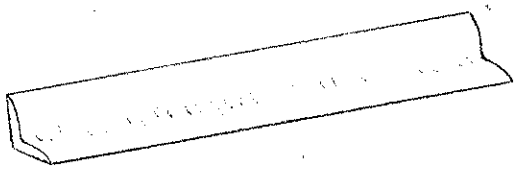
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-23-71 | ANGLE, ALUMINUM 6061<br>AMERICAN STANDARD | 48-00501 |
| LAST CHG LTR: D | | SHEET 1 OF 2 |

**SCOPE** This specification identifies 6061 American Standard aluminum angle.

**APPLICATION** Heavy duty structures requiring good corrosion resistance.

**SKETCH**



**SPECIFICATION NUMBERS**

| SIZE | THICK. | TEMPER | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|
| 3/4 x 3/4 | 1/8 | T6 | 48-00501-000 |
| 1 x 1 | 1/8 | T6 | -001 |
| | 3/16 | T6 | -002 |
| | 1/4 | T6 | -003 |
| 1-1/4 x 1-1/4 | 1/8 | T6 | -004 |
| | 3/16 | T6 | -005 |
| | 1/4 | T6 | -006 |
| 1-1/2 x 1-1/4 | 1/8 | T6 | -007 |
| | 3/16 | T6 | -008 |
| 1-1/2 x 1-1/2 | 1/8 | T6 | -009 |
| | 3/16 | T6 | -010 |
| | 1/4 | T6 | -011 |
| 1-3/4 x 1-1/4 | 1/8 | T6 | -012 |
| 1-3/4 x 1-3/4 | 1/8 | T6 | -013 |
| | 3/16 | T6 | -014 |
| | 1/4 | T6 | -015 |
| 2 x 1-1/2 | 1/8 | T6 | -016 |
| | 3/16 | T6 | -017 |
| | 1/4 | T6 | -018 |
| 2 x 2 | 1/8 | T6 | -019 |
| | 3/16 | T6 | -020 |
| | 5/16 | T6 | -021 |
| | 3/8 | T6 | -022 |

| SIZE | THICK. | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| 2-1/2 x 2 | 3/16 | T6 | 48-00501-023 |
| | 1/4 | T6 | -024 |
| 2-1/2 x 2-1/2 | 3/16 | T6 | -025 |
| | 1/4 | T6 | -026 |
| | 3/8 | T6 | -027 |
| 3 x 2 | 3/16 | T6 | -028 |
| | 1/4 | T6 | -029 |
| | 3/8 | T6 | -030 |
| 3 x 2-1/2 | 1/4 | T6 | -031 |
| 3 x 3 | 3/16 | T6 | -032 |
| | 1/4 | T6 | -033 |
| | 5/16 | T6 | -034 |
| | 3/8 | T6 | -035 |
| | 1/2 | T6 | -036 |
| 3-1/2 x 2-1/2 | 1/4 | T6 | -037 |
| 3-1/2 x 3-1/2 | 1/4 | T6 | -038 |
| | 3/8 | T6 | -039 |
| | 1/2 | T6 | -040 |
| 4 x 3 | 1/4 | T6 | -041 |
| | 3/8 | T6 | -042 |
| 4 x 4 | 1/4 | T6 | -043 |
| | 3/8 | T6 | -044 |
| | 1/2 | T6 | -045 |
| | 5/16 | T6 | -046 |
| B 3/4 x 1 | 1/8 | T6 | -047 |
| B 1 x 1 | 1/16 | T6 | -048 |
| C 2 x 2 | 1/4 | T6 | -049 |
| 3-1/2 x 3-1/2 | 5/16 | T6 | -050 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | RLR | 6-22-71 | Added Note 2 and sheet 2 |
| B | RWG | 9-10-71 | Added dash numbers |
| C | RJR | 12-7-71 | Added -049 (Tol. No. 84030) |
| D | RJR | 7-25-73 | Added -050; J #A0508 |

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| COMPILED | RWG | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | [illegible] | 4-27-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

B

48-00501

Materials Specification

| PRINT ISSUED | TITLE | PART NO |
|---|---|---|
| 9-23-71 | ANGLE, ALUMINUM 6061<br>AMERICAN STANDARD | 48-00501 |
| LAST CHG LTR D | | SHEET 2 OF 2 |

## SPECIFICATIONS

1. Angle herein described shall meet applicable provisions of ASTM B308-68.

2. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. K.S.I. | YIELD K.S.I. | ELONGATION % IN 2 INCHES |
| T 6 | 38 | 35 | 8 - 10* |

*Varies with Thickness or Size

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | RLR | 6-22-71 | Added Note 2 and Sht 2 |
| B | RWG | 9-10-71 | Added dash numbers |
| C | HJR | 12-7-71 | See Sheet 1 (Dr. No. Change) |
| D | HJR | 7-25-73 | See Sht. 1; J #A0508 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

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| | | | | | |
|---|---|---|---|---|---|
| COMPILED | RLR | DATE DRAWN | | | UNIT OF MEASURE |
| APPROVED | | 6-22-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

B

E-183

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | ANGLE, ALUMINUM 6063<br>SHARP CORNER | 48-00502 |
| LAST CHG. LTR. E | | SHEET 1 OF 1 |

SCOPE This specification identifies 6063 sharp corner aluminum angle.

APPLICATION Decorative, corrosion resistant applications

SKETCH



SPECIFICATION NUMBERS

| SIZE | THK. | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| 1/2 x 1/2 | 1/16 | T52 | 48-00502-000 |
| | 1/8 | | -001 |
| 5/8 x 5/8 | 1/8 | | -002 |
| 3/4 x 3/8 | 1/16 | | -003 |
| 3/4 x 3/4 | 1/16 | | -004 |
| | 1/8 | | -005 |
| 1 x 1/2 | 3/32 | | -006 |
| | 1/8 | | -007 |
| 1 x 3/4 | 1/8 | | -008 |
| 1 x 1 | 1/16 | | -009 |
| | 1/8 | | -010 |
| | 3/8 | | -011 |
| 1-1/4 x 1/2 | 1/8 | | -012 |
| 1-1/4 x 1-1/4 | 1/8 | | -013 |
| | 3/16 | | -014 |
| 1-1/2 x 3/4 | 1/8 | | -015 |
| 1-1/2 x 1 | 1/8 | | -016 |
| 1-1/2 x 1-1/2 | 1/8 | | -017 |
| | 3/16 | | -018 |
| 1-3/4 x 1-3/4 | 1/8 | | -019 |
| 2 x 1 | 1/8 | | -020 |
| 2 x 1-1/2 | 1/8 | | -021 |
| 2 x 2 | 1/8 | | -022 |
| | 3/16 | | -023 |
| | 1/4 | | -024 |
| 3-1/2 x 1-1/4 | 1/8 | | -025 |
| 2 x 1 | 3/16 | | -026 |
| 1-1/2 x 1 | 3/16 | | -027 |

