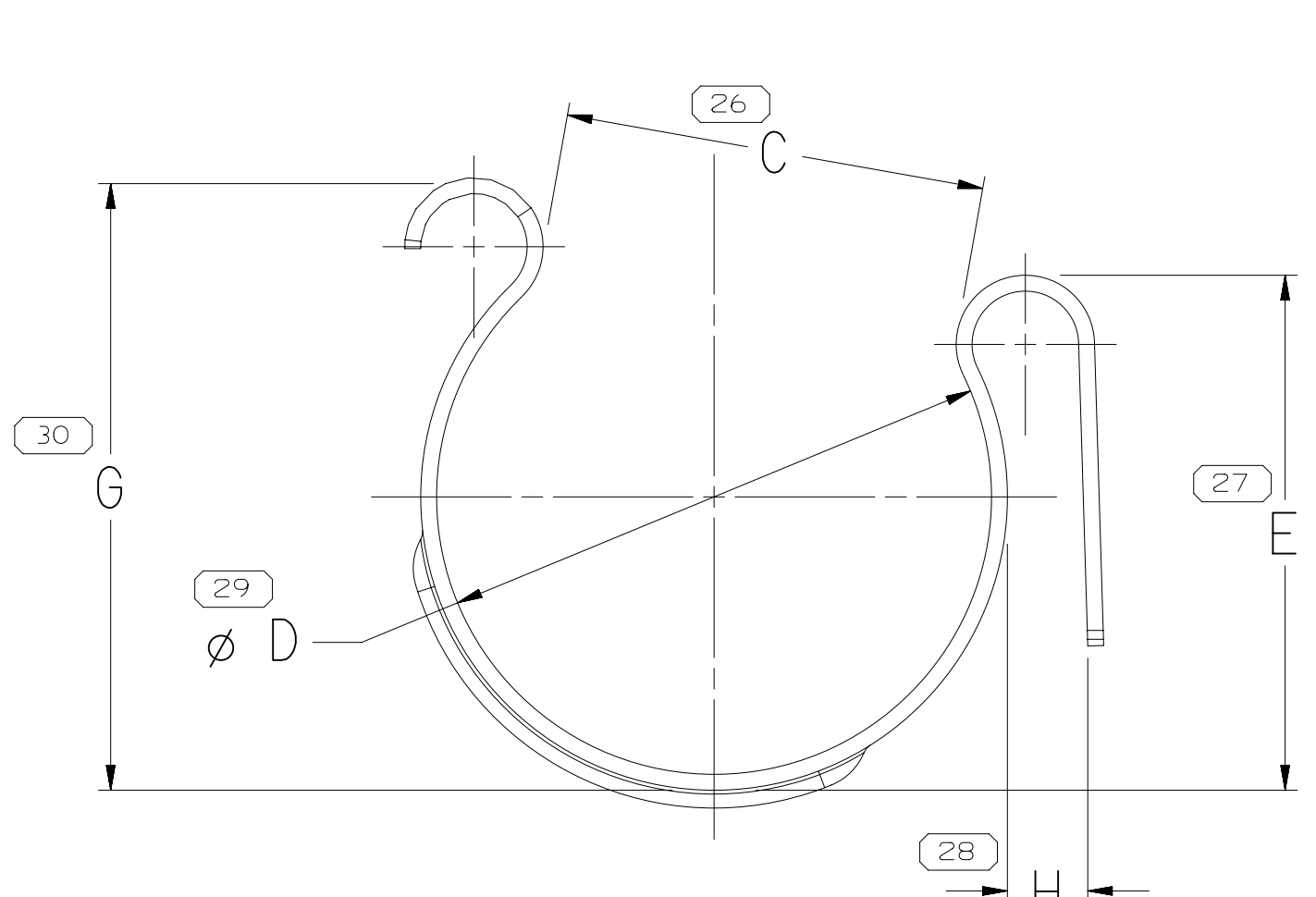
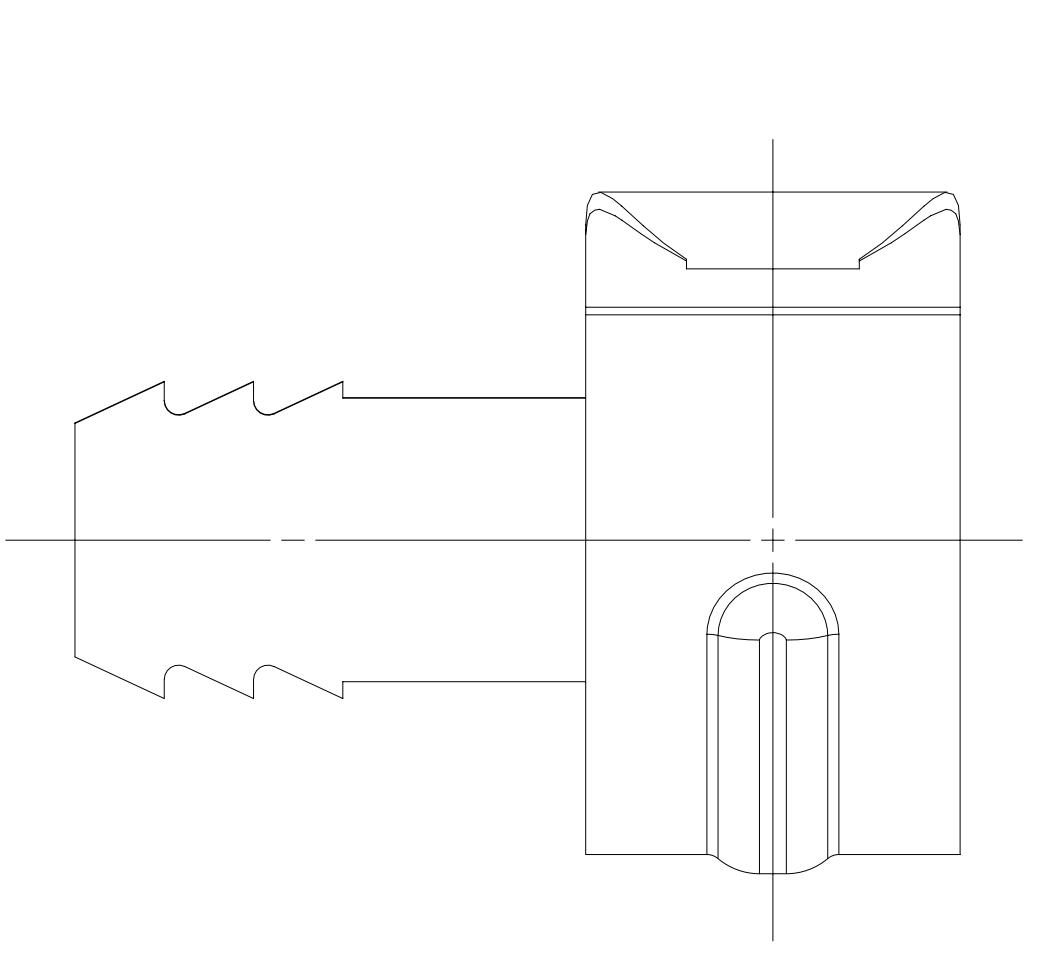
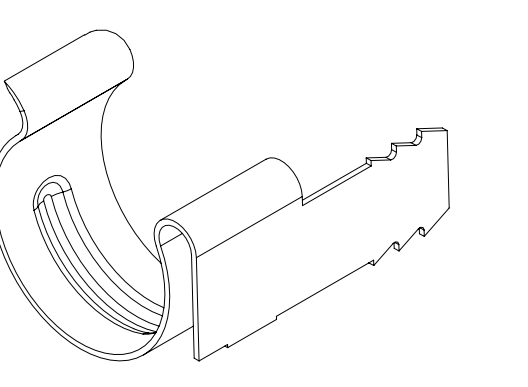
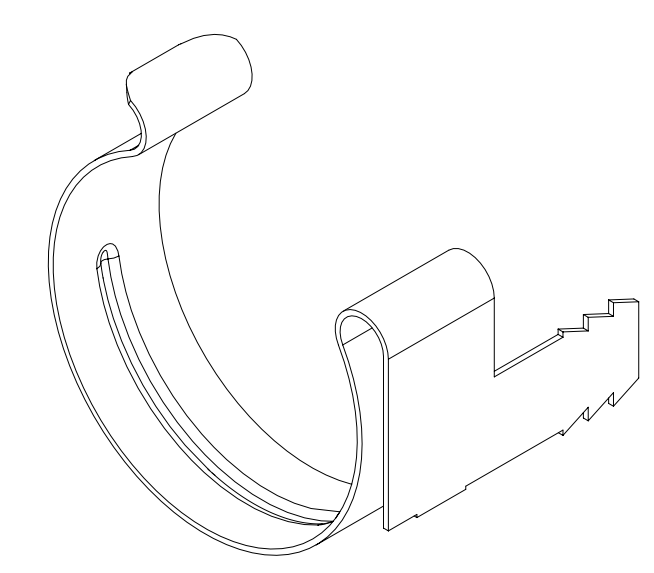
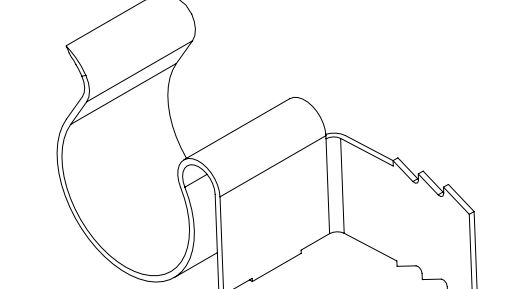
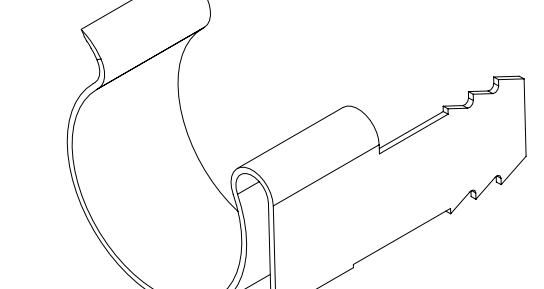
