

REV. #	ZONE	DATE	BY
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REVISION	DESCRIPTION	DATE	BY
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16			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Angles: ± .5° Fractions: ± 1/64 Decimals: .xx ± .01 Surface FINISH: 125 * DO NOT SCALE DRAWINGS *	ENGINEERED: D. BEACH DATE: 12/19/97	DEPARTMENT OF TRANSPORTATION <b>NHTSA</b>
	DRAWN: B. SECK DATE: 12/03/04	CONTRACT NO.: DTMB 28-94-C-07010 DESIGNED BY: GESAC, INC. <small>10000 W. 10th Ave. • Aurora, CO 80015</small>
	CHECKED: J. McDONALD DATE: 12/03/04	DRAWING TITLE: ANKLE MECHANICAL ASSEMBLY
	SCALE: 1=1 SIZE: D	FINISH: 12 QUANTITY FOR AN ASSEMBLY: 1 QUANTITY FOR ENTIRE DUMMY: 2
SEE DWGS.	MATERIAL:	DRAWING NUMBER: TIAKM000-1 Page: 1/1

16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1
J															
I															
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C															
B															
A															
16	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1

**NOTES:**

△ PRIOR TO INSTALLATION, ALL POTENTIOMETERS ARE CALIBRATED WITH AT LEAST A TEN POINT CALIBRATION CENTERED AT THE MID-POINT OF THE POTENTIOMETER RANGE AND COVERING AN ANGULAR RANGE OF +/- 90° FROM THE MID-POINT. THE ACCURACY OF THIS CALIBRATION MUST BE BETTER THAN 1/2°. THE MID-POINT SHOULD BE APPROACHED FROM BOTH A CLOCKWISE AND COUNTERCLOCKWISE ROTATION TO ASSURE REPEATABILITY.

△ POTENTIOMETER #1 IS ALWAYS MOUNTED TOWARD THE FRONT OF THE FOOT WITH THE TOP OF THE POTENTIOMETER FACING OUT (VISIBLE).

△ POTENTIOMETER #2 IS ALWAYS MOUNTED TOWARD THE RIGHT SIDE (→) OF THE FOOT WITH THE TOP OF THE POTENTIOMETER FACING OUT (VISIBLE).

△ POTENTIOMETER #3 IS ALWAYS MOUNTED WITH THE TOP OF THE POTENTIOMETER FACING DOWN IN THE ASSEMBLED ANKLE. BUSHING PLATE ASSEMBLY WITH THE BUSHING PLATE - POT END (TIAKM10) IS TO BE USED AT THE POTENTIOMETER END OF EACH TORQUE SHAFT ASSEMBLY.

△ BUSHING PLATE ASSEMBLY WITH THE BUSHING PLATE - END COVER (TIAKM12) IS TO BE USED ON THE END OPPOSITE THE POTENTIOMETER END OF EACH TORQUE SHAFT ASSEMBLY.

△ ASSEMBLE ONE OF THE Z-AXIS STOPS (TIAKM027) AT EACH END OF THE ANNULAR GROOVE IN THE TOP ANKLE BASE (TIAKM011) USING A DROP OF SUPER GLUE TO HOLD THE STOP IN PLACE.

△ PLACE A DROP OF LOCKTITE #242 ON EACH POTENTIOMETER SHAFT PRIOR TO ASSEMBLY

△ THE LOWER LEG ASSEMBLY IS SHOWN FOR REFERENCE ONLY.

REV. #	ZONE	DESCRIPTION	DATE	BY
1	G-7	ADDED DORSIFLEXION SOFT STOP	4/29/00	D. BEACH
2	ITEM 18.17	CORRECTED SHOULDER BOLT CALL-OUT	4/29/00	D. BEACH
3	ITEM 18.18	CHANGED CALLOUT LOCATION FOR CLARITY	11/17/00	D. BEACH
4	ITEM 18	CHANGED FROM F.H.S.C.S. TO B.H.S.C.S.	5/23/00	D. BEACH
5	GLOBAL	CHANGED TO Z-AXIS ROTATION DESIGN	6/29/00	D. BEACH
6	GLOBAL	UPDATED ACHILLES PULLEY ADDED ITEM 20	6/29/00	D. BEACH
7	GLOBAL	CHANGED ITEM 17 TO A MANUFACTURED PART	10/6/00	D. BEACH
8	GLOBAL	ADDED NOTE 1 REGARDING POT CALIBRATION	11/16/00	D. BEACH
9	GLOBAL	NOTE REGARDING INSTALLATION OF POT AS REVISED NOTE 8	12/9/00	D. BEACH
10	GLOBAL	ADDED TIAKM004 ASSEMBLY, REARRANGED NOTES	5/9/01	D. BEACH
11	GLOBAL	ADDED NOTE 7	6/29/00	D. BEACH
12	GLOBAL	EXPLODED ASSEMBLY CREATED PAGE 2	1/14/05	J. McDONALD

REV. #	QTY	DWG/PART NUMBER	DESCRIPTION	DATE	BY
16	2	TIAKM027	Z-ROTATION STOP	SEE DWG.	
17	2	MCMJ 9125SA110	#4-40 x 1/2" F.H.S.C.S. (ALLOY)	PURCHASED	
18	1	TIAKM028	DORSI-FLEXION SOFT STOP COVER	DELFIN	
19	8	MCMJ 9125SA159	1/4 - 20 x 5/8" B.H.S.C.S. (ALLOY)	PURCHASED	
20	4	MCMJ 9125SA112	#4-40 x 5/8" F.H.S.C.S. (ALLOY)	PURCHASED	
21	4	MCMJ 9125SA148	#6-32 x 1/2" F.H.S.C.S. (ALLOY)	PURCHASED	
22	4	MCMJ 9125SA145	#6-32 x 5/16" B.H.S.C.S. (ALLOY)	PURCHASED	
23	2	MCMJ 92311A146	#6-32 x 3/8" S.S.S. (18-8 SS)	PURCHASED	
24	4	MCMJ 92311A142	#6-32 x 1/8" S.S.S. (18-8 SS)	PURCHASED	
25	4	MCMJ 9125SA165	#6-32 x 1" F.H.S.C.S. (ALLOY)	PURCHASED	
26	4	MCMJ 9125SA108	#4-40 x 3/8" F.H.S.C.S. (ALLOY)	PURCHASED	
27	3	MCMJ PD210-4B	CONTROL ROTARY POTENTIOMETER	PURCHASED	
28	6	TIAKM022	DELFIN SPACER WASHER	DELFIN	
29	16	TIAKM018	RUBBER TORQUE CYLINDERS	SEE DWG.	
30	4	TIAKM014	TORQUE BASE CAP	6061-T6	
31	2	TIAKM013	POTENTIOMETER COVER	DELFIN	
32	1	TIAKM011	TOP TORQUE BASE	6061-T6	
33	1	TIAKM010	BOTTOM TORQUE BASE	6061-T6	
34	1	TIAKM004	ANKLE RETAINING BOLT ASSEMBLY	SEE DWG	
35	1	TIAKM050	ACHILLES PULLEY BRACKET ASSEMBLY	ASSEMBLY	
36	4	TIAKM100	BUSHING PLATE ASSEMBLY	SEE DWG.	
37	2	TIAKM003	INVERSION-EVERSION SOFT STOP ASSEM.	SEE DWG.	
38	1	TIAKM002	DORSI-PLANTAR SOFT STOP ASSEMBLY	SEE DWG.	
39	1	TIAKM001	CENTER BLOCK ASSEMBLY	6061-T6	

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

ENGINEER:	D. BEACH	DATE:	12/9/07
DRAWN:	B. SECK	DATE:	12/05/04
CHECKED:	J. McDONALD	DATE:	12/09/04
SCALE:	1=1	SIZE:	D 12

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
 Tolerances  
 Fractions ± 1/64  
 Decimals: .01  
 Surface Finish: Ra .125  
 \* DO NOT SCALE DIMENSIONS

QUANTITY FOR AN ASSEMBLY: 1  
 QUANTITY FOR ENTIRE DUMMY: 2

SEE DWGS.  
 MATERIAL: ANKLE MECHANICAL ASSEMBLY

DEPARTMENT OF TRANSPORTATION  
 NHTSA  
 CONTRACT NO.: DTFR 04-1-0740  
 DESIGNED BY: GESA/C, INC.  
 IS INCLUDE W/IT  
 ESTIMATED BY STS

DRAWING TITLE: ANKLE MECHANICAL ASSEMBLY  
 DRAWING NUMBER: TIAKM000-2  
 Page 1/1

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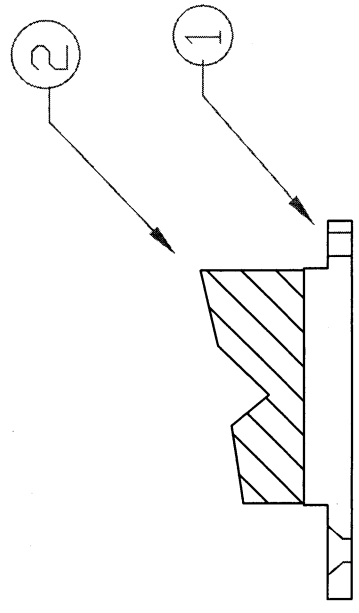
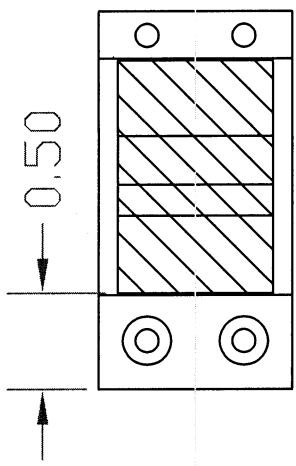
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REVISIONS		DATE	BY
REV. #	ZONE		
1	C-4	11/15/99	D. BEACH
2	C-3	1/4/02	D. BEACH

NOTE:

- ① SANDBLAST T1AKM024 AND CLEAN WITH MEK
- ② ABRABE T1AKM025 WITH SANDPAPER AND CLEAN WITH MEK AND ALCOHOL
- ③ BOND THE PARTS UNDER PRESSURE USING LORD 305 EPOXY ADHESIVE
- ④ PART IS LOCATED ON CENTER AS SHOWN



D

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REV. #	QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
2	1	T1AKM025	DORSI-PLANTAR SOFT STOP	NEOPRENE
1	1	T1AKM024	DORSI-PLANTAR SOFT STOP BASE	6081-T6

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

ENGINEERED:	DATE:
D. BEACH	2/5/99
DRAWN:	DATE:
D. BEACH	4/22/99
APPROVED:	DATE:
D. DELBRIDGE	10/8/01

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
Tolerances  
Angles: ± .5°  
Fractions: ± 1/64  
Decimals: .xx ± .01  
              .xxx ± .005

\* DO NOT SCALE DRAWING \*  
FINISH:

SCALE	SIZE	REVISION
1=1	A	2

QUANTITY FOR AN ASSEMBLY: 1  
QUANTITY FOR ENTIRE DUMMY: 2

MATERIAL: SEE DWGS.

DEPARTMENT OF TRANSPORTATION  
NHTSA  
CONTRACT NO.: DTMB 28-94-C-07010  
DESIGNED BY: GESAC, INC.  
125 OSWEGO AVE.  
ROSELAND, NJ 07068  
ASTC  
4077 US HWY 200 N.  
MESA, AZ 85609-2000

DRAWING TITLE: ANKLE  
DORSI-PLANTAR SOFT STOP ASSEMBLY  
DRAWING NUMBER: T1AKM002  
Page 1/1

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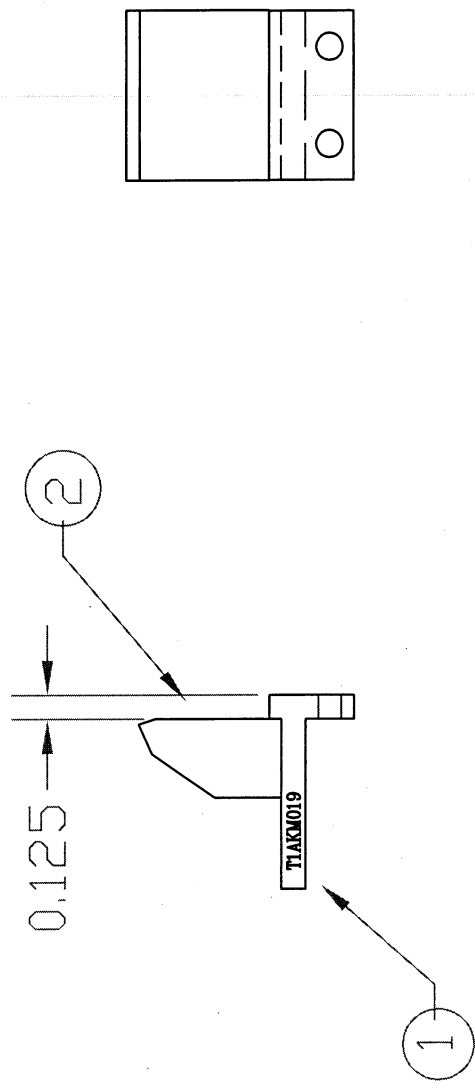
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1

REVISIONS		DATE	BY
1	NOTE 1,2,4 CORRECTIONS, ADDED LOCATION DIMENSIONS FOR ASSEMBLY UPDATED ASSEMBLY WITH NEW PARTS	11/15/99	D. BEACH
2	GLOBAL	7/12/00	D. BEACH

- NOTE:
- ① SANDBLAST T1AKM019 AND CLEAN WITH MEK
  - ② ABRABE T1AKM016 WITH SANDPAPER AND CLEAN WITH MEK AND ALCOHOL
  - ③ BOND THE PARTS UNDER PRESSURE USING LORD 305 EPOXY ADHESIVE
  - ④ PART IS LOCATED ON CENTERLINE AS SHOWN



REV.	QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
2	1	T1AKM016	INVERSION-EYERSON SOFT STOP	NEOPRENE
1	1	T1AKM019	SOFT STOP BRACKET	6081-T6

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

ENGINEERED:	D. BEACH	DATE:	1/6/98
DRAWN:	D. BEACH	DATE:	1/6/98
APPROVED:	D. DELBRIDGE	DATE:	10/8/01
SCALE:	1=1	SIZE:	A
REVISION:	2	QUANTITY FOR AN ASSEMBLY:	2
FINISH:		QUANTITY FOR ENTIRE DUMMY:	4

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
Tolerances  
Angles: ± .5°  
Fractions ± 1/64  
Decimals: .xx ± .01  
.xxx ± .005  
\* DO NOT SCALE DRAWING \*

DEPARTMENT OF TRANSPORTATION  
NHTSA  
CONTRACT NO.: DTMB 22-94-C-07010  
DESIGNED BY: GESAC, INC.  
125 GEORGE AVE  
ROSELAND, NJ 07068  
ASTC  
8007 US HWY 200 N.  
MESA, AZ 85205-2002  
DRAWING TITLE: THOR-IX  
INVERSION-EYERSON SOFT STOP ASSEMBLY  
DRAWING NUMBER: T1AKM003  
Page 1/1

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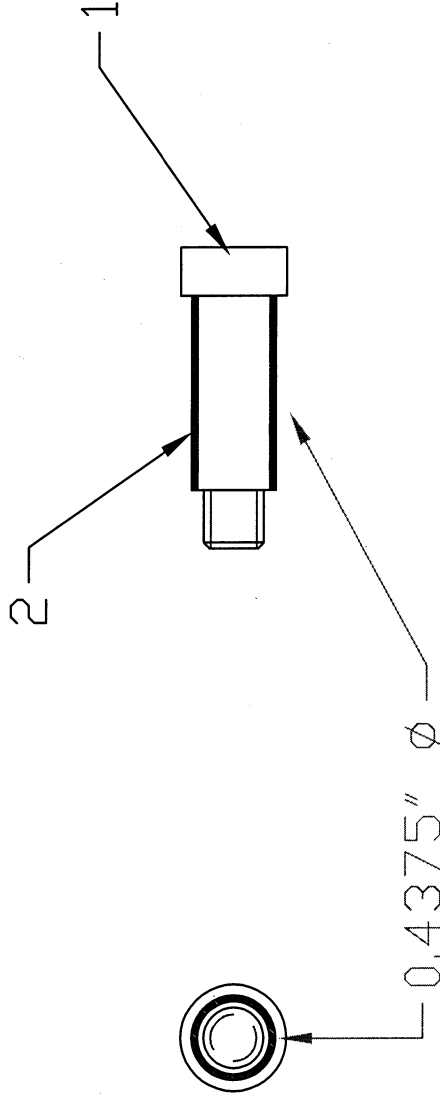
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REVISIONS			
REV. #	ZONE	DESCRIPTION	DATE
1	GLOBAL	ADDED NOTE 2 AND OD DIMENSION	7/16/01
2	GLOBAL	REMOVED NOTE 2	9/17/04

NOTE



PRESS ANKLE BOLT SLEEVE ONTO SHOULDER OF ANKLE RETAINING BOLT.