| SIZE | THK. | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| 1/2 x 1/2 | 1/16 | -0 | 48-00502-100 |
| | 1/8 | | -101 |
| 5/8 x 5/8 | 1/8 | | -102 |
| 3/4 x 3/8 | 1/16 | | -103 |
| 3/4 x 3/4 | 1/16 | | -104 |
| | 1/8 | | -105 |
| 1 x 1/2 | 3/32 | | -106 |
| | 1/8 | | -107 |
| 1 x 3/4 | 1/8 | | -108 |
| 1 x 1 | 1/16 | | -109 |
| | 1/8 | | -110 |
| | 3/8 | | -111 |
| 1-1/4 x 1/2 | 1/8 | | -112 |
| 1-1/4 x 1-1/4 | 1/8 | | -113 |
| | 3/16 | | -114 |
| 1-1/2 x 3/4 | 1/8 | | -115 |
| 1-1/2 x 1 | 1/8 | | -116 |
| 1-1/2 x 1-1/2 | 1/8 | | -117 |
| | 3/16 | | -118 |
| 1-3/4 x 1-3/4 | 1/8 | | -119 |
| 2 x 1 | 1/8 | | -120 |
| 2 x 1-1/2 | 1/8 | | -121 |
| 2 x 2 | 1/8 | | -122 |
| | 3/16 | | -123 |
| | 1/4 | | -124 |
| 3-1/2 x 1-1/4 | 1/8 | | -125 |
| 2 x 1 | 3/16 | | -126 |
| 1-1/2 x 1 | 3/16 | | -127 |

SPECIFICATIONS

1. Angle herein described shall meet applicable provisions of ASTM B221-69.
2. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. K.S.I. | YIELD K.S.I. | ELONGATION % IN 2 INCHES |
| T52 | 22 | 16 | 8 |
| -0 | 19 | - | 18 |

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | HJR | 7-19-72 | | | FT. |
| APPROVED | Rollins | | | | |

FREIGHTLINER CORPORATION

Portland Oregon 97208

| CHG | BY | DATE | WAS JOB NO |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS JOB NO |
|---|---|---|---|
| D | HJR | 7-19-72 | Add -0 Temper Series; Retype 72890 |
| E | HJR | 5-10-76 | Add -027, -127 A0815 |

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48-00503

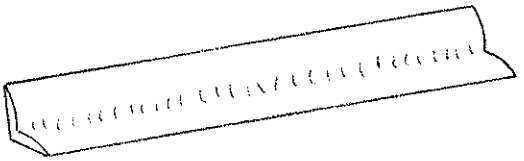
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-23-71 | ANGLE, ALUMINUM<br>AMERICAN STANDARD, 5052 | 48-00503 |
| LAST CHG LTR | | SHEET 1 OF 1 |

SCOPE This specification identifies 5052 American Standard aluminum angle.

APPLICATION Good corrosion resistance and formability.

SKETCH



SPECIFICATION NUMBERS

| SIZE | THICK | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| 2 x 1-1/2 | 1/4 | H32 | 48-00503-001 |
| 3 x 2 | | | -002 |

SPECIFICATIONS

1. Angle is not readily available in 5052 alloy and mechanical properties are not available.

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | RWG | 9-10-71 | | | FT. |
| APPROVED | | | | | |

Portland FREIGHTLINER CORPORATION Oregon 97208

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

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E-183

Materials Specification

| PRINT ISSUED | TITLE | PART NO |
|---|---|---|
| 6/8/71 | EXTRUSION, ZEE (UPHOLSTERY STRIP) | 48-00526 |
| LAST CHG LTR: A | | SHEET 1 OF 1 |

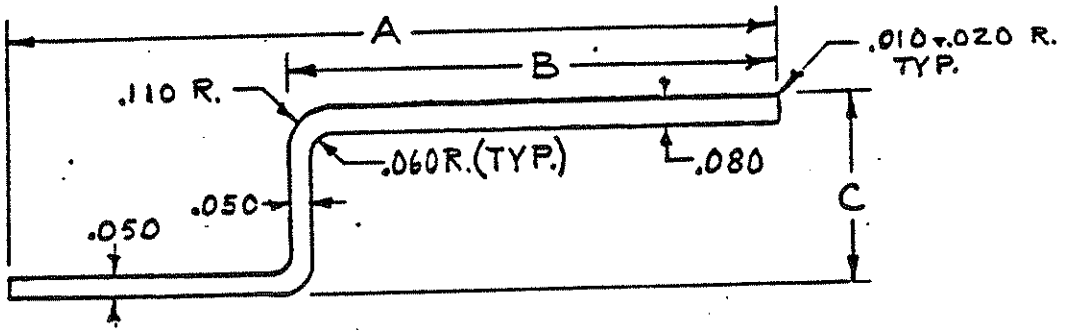
| CHG | BY | DATE | WAS | JOB NO. |
|---|---|---|---|---|
| | | | | |

| CHG | BY | DATE | WAS | JOB NO. |
|---|---|---|---|---|
| A | HJR | 5-21-76 | -010 Added | C0894 |

SCOPE This specification identifies the configuration of a particular light metal extrusion.

APPLICATION Especially used to support cab upholstery.

SKETCH




SPECIFICATION NUMBERS

| | A LENGTH | B FLANGE | C HEIGHT | MATERIAL (1) | WT LB/FT | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER ALU | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|
| | 2.340 | 1.440 | 0.620 | 6061-T5<br>6063-T5 | 0.220<br>0.220 | 51413<br>51413 | 187444<br>187444 | 48-00526-000 X •<br>-001 |
| A | 1.875 | 1.068 | 1.000 | 6061-T5 or 6063-T5 | 0.212 | * | * | -010 X • |

* To be assigned.

SPECIFICATIONS

(1) Material: Aluminum (See table).

2. Finish: As extruded.

| | | | | | |
|---|---|---|---|---|---|
| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
| APPROVED | | 5-20-71 | | | FT. |

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E-183

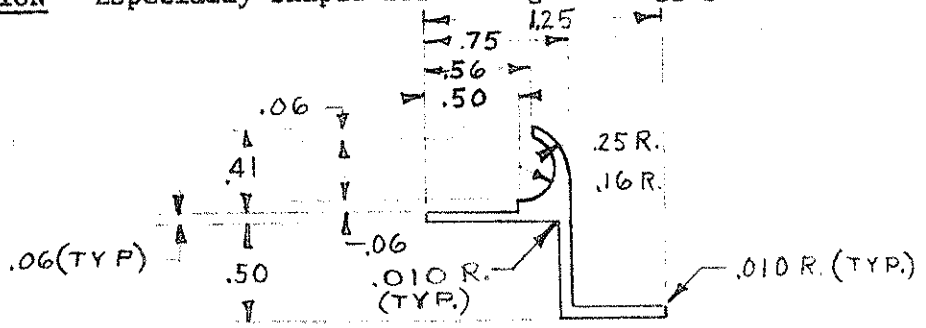
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6-8-71 | EXTRUSION, ANGLE TEE (BAGGAGE DOOR FRAME) | 48-00527 |
| LAST CHG. LTR | | SHEET 1 OF 1 |