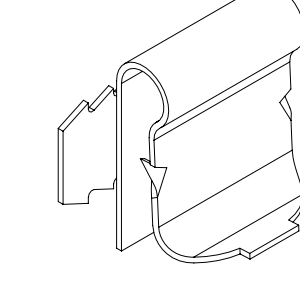
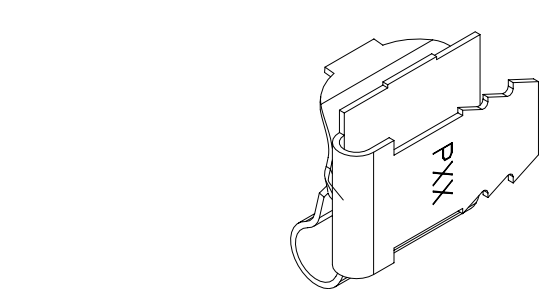
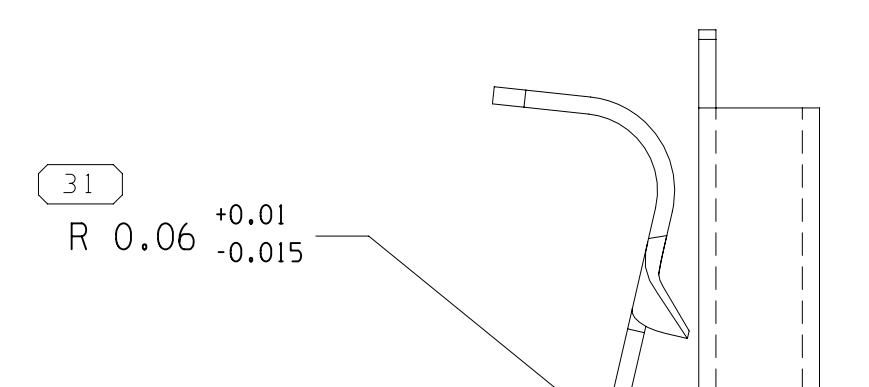
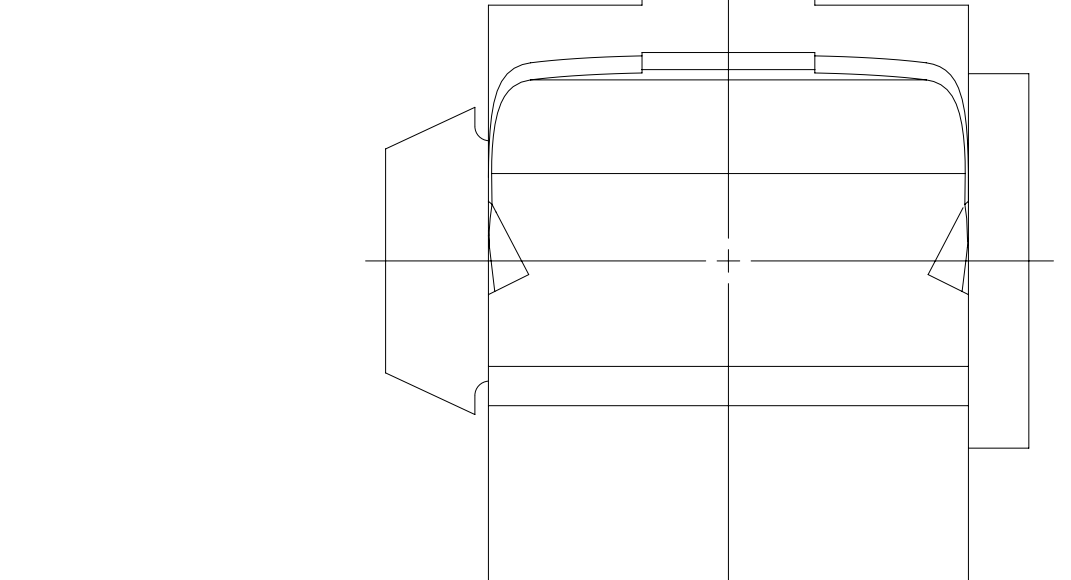
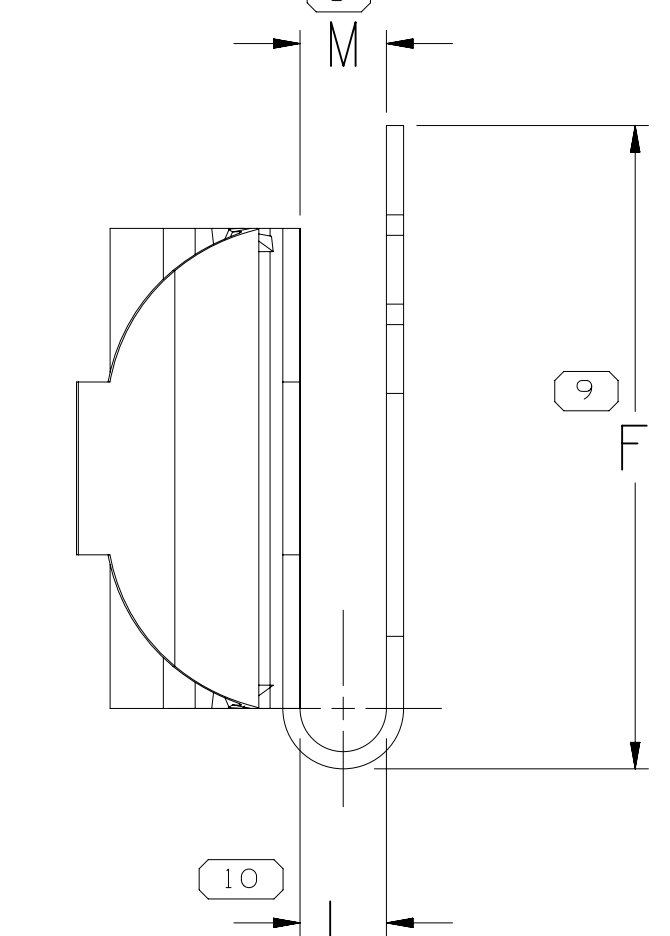