2	1	TIAXM028	ANKLE BOLT SLEEVE	DELFIN
1	1	TIAXM029	ANKLE RETAINING BOLT	SEE DWG
QTY		DWG/PART NUMBER	DESCRIPTION	MATERIAL
ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY				
UNLESS OTHERWISE SPECIFIED		ENGINEERED:	DATE:	DEPARTMENT OF TRANSPORTATION
DIMENSIONS ARE IN INCHES		D. BEACH	5/9/01	NHTSA
Tolerances		DRAWN:	DATE:	CONTRACT NO.: DPMR 22-94-C-07010
Angles: ± .5°		D. BEACH	5/9/01	DESIGNED BY: GESAC, INC.
Fractions: ± 1/64		APPROVED:	DATE:	ASTC
Decimals: .xx ± .01		D. DELBRIDGE	10/6/01	1450 W. 10th St. N.
.xxx ± .005		SCALE	SIZE	REVISION
* DO NOT SCALE DRAWING *		1=1	A	2
FINISH:		QUANTITY FOR AN ASSEMBLY		
MATERIAL:		1		
SEE ITEM 1		QUANTITY FOR ENTIRE DUMMY		
		2		
		DRAWING NUMBER: TIAXM004		
		Page 1/1		

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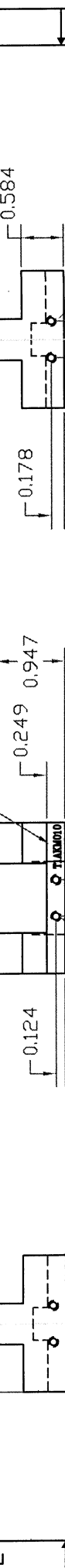
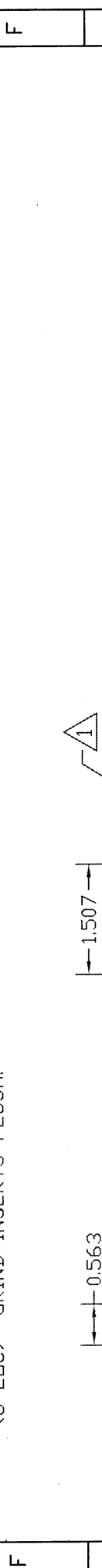
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10 9 8 7 6 5 4 3 2 1

REV. #	ZONE	DESCRIPTION	DATE	BY
1	GLOBAL	ADDED ROTATION STOPS	11/17/97	D. BEACH
2	GLOBAL	WIRE GROOVE - CHANGED MOUNTING HOLES	3/24/98	D. BEACH
3	D-6	ADDED HOLES FOR SOFT STOP MOUNT	3/25/98	D. BEACH
4	GLOBAL	CHANGED THICKNESS FOR GESAC/ASTC REVISION	9/21/98	S. RICE
6	GLOBAL	ELIMINATED SLOT FOR HEEL LC WIRE	2/26/99	D. BEACH
7	ITEM 1	ADDED HARDWARE REFERENCE	4/23/99	D. BEACH
8	NOTE 1	ADDED PART NUMBER ENGRAVING NOTE	6/5/99	D. BEACH
9	GLOBAL	SPECIFIED BLACK ANODIZE FINISH	6/8/00	D. BEACH
10	GLOBAL	CORRECTED DIMENSION, CHANGED C'BORE TO 1.00"	9/18/00	D. BEACH
11	GLOBAL	ADDED ITEM #2 - SCREW LOCK HELICOIL INSERT	12/9/00	D. BEACH
12	B-6	CHANGED HORIZONTAL DIMENSION OF OUTER HOLES	9/19/01	D. BEACH
13	NOTE 1	REVISED PART MARKING REQUIREMENTS	9/19/01	C. SPADIE
14	NOTE 4	ADDED NOTE 4	10/9/01	C. SPADIE

BORE 1.00" DIAM x 0.45" DEPTH

DRILL AND TAP THRU FOR 1/4-20 x 0.25" HELI-COIL INSERTS (8 LOC) GRIND INSERTS FLUSH.



4X DRILL AND TAP FOR #6-32 x .138" SCREW LOCK HELICOIL INSERT



NOTE:

1 MARK PART NUMBER TIAKM010 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP.

2 PART MUST BE ANNOIDIZED PRIOR TO INSERTION OF HELICOILS.

3 #6-32 HELICOIL INSERT MUST BE SCREW LOCK TYPE.

4 HELICOILS ARE TRIMMED APPROXIMATELY HALF A THREAD PRIOR TO INSERTION, TO MEET PROPER LENGTH.

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
2	4	MSC# 00082703 #6-32 x 0.138" SCREW LOCK HELICOIL INSERT	PURCHASED
1	8	MSC# 00080632 1/4-20 x 0.25" HELICOIL INSERT	PURCHASED

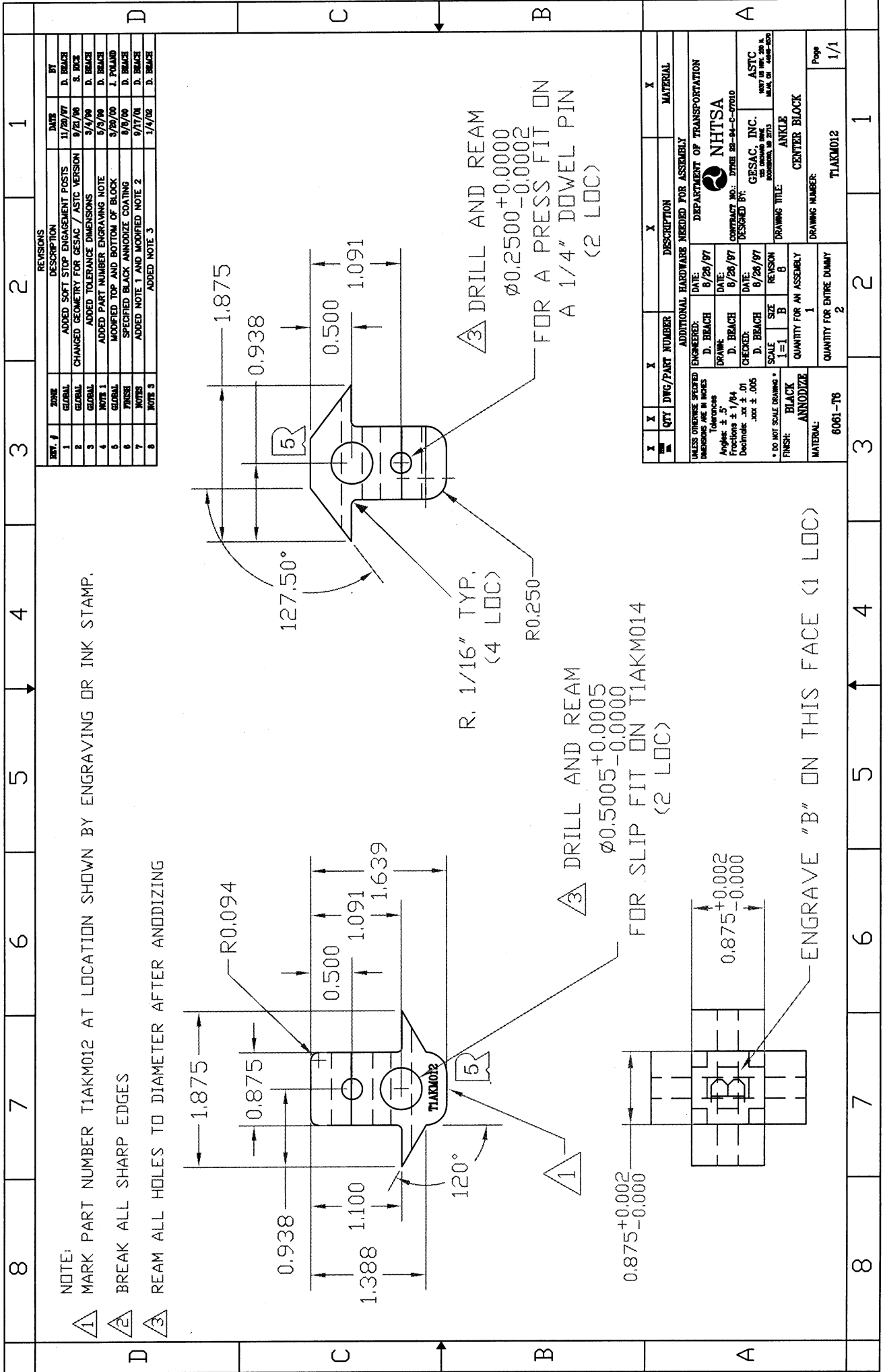
ENGINEERED:	DATE:	DEPARTMENT OF TRANSPORTATION
D. BEACH	11/17/97	NHTSA
DRAWN:	DATE:	CONTRACT NO.:
D. BEACH	11/17/97	DNHB 28-94-C-07010
APPROVED:	DATE:	DESIGNED BY:
D. DELBRIDGE	10/8/01	GESAC, INC.
SCALE	SIZE	125 BRADWAY AVE.
1=1	C	BOZEMAN, MT 59715
REVISION	13	DRAWING TITLE:
1		ANKLE

QUANTITY FOR AN ASSEMBLY	DRAWING NUMBER:	Page
1	6061-76	1/1
2	TIAKM010	

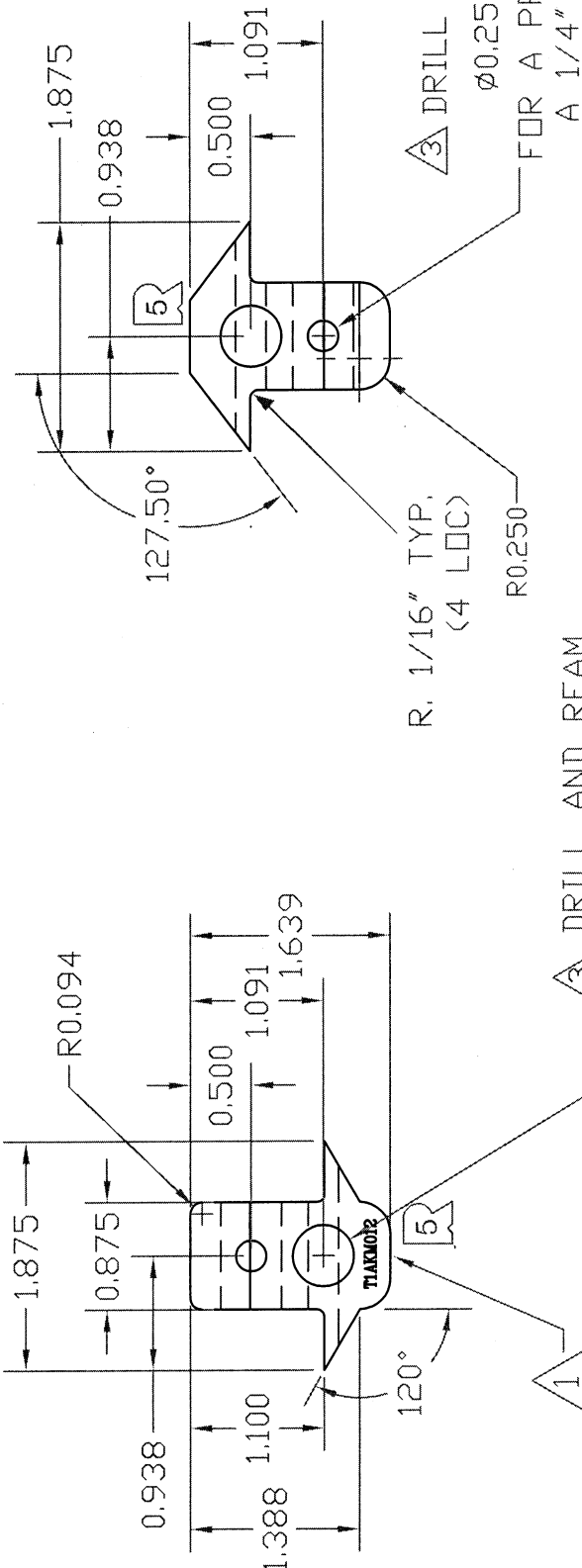
REVISION	DESCRIPTION	DATE	BY
1	ADDED ROTATION STOPS	11/17/97	D. BEACH
2	WIRE GROOVE - CHANGED MOUNTING HOLES	3/24/98	D. BEACH
3	ADDED HOLES FOR SOFT STOP MOUNT	3/25/98	D. BEACH
4	CHANGED THICKNESS FOR GESAC/ASTC REVISION	9/21/98	S. RICE
6	ELIMINATED SLOT FOR HEEL LC WIRE	2/26/99	D. BEACH
7	ADDED HARDWARE REFERENCE	4/23/99	D. BEACH
8	ADDED PART NUMBER ENGRAVING NOTE	6/5/99	D. BEACH
9	SPECIFIED BLACK ANODIZE FINISH	6/8/00	D. BEACH
10	CORRECTED DIMENSION, CHANGED C'BORE TO 1.00"	9/18/00	D. BEACH
11	ADDED ITEM #2 - SCREW LOCK HELICOIL INSERT	12/9/00	D. BEACH
12	CHANGED HORIZONTAL DIMENSION OF OUTER HOLES	9/19/01	D. BEACH
13	REVISED PART MARKING REQUIREMENTS	9/19/01	C. SPADIE
14	ADDED NOTE 4	10/9/01	C. SPADIE



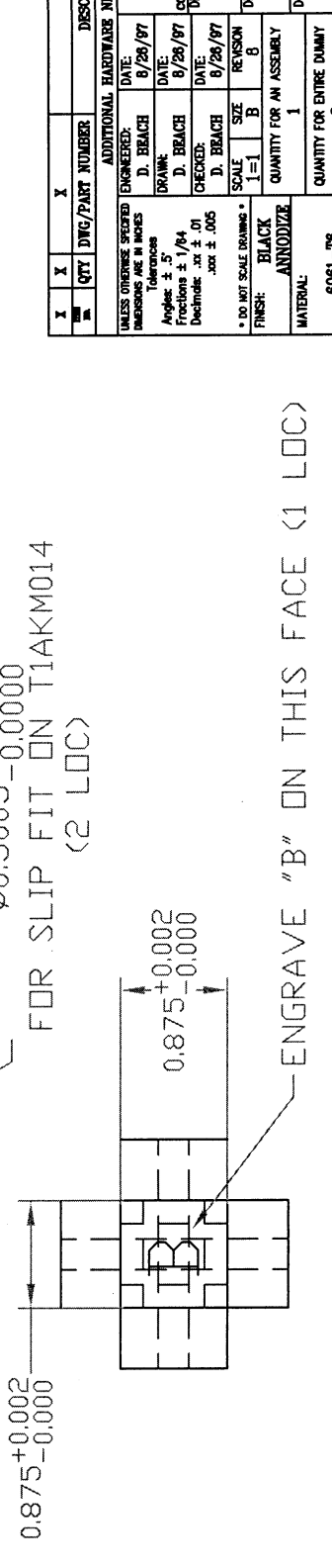




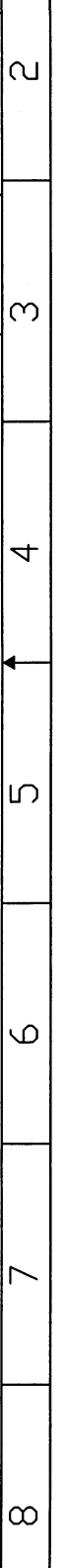
NOTE:  
 1 MARK PART NUMBER T1AKM012 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP.  
 2 BREAK ALL SHARP EDGES  
 3 REAM ALL HOLES TO DIAMETER AFTER ANNOIDIZING

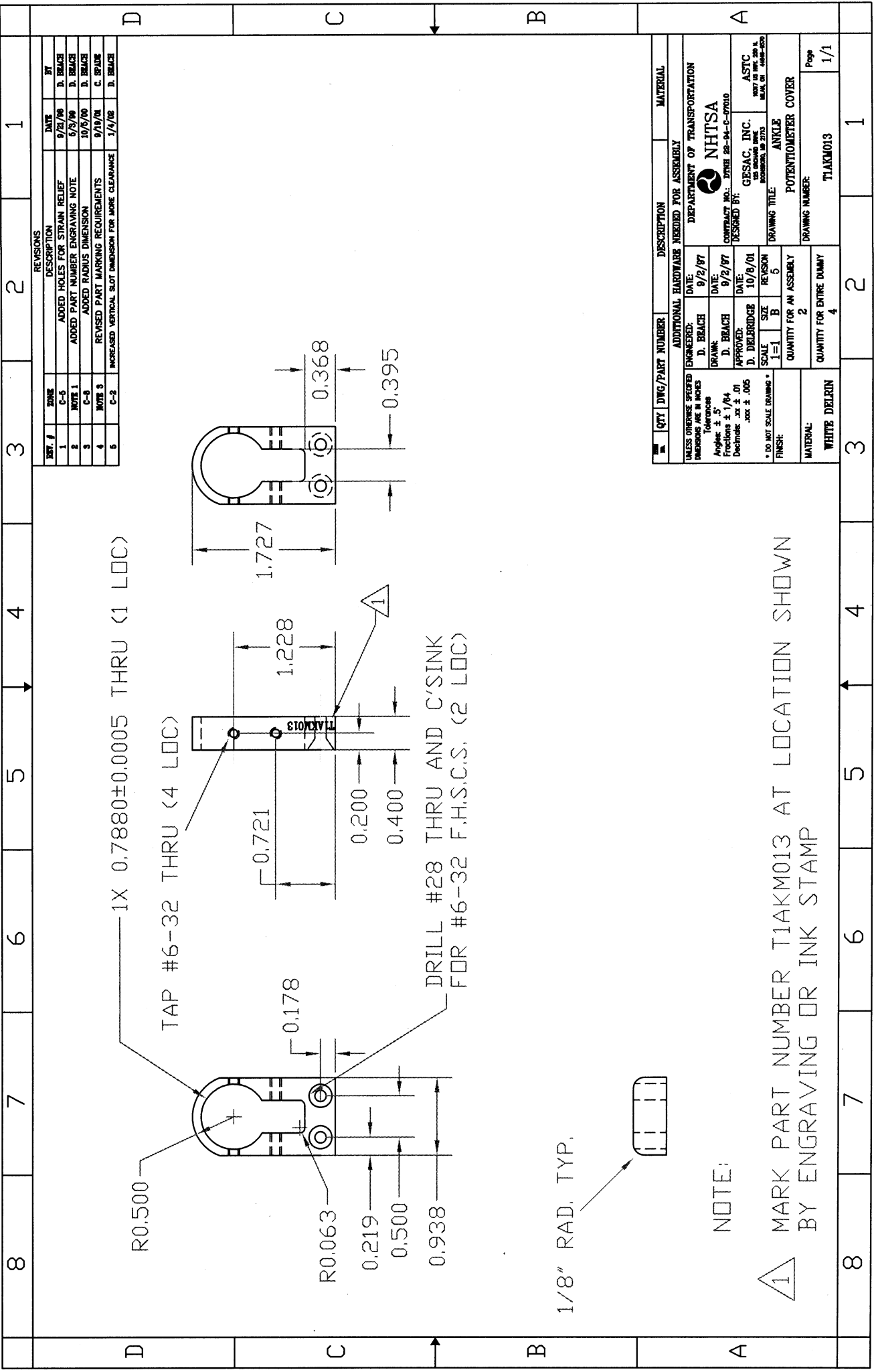


NOTE:  
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 3 REAM ALL HOLES TO DIAMETER AFTER ANNOIDIZING



NOTE:  
 1 MARK PART NUMBER T1AKM012 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP.  
 2 BREAK ALL SHARP EDGES  
 3 REAM ALL HOLES TO DIAMETER AFTER ANNOIDIZING