**SCOPE** This specification identifies a particular light metal extrusion.

**APPLICATION** Especially shaped for making the baggage door frame.

**SKETCH**




**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER ALU | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|
| | 6063-T42 | 0.185 | 50752 | 189884 | 48-00527-000 |

**SPECIFICATIONS**

(1) Material: Aluminum (See table)

2. Finish: As extruded

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

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| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 5-20-71 | | | FT. |

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48-00528

Materials Specification

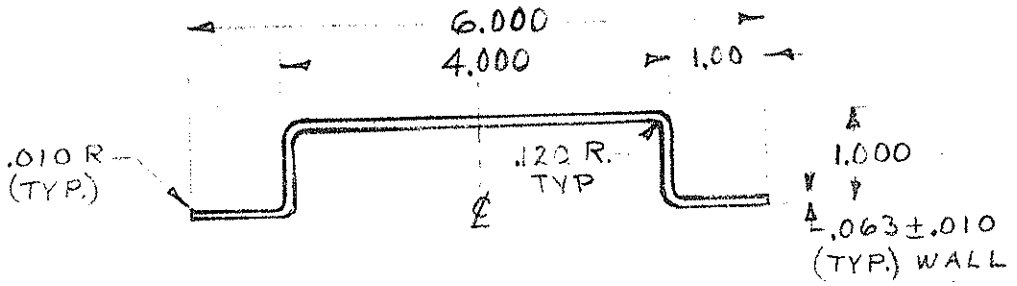
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, WINGED CHANNEL (CHANNEL, CAB BACK) | 48-00528 |
| LAST CHG. LTR. | | SHEET OF |

**SCOPE** This specification identifies a particular light metal extrusion.

**APPLICATION** General use flanged channel, used especially for inside back-of-cab reinforcement.

**SKETCH**

ALLOWABLE DEVIATION FROM FLAT, .006 IN. PER IN. OF WIDTH.




**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER ALU | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|
| | 6063-T5* | .575 | 50679 | 187504 | 48-00528-000 |

* Alternate: 5052-H32 Sheet, formed.

**SPECIFICATIONS**

(1) Material: Aluminum (see table)

2. Finish: As extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | HJR | 5-20-71 | | | FT. |
| APPROVED | | | | | |

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Portland FREIGHTLINER CORPORATION Oregon 97208

E-183

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

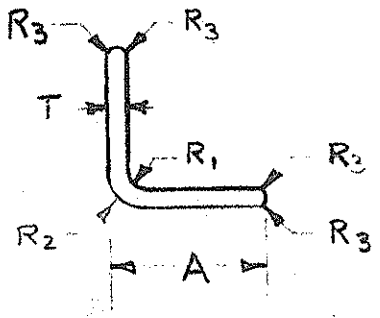
Materials Specification

| PRINT ISSUED | TITLE | PART NO |
|---|---|---|
| 6/9/71 | EXTRUSION, ANGLE EQUAL LEG | 48-00529 |
| LAST CHG LTR | | SHEET 1 OF 1 |

**SCOPE** This specification identifies equal leg angle light metal extrusions.

**APPLICATION** General; Cab nose stiffener, cab rear deck angle.

**SKETCH**




**SPECIFICATION NUMBERS**

| A | T | $R_1$ | $R_2$ | $R_3$ | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER ALU | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|---|
| .88 | 1/8 | .120 | .250 | .010 | 6063-T6 | .228 | 50751 | 187514 | 48-00529-001 |
| 2.00 | 1/8 | .010 | .010 | .010 | 6063-T5 | .572 | HA 091 | 79K | -002 |

**SPECIFICATIONS**

(1) Material: Aluminum (see table)

2. Finish: As extruded

COPY ONLY
ORIGINAL BEING REVISED
CHECKED OUT BY Hf Richards
DATE 4-1-74

| | | | | | | UNIT OF MEASURE |
|---|---|---|---|---|---|---|
| COMPILED | HJR | DATE DRAWN | | | | FT. |
| APPROVED | | 5-20-71 | | | | |

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Portland FREIGHTLINER CORPORATION Oregon 97208

E-183

WAS | DATE | BY | CHG

WAS | DATE | BY | CHG

48-00530

Materials Specification

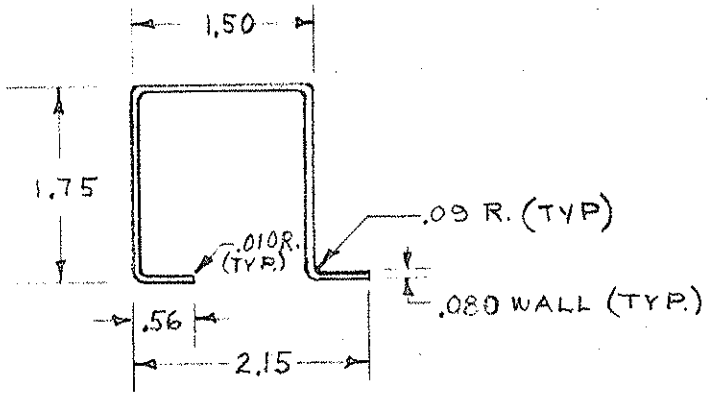
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, FLANGED CHANNEL (DOOR POST) | 48-00530 |
| LAST CHG LTR | | SHEET OF |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SCOPE** This specification identifies a specific light metal flanged channel extrusion.

**APPLICATION** A general use structural section used especially for cab door posts.

**SKETCH**




**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | | | KAC | ALU | |
| | 6063-T6 | .552 | 50682 | 187494 | 48-00530-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SPECIFICATIONS**

(1) Material: Aluminum (See Table)

2. Finish: As extruded

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| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | [signature] | 5-24-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, WINGED CHANNEL (DOOR FRAME BOTTOM CHANNEL) | 48-00531 |
| LAST CHG LTR. A | | SHEET 1 OF 1 |

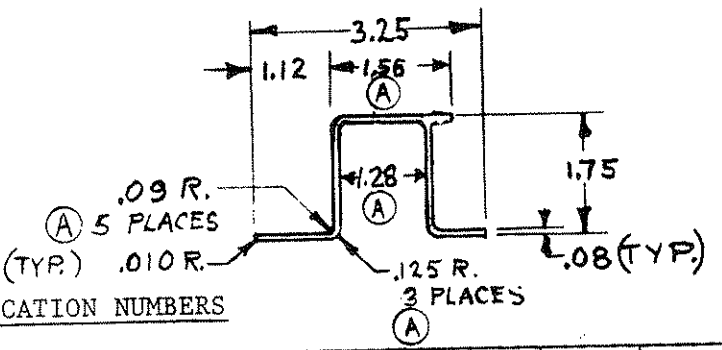
| CHG | BY | DATE |
|---|---|---|
| WAS | | |

| CHG | BY | DATE |
|---|---|---|
| WAS 1.44 1.43 AND 1.28 C11988 | TC | 3/20/72 |
| A | | |

SCOPE This specification identifies a specific light metal flanged channel extrusion.