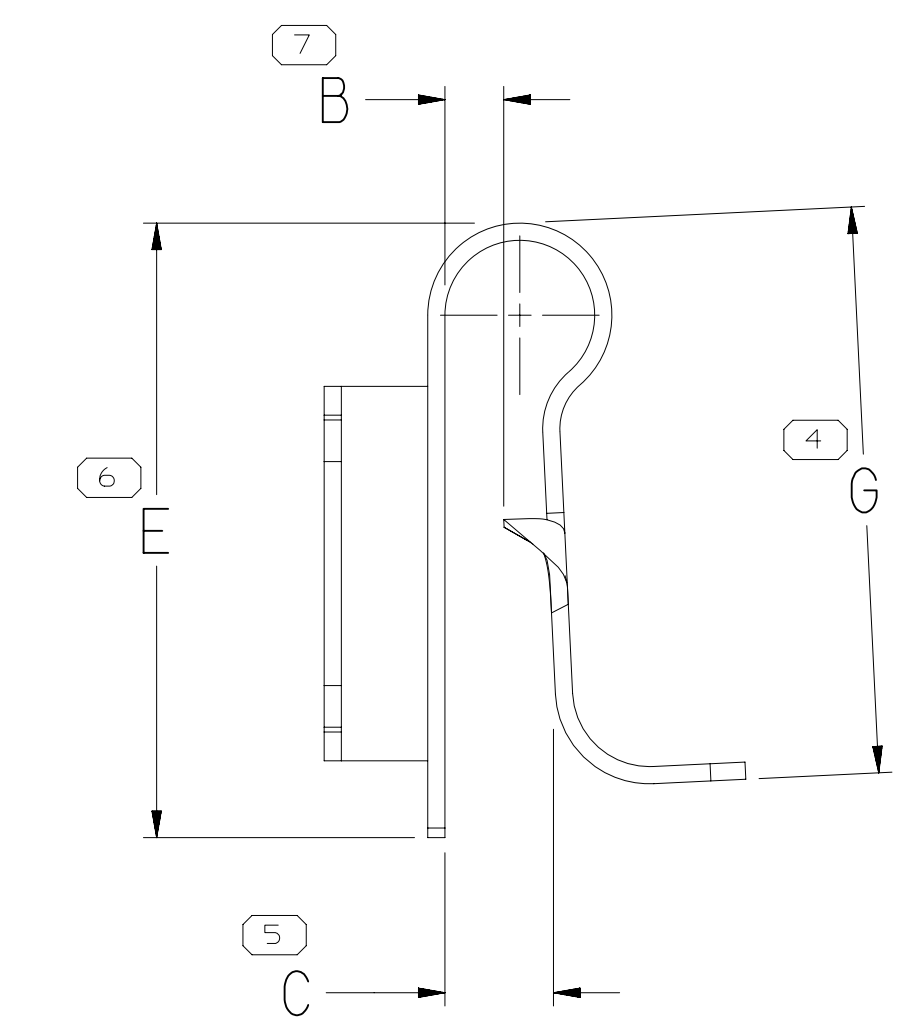
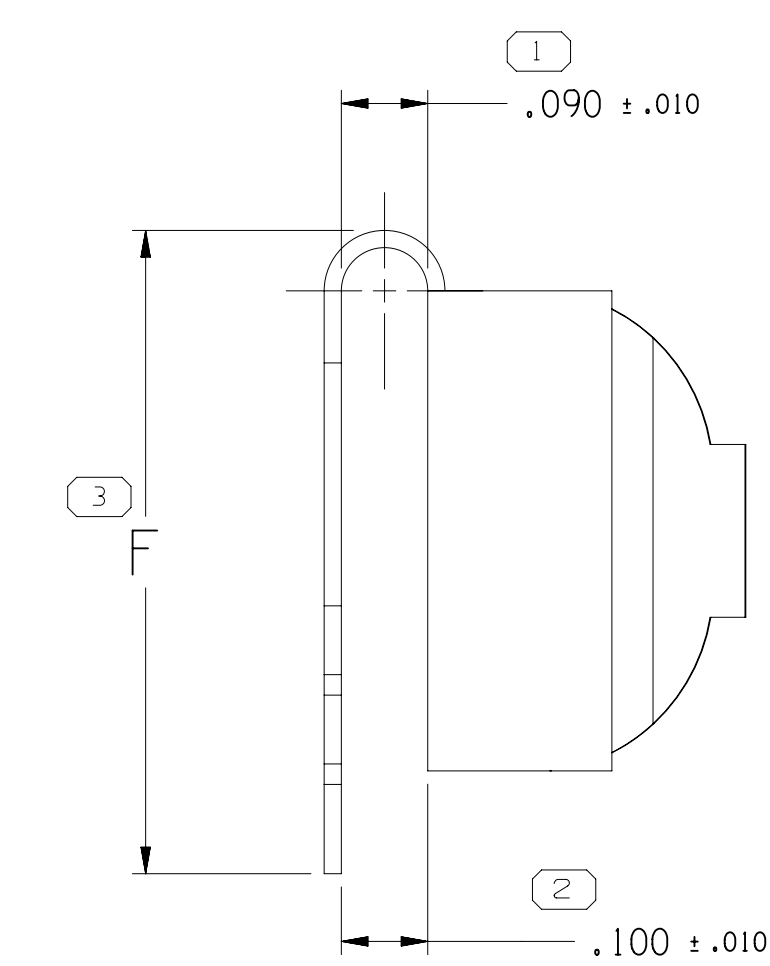


[illegible]

1. HEAT TREAT TO ROCKWELL "15M" 83-86.
2. ZINC PLATE PER POS 1065-15 (GM-4342-M, CODE 10K).
3. ZINC PLATE AND GOLD CHROMATE TREAT PER POS 1065-8-15.
(10K-4342-M CODE 1007).
4. CADMIUM PLATE AND GOLD CHROMATE TREAT PER POS 1005T-15.
(GM 4341-M CODE 1001).
5. BAKE PER POS 1253 (RELIEVE HYDROGEN EMBRITTLEMENT, IF PRESENT 14 HOURS AT 375° F TO 450° F).
6. ZINC PLATE AND CLEAR CHROMATE TREATMENT PER POS 1065-15 (GM-4345-M, CODE 3K32/B1).
7. PLATE TO .0003 INCH ZINC, BLACK CHROMATE & CLEAR DIP.
PLATING MUST WITHSTAND 168 HOUR MINIMUM TO RED RUST IN NEW TEST FOG, EXCEPT "SHARP" EDGES & SHOULD BE BLACK IN COLOR.
8. BLACK PHOSPHATE/OIL PLATE PER 06M174-M, PART MUST NOT BE OILY TO THE TOUCH.
9. CHROMATE/ZINC/ORGANIC TYPE COATING PER 6173M BLACK MUST WITHSTAND 168 HOUR MINIMUM TO RED RUST IN NEUTRAL SALT FOG EXCEPT FOR SHARP EDGES.