REV. #	ZONE	DESCRIPTION	DATE	BY
1	C-5	ADDED HOLES FOR STRAIN RELIEF	9/21/00	D. BEACH
2	NOTE 1	ADDED PART NUMBER ENGRAVING NOTE	5/5/00	D. BEACH
3	C-3	ADDED RADIUS DIMENSION	10/6/00	D. BEACH
4	NOTE 3	REVISED PART MARKING REQUIREMENTS	9/19/00	C. SPAUS
5	C-2	INCREASED VERTICAL SLOT DIMENSION FOR MORE CLEARANCE	1/4/02	D. BEACH

QTY	DRG/PART NUMBER	DESCRIPTION	MATERIAL
1	T1AKM013	POTENTIOMETER COVER	WHITE DELRIN

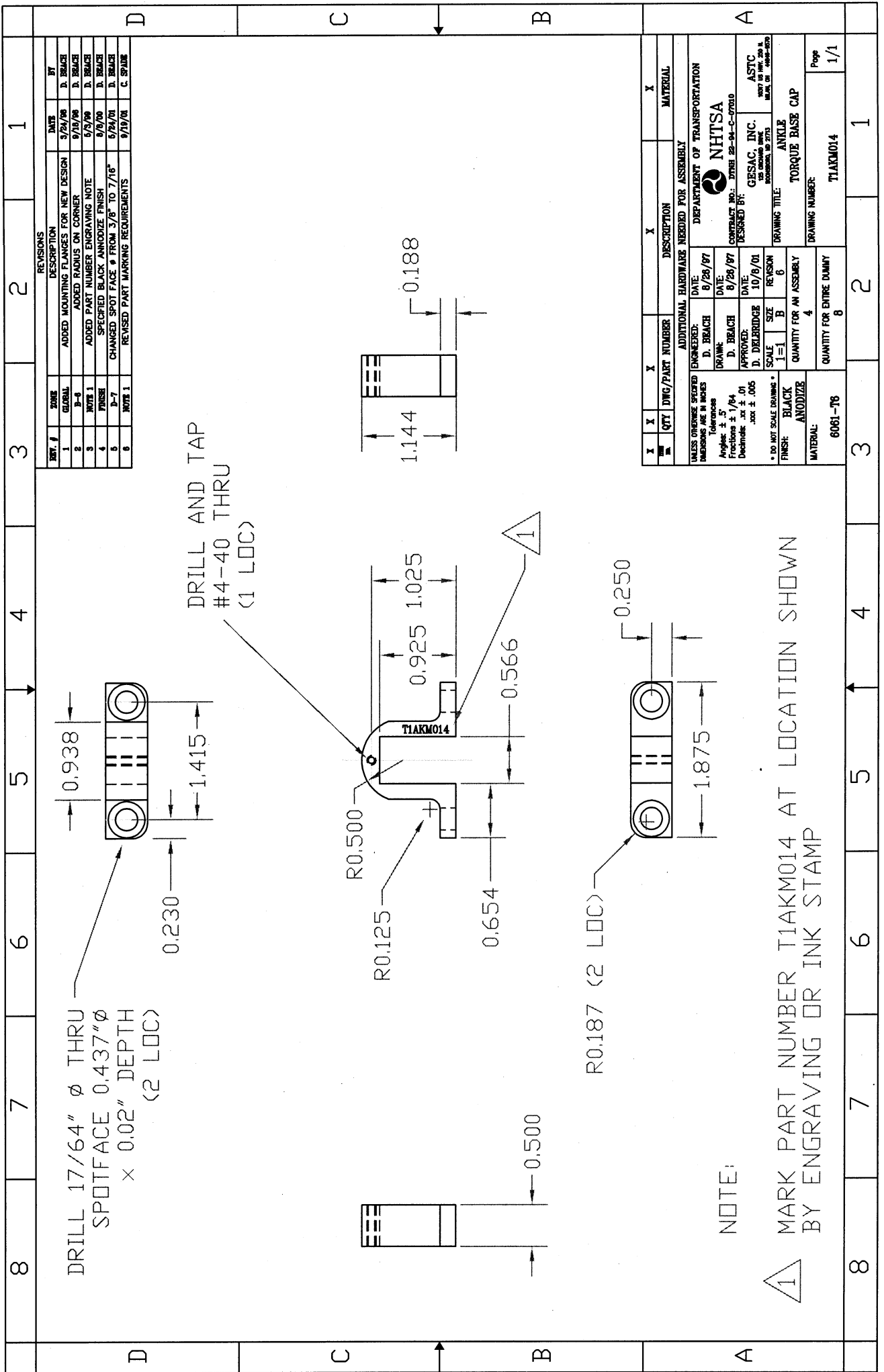
  

UNLESS OTHERWISE SPECIFIED		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY		MATERIAL	
Dimensions	Tolerances	ENGINEERED:	DATE:	DEPARTMENT OF TRANSPORTATION	
Angles	± .5°	D. BEACH	9/2/07	NHTSA	
Fractions	± 1/64	DRAWN:	DATE:	CONTRACT NO.: DTRE 88-84-C-07010	
Decimals	.xx ± .01	D. BEACH	9/2/07	DESIGNED BY:	
	.xxx ± .005	APPROVED:	DATE:	GESAC, INC.	
		D. DELBRIDGE	10/8/01	1000 W. WILSON BLVD.	
				BOZEMAN, MT 59715	
* DO NOT SCALE DRAWING *		SCALE:	SIZE:	DRAWING TITLE: ANKLE	
FINISH:		1=1	B	POTENTIOMETER COVER	
		2	5	DRAWING NUMBER: T1AKM013	
		QUANTITY FOR AN ASSEMBLY		Page	
		2		1/1	
		QUANTITY FOR ENTIRE DUMMY		1/1	
		4			

NOTE:

1 MARK PART NUMBER T1AKM013 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP

1/8" RAD. TYP.



REV. #	ZONE	DESCRIPTION	DATE	BY
1	GLOBAL	ADDED MOUNTING FLANGES FOR NEW DESIGN	5/24/98	D. BRACH
2	B-4	ADDED RADIUS ON CORNER	9/16/98	D. BRACH
3	NOTE 1	ADDED PART NUMBER ENGRAVING NOTE	9/16/98	D. BRACH
4	FINISH	SPECIFIED BLACK ANODIZE FINISH	8/8/00	D. BRACH
5	D-7	CHANGED SPOT FACE FROM 3/8" TO 7/16"	5/14/01	D. BRACH
6	NOTE 1	REVISED PART MARKING REQUIREMENTS	9/19/04	C. SPURK

REV. #	QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
1	1	6061-76	TORQUE BASE CAP	TIAKM014

DATE	ENGINEER	DATE	DESCRIPTION
8/28/97	D. BRACH	8/28/97	ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY
8/28/97	D. BRACH	8/28/97	ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY
10/6/00	D. DELERIDGE	10/6/00	ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

SCALE	SIZE	REVISION	QUANTITY FOR AN ASSEMBLY	QUANTITY FOR ENTIRE DUMMY
1=1	B	6	4	8

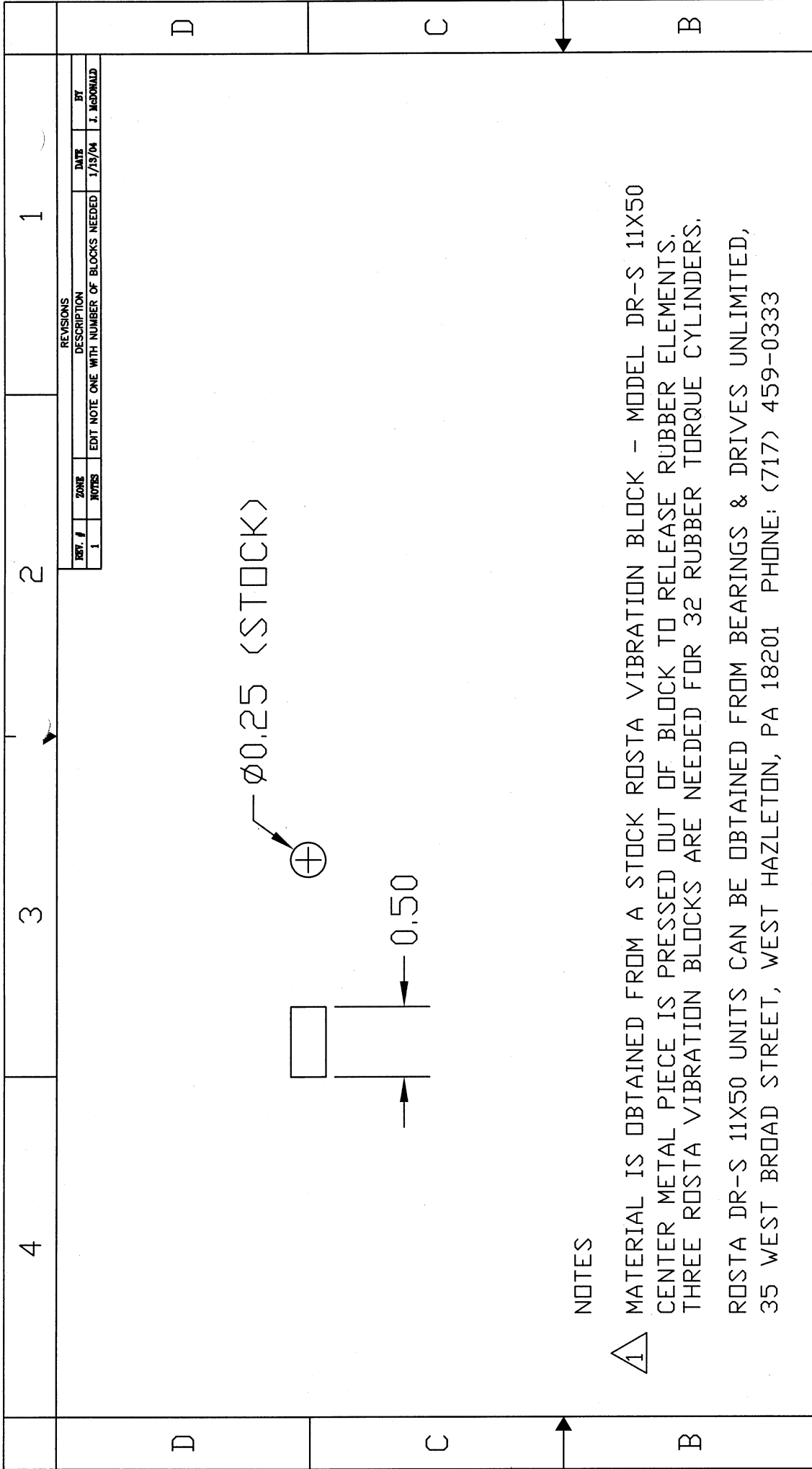
FINISH	ANODIZE	DRAWING TITLE	DRAWING NUMBER	Page
BLACK	ANODIZE	TORQUE BASE CAP	TIAKM014	1/1

NOTE:

MARK PART NUMBER TIAKM014 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP



8	7	6	5	4	3	2	1																																																																																																																																																																																																																																																																																																																																																								
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ASTC			DATE: 11/20/97	REV. 10, 11, 20 & 21			DATE: 11/20/97	REV. 22			DATE: 10/8/01	REV. 23			DATE: 10/8/01	REV. 24			DATE: 10/8/01	REV. 25			DATE: 10/8/01	REV. 26			DATE: 10/8/01	REV. 27			DATE: 10/8/01	REV. 28			DATE: 10/8/01	REV. 29			DATE: 10/8/01	REV. 30			DATE: 10/8/01	REV. 31			DATE: 10/8/01	REV. 32			DATE: 10/8/01	REV. 33			DATE: 10/8/01	REV. 34			DATE: 10/8/01	REV. 35			DATE: 10/8/01	REV. 36			DATE: 10/8/01	REV. 37			DATE: 10/8/01	REV. 38			DATE: 10/8/01	REV. 39			DATE: 10/8/01	REV. 40			DATE: 10/8/01	REV. 41			DATE: 10/8/01	REV. 42			DATE: 10/8/01	REV. 43			DATE: 10/8/01	REV. 44			DATE: 10/8/01	REV. 45			DATE: 10/8/01	REV. 46			DATE: 10/8/01	REV. 47			DATE: 10/8/01	REV. 48			DATE: 10/8/01	REV. 49			DATE: 10/8/01	REV. 50			DATE: 10/8/01	REV. 51			DATE: 10/8/01	REV. 52			DATE: 10/8/01	REV. 53			DATE: 10/8/01	REV. 54			DATE: 10/8/01	REV. 55			DATE: 10/8/01	REV. 56			DATE: 10/8/01	REV. 57			DATE: 10/8/01	REV. 58			DATE: 10/8/01	REV. 59			DATE: 10/8/01	REV. 60			DATE: 10/8/01	REV. 61			DATE: 10/8/01	REV. 62			DATE: 10/8/01	REV. 63			DATE: 10/8/01	REV. 64			DATE: 10/8/01	REV. 65			DATE: 10/8/01	REV. 66			DATE: 10/8/01	REV. 67			DATE: 10/8/01	REV. 68			DATE: 10/8/01	REV. 69			DATE: 10/8/01	REV. 70			DATE: 10/8/01	REV. 71			DATE: 10/8/01	REV. 72			DATE: 10/8/01	REV. 73			DATE: 10/8/01	REV. 74			DATE: 10/8/01	REV. 75			DATE: 10/8/01	REV. 76			DATE: 10/8/01	REV. 77			DATE: 10/8/01	REV. 78			DATE: 10/8/01	REV. 79			DATE: 10/8/01	REV. 80			DATE: 10/8/01	REV. 81			DATE: 10/8/01	REV. 82			DATE: 10/8/01	REV. 83			DATE: 10/8/01	REV. 84			DATE: 10/8/01	REV. 85			DATE: 10/8/01	REV. 86			DATE: 10/8/01	REV. 87			DATE: 10/8/01	REV. 88			DATE: 10/8/01	REV. 89			DATE: 10/8/01	REV. 90			DATE: 10/8/01	REV. 91			DATE: 10/8/01	REV. 92			DATE: 10/8/01	REV. 93			DATE: 10/8/01	REV. 94			DATE: 10/8/01	REV. 95			DATE: 10/8/01	REV. 96			DATE: 10/8/01	REV. 97			DATE: 10/8/01	REV. 98			DATE: 10/8/01	REV. 99			DATE: 10/8/01	REV. 100
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<p>MATERIAL: NEOPRENE 78A</p> <p>QUANTITY FOR ENTIRE DUMMY: 2</p> <p>QUANTITY FOR AN ASSEMBLY: 4</p> <p>INVERSION - EVERSON SOFT STOP</p> <p>DRAWING NUMBER: T1AKM016</p> <p>Page: 1/1</p>																																																																																																																																																																																																																																																																																																																																																															
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NOTES

1 MATERIAL IS OBTAINED FROM A STOCK ROSTA VIBRATION BLOCK - MODEL DR-S 11X50 CENTER METAL PIECE IS PRESSED OUT OF BLOCK TO RELEASE RUBBER ELEMENTS. THREE ROSTA VIBRATION BLOCKS ARE NEEDED FOR 32 RUBBER TORQUE CYLINDERS. ROSTA DR-S 11X50 UNITS CAN BE OBTAINED FROM BEARINGS & DRIVES UNLIMITED, 35 WEST BROAD STREET, WEST HAZLETON, PA 18201 PHONE: (717) 459-0333

REV. #		ZONE	NOTES	DESCRIPTION	DATE	BY
1	1			EDIT NOTE ONE WITH NUMBER OF BLOCKS NEEDED	1/13/04	J. MCDONALD

REV. #	QTY	DWG/PART NUMBER	ROSTA DR-S 11X50	DESCRIPTION	PURCHASED MATERIAL
1	1				

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		Tolerances		DATE	
Angles	± .5°	Fractions	± 1/64	ENGINEERED:	12/9/87
Decimals	.xx ± .01	APPROVED:		DRAWN:	12/9/87
	.xxx ± .005	D. DELBRIDGE	10/8/01	D. BEACH	12/9/87

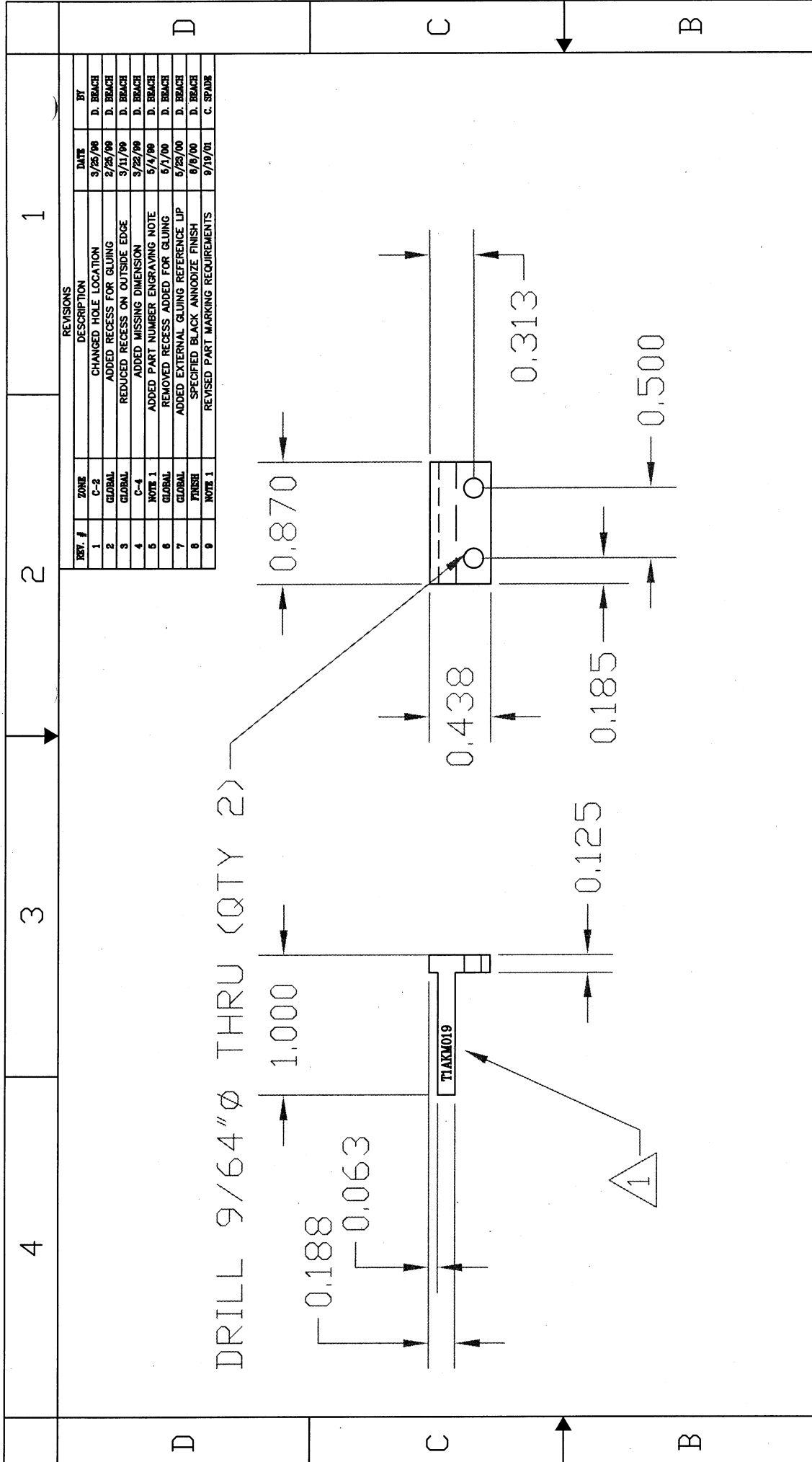
FINISH:		SCALE		QUANTITY FOR AN ASSEMBLY	
* DO NOT SCALE DRAWING		1=1	A	16	
		QUANTITY FOR ENTIRE DUMMY		32	