APPLICATION A general use structural section, especially used for the bottom portion of the frame of the cab door.

SKETCH




SPECIFICATION NUMBERS

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | | | KAC | ALU | |
| | 6063-T6 | .611 | 50603 | 187484 | 48-00531-000 |

SPECIFICATIONS

(1) Material: Aluminum (See table).

2. Finish: As extruded

| | | | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | HJR | DATE DRAWN | | | FT. |
| APPROVED | Rand | 5-25-71 | | | |

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48-00532

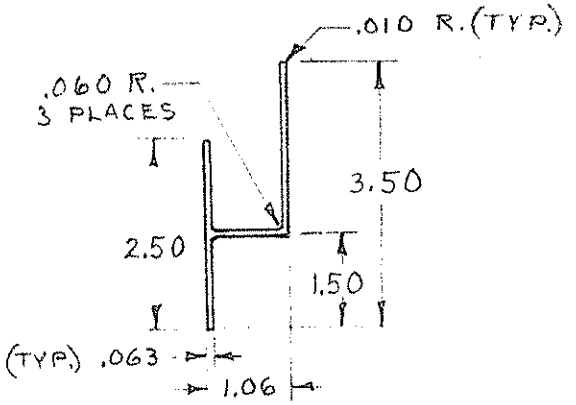
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, ANGLE TEE (CAB REAR TOP BEAM) | 48-00532 |
| LAST CHG LTR | | SHEET 1 OF 1 |

**SCOPE** This specification identifies a specific light metal angle tee extrusion.

**APPLICATION** Used especially for the cab rear top beam.

**SKETCH**




**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | | | KAC | ALU | |
| | 6063-T5 | .414 | 50871 | 187474 | 48-00532-000 |

**SPECIFICATIONS**

(1) Material: (See table above)

2. Finish: As extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | HJR | | | | FT. |
| APPROVED | | 5-25-71 | | | |

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E-183

WAS | CHG | BY | DATE

WAS | CHG | BY | DATE

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Materials Specification

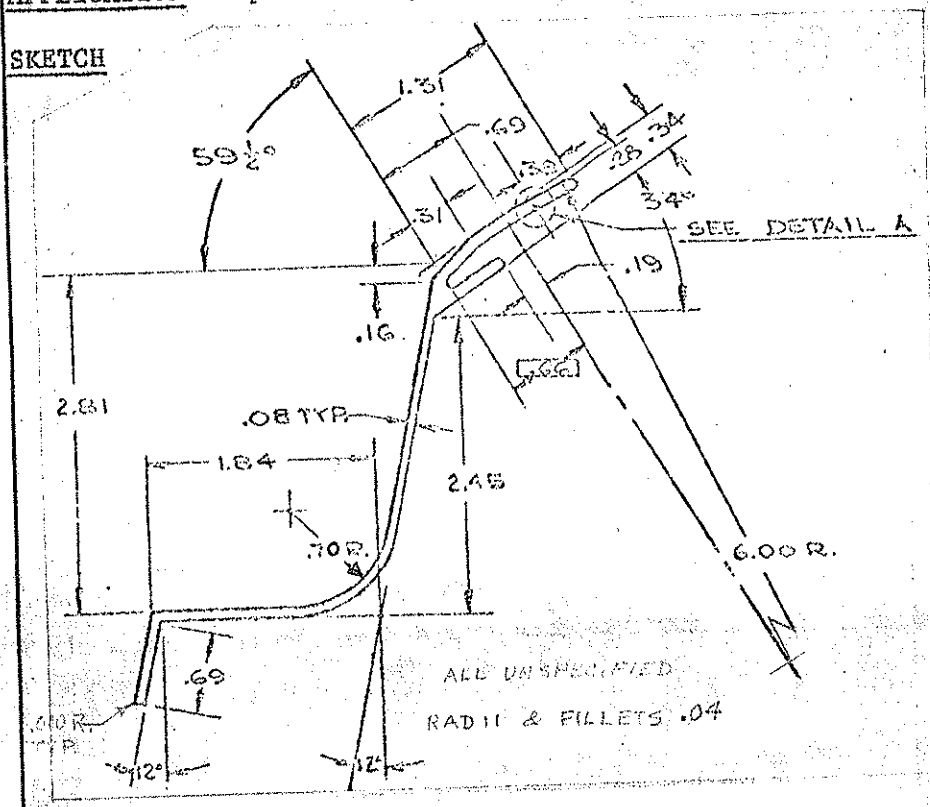
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, WINDSHIELD HEADER | 48-00533 |
| LAST CHG LTR. | | SHEET 1 OF 1 |

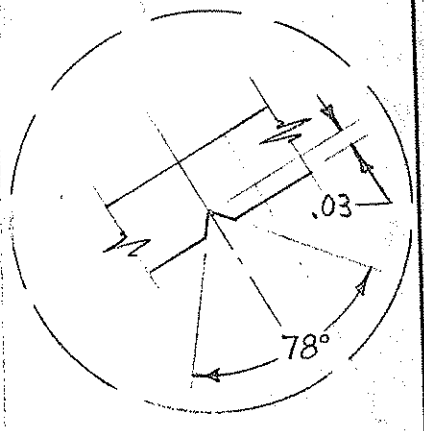
| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

**SCOPE** This specification identifies a specific light metal extrusion.

**APPLICATION** Specifically for windshield header use.

**SKETCH**




DETAIL A

**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | | | KAC | ALU | |
| | 6063-T5 | .698 | 50872 | 187434 | 48-00533-000 |

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

**SPECIFICATIONS**

(1) Material: Aluminum (See table)

2. Finish: As extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | HJR | 5-25-71 | | | FT. |
| APPROVED | | | | | |

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Portland FREIGHTLINER CORPORATION Oregon 97208

8-00534

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, VALVE BODY (CYCLOMATIC VALVE BODY) | 48-00534 |
| LAST CHG. LTR. E | | SHEET 1 OF 1 |

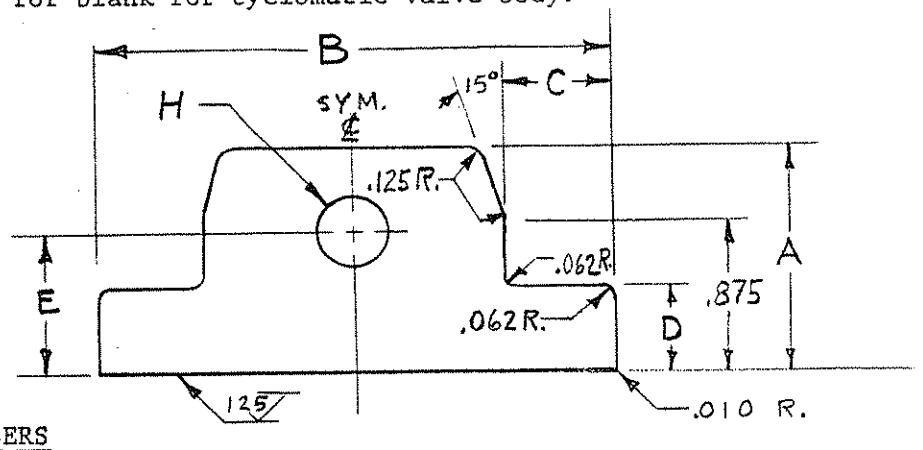
| CHG | BY | DATE | WAS |
|---|---|---|---|
| C | HJR | 12-11-74 | 6062; delete hole C0382 |
| D | DL | 1-27-75 | -001 to X A0731 |
| E | LD | 1-8-80 | 6062-T6 TO 6061-T6 92852 |
| | | | NORMO |

SCOPE This specification identifies a specific light metal extrusion.