0. ZINC PLATE AND BLACK CHROMATE PER GM-4342-M, CODE 20L24.
1. ZINC PLATE PER GM4345-M, CODE 3U24/0.
2. ZINC PLATE AND CLEAR CHROMATE TREATMENT PER GM-4345-M, CODE 3U24/0.

NOTES

- UNLESS OTHERWISE SPECIFIED AND/OR INDICATED:
- DIMENSIONS ARE TO FACE OF VIEW SHOWN AND AUTOMATICALLY ROUNDED BY COMPUTER FOR INSPECTION USE (MATH MODEL FOR PRECISE DIMENSIONS). FOR ALL OTHER DIMENSIONS NOT SHOWN BUT REQUIRED FOR TOOL BUILD, USE MATH MODEL FOR PRECISE TOOL PATH DATA.
- PROCESS OPERATIONS TO BE PERFORMED IN SEQUENCE SHOWN IN CHART
- FORMED DIMENSIONS APPLY TO THE PARTS AFTER HEAT TREATING AND PLATING.
- VISIBLE CRACKS ARE NOT PERMISSIBLE.
- "PKY" INDICATES "P" PLUS LAST TWO DIGITS OF MAKE DIE SERIES NUMBER (P01, P02, P03, ETC.).
- OBSCURE PART(S) CONTAIN A HEXAVALENT CHROME COATING. DO NOT USE THIS PART ON NEW APPLICATIONS; HEXAVALENT CHROME IS A BANNED SUBSTANCE. IF THIS PART IS REQUIRED FOR CURRENT OR FUTURE BUS OR TRUCK REPAIRS, CONTACT THE TRUCK LINE ENGINEER OR MATERIALS ENGINEERING TO GET A NEW PART THAT IS FREE FROM HEXAVALENT CHROME. EXISTING INVENTORY OF THIS PART MAY BE USED FOR REPAIR OF EXISTING TRUCKS.
- MANUAL INSERTION OF THESE TYPES OF CLIPS INTO CONNECTORS OR PLASTIC CLIPS IS NOT RECOMMENDED.
- P50 FOR TYPE 301, 304 & 316 WILL BE ITEM 4 B

DATE	DWG	STATUS	REV	INFO	ZONE	REVISION HISTORY	AUTH	DR	APPROVER
160C00	R	01	-	-	-	CLEARER REV COLUMN: ALL PARTS REBARRED TO POS (1204933) - 0991218 - 0.25% - 0107/-020 WAS .025 ±.010	201373	AAH	FRG
07A001	R	02	-	-	-	1541263 - RELEASED	212535	EES	JLARP
10A001	R	03	-	-	-	0299990 & 1262040 REVISED CHART	214121	FSH	TEH
10S001	R	04	-	-	-	ADDED TOLERANCE TO DIM #137	214424	CLC	JCARP
30C001	R	05	-	-	-	TYPE 306-ADDED P.O & R VALUES TO CHART TYPE 301,302,304 & 306 REVISED GRAPHICS	214438	FSH	TEH
20C001	R	06	-	-	-	15418281 & 15418331 - RELEASED	216039	MAC	MAC
20A002	R	07	-	-	-	1204933 - .5800/-010/-060 WAS .5800/-010/-060/-010 WAS .6900/-015/-015, .025/-025 WAS .090	234945	LEG	LEG
10S003	R	08	-	-	-	15479735 - 37 - RELEASED; 1204890 - ADDED PROCESS NOTE 13 AND REVISED PROCESS NOTES CALL OUT INFORMATION	245899	CMZ	FRH
08C003	R	09	-	-	-	1541263 - REVISED PROCESS NOTES CALL OUT INFORMATION	247246	CMZ	FRH
11A004	R	10	-	-	-	12612010 - OBSOLETE AND ADDED NOTE 7,	255203	JBD	JAN
01A004	R	11	-	-	-	15495800B-20, 15495961 & 15495963-RELEASED AND ADDED PROCESS NOTES 14 & 15	256627	ABD	JAN