MATERIAL:		DRAWING TITLE:		DRAWING NUMBER:	
SEE NOTE 1		ANKLE		TIAKM018	
		RUBBER TORQUE CYLINDERS		Page 1/1	

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY		DEPARTMENT OF TRANSPORTATION	
		NHTSA	
		CONTRACT NO.: DTRH 22-94-C-07010	
		DESIGNED BY: GESAC, INC. ASTC	
		125 BROADWAY NEW YORK, NY 10038-5070	



QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
1	6061-T6	SOFT STOP BRACKET	TIAKM019
2	6061-T6	QUANTITY FOR AN ASSEMBLY	TIAKM019
3	6061-T6	QUANTITY FOR ENTIRE DUMMY	TIAKM019
4	6061-T6	QUANTITY FOR ENTIRE DUMMY	TIAKM019

NOTE:

MARK PART NUMBER T1AKM019 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP

1

ENGINEERED:	DATE:	DEPARTMENT OF TRANSPORTATION
D. BRANCH	1/6/98	NHTSA
DRAWN:	1/6/98	CONTRACT NO.: DTMB 22-94-C-07010
D. BRANCH	1/6/98	DESIGNED BY: GESAC, INC.
D. DELBRIDGE	10/8/01	125 ORANGE AVE.
SCALE:	1=1	ROCKFORD, IL 60170
SIZE:	A	DRAWING TITLE: ANKLE
REVISION:	9	ASTC
QUANTITY FOR AN ASSEMBLY:	2	SOFT STOP BRACKET
QUANTITY FOR ENTIRE DUMMY:	4	DRAWING NUMBER:
		TIAKM019
		Page
		1/1

8	7	6	5	4	3	2	1																								
<table border="1"> <tr> <td>REV. #</td> <td>ZONE</td> <td>DATE</td> <td>BY</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>								REV. #	ZONE	DATE	BY																				
REV. #	ZONE	DATE	BY																												
<p>STOCK ID FOR PACIFIC BEARING</p> <p><math>\phi 0.876^{+0.001}_{-0.000}</math></p>																															
<p>0.85</p>																															
<p>TRIM TO LENGTH OF 0.85" (QTY. 1)</p>																															
<p>NOTES:</p> <p>1 MODIFY PART TO LENGTH AND OD AS INDICATED. BEGIN WITH A STOCK PS1216-8 BEARING</p> <p>2 INVENTORY CONTROL REFERENCE: PART IS IDENTICAL TO T2AKM020</p>																															
<table border="1"> <tr> <td>1</td> <td>1</td> <td>PB# PS1216-8</td> <td>QTY</td> <td>DWG/PART NUMBER</td> <td>DESCRIPTION</td> <td>PURCHASED</td> <td>MATERIAL</td> </tr> <tr> <td colspan="8">           ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY            DEPARTMENT OF TRANSPORTATION            NHTSA            CONTRACT NO.: DTMB 22-99-C-07007            DESIGNED BY: GESAC INC.            125 CHERRY AVE            BOZEMAN, MT 59715         </td> </tr> <tr> <td colspan="8">           UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES            Tolerances            Angles: ± .5            Flatness: ± .004            D. BEACHI DATE: 6/9/00            APPROVED: DATE: 6/9/00            D. DELEBRIDGE 10/9/01            SCALE: 1=1 SIZE: B REVISION: N/C            * DO NOT SCALE DRAWING *            FINISH: N/A            QUANTITY FOR AN ASSEMBLY: 1            QUANTITY FOR ENTIRE DUMMY: 2            DRAWING TITLE: THOR-IX            Z ROTATION BEARING            DRAWING NUMBER: T1AKM020            Page: 1/1         </td> </tr> </table>								1	1	PB# PS1216-8	QTY	DWG/PART NUMBER	DESCRIPTION	PURCHASED	MATERIAL	ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY DEPARTMENT OF TRANSPORTATION NHTSA CONTRACT NO.: DTMB 22-99-C-07007 DESIGNED BY: GESAC INC. 125 CHERRY AVE BOZEMAN, MT 59715								UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Angles: ± .5 Flatness: ± .004 D. BEACHI DATE: 6/9/00 APPROVED: DATE: 6/9/00 D. DELEBRIDGE 10/9/01 SCALE: 1=1 SIZE: B REVISION: N/C * DO NOT SCALE DRAWING * FINISH: N/A QUANTITY FOR AN ASSEMBLY: 1 QUANTITY FOR ENTIRE DUMMY: 2 DRAWING TITLE: THOR-IX Z ROTATION BEARING DRAWING NUMBER: T1AKM020 Page: 1/1							
1	1	PB# PS1216-8	QTY	DWG/PART NUMBER	DESCRIPTION	PURCHASED	MATERIAL																								
ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY DEPARTMENT OF TRANSPORTATION NHTSA CONTRACT NO.: DTMB 22-99-C-07007 DESIGNED BY: GESAC INC. 125 CHERRY AVE BOZEMAN, MT 59715																															
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Angles: ± .5 Flatness: ± .004 D. BEACHI DATE: 6/9/00 APPROVED: DATE: 6/9/00 D. DELEBRIDGE 10/9/01 SCALE: 1=1 SIZE: B REVISION: N/C * DO NOT SCALE DRAWING * FINISH: N/A QUANTITY FOR AN ASSEMBLY: 1 QUANTITY FOR ENTIRE DUMMY: 2 DRAWING TITLE: THOR-IX Z ROTATION BEARING DRAWING NUMBER: T1AKM020 Page: 1/1																															



1

2

3

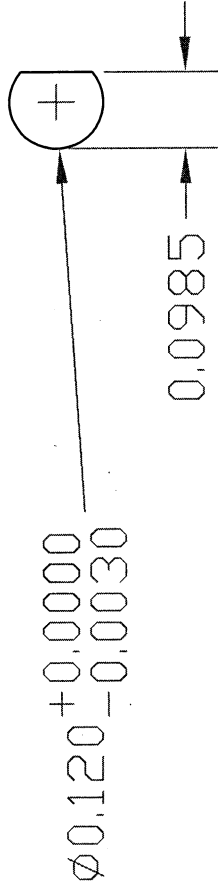
4

REVISIONS		DATE	BY
REV. #	ZONE	DESCRIPTION	
1	B-2	CHANGED TOLERANCE ON D-SHAFT	D. BEACH

D

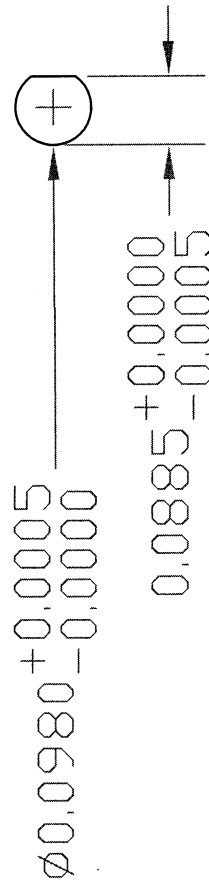
SEE DETAIL A-A

DETAIL A-A (SCALE 4X)



C

DETAIL B-B (SCALE 4X)



B

SEE DETAIL B-B

A

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
1		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
Tolerances		DATE: 12/9/87	DEPARTMENT OF TRANSPORTATION
Angles: ± .5°		ENGINEERED: D. BEACH	NHTSA
Fractions: ± 1/64		DRAWN: D. BEACH	CONTRACT NO.: DTMB 22-94-C-0700
Decimals: .xx ± .01		APPROVED: D. DELBRIDGE	DESIGNED BY: GESAC, INC.
.xxx ± .005		DATE: 10/8/01	ASTC
* DO NOT SCALE DRAWING *		SCALE: 1=1	FOR PARTS N
FINISH:		SIZE: A	MAN. BY: 448-870
QUANTITY FOR AN ASSEMBLY		REVISION: 1	DRAWING TITLE: ANKLE
1			TIBIA ROTARY POTENTIOMETER SHAFT
QUANTITY FOR ENTIRE DUMMY			DRAWING NUMBER:
2			TIAKM021
MATERIAL:			Page
1018 CRS			1/1

D

C

B

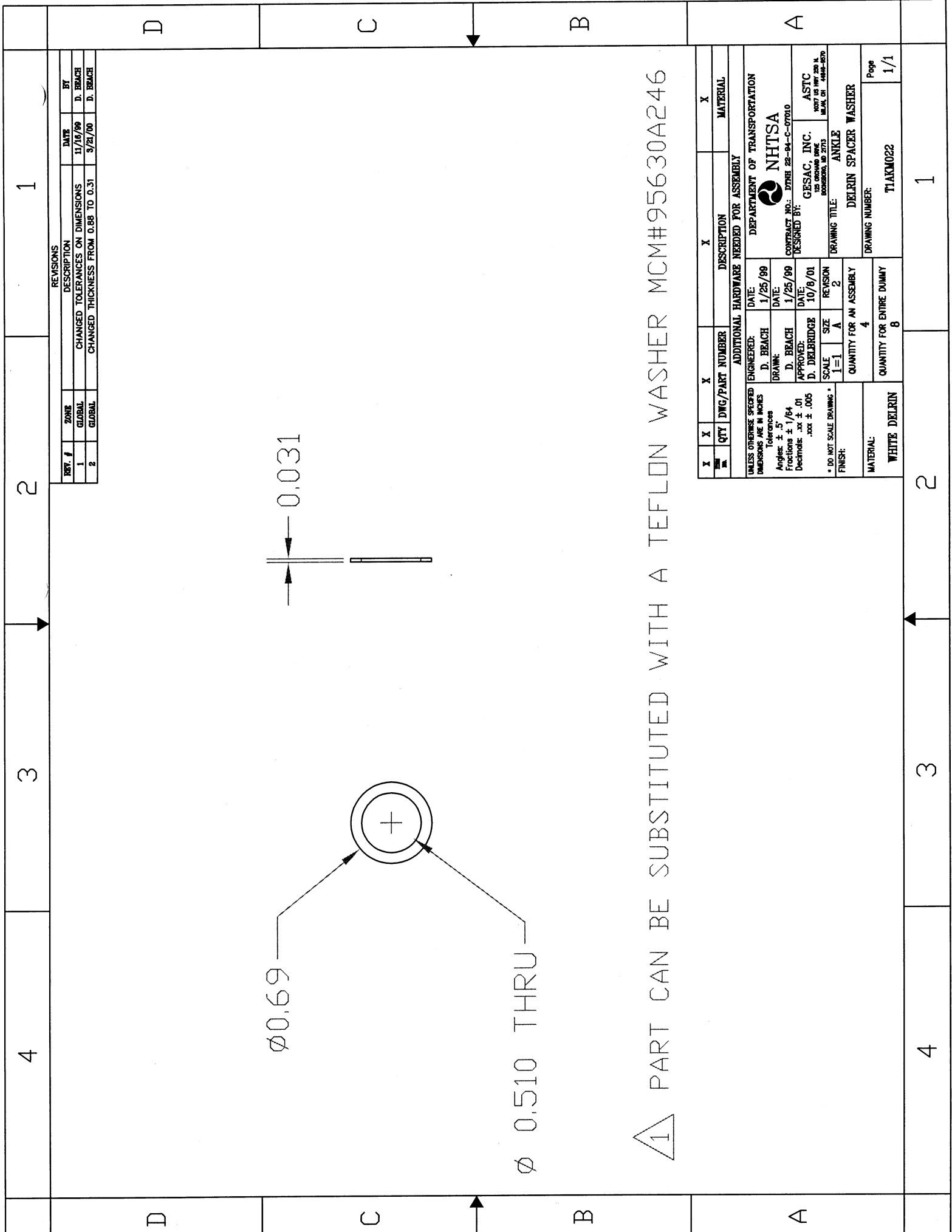
A

2

3

4

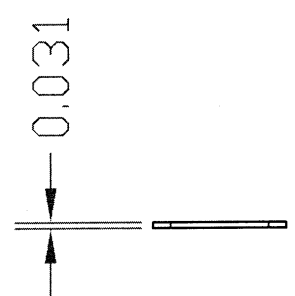
1



4 3 2 1

D C B A

REVISIONS				
REV. #	ZONE	DESCRIPTION	DATE	BY
1	GLOBAL	CHANGED TOLERANCES ON DIMENSIONS	11/15/99	D. BEACH
2	GLOBAL	CHANGED THICKNESS FROM 0.88 TO 0.31	3/21/00	D. BEACH



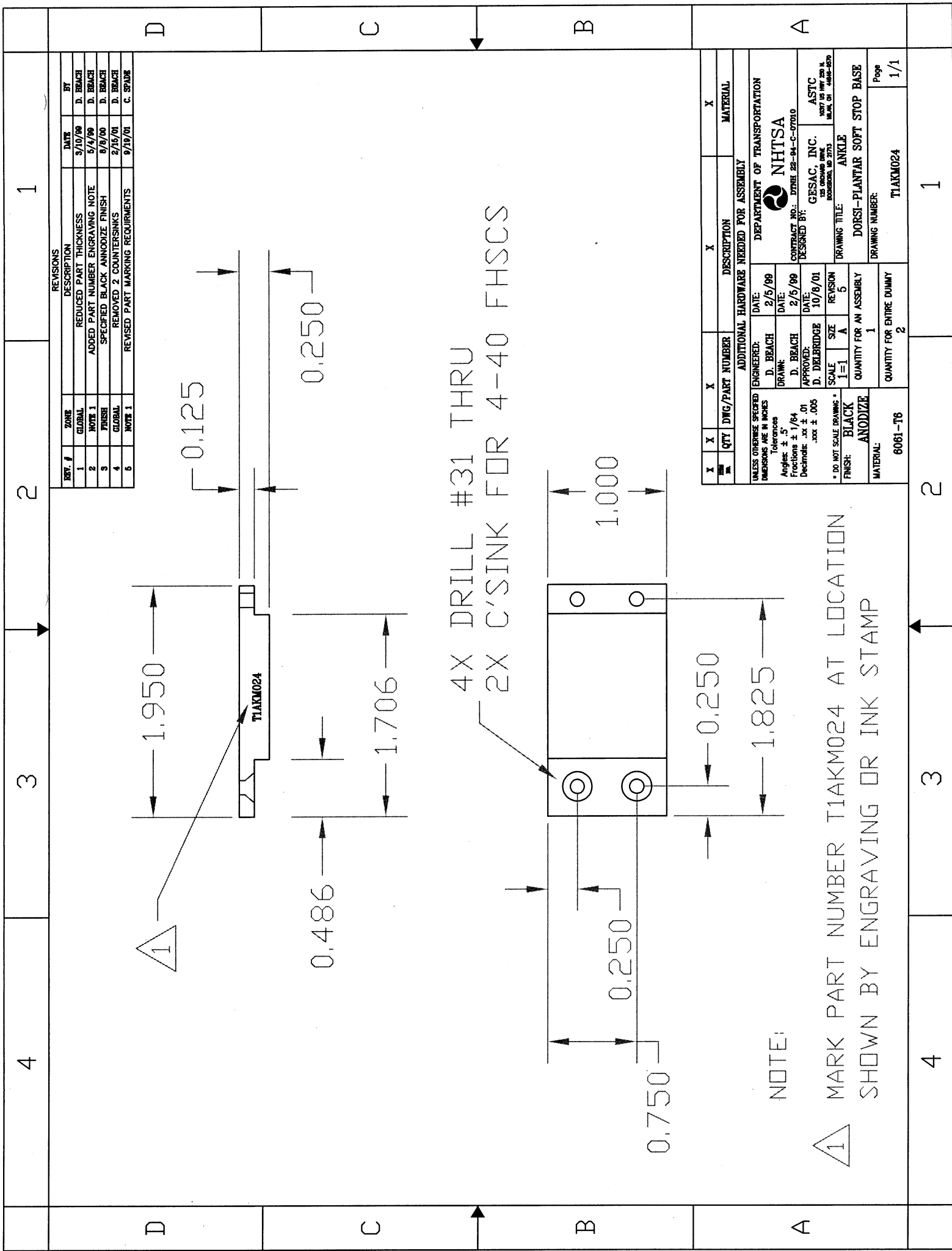
Ø 0.510 THRU

⚠ PART CAN BE SUBSTITUTED WITH A TEFLON WASHER MCM#95630A246

REV. #	QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
1	1		DELBRIN SPACER WASHER	WHITE DELBRIN
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
Tolerances				
Angles: ± .5°				
Fractions: ± 1/64				
Decimals: .xx ± .01				
.xxx ± .005				
* DO NOT SCALE DRAWING *				
FINISH:				
SCALE: 1=1				
SIZE: A				
REVISION: 2				
QUANTITY FOR AN ASSEMBLY: 4				
QUANTITY FOR ENTIRE DUMMY: 8				
DRAWING TITLE: ANKLE				
DRAWING NUMBER: TIAKM022				
Page: 1/1				