APPLICATION Used for blank for cyclomatic valve body.

SKETCH

SCALE: None




SPECIFICATION NUMBERS

| A | B | C | D | E | H HOLE DIA. | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER ALU | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|---|---|---|---|---|
| 1.312 | 3.000 | .625 | .500 | | NONE | 6061-T6 | 3.439 | 50683 | 155084 | 48-00534-000 E |
| 1.188 | 2.500 | .813 | .375 | | NONE | 2014-T6 | 1.97 | | | -001 |

SPECIFICATIONS

(1) Material: Aluminum (See table)

2. Finish: As extruded

| STATUS | SPECIFICATION NUMBER |
|---|---|
| C | 48-00534-000 |
| X | 48-00534-001 |

D

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | HJR | 10-12-74 | Add die no. ALU, reconcile dims. w/actual; J #60170 |
| B | HJR | 9-11-74 | Add -001; I#C0382 |

ns

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 5-25-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

E D

48-00535

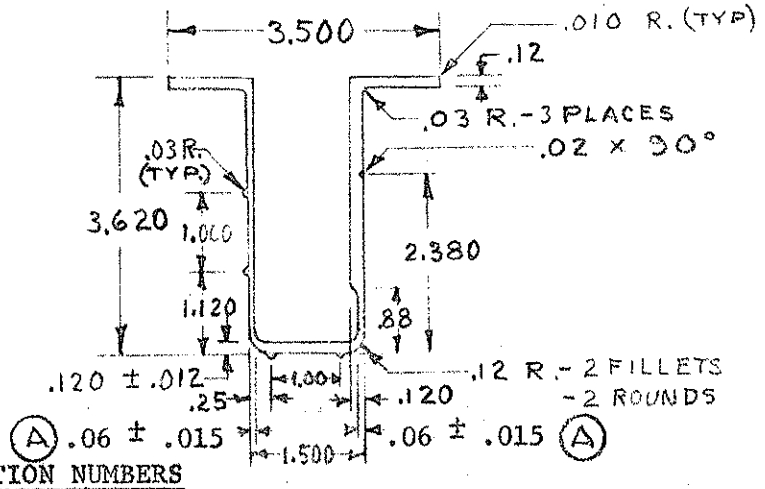
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/8/71 | EXTRUSION, WINGED CHANNEL (CURTAIN BOW) | 48-00535 |
| LAST CHG LTR: A | | SHEET 1 OF 1 |

**SCOPE** This specification identifies a specific light metal extrusion.

**APPLICATION** Especially used for roof reinforcement and curtain bow for cab sleeper compartment.

**SKETCH**




$I_x = 1.93$ IN.$^4$

**SPECIFICATION NUMBERS**

| | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | | | KAC | ALU | |
| | 6063-T5 | 1.25 | 50748 | 187454 | 48-00535-000 |

**SPECIFICATIONS**

(1) Material: Aluminum (See table)

2. Finish: As extruded

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | DL | 3-9-73 | Was ± .006 Tir A0162 |

ns

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 5-25-71 | | | FT. |

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E-183

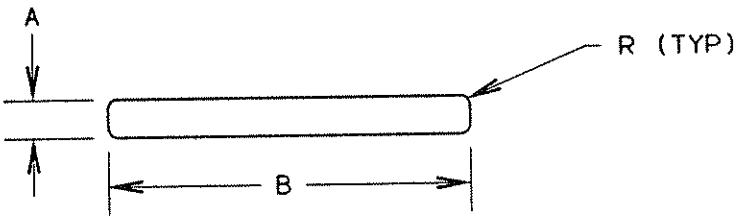
| DRAWN | JKB | TITLE | DRAWING NUMBER |
|---|---|---|---|
| APPRV | TAL | EXTRUSION, FLAT BAR ALUMINUM | 48-00536 |
| DATE | 01-19-88 | FREIGHTLINER CORPORATION PORTLAND, OREGON | SHEET 1 OF 1 / CHG. LTR. G |
| CADAM ORIGINAL | | | |

UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES | UNIT OF MEASURE: LB.

SCOPE: THIS SPECIFICATION IDENTIFIES A SERIES OF SOLID, RECTANGULAR SECTION, LIGHT METAL EXTRUSIONS.

APPLICATION: GENERAL USE AS BAR AND FLAT. NARROW BAR FOR CAB LATCH LINKAGE, ETC.; WIDE FLAT AS AXLE SPRING SPACERS.

SKETCH:




SPECIFICATION NUMBERS:

| A | B | R | AREA (IN.)² | MATERIAL (1) | WT. LB/FT | EXTRUSION DIE # KAC | EXTRUSION DIE # ALU | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|---|---|---|
| 9/16 | 3/4 | .060 | .422 | 6061-T4 | 0.505 | 50749 | 187464 | 48-00536-001 |
| 1-1/2 | 3-1/4 | .010 | 4.88 | 6063-T5 | 5.85 | HK880 | STD.DIE | 48-00536-002 |
| 1 | 3-1/4 | .010 | 3.25 | 6063-T5 | 3.90 | HK864 | STD.DIE | 48-00536-003 |
| 1/2 | 3-1/4 | ----- | 1.62 | 5052-H32 | 1.94 | SHEARED PLATE | | 48-00536-004 * |
| 9/16 | 3/4 | .010 | .422 | 6061-T6 | 0.505 | 50749 | 187464 | 48-00536-005 |
| 2 | 3-1/4 | .010 | 6.50 | 6063-T5 | 7.800 | HK700 | STD.DIE | 48-00536-006 |
| 2-1/2 | 3-1/4 | .010 | 8.12 | 6063-T5 | 9.749 | HK835 | STD.DIE | 48-00536-007 |
| 3/16 | 4-1/4 | FULL | .789 | 6063-T6 | .927 | | | 48-00536-008 ** (4) |
| 3/16 | 1-1/4 | FULL | .227 | 6063-T6 | .273 | | | 48-00536-009 ** (4) |
| 1 | 4 | .010 | 4.00 | 6061-T6 | 4.800 | | | 48-00536-010 |
| 1-1/4 | 4 | .010 | 5.00 | 6061-T6 | 6.000 | | | 48-00536-011 |
| (G) 3/16 | 3-5/8 | FULL | .590 | 6063-T6 | .687 | | | 48-00536-012 |