28S004	R	12	-	-	-	ALL PARTS - REVISED NOTE 15; 1549981 - RELEASED	259573	ADK	ADK
25C004	R	13	-	-	-	15495800B-20, 15495961, 15495963 & 1549981 - ADDED PROCESS NOTE CHART 1, AND REVISED PROCESS NOTES - OBSOLETE	260600	RTV	AUG
07D004	R	14	-	-	-	15495813 & 15495815 - OBSOLETE	261918	CCV	JWM
14F005	R	15	-	-	-	13522643 - RELEASED	264664	APM	JAM
28E005	R	16	-	-	-	15495811 - UPDATED PMO ATTRIBUTES	264654	JBH	PYM
01M005	R	17	-	-	-	12618616 & 15495818 - .500 ±.020 WAS ±.30 ±0.015 AND 0.045 ±0.010 WAS ±.017 ±0.018	264937	JTV	FRH
01A005	R	18	-	-	-	1549981 - ADDED MAT'L SIZE AND MATERIAL SPEC	266581	JBD	FRH
09M005	R	19	-	-	-	1354115-16 - RELEASED	267626	EVN	JAG
19C005	R	20	-	-	-	02973464, 06288612, 08912218, 12084580, 12089444, 12089444, 15418281, 15418331, 15479735, 15479737 - OBSOLETE	273624	HCS	JVM
19C005	R	21	-	-	-	12618616 - OBSOLETE	276109	CCV	JVM
19C005	R	22	-	-	-	12041482 - OBSOLETE	273757	JTZ	JVM
30A006	R	23	-	-	-	ALL ACTIVE PARTS - CREATED TOOL DRAWS 12612010	276817	RTV	JAN
10F006	R	24	-	-	-	ALL ACTIVE PARTS - ADDED NOTE #7	277187	GLG	JAN
21F006	R	25	-	-	-	09997330, 02999916 & 06288295 - OBSOLETE	277590	AMM	JAN
30C006	R	26	-	-	-	02999730 - RELEASED AND ADDED PROCESS NOTE #16	284100	OPS	AUG
110C06	R	27	-	-	-	13601715 - RELEASED AND ADDED PROCESS NOTE #17	289537	MOH	JAN
180C06	R	28	-	-	-	13522643 - MAT'L SPEC WAS M095055	285862	MOH	FRH
22A006	R	29	-	-	-	13522643 - PROCESS NOTE WAS DIM 1 & 14	287613	LOM	FRH
06C007	R	30	-	-	-	13522643 - DIM "C" WAS .842, DIM "O" WAS .812 AND REMOVED R 5/16" DIM WAS #17	400237	HCS	JVM
07E007	R	31	-	-	-	13599737-38 & 13601715 - REMOVED STAMP "P" FROM CHART	400438	EFS	JVM
26A007	R	32	-	-	-	13522643 - ADDED RIB & WAS TYPE 305	401240	JBD	FRH
26A007	R	33	-	-	-	13522643 - DIM "E" WAS .6458-040	401737	ABD	FRH
26A007	R	34	-	-	-	13534115 & 13534116 - OBSOLETE	401763	ABD	FRH
16L007	R	35	-	-	-	13601715 - ADDED STIFFENING RIB & TYPE 305	401866	ABD	FRH
28A008	R	36	-	-	-	13599937, 13599938 & 13601715 - OBSOLETE	404508	JTZ	JAN
08M014	R	37	-	-	-	15495810 - WAS TYPE 304 AND ADDED (I PLCL); 12077361 - OBSOLETED	426742	AHG	JAN
27A014	R	38	-	-	-	15495810, 08900012, 06288213, 13599938, 13599937, 1354118, 15495815, 15495816, 15495808, 15418331, 12041482, 02999916, 15454881, 12612010, 12612010, 12612010 WAS #17 AND ADDED PDS INFORMATION NOTE	427328	AHG	JAN
01A026	R	39	-	-	-	15495820 - OBSOLETE	529718	GSD	GH

[illegible]