D C B A

4 3 2 1



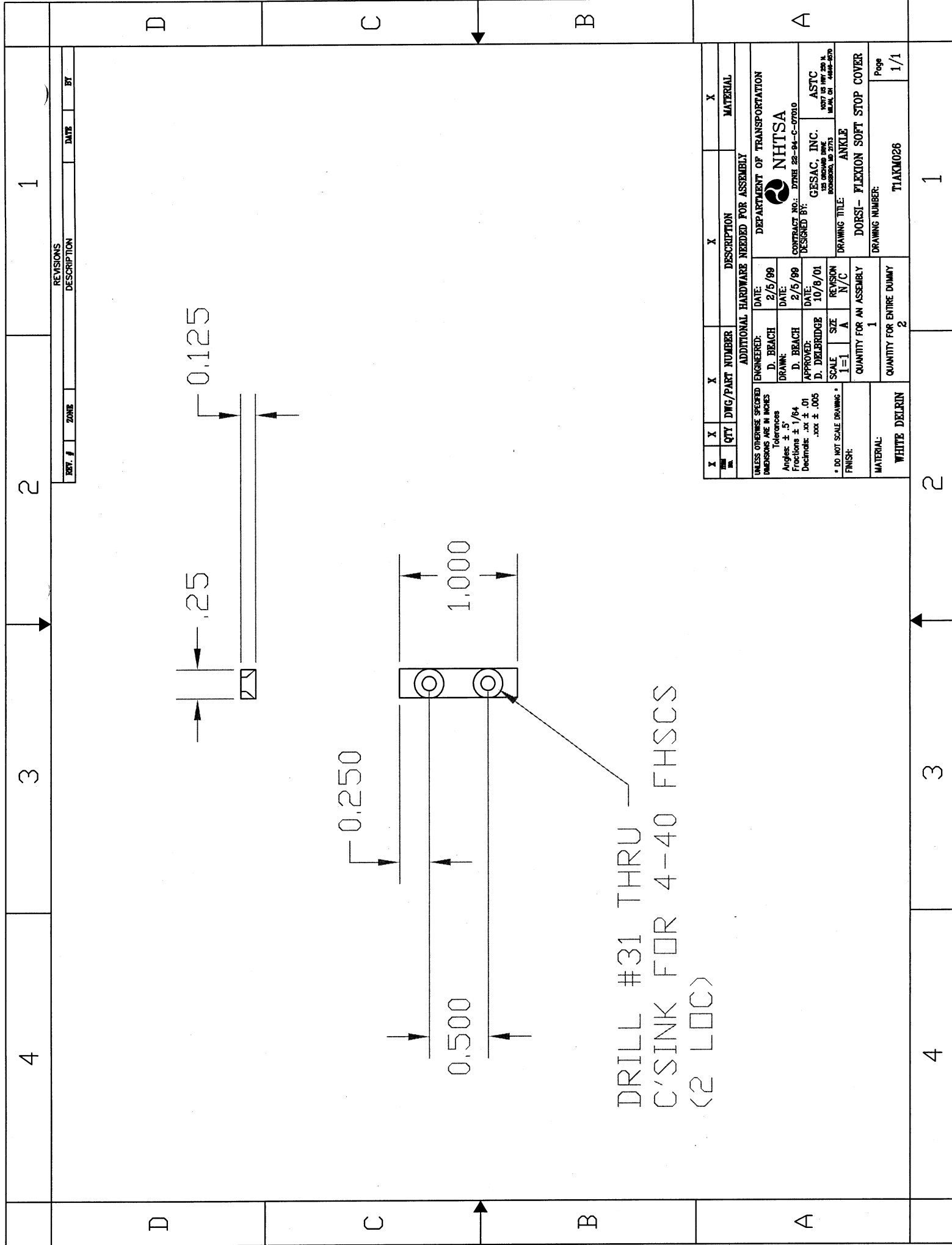
REVISIONS		
REV. #	DATE	BY
1	5/10/99	D. BEACH
2	5/4/99	D. BEACH
3	6/8/00	D. BEACH
4	2/15/01	D. BEACH
5	9/19/01	C. SPAN

REV. #	DATE	DESCRIPTION	MATERIAL
1	5/10/99	REDUCED PART THICKNESS	D. BEACH
2	5/4/99	ADDED PART NUMBER ENGRAVING NOTE	D. BEACH
3	6/8/00	SPECIFIED BLACK ANODIZE FINISH	D. BEACH
4	2/15/01	REMOVED 2 COUNTERSINKS	D. BEACH
5	9/19/01	REVISED PART MARKING REQUIREMENTS	C. SPAN

NOTE:

1 MARK PART NUMBER TIAKM024 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP

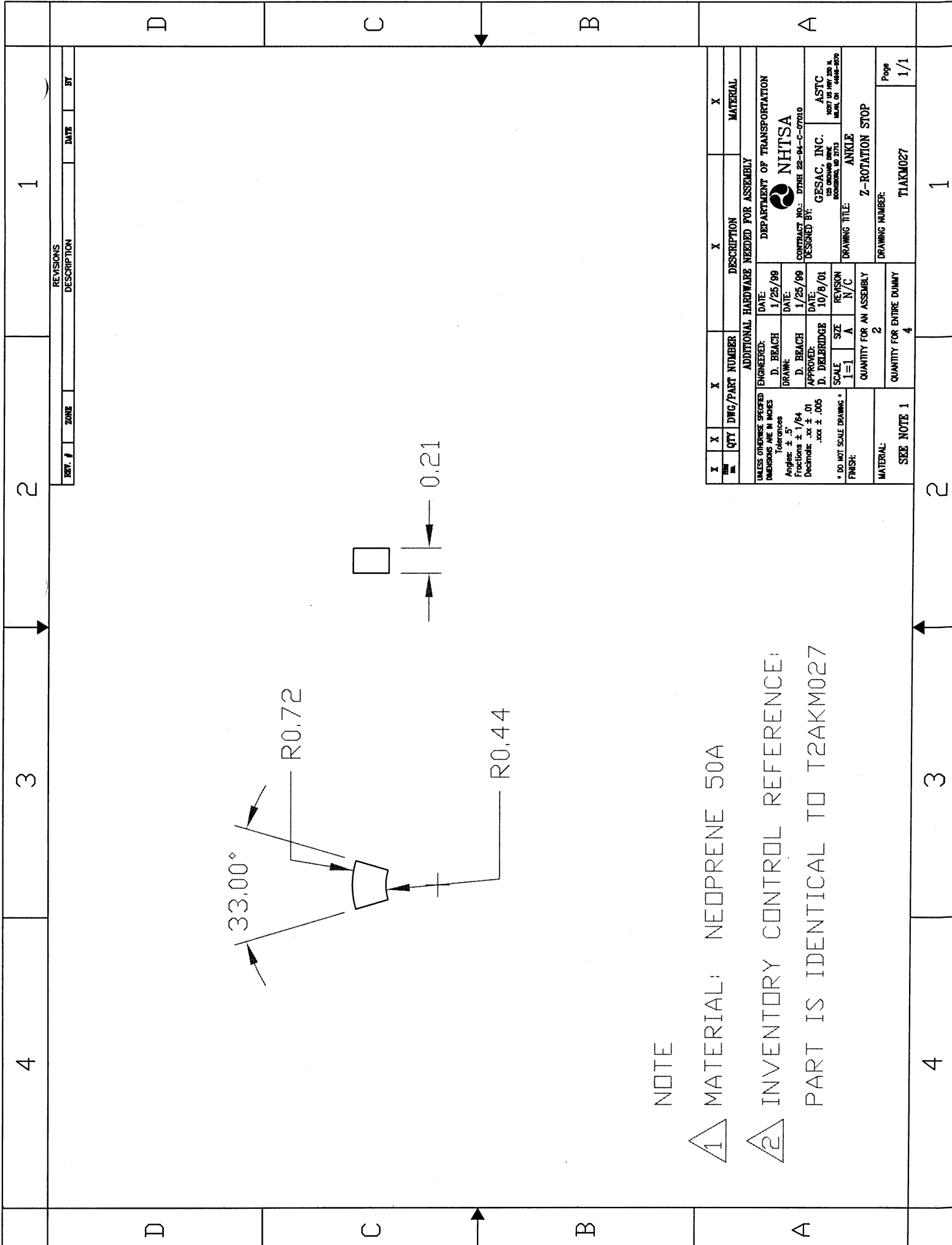
4X DRILL #31 THRU  
2X C'SINK FOR 4-40 FHSCS



REV. #	ZONE	DATE	BY
1			

NO.	QTY	DWG/PART NUMBER	X	X	DESCRIPTION	X	X	MATERIAL
ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY DEPARTMENT OF TRANSPORTATION <b>NHTSA</b> CONTRACT NO.: DTRM 22-04-C-07010 DESIGNED BY: GESAC, INC. ASTC 1037 US HWY 250 N. BOONSBORO, MD 2713 DRAWING TITLE: ANKLE DORSI-FLEXION SOFT STOP COVER DRAWING NUMBER: T1AKM026 Page 1/1								
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Fractions ± 1/64 Decimals .001 ± .005 * DO NOT SCALE DRAWINGS * FINISH: MATERIAL: WHITE DELRIN								
ENGINEERED: D. BEACH DATE: 2/5/09 DRAWN: D. BEACH DATE: 2/5/09 APPROVED: D. DELBRIDGE DATE: 10/8/01 SCALE: 1=1 SIZE: A REVISION: N/C			QUANTITY FOR AN ASSEMBLY: 1 QUANTITY FOR ENTIRE DUMMY: 2					

DRILL #31 THRU  
C'SINK FOR 4-40 FHSCS  
(2 LOC)



NOTE

- 1 MATERIAL: NEOPRENE 50A
- 2 INVENTORY CONTROL REFERENCE:  
PART IS IDENTICAL TO T2AKM027

REV. #	ZONE	DESCRIPTION	DATE	BY
1				

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	

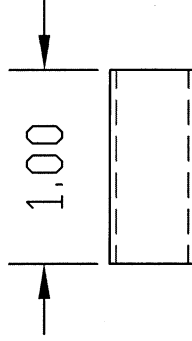
  

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Angles: ± .5° Fractions: 1/64 Decimals: .xx ± .01 .xxx ± .005	ENGINEERED: D. BEACH DATE: 1/25/99	DEPARTMENT OF TRANSPORTATION <b>NHTSA</b> CONTRACT NO.: DTMB 22-94-C-07010
* DO NOT SCALE DRAWING *	DRWN: D. BEACH DATE: 1/25/99	DESIGNED BY: <b>ASTC</b> 1077 W HWY 200 N. MILWAUKEE, WI 53126
FINISH:	APPROVED: D. DELBRIDGE DATE: 10/8/01	DRAWING TITLE: <b>ANKLE</b>
	SCALE: 1=1	DRAWING NUMBER: <b>Z-ROTATION STOP</b>
	SIZE: A	REVISION: N/C
	QUANTITY FOR AN ASSEMBLY: 2	QUANTITY FOR ENTIRE DUMMY: 4
MATERIAL: SEE NOTE 1		Page 1/1

$\varnothing 0.436^{+0.000}_{-0.002}$

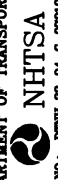


$\varnothing 0.370^{+0.002}_{-0.000}$

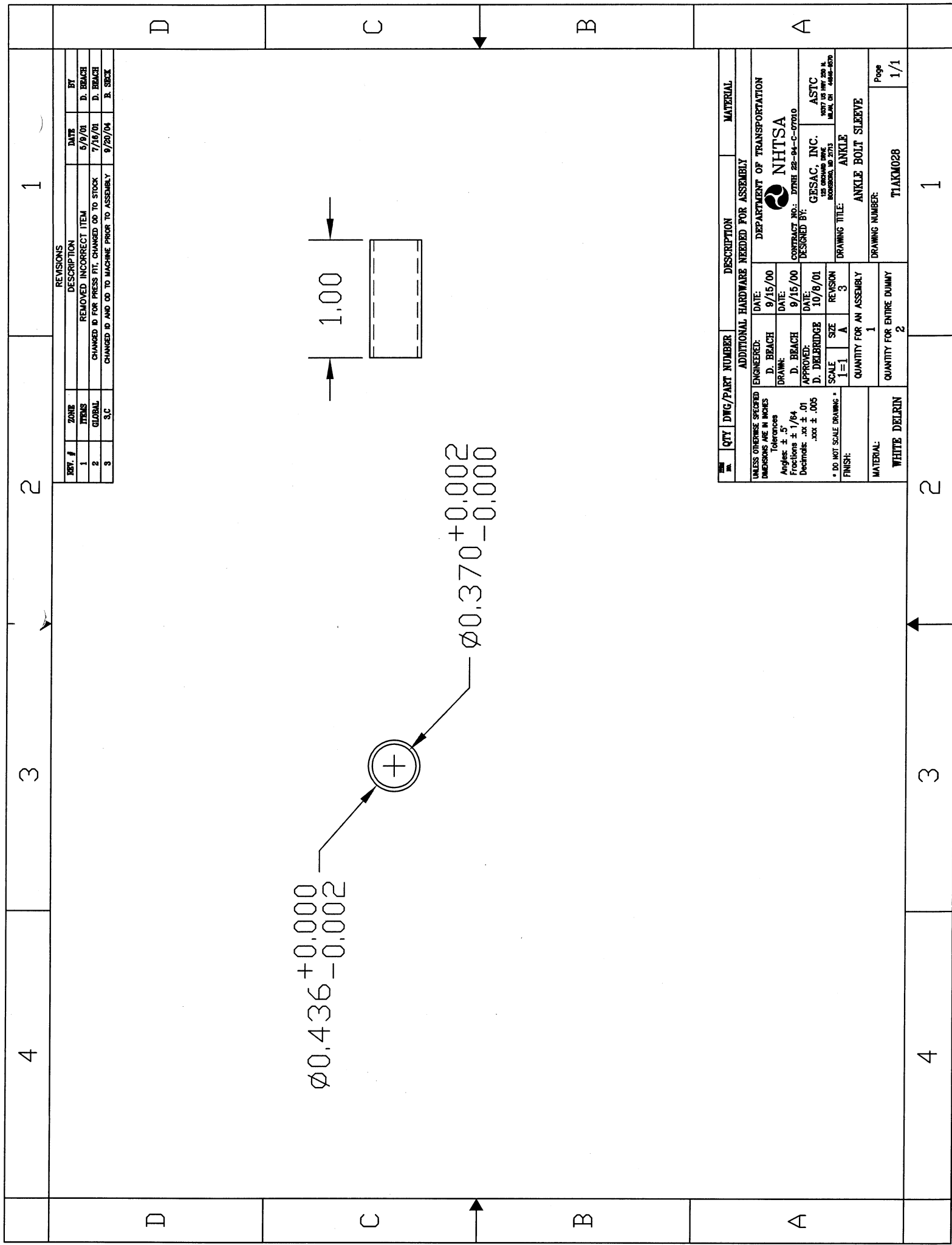


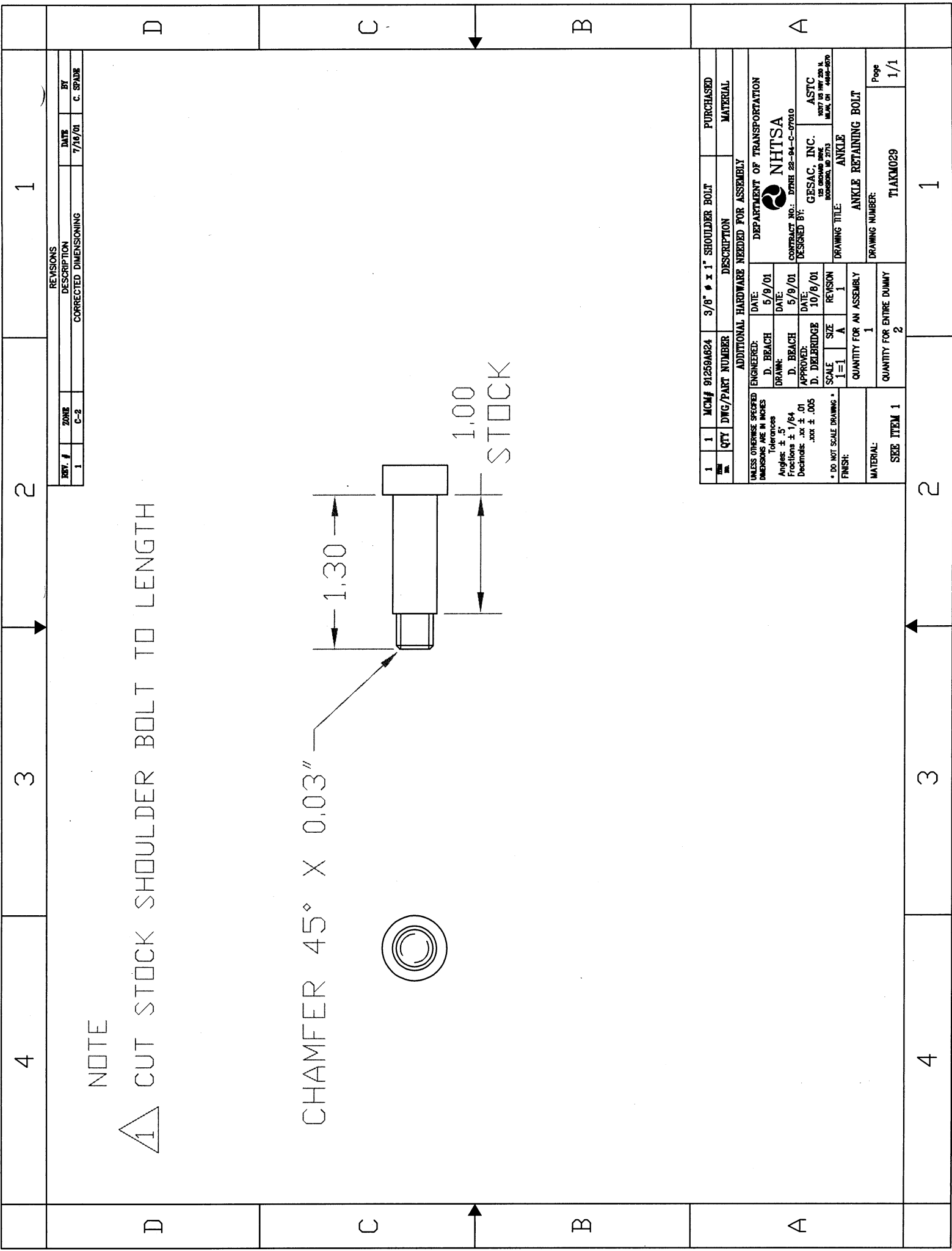
REV. #	ZONE	DESCRIPTION	DATE	BY
1		REMOVED INCORRECT ITEM	5/9/01	D. BEACH
2		CHANGED ID FOR PRESS FIT, CHANGED OD TO STOCK	7/16/01	D. BEACH
3	S,C	CHANGED ID AND OD TO MACHINE PRIOR TO ASSEMBLY	9/20/04	B. SECK