* USE 48-00176-011 SHEARED TO WIDTH.
** ANODIZING INC. DIE #6028 (FOR-008), #6027 (FOR-009)

SPECIFICATIONS

(1) MATERIAL: ALUMINUM (SEE TABLE)

2. FINISH: AS EXTRUDED

3. EXTRUSION HEREIN DESCRIBED SHALL MEET THE LATEST PROVISIONS OF ASTM B221.

(4) MUST MEET STANDARDS FOR COSMETIC NON-PAINTED PARTS.

| CHG | JOB NO | DATE | BY | REVISION |
|---|---|---|---|---|
| G | PH0278 | 01-19-88 | JKB | REVISED & REDRAWN ON CADAM; ADDED -012 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

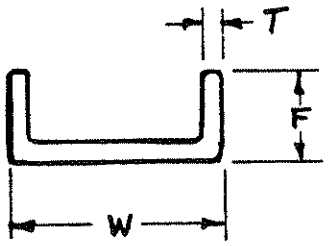
Materials Specification

| PRINT ISSUED | | TITLE | PART NO. |
|---|---|---|---|
| | | EXTRUSION, CHANNEL ALUMINUM | 48-00537 |
| LAST CHG LTR | F | | SHEET 1 OF 1 |

SCOPE This specification describes extruded aluminum alloy channel sections.

APPLICATION General structural section.

SKETCH




SPECIFICATION NUMBERS (D)

| WIDTH W | DEPTH F | SECTION THICKNESS T | MATERIAL (1) | DIE NUMBER RYN | DIE NUMBER ALU | DIE NUMBER PFM | WT. LBS/FT | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|
| 0.50 | .38 | .125 | 6063-T52 | 7892 | 2335 | | .147 | 48-00537- |
| 0.75 | .75 | .125 | 6063-T52 | | 3547 | | .292 | - |
| 1.00 | 1.00 | .125 | 6063-T52 | | 7484 | | .401 | -100 |
| 1.25 | .50 | .125 | 6063-T52 | 3824 | 4286 | | .292 | 7P-125 |
| 1.50 | .50 | .125 | 6063-T52 | | | 4300 | .328 | 7E-150 |
| 1.75 | 1.00 | .156 | 6061-T6 | 10383 | 5714 | | .628 | - |
| 2.00 | 1.25 | .125 | 6061-T6 | 9516 | | | .622 | - |

SPECIFICATIONS

(1) Material: Aluminum (See Table)

2. Finish: As Extruded.

(D)

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 4-27-73 | | | LBS. |

Portland FREIGHTLINER CORPORATION Oregon 97208

| CHG | BY | DATE | WAS |
|---|---|---|---|
| D1 | TTR | 03-31-82 | Add WT.-LBS/FT; From |
| D2 | TTR | 03-31-82 | FT. To LBS.;J# 2767B |
| E | FHF | 03-04-87 | -100,-125,-150 to T52 #4279C |
| F | ERK | 11/28/88 | RMVD. INACTIVE MTLS. P*A078-87 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | HJR | 4-27-73 | Add ALU Nos; -050, -0, dash nos; J #00040 |
| B | DL | 3-22-74 | Add -100 J# A0591 |
| C | HJR | 4-19-74 | Add -150; J#A0607 |

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E-183

48-00538

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | EXTRUSION, PEG<br>EQUALIZER STOP, ALUMINUM | 48-00538 |
| LAST CHG LTR: B | | SHEET 1 OF 1 |

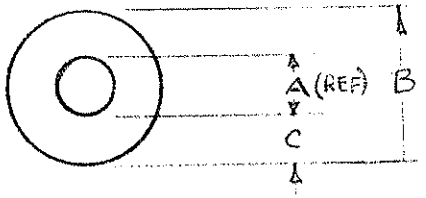
| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| B | HJR | 5-14-73 | Revised & Retyped; J #A0401 |

SCOPE This specification identifies a round tube section aluminum extrusion.

APPLICATION General use as a spacer or stop. Specifically used as an equalizer stop.

SKETCH




SPECIFICATION NUMBERS

| INSIDE DIAMETER A (REF) | OUTSIDE DIAMETER B | WALL C | MATERIAL (1) | EXTRUSION DIE NUMBER RYN | EXTRUSION DIE NUMBER KAC | EXTRUSION DIE NUMBER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|
| .810 | 1.750 | .470 | 6063-T6 | HR-5109 | | | 48-00538-000 |
| .690 | 1.500 | .405 | 6061-T6 | | HP 576 | | -001 |

SPECIFICATIONS

(1) Material: Aluminum (See Table)

2. Finish: As extruded.

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 5-14-73 | | | FT. |

ns

Portland FREIGHTLINER CORPORATION Oregon 97208

48-00539

Materials Specification

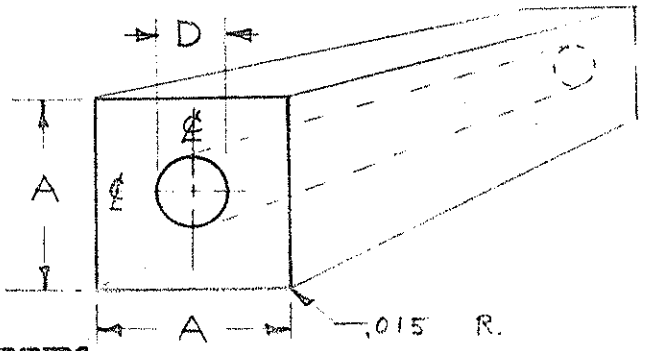
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-1-71 | EXTRUSION, HOLLOW SQUARE BAR (AIR JUNCTION BLOCK) | 48-00539 |
| LAST CHG LTR. | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SCOPE** This specification identifies a light metal extrusion.

**APPLICATION** Fluid manifold.

**SKETCH**




**SPECIFICATION NUMBERS**

| A | B | D | MATERIAL (1) | DIE NUMBERS PAC | DIE NUMBERS | WEIGHT LB/FT. | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|---|---|
| .750 | .750 | 0.339 | 6063-T6 | 185743 | | 0.348 | 48-00539-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SPECIFICATIONS**

(1) Material: Aluminum (See Table)

2. Finish: As Extruded

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 8-17-71 | | | LB. |

ns

Portland FREIGHTLINER CORPORATION Oregon 97208

48-00540

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-17-71 | TEE, ALUMINUM, SHARP CORNER, 5052 | 48-00540 |
| LAST CHG. LTR | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SCOPE** This specification identifies sharp corner aluminum tee section in the 5052 alloy.

**APPLICATION** Good corrosion resistance.

**SKETCH**



**SPECIFICATION NUMBERS**

| FLANGE WIDTH | STEM DEPTH | SECTION THICKNESS | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|
| 3/4 | 3/4 | 1/8 | H32 | 48-00540-000 |
| 7/8 | 1-1/4 | 1/8 | | -001 |
| 1 | 3/4 | 1/8 | | -002 |
| 1 | 1 | 1/8 | | -003 |
| 1-1/4 | 7/8 | 1/8 | | -004 |
| 2 | 3/4 | 1/8 | | -005 |
| 2 | 2 | 1/4 | | -006 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

**SPECIFICATIONS**

1. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. KSI | YIELD KSI | ELONGATION % IN 2 INCHES |
| H32 | 31 | 23 | 4 - 12 |

ns

| COMPILED | RLR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 8-27-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

48-0

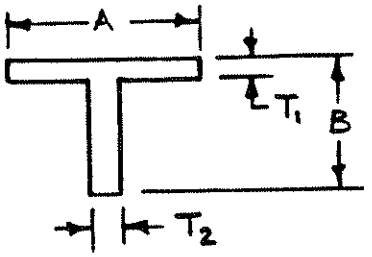
| | | | |
|---|---|---|---|
| 9/17/71 | TEE, ALUMINUM, SHARP CORNER, 6063 | | |
| LAST CHG LTR D | | | SHEET 1 OF 1 |

SCOPE This specification identifies sharp corner aluminum tee section in 6063 alloy.

APPLICATION Good formability, weldability, corrosion resistance and strength after heat treatment.

SKETCH






SPECIFICATION NUMBERS (A)

| FLANGE WIDTH A | STEM DEPTH B | SECTION THICKNESS T1 | SECTION THICKNESS T2 | TEMPER | WT. LBS/FT. | DIE NUMBER ALU | DIE NUMBER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|
| 3/4 | 3/4 | 1/8 | | T52 | .0167 | | | 48-00541- |
| 7/8 | 1-1/4 | 1/8 | | | .0243 | | | - |
| 1 | 3/4 | 1/8 | | | .0198 | | | -002 |
| 1 | 1 | 1/8 | | | .0228 | | | - |
| 1-1/4 | 7/8 | 1/8 | | | .0243 | | | -004 |
| 2 | 3/4 | 1/8 | | | .0319 | | | - |
| 2 | 2 | 1/4 | | | .0912 | | | - |
| 3/4 | 3/4 | 1/8 | | T6 | .0167 | | | - |
| 7/8 | 1-1/4 | 1/8 | | | .0243 | | | - |
| 1 | 3/4 | 1/8 | | | .0198 | | | - |
| 1 | 1 | 1/8 | | | .0228 | | | - |
| 1-1/4 | 7/8 | 1/8 | | | .0243 | | | - |
| 2 | 3/4 | 1/8 | | | .0319 | | | - |
| 2 | 2 | 1/4 | | | .0912 | | | - |
| 1 | 1/2 | 1/8 | 3/8 | T52 | .0258 | 1257 | | -301 |

SPECIFICATIONS

1. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. KSI | YIELD KSI | ELONGATION % IN 2 INCHES |
| T5, T52 | 22 - 30 | 16-25 | 8 |
| T6 | 30 | 25 | 8 |

(A)

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | RLR | 8-27-71 | | | LBS. |
| APPROVED | | | | | |

Portland FREIGHTLINER CORPORATION Oregon 97208

CB

| CHG | BY | DATE | WAS |
|---|---|---|---|
| C2 | FHF | 3-04-87 | Rev. Mech. Prop. |
| D | EEK | 09/07/85 | #4279C |
| | | | PA 2006-10 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | HJR | 10-16-73 | Add -301; J#D0513 |
| B1 | TTR | 03-31-82 | Add WT.-LBS/FT; From |
| B2 | TTR | 03-31-82 | FT. To LBS.; J# 2767B |
| C1 | FHF | 03-04-87 | -000 thru -006 to T52 |

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E-189

Materials Specification

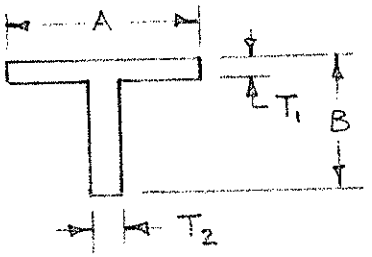
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9/17/71 | TEE, ALUMINUM, SHARP CORNER, 6063 | 48-00541 |
| LAST CHG LTR: A | | SHEET 1 OF 1 |

**SCOPE** This specification identifies sharp corner aluminum tee section in 6063 alloy.

**APPLICATION** Good formability, weldability, corrosion resistance and strength after heat treatment.

**SKETCH**






**SPECIFICATION NUMBERS**

| FLANGE WIDTH A | STEM DEPTH B | SECTION THICKNESS T1 | SECTION THICKNESS T2 | TEMPER | | DIE NUMBER ALU | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|
| 3/4 | 3/4 | 1/8 | | T5 | | | | 48-00541-000 |
| 7/8 | 1-1/4 | 1/8 | | | | | | -001 |
| 1 | 3/4 | 1/8 | | | | | | -002 |
| 1 | 1 | 1/8 | | | | | | -003 |
| 1-1/4 | 7/8 | 1/8 | | | | | | -004 |
| 2 | 3/4 | 1/8 | | | | | | -005 |
| 2 | 2 | 1/4 | | | | | | -006 |
| 3/4 | 3/4 | 1/8 | | T6 | | | | -107 |
| 7/8 | 1-1/4 | 1/8 | | | | | | -108 |
| 1 | 3/4 | 1/8 | | | | | | -109 |
| 1 | 1 | 1/8 | | | | | | -110 |
| 1-1/4 | 7/8 | 1/8 | | | | | | -111 |
| 2 | 3/4 | 1/8 | | | | | | -112 |
| 2 | 2 | 1/4 | | | | | | -113 |
| A 1 | 1/2 | 1/8 | 3/8 | T52 | | 1257 | | -301 |

**SPECIFICATIONS**

1. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. KSI | YIELD KSI | ELONGATION % IN 2 INCHES |
| T5,T52 | 21 - 22 | 15-16 | 8 - 10 |
| T6 | 30 | 25 | 8 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| A | RJR | 10-16-73 | Add -301; J#D0513 |

| COMPILED | RLR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 8-27-71 | | | FT. |

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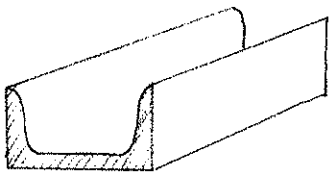
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-17-71 | CHANNEL, ALUMINUM, AMERICAN STD, 6061 | 48-00542 |
| LAST CHG LTR. | | SHEET 1 OF 1 |