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
Tolerances			
Angles: ± .5°			
Fractions: ± 1/64			
Decimals: .xx ± .01			
.xxx ± .005			
* DO NOT SCALE DRAWING *			
FINISH:			
ENGINEERED: D. BEACH DATE: 9/15/00			
DRAWN: D. BEACH DATE: 9/15/00			
APPROVED: D. DELBRIDGE DATE: 10/8/01			
SCALE: 1=1 SIZE: A REVISION: 3			
QUANTITY FOR AN ASSEMBLY: 1			
QUANTITY FOR ENTIRE DUMMY: 2			
MATERIAL: WHITE DELRIN			
DRAWING TITLE: ANKLE BOLT SLEEVE			
DRAWING NUMBER: T1AKM028			
Page: 1/1			



DEPARTMENT OF TRANSPORTATION  
 CONTRACT NO.: DTRM 22-94-C-0700  
 DESIGNED BY: GESAC, INC.  
 ASTC  
 10070 W. 19TH AVE.  
 DENVER, CO 80202-5700

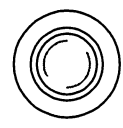




NOTE

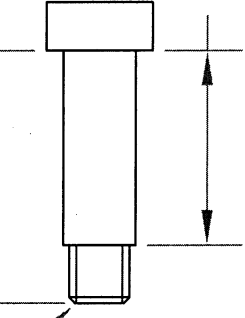
△ CUT STOCK SHOULDER BOLT TO LENGTH

CHAMFER 45° X 0.03"



1.00  
STOCK

1.30



1	1	MCM# 91259A824	3/8" x 1" SHOULDER BOLT	PURCHASED
QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL	
ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ENGINEERED:	DATE:	
Fractions ± 1/64		D. BEACH	5/9/01	
Decimals .xx ± .01		DRAWN:	DATE:	
.xxx ± .005		D. BEACH	5/9/01	
* DO NOT SCALE DRAWING *		APPROVED:	DATE:	
FINISH:		D. DELBRIDGE	10/6/01	
MATERIAL:		SCALE	SIZE	REVISION
SEE ITEM 1		1=1	A	1
QUANTITY FOR AN ASSEMBLY		DEPARTMENT OF TRANSPORTATION		
1		NHTSA		
2		CONTRACT NO.: DTRM 22-94-C-07010		
QUANTITY FOR ENTIRE DUMMY		DESIGNED BY: GESAC, INC. ASTC		
1		1000 N. 400 N.		
2		BOWERSVILLE, MD 2173		
1/1		DRAWING TITLE: ANKLE		
1/1		ANKLE RETAINING BOLT		
1/1		DRAWING NUMBER: TIAKMO29		

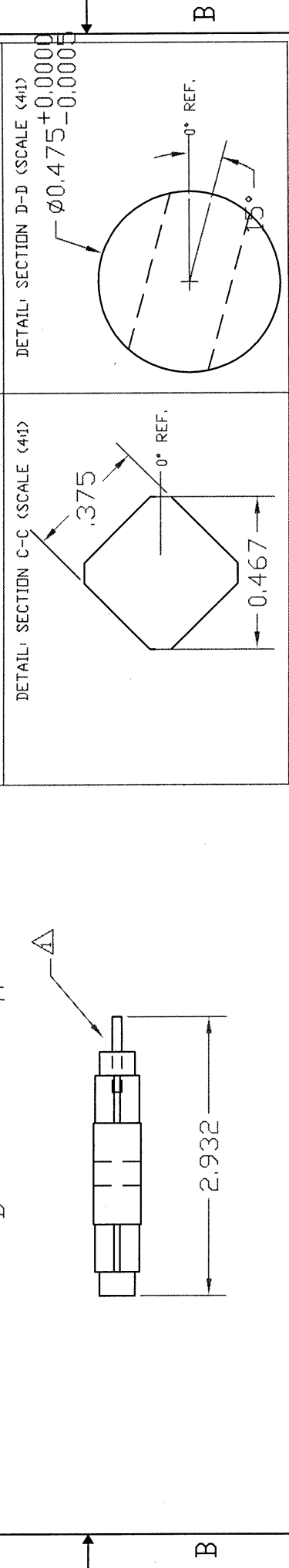
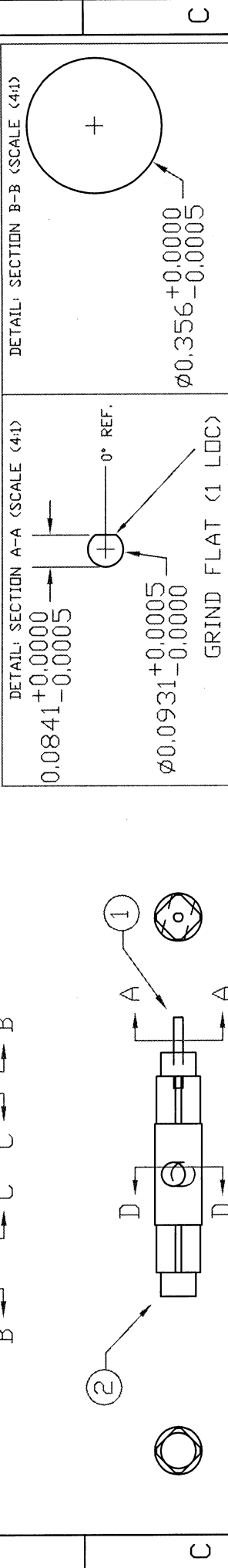
4 3 2 1

4 3 2 1

8	7	6	5	4	3	2	1
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REV. #		ZONE		DESCRIPTION		DATE		BY	
1	GLOBAL	CHANGES FOR GESAC / ASTC REVISIONS	6/21/99	D. BRANCH		6/21/99	D. BRANCH		
2	GLOBAL	ADDED TOLERANCE DIMENSIONS	9/2/97	D. BRANCH		9/2/97	D. BRANCH		
3	NOTE 1	ADDED ASSEMBLY CLARIFICATION	6/21/99	D. BRANCH		6/21/99	D. BRANCH		
4	NOTE 2	ADDED ITEM CALLOUT FOR CLARITY	11/17/99	D. BRANCH		11/17/99	D. BRANCH		
5	DETAIL	CORRECTED MIS-SCALED DIMENSIONS	12/22/00	D. BRANCH		12/22/00	D. BRANCH		
6	DETAIL	ADDED TOLERANCE TO D-SHAFT	6/26/00	D. BRANCH		6/26/00	D. BRANCH		
7	NOTES	ELIMINATED NOTE 3	10/9/01	D. BRANCH		10/9/01	D. BRANCH		

D  
C  
B  
A



2	1	TIAKM031	TORQUE SHAFT - UPPER JOINT	SEE DWG.
1	1	MSC # 8880880	0.0960" ∅ GAGE PIN	STEEL
QTY		DWG/PART NUMBER	DESCRIPTION	MATERIAL

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY			
ENGINEERED:	DATE:	DEPARTMENT OF TRANSPORTATION	
D. BRANCH	9/2/97	NHTSA	
APPROVED:	DATE:	CONTRACT NO.: DTMB 22-94-C-07010	
D. B. / S. R.	9/2/97	DESIGNED BY:	
D. DELBRIDGE	10/9/01	GESAC, INC.	
SCALE:	SIZE:	ASTC	
1=1	B	PART # 22-94-C-07010	
REVISION:	7	ASTC	
QUANTITY FOR AN ASSEMBLY:	1	DRAWING TITLE: ANKLE TORQUE SHAFT	
1	2	UPPER JOINT - MECHANICAL ASSEMBLY	
QUANTITY FOR ENTIRE DUMMY:		DRAWING NUMBER:	
2		TIAKM030	

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

ANGLES ± 5°

FRACTIONS ± 1/64

DECIMALS: .XX ± .01

.XXX ± .005

\* DO NOT SCALE DRAWING \*

FINISH:

MATERIAL:	440C SS
-----------	---------

NOTES:

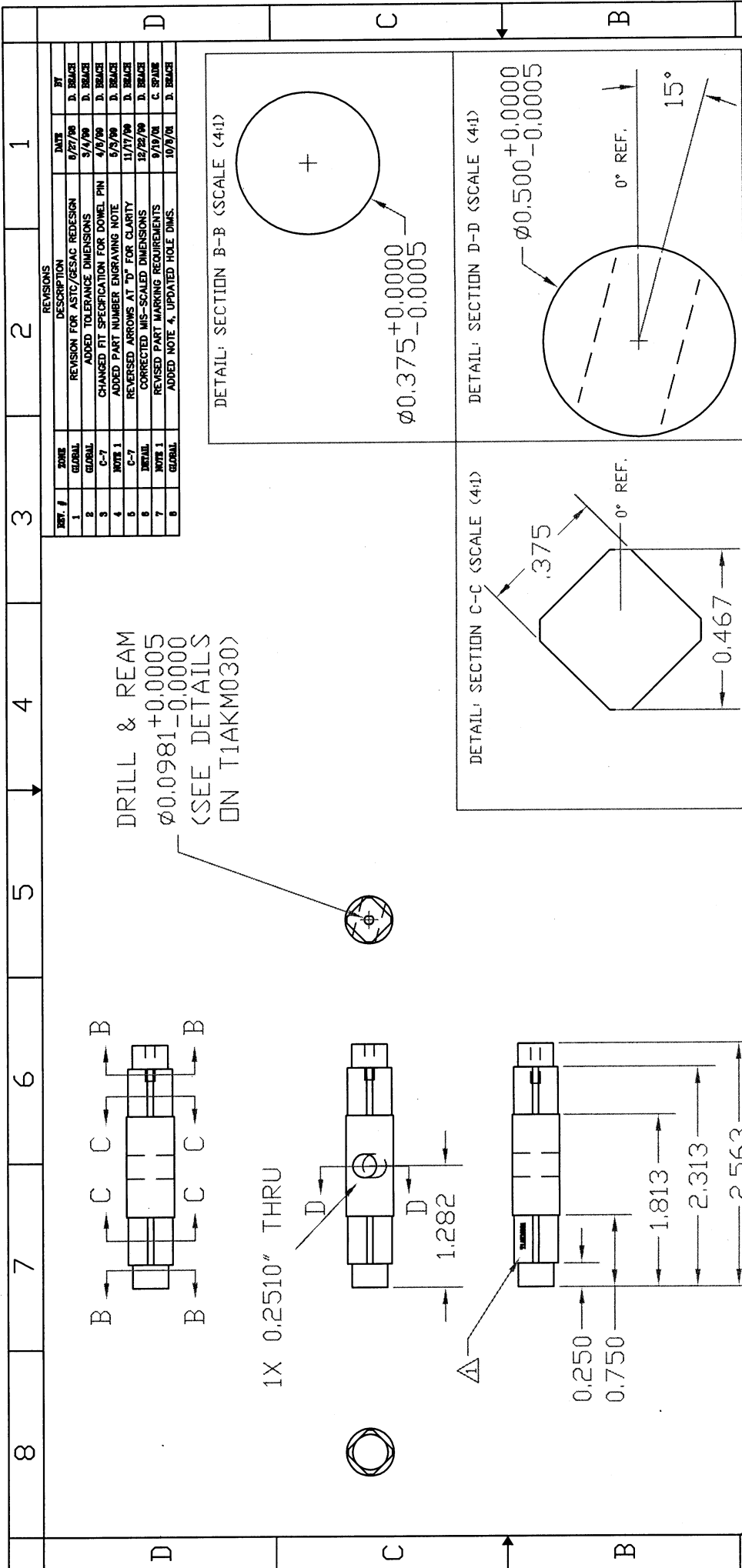
△ ABRASE THE SMOOTH SURFACE AT ONE END OF THE GAGE PIN AND CLEAN BOTH PARTS WITH MEK. USE A 5 MINUTE EPOXY AND PRESS THE PIN INTO PLACE AS SHOWN. ALLOW 2 HOURS TO DRY COMPLETELY. GRIND THE PIN TO THE CORRECT LENGTH AND THEN GRIND THE FLAT ON THE GAGE PIN AS INDICATED.

△ THE GROUND FLAT ON THE GAGE PIN MUST BE ORIENTED AT -15° FROM THE 1/4" REAMED HOLE - AS SHOWN.

8	7	6	5	4	3	2	1
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Page	1/1
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DRILL & REAM  
 $\phi 0.0981^{+0.0005}$   
 (SEE DETAILS  
 ON T1AKM030)

1X 0.2510" THRU

REVISIONS			
REV. #	DATE	DESCRIPTION	BY
1	8/27/80	REVISION FOR ASTC/GESAC REDESIGN	D. BEACH
2	9/4/80	ADDED TOLERANCE DIMENSIONS	D. BEACH
3	4/8/80	CHANGED FIT SPECIFICATION FOR DOWEL PIN	D. BEACH
4	5/9/80	ADDED PART NUMBER ENGRAVING NOTE	D. BEACH
5	11/7/80	REVERSED ARROWS AT "D" FOR CLARITY	D. BEACH
6	12/25/80	CORRECTED MIS-SCALED DIMENSIONS	D. BEACH
7	9/19/81	REVERSED PART MARKING REQUIREMENTS	C. SPAIN
8	10/9/81	ADDED NOTE 4, UPDATED HOLE DIMS.	D. BEACH

NOTES:  
 1 MARK PART NUMBER T1AKM031 AS SHOWN BY ENGRAVING DR INK STAMP  
 2 HEAT TREAT TO Rc 57 HARDNESS  
 3 CLEAN OUT REAMED HOLES AFTER HEAT TREATING.  
 4 POLISH 0.375" AND 0.500"  $\phi$  SECTIONS AFTER HEAT TREATMENT TO REMOVE SCALE

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
1	T1AKM031	TORQUE SHAFT - UPPER JOINT	440C SS
ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY DEPARTMENT OF TRANSPORTATION <b>NHTSA</b> CONTRACT NO. DTRC 80-04-C-07010 DESIGNED BY: GESAC, INC. 10000 W. 10TH AVE. BOULDER, CO 80501-3775 DRAWING TITLE: ANKLE ASTC 1000 W. 10TH AVE. BOULDER, CO 80501-3775			
ENGR: D. BEACH		DATE: 9/2/81	
DRAWN: D. B. / SR		DATE: 9/2/81	
APPROVED: D. DELBRIDGE		DATE: 10/9/81	
SCALE: 1=1		REVISION: 8	
QUANTITY FOR AN ASSEMBLY: 1			
QUANTITY FOR ENTIRE DUMMY: 2			
MATERIAL: 440C SS			
PAGE: 1/1			

8	7	6	5	4	3	2	1	
DIMENSIONS								
REV. #	ZONE	DESCRIPTION	DATE	BY				
1	GLOBAL	REVISION FOR GESAC / ASTC ANGLE - INCREASED LENGTH	8/25/98	S. BRUCE				
2	GLOBAL	ADDED TOLERANCES FOR DIAMETERS	3/4/99	D. BRUCE				
3	GLOBAL	CLARIFIED NOTE 1	6/24/99	D. BRUCE				
4	ITEM 2	ADDED ITEM 2 AND CALLOUTS FOR CLARITY	12/7/99	D. BRUCE				
5	DETAIL	CORRECTED MISC-SCALED DIMENSIONS	12/7/99	D. BRUCE				
6	DETAIL	ADDED TOLERANCE TO D-SHAFT DIMS.	6/25/00	D. BRUCE				
7	NOTES	ELIMINATED NOTE 3	10/2/04	D. BRUCE				

DETAIL: SECTION A-A (SCALE (4:1))

$0.0841^{+0.0000}_{-0.0005}$

$\phi 0.0931^{+0.0005}_{-0.0000}$

GRIND FLAT (1 LOC)

0° REF.

DETAIL: SECTION B-B (SCALE (4:1))

$\phi 0.356^{+0.0000}_{-0.0005}$

DETAIL: SECTION C-C (SCALE (4:1))

0.375

0.467

0° REF.

DETAIL: SECTION D-D (SCALE (4:1))

$\phi 0.475^{+0.0000}_{-0.0005}$

DETAIL: SECTION B-B (SCALE (4:1))

0° REF.

NOTE:

ABRADE THE SMOOTH SURFACE AT ONE END OF THE GAGE PIN AND CLEAN THE MATING PARTS WITH MEK. USE A 5 MINUTE EPOXY AND PRESS THE PIN INTO PLACE AS SHOWN. ALLOW 2 HOURS FOR COMPLETE CURE. GRIND THE PIN TO THE CORRECT LENGTH AND THEN GRIND FLAT ON GAGE PIN AS INDICATED.

THE FLAT GROUND ON THE GAGE PIN MUST BE ORIENTED PERPENDICULAR TO THE 1/4" REAMED HOLE.

2	1	TIAXM041	TORQUE SHAFT - LOWER JOINT	SEE DWG.
1	1	MSC # 8890980	0.098" Ø GAGE PIN	STEEL
QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
Tolerances  
Angles: ± .5°  
Fractions: ± 1/64  
Decimals: .xx ± .01  
D. DELORIDGE 10/6/01  
SCALE SIZE REVISION  
1=1 B 7

ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

ENGINEERED: D. BRUCE DATE: 9/2/97  
DRAWN: D. BRUCE DATE: 9/2/97  
APPROVED: D. DELORIDGE 10/6/01

DESIGNED BY: GESAC, INC. ASTC  
125 DELAWARE AVE. NEW BRUNSWICK, NJ 07102  
REV. 10 10/1/98

QUANTITY FOR AN ASSEMBLY: 1  
QUANTITY FOR ENTIRE DUMMY: 2

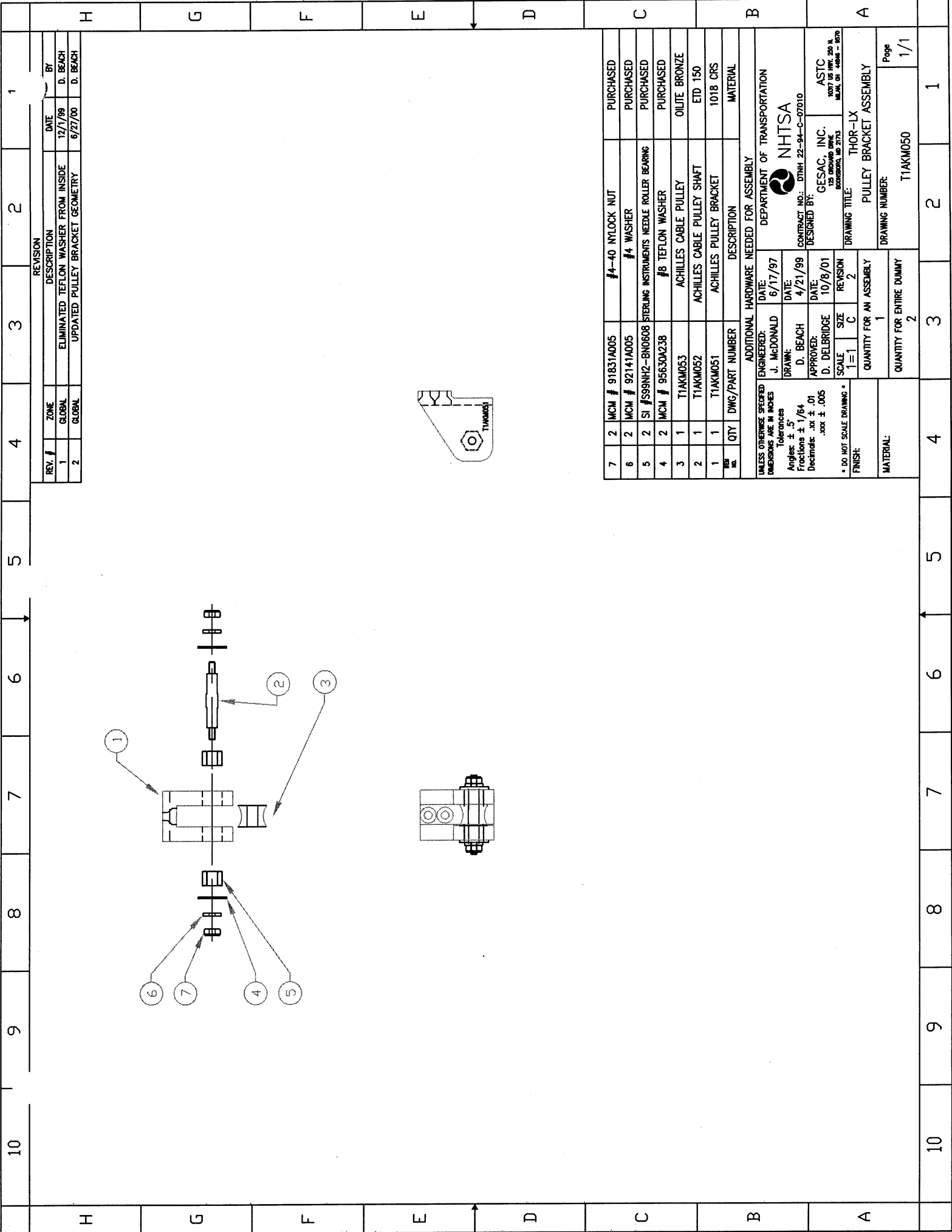
MATERIAL: 440C SS

DRAWING NUMBER: TIAXM040

LOWER JOINT - MECHANICAL ASSEMBLY

Page: 1/1

8	7	6	5	4	3	2	1																																												
<p>REVISIONS</p> <table border="1"> <thead> <tr> <th>REV. #</th> <th>DATE</th> <th>DESCRIPTION</th> <th>BY</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>8/28/80</td> <td>DESIGN FOR GESAC / ASTC ANGLE - INCREASED LENGTH</td> <td>D.B. / S.R.</td> </tr> <tr> <td>2</td> <td>9/4/80</td> <td>ADDED DIMENSIONAL TOLERANCES</td> <td>D. BEACH</td> </tr> <tr> <td>3</td> <td>5/9/80</td> <td>ADDED PART NUMBER ENGRAVING NOTE</td> <td>D. BEACH</td> </tr> <tr> <td>4</td> <td>9/19/81</td> <td>REVISED PART MARKING REQUIREMENTS</td> <td>C. SPAIN</td> </tr> <tr> <td>6</td> <td>10/9/81</td> <td>ADDED NOTE 4, REVISED HOLE DIMENSIONS</td> <td>D. BEACH</td> </tr> </tbody> </table>								REV. #	DATE	DESCRIPTION	BY	1	8/28/80	DESIGN FOR GESAC / ASTC ANGLE - INCREASED LENGTH	D.B. / S.R.	2	9/4/80	ADDED DIMENSIONAL TOLERANCES	D. BEACH	3	5/9/80	ADDED PART NUMBER ENGRAVING NOTE	D. BEACH	4	9/19/81	REVISED PART MARKING REQUIREMENTS	C. SPAIN	6	10/9/81	ADDED NOTE 4, REVISED HOLE DIMENSIONS	D. BEACH																				
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<p>DRILL &amp; REAM  <math>\phi 0.0981^{+0.0005}</math>          (SEE DETAILS          ON T1AKM040)</p>																																																			
<p>DETAIL: SECTION B-B (SCALE (4:1))</p> <p><math>\phi 0.375^{+0.0000}_{-0.0005}</math></p> <p>DETAIL: SECTION C-C (SCALE (4:1))</p> <p>0.375</p> <p>0.467</p> <p>0° REF.</p> <p>DETAIL: SECTION D-D (SCALE (4:1))</p> <p><math>\phi 0.500^{+0.0000}_{-0.0005}</math></p> <p>0° REF.</p>																																																			
<p>NOTE:</p> <p>MARK PART NUMBER T1AKM041 AS SHOWN BY ENGRAVING OR INK STAMP</p> <p>HEAT TREAT TO Rc 57 HARDNESS</p> <p>CLEAN OUT REAMED HOLE FOR GAGE PIN PRESS FIT AFTER HEAT TREATING PART.</p> <p>POLISH 0.375" AND 0.500" <math>\phi</math> SECTIONS AFTER HEAT TREATMENT TO REMOVE SCALE</p>																																																			
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<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p> <p>Tolerances</p> <p>Angles <math>\pm .5</math></p> <p>Locations <math>\pm .04</math></p> <p>Diameters <math>\pm .005</math></p> <p>Distances <math>\pm .005</math></p> <p>* DO NOT SCALE DIMENSIONS * FINISH</p> <p>DEPARTMENT OF TRANSPORTATION  <b>NHTSA</b>      CONTRACT NO. DTRC 22-84-C-07010      DESIGNED BY: GESAC, INC.      125 BROADWAY, NEW YORK, NY 10038      DRAWING TITLE: ANKLE      ASTC      NEW YORK, NY 10014      MAIL OR PHONE: 212 633-6272</p>																																																			
8	7	6	5	4	3	2	1																																												



REV. #	ZONE	DESCRIPTION	DATE	BY
1	GLOBAL	ELIMINATED TEFLON WASHER FROM INSIDE	12/1/99	D. BEACH
2	GLOBAL	UPDATED PULLEY BRACKET GEOMETRY	6/27/00	D. BEACH

REVISION

1	2	3	4	5	6	7	8	9	10
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ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
2	MCM # 91831A005	#4-40 NYLOCK NUT	PURCHASED
2	MCM # 92141A005	#4 WASHER	PURCHASED
2	SI #S99NH2-BN0608	STERLING INSTRUMENTS NEEDLE ROLLER BEARING	PURCHASED
2	MCM # 95630A238	#8 TEFLON WASHER	PURCHASED
1	T1AKM053	ACHILLES CABLE PULLEY	OLITE BRONZE
1	T1AKM052	ACHILLES CABLE PULLEY SHAFT	ETD 150
1	T1AKM051	ACHILLES PULLEY BRACKET	1018 CRS

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
ENGINEERED: J. McDONALD
DATE: 6/17/97
DRAWN: D. BEACH
DATE: 4/21/99
APPROVED: D. DELBRIDGE
DATE: 10/8/01
SCALE: 1=1
SIZE: C
REVISION: 2
FINISH:
QUANTITY FOR AN ASSEMBLY: 1
QUANTITY FOR ENTIRE DUMMY: 2

\* DO NOT SCALE DRAWING \*

Tolerances:  
Angles: ± 5°  
Fractions: ± 1/64  
Decimals: .xx ± .01  
.xxx ± .005

ASTC  
1007 10 MAY 200 N  
1007 10 MAY 200 N  
1007 10 MAY 200 N

DESIGNED BY: CESAC, INC.  
1007 10 MAY 200 N  
1007 10 MAY 200 N

CONTRACT NO.: DTNH 22-94-C-07010

DEPARTMENT OF TRANSPORTATION  
NHTSA

DRAWING TITLE: THOR-LX  
PULLEY BRACKET ASSEMBLY

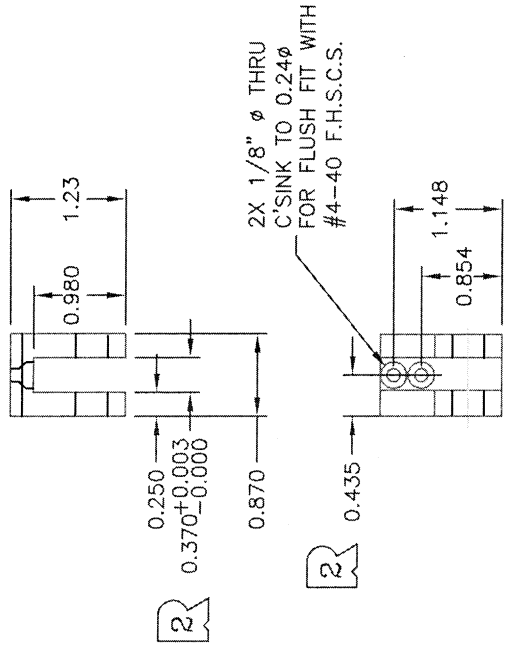
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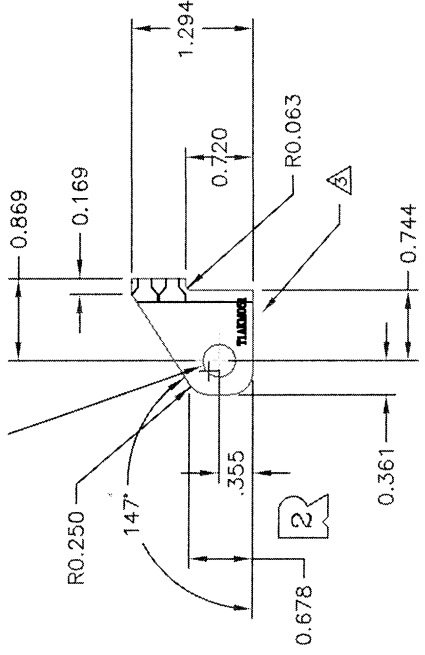
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H	G	F	E	D	C	B	A		

REV. #	ZONE	DESCRIPTION	DATE	BY
1	G-B	DELETE RADIUS FROM INNER AREA	3/25/99	D. BEACH
2	F-D	CORRECTED HOLE LOCATION DIMENSIONS, SLOT TOLERANCE	11/29/99	D. BEACH
3	GLOBAL	MODIFIED DESIGN FOR Z-ROTATION	6/27/00	D. BEACH
4	FINISH	SPECIFIED BLACK ANODIZE FINISH	6/6/00	D. BEACH
5	NOTE 3	REVISED PART MARKING REQUIREMENTS	9/19/01	C. SPADE



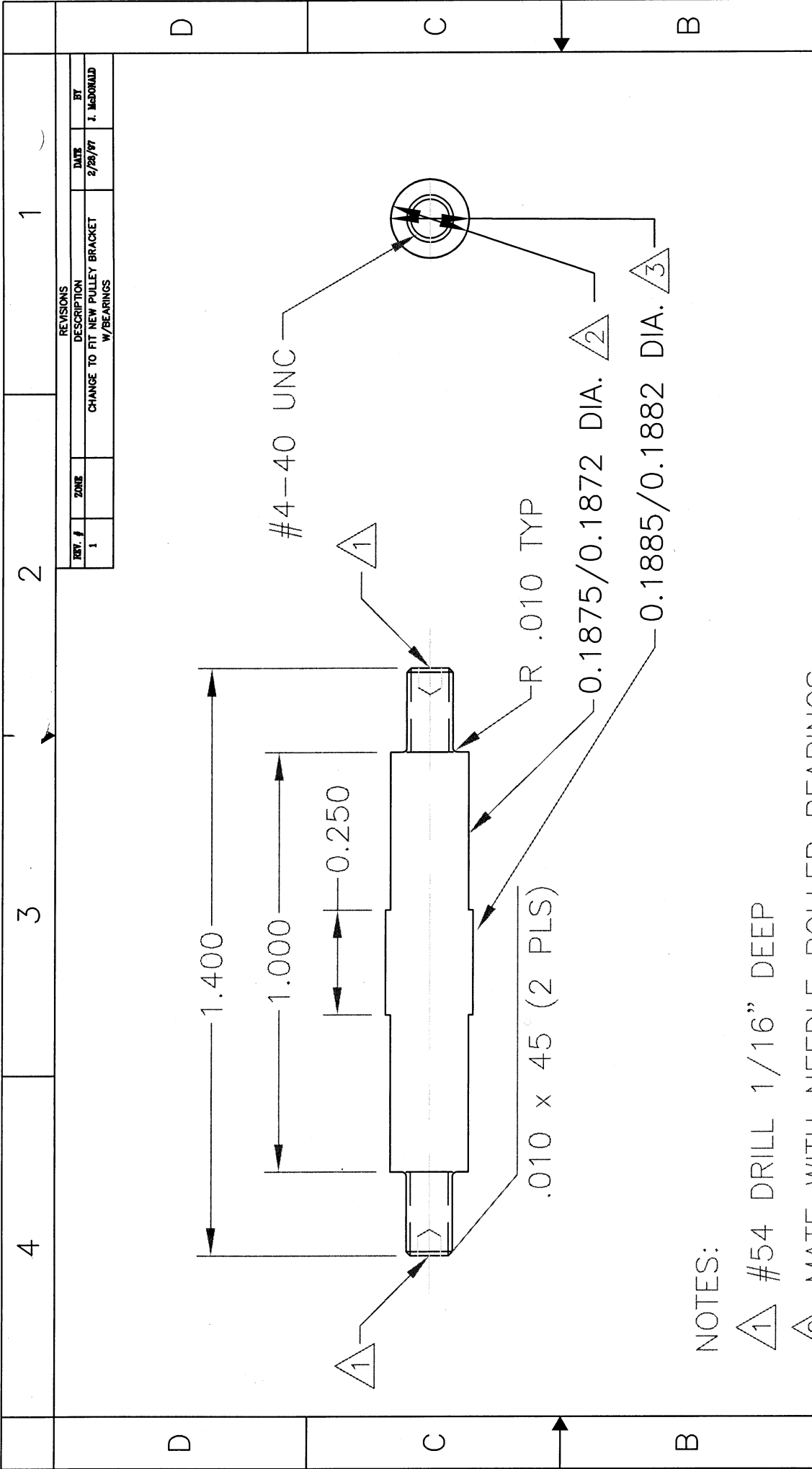
2X 0.3432/0.3437 DIA. THRU



QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
4	7075-T6	ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	7075-T6
1	1-1	SCALE	1-1
1	C	SIZE	C
1	1	QUANTITY FOR AN ASSEMBLY	1
2	2	QUANTITY FOR ENTIRE DUMMY	2
3	3	REVISION	5
4	4	DATE	10/6/01
5	5	DATE	3/4/99
6	6	DATE	2/26/97
7	7	ENGINEER	J. McDONALD
8	8	DRAWN	D. BEACH
9	9	APPROVED	D. BEACH
10	10	CONTRACT NO.	DYNE 22-94-C-07010
11	11	DESIGNED BY	GESAC, INC.
12	12	DESIGNED BY	GESAC, INC.
13	13	CONTRACT NO.	DYNE 22-94-C-07010
14	14	DESIGNED BY	GESAC, INC.
15	15	DESIGNED BY	GESAC, INC.
16	16	CONTRACT NO.	DYNE 22-94-C-07010
17	17	DESIGNED BY	GESAC, INC.
18	18	DESIGNED BY	GESAC, INC.
19	19	CONTRACT NO.	DYNE 22-94-C-07010
20	20	DESIGNED BY	GESAC, INC.
21	21	DESIGNED BY	GESAC, INC.
22	22	CONTRACT NO.	DYNE 22-94-C-07010
23	23	DESIGNED BY	GESAC, INC.
24	24	DESIGNED BY	GESAC, INC.
25	25	CONTRACT NO.	DYNE 22-94-C-07010
26	26	DESIGNED BY	GESAC, INC.
27	27	DESIGNED BY	GESAC, INC.
28	28	CONTRACT NO.	DYNE 22-94-C-07010
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199	199	CONTRACT NO.	DYNE 22-94-C-07010
200	200	DESIGNED BY	GESAC, INC.

NOTES:

- REMOVE BURRS, BREAK SHARP EDGES.
- ALL FILLETS AND ROUNDS R.1
- MARK PART NUMBER T1AKM051 AT LOCATION SHOWN BY ENGRAVING OR INK STAMP.

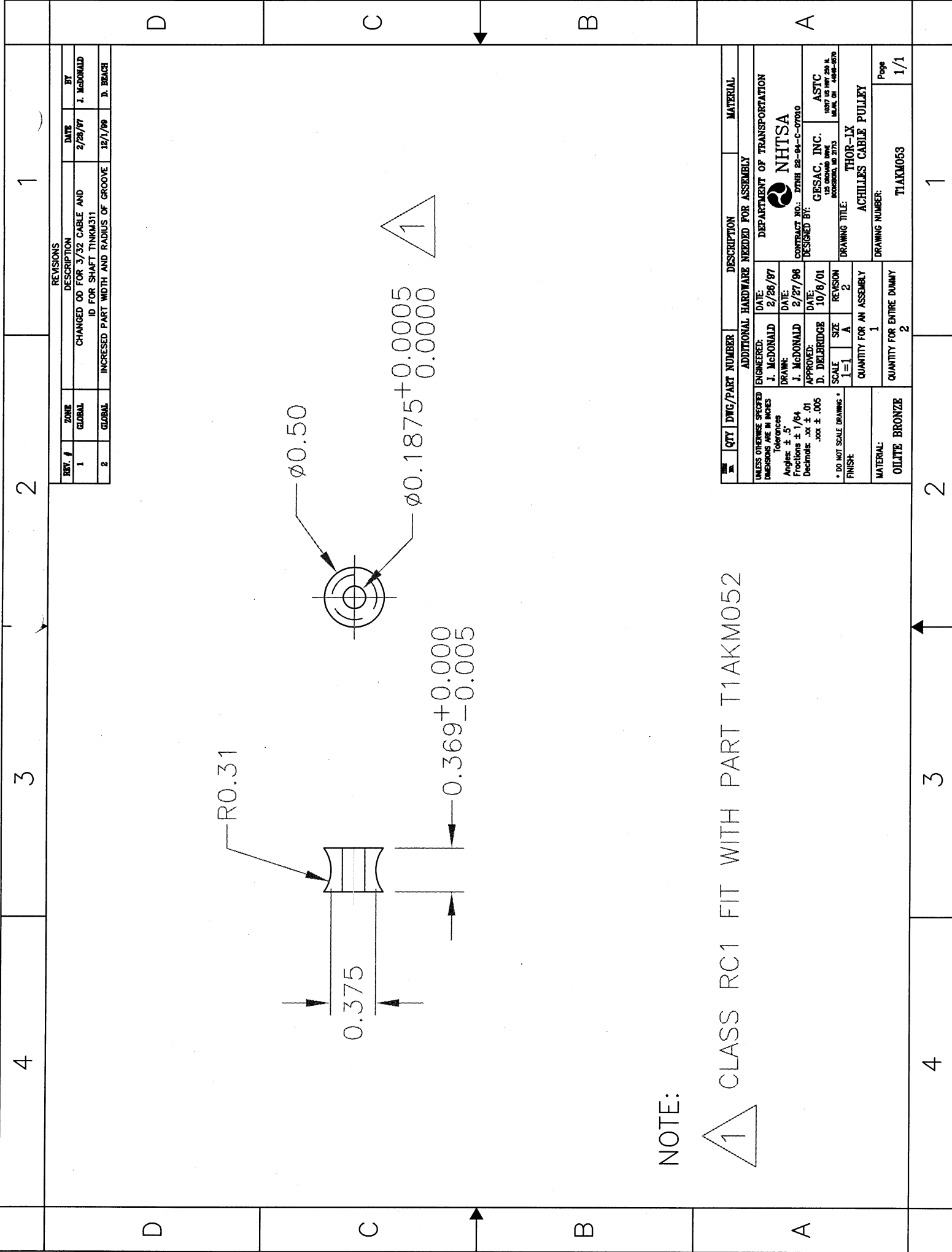


NOTES:

- ① #54 DRILL 1/16" DEEP
- ② MATE WITH NEEDLE ROLLER BEARINGS
- ③ CLASS RC1 FIT WITH PART T1AKM053
- ④ REFERENCE T1NKM311 - IDENTICAL PART

REV. #	ZONE	DESCRIPTION	DATE	BY
1		CHANGE TO FIT NEW PULLEY BRACKET W/BEARINGS	2/28/97	J. McDONALD

QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES Tolerances Fractions ± 3/64 Decimals .xx ± .01 .xxx ± .005 * DO NOT SCALE DRAWING FINISH:			
ENGINEERED:	J. McDONALD	DATE:	2/26/97
DRAWN:	J. McDONALD	DATE:	2/28/97
APPROVED:	D. DELBRIDGE	DATE:	10/8/01
SCALE:	3=1	SIZE:	A
REVISION:	1	REVISION:	1
QUANTITY FOR AN ASSEMBLY		1	
QUANTITY FOR ENTIRE DUMMY		2	
MATERIAL:		ETD 150	
DRAWING NUMBER:		T1AKM052	
DRAWING TITLE:		THOR-1X ACHILLES CABLE PULLEY SHAFT	
DESIGNED BY:		GESAC, INC. 125 BROADWAY ROSELAND, NJ 07068-2870	
CONTRACT NO.:		DYNE 22-94-C-07010	
DEPARTMENT OF TRANSPORTATION		NHTSA	
Page		1/1	



REVISIONS				
REV. #	ZONE	DESCRIPTION	DATE	BY
1	GLOBAL	CHANGED OD FOR 3/32 CABLE AND ID FOR SHAFT T1AKM311	2/28/97	J. McDONALD
2	GLOBAL	INCREASED PART WIDTH AND RADIUS OF GROOVE	12/1/99	D. BRACE

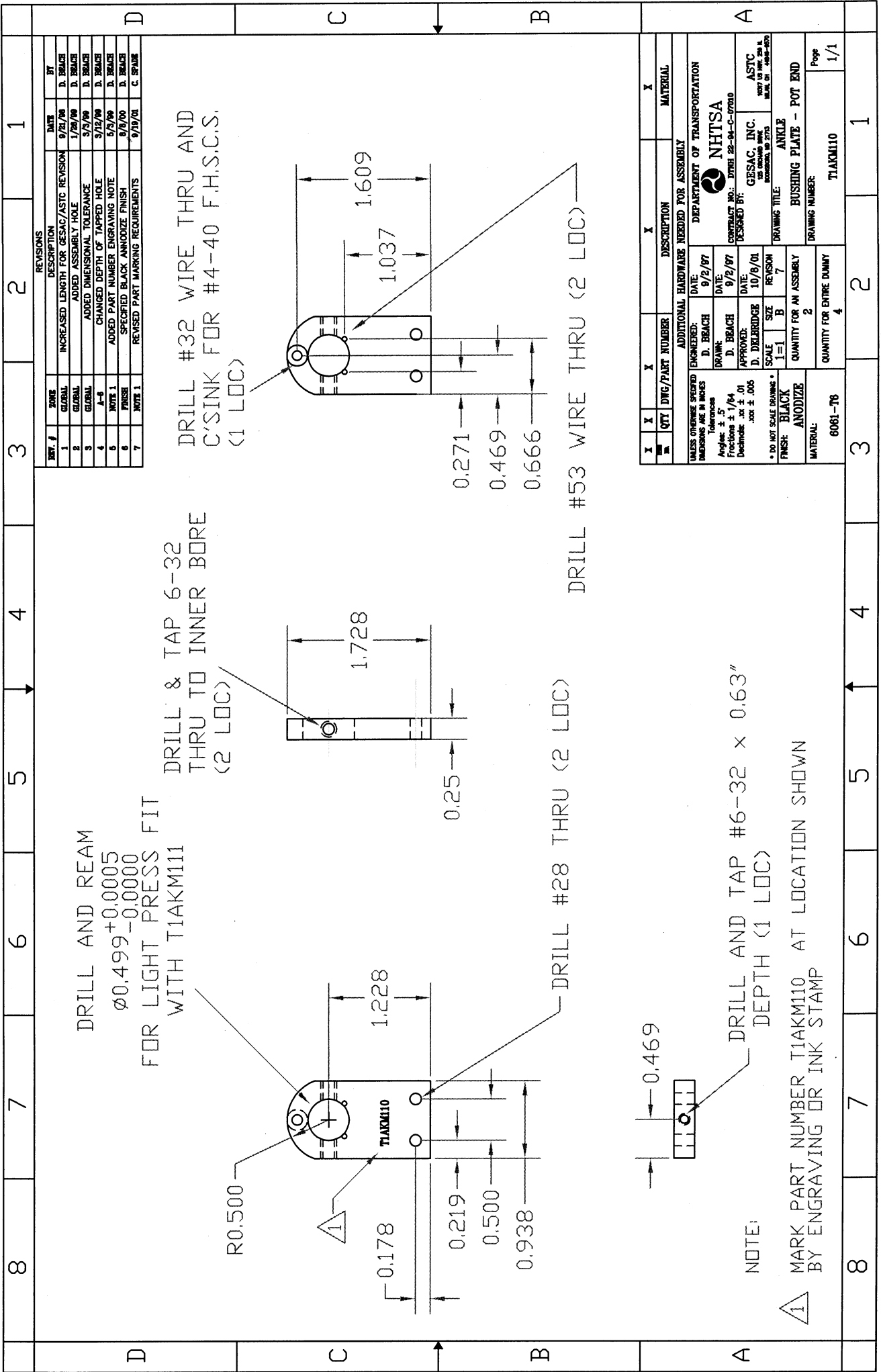
QTY	DTG/PART NUMBER	DESCRIPTION	MATERIAL
1	T1AKM052	ACHILLES CABLE PULLEY	OILITE BRONZE
2	T1AKM053	ACHILLES CABLE PULLEY	OILITE BRONZE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES	
Angles	$\pm .5$	Fractions	$\pm 1/64$
Decimals	.xx $\pm .01$	.xxx	$\pm .005$
* DO NOT SCALE DRAWING *			
FINISH:			
ENGINEERED:	J. McDONALD	DATE:	2/28/97
DRAWN:	J. McDONALD	DATE:	2/27/98
APPROVED:	D. DELBRIDGE	DATE:	10/8/01
SCALE:	1=1	SIZE:	A
REVISION:	1	QUANTITY FOR AN ASSEMBLY:	1
REVISION:	2	QUANTITY FOR ENTIRE DUMMY:	2

DEPARTMENT OF TRANSPORTATION  
**NHTSA**  
 CONTRACT NO.: DTMB 22-94-C-07010  
 DESIGNED BY: GESAC, INC.  
 125 GREENWAY DRIVE  
 WASHINGTON, DC 20535  
 ASTC  
 1407 US HWY 26  
 WYOMING, WY 83091-2825  
 DRAWING TITLE: THOR-LX  
 ACHILLES CABLE PULLEY  
 DRAWING NUMBER: T1AKM053  
 Page 1/1

8	7	6	5	4	3	2	1																														
<p style="text-align: center;">PRESS BUSHING &lt;T1AKM111&gt; INTO THE BUSHING PLATE &lt;T1AKM110&gt;</p>																																					
<p style="text-align: center;">NOTE:</p> <p style="text-align: center;">EACH THOR ANKLE ASSEMBLY REQUIRES TWO BUSHING PLATE ASSEMBLIES WITH T1AKM110 AND TWO BUSHING PLATE ASSEMBLIES WITH T1AKM112</p> <p style="text-align: center;">REAM BUSHING &lt;T1AKM111&gt; 0.375"Ø AFTER PRESS FIT</p>																																					
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REV. #	DATE	DESCRIPTION	BY
1	9/21/98	INCREASED LENGTH FOR GESAC/ASTC REVISION	D. BRACH
2	1/26/99	ADDED ASSEMBLY HOLE	D. BRACH
3	5/27/99	ADDED DIMENSIONAL TOLERANCE	D. BRACH
4	5/12/99	CHANGED DEPTH OF TAPPED HOLE	D. BRACH
5	5/2/99	ADDED PART NUMBER ENGRAVING NOTE	D. BRACH
6	9/2/00	SPECIFIED BLACK ANODIZE FINISH	D. BRACH
7	9/19/01	REVISED PART MARKING REQUIREMENTS	C. SPURK

QTY	DRG/PART NUMBER	DESCRIPTION	MATERIAL
1		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	
		DEPARTMENT OF TRANSPORTATION	
		NHTSA	
		CONTRACT NO.: DTRE 22-94-C-07010	
		DESIGNED BY: GESAC, INC.	ASTC
		125 CALDWAY AVE.	1037 18 18E 28 A
		INDIANAPOLIS, IN 46219	W.K. OF 1488-020
		DRAWING TITLE: ANKLE	
		QUANTITY FOR AN ASSEMBLY	
		2	
		QUANTITY FOR ENTIRE DUBNY	
		4	
		DRAWING NUMBER:	
		T1AKM110	
		Page	
		1/1	

DRILL AND REAM  
 $\varnothing 0.499^{+0.0005}_{-0.0000}$   
 FOR LIGHT PRESS FIT  
 WITH T1AKM111

DRILL & TAP 6-32  
 THRU TO INNER BORE  
 (2 LOC)

DRILL #32 WIRE THRU AND  
 C'SINK FOR #4-40 F.H.S.C.S.  
 (1 LOC)

DRILL #28 THRU (2 LOC)

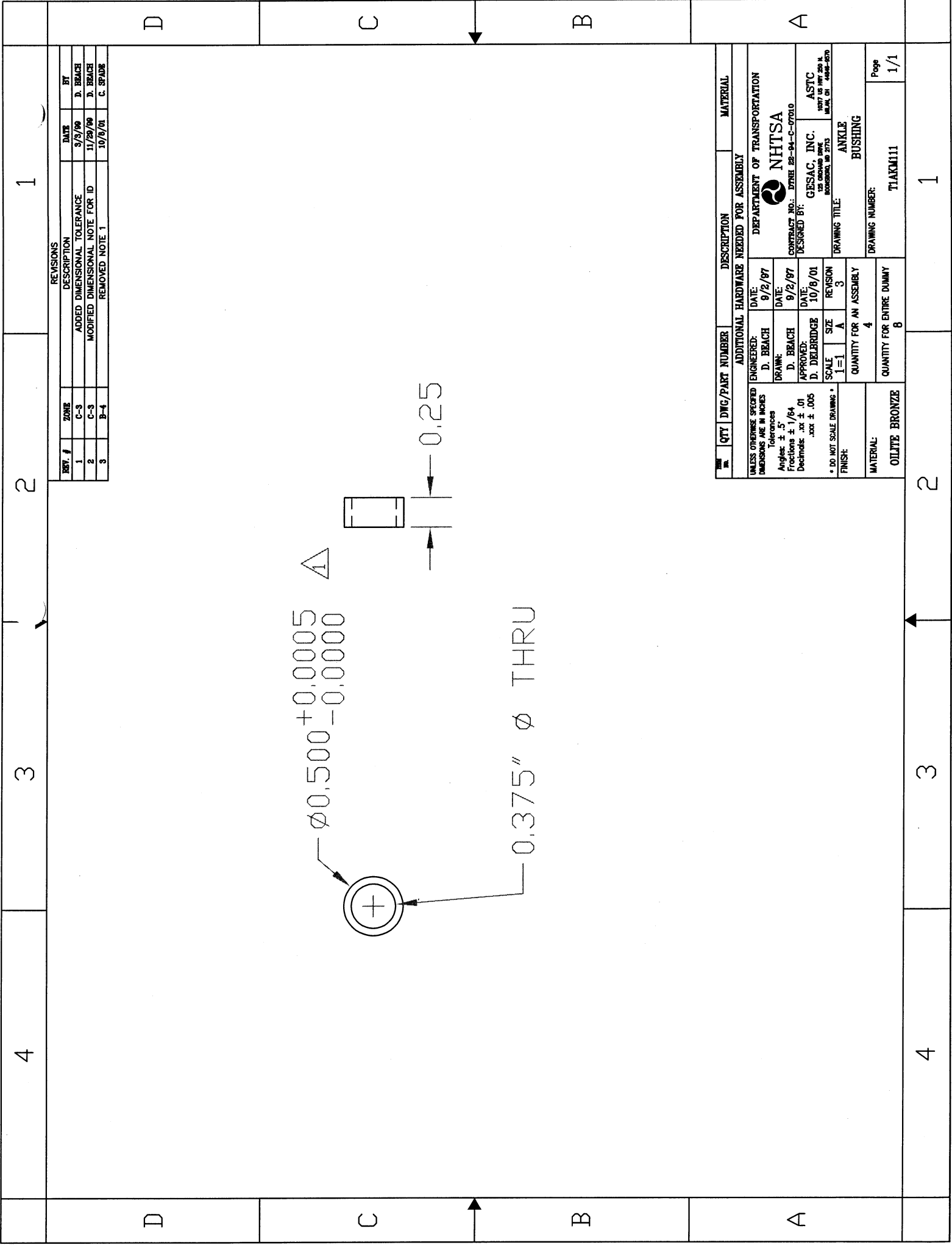
DRILL #53 WIRE THRU (2 LOC)

DRILL AND TAP #6-32 x 0.63"  
 DEPTH (1 LOC)

NOTE:

MARK PART NUMBER T1AKM110 AT LOCATION SHOWN  
 BY ENGRAVING OR INK STAMP





QTY	DWG/PART NUMBER	DESCRIPTION	MATERIAL
		ADDITIONAL HARDWARE NEEDED FOR ASSEMBLY	
		ENGINEERED: DATE: 9/2/97	
		D. BRANCH	
		DRAWN: DATE: 9/2/97	
		D. BRANCH	
		APPROVED: DATE: 10/8/01	
		D. DELBRIDGE	
		SCALE: SIZE: REVISION	
		1=1 A 3	
		QUANTITY FOR AN ASSEMBLY	
		4	
		QUANTITY FOR ENTIRE DUMMY	
		8	
		MATERIAL:	
		OILITE BRONZE	
		FINISH:	
		* DO NOT SCALE DRAWING *	
		DEPARTMENT OF TRANSPORTATION	
		NHTSA	
		CONTRACT NO.: DTRE 94-C-07010	
		DESIGNED BY: GBSAC, INC.	
		128 WILSON DRIVE	
		BROOKFIELD, IL 60513	
		DRAWING TITLE: ANKLE BUSHING	
		DRAWING NUMBER: T1AKM111	
		Page 1/1	

8	7	6	5	4	3	2	1																																																				
<p>DRILL #32 WIRE THRU AND C'SINK FOR #4-40 F.H.S.C.S. (1 LOC)</p> <p>DRILL AND REAM <math>\phi 0.499^{+0.0005}_{-0.0000}</math> FOR A LIGHT PRESS FIT WITH T1AKM111</p> <p>R0.500</p> <p>DRILL #28 THRU AND C'SINK FOR #6-32 F.H.S.C.S. (2 LOC)</p> <p>DRILL #32 THRU TO INNER BORE (2 LOC)</p> <p>DRILL #28 THRU AND C'SINK FOR #6-32 F.H.S.C.S. (2 LOC)</p>																																																											
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