**SCOPE** This specification identifies American Std aluminum channel in the 6061 alloy.

**APPLICATION** Good formability, weldability, corrosion resistance, and strength after heat treatment.

**SKETCH**



**SPECIFICATION NUMBERS**

| WEB (INCHES) | FLANGE (INCHES) | SECTION THICKNESS (@ WEB) | TEMPER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|
| 2-1/2 | 2.00 | .188 | T6 | 48-00542-000 |
| 3 | 1.41 | .170 | | -001 |
| | 1.498 | .258 | | -002 |
| | 1.596 | .356 | | -003 |
| 4 | 1.58 | .180 | | -004 |
| | 1.65 | .247 | | -005 |
| | 1.72 | .320 | | -006 |
| | 2.00 | .215 | | -007 |
| | 2.50 | .318 | | -008 |
| 5 | 1.75 | .190 | | -009 |
| | 1.89 | .325 | | -010 |
| | 1.92 | .200 | | -011 |
| | 1.95 | .225 | | -012 |

**SPECIFICATIONS**

1. Mechanical Properties:

| TEMPER | MINIMUM PROPERTIES | | |
|---|---|---|---|
| | TENSILE ULT. KSI | YIELD KSI | ELONGATION % IN 2 INCHES |
| T6 | 38 | 35 | 10 |

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

ns

| COMPILED | RLR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 8-27-71 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

Materials Specification

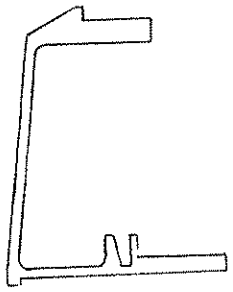
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-23-71 | DOOR FRAME EXTRUSION<br>HALF CAB | 48-00543 |
| LAST CHG. LTR. | | SHEET 1 OF 1 |

WAS / DATE / BY / CHG

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Specifically used in the Half Cab door frame assembly.

SKETCH



SPECIFICATION NUMBERS

| | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| | | ALU | |
| | | 130184 | 48-00543-000 |

WAS / DATE / BY / CHG

SPECIFICATIONS

1. Material: 6063-T6 Aluminum
2. Finish: As Extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | RWC | 9-10-71 | | | FT. |
| APPROVED | | | | | |

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Portland FREIGHTLINER CORPORATION Oregon 97208

Materials Specification

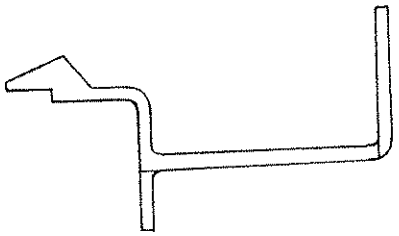
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-23-71 | GARNISH MOULDING, HALF CAB | 48-00544 |
| LAST CHG LTR | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Specifically used as a half cab lower rear door frame garnish moulding.

SKETCH



SPECIFICATION NUMBERS

| | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| | | ALU | |
| | | 130194 | 48-00544-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SPECIFICATIONS

1. Material: 6063-T5 Aluminum
2. Finish: As Extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | RWG | 9-10-71 | | | FT. |
| APPROVED | | | | | |

ns

Portland FREIGHTLINER CORPORATION Oregon 97208

48-00545

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 9-23-71 | RAIL, BUNK END, R.H. | 48-00545 |
| LAST CHG LTR | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Specifically used as a R.H. bunk end rail.

SKETCH



SPECIFICATION NUMBERS

| EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|
| | ALU | |
| | 4477 | 48-00545-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SPECIFICATIONS

1. Material:
2. Finish: As Extruded

| | | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| COMPILED | RWG | 9-10-71 | | | FT. |
| APPROVED | | | | | |

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Portland FREIGHTLINER CORPORATION Oregon 97208

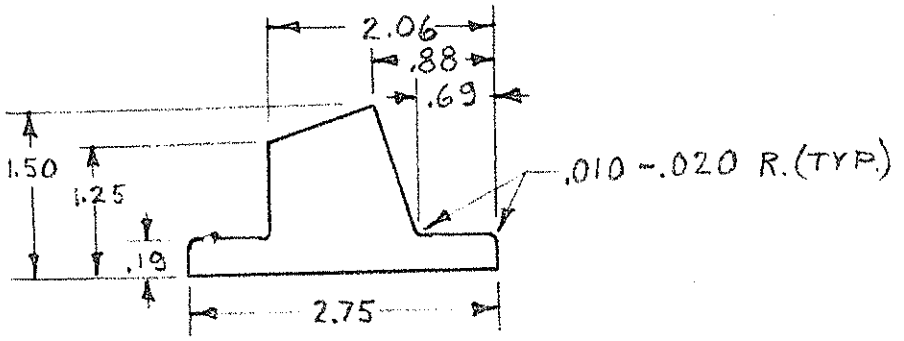
Materials Specification

| PRINT ISSUED | | TITLE | PART NO. |
|---|---|---|---|
| | | EXTRUSION, JUNCTION BLOCK (FLANGED) | 48-00546 |
| LAST CHG LTR | | | SHEET 1 OF 1 |

SCOPE This specification describes an extruded light metal section.

APPLICATION Fluid junction block.

SKETCH




SPECIFICATION NUMBERS

| | MATERIAL (1) | DIE NUMBERS ALU | | WT LB/FT | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| | 6061-T6 | 185644 | | 2.419 | 48-00546-000 |

SPECIFICATIONS

(1) Material: Aluminum (See table)

Finish: As Cast

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

| WAS | DATE | BY | CHG |
|---|---|---|---|
| | | | |

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 12-7-71 | | | FT. |

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Portland FREIGHTLINER CORPORATION Oregon 97208

48-00547

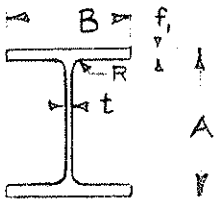
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | I-BEAM, ALUMINUM 6061 (ALUM. ASSOC. STD) | 48-00547 |
| LAST CHG LTR | | SHEET 1 OF 1 |

SCOPE This specification describes Aluminum Association Standard I-Beam.

APPLICATION General structural use.

SKETCH




SPECIFICATION NUMBERS

| DEPTH A IN. | WIDTH B IN. | AREA * IN.$^2$ | WEIGHT ** LB/FT. | FLANGE THK. $f_1$ IN. | WEB THK. t IN. | FILLET RADIUS R IN. | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|---|---|---|
| 3.00 | 2.50 | 1.392 | 1.637 | 0.20 | 0.13 | 0.25 | | 48-00547-031 |
| 3.00 | 2.50 | 1.726 | 2.030 | 0.26 | 0.15 | 0.25 | | -032 |
| 4.00 | 3.00 | 1.965 | 2.311 | 0.23 | 0.15 | 0.25 | | -041 |
| 4.00 | 3.00 | 2.375 | 2.793 | 0.29 | 0.17 | 0.25 | | -042 |
| 5.00 | 3.50 | 3.146 | 3.700 | 0.32 | 0.19 | 0.30 | | -051 |
| 6.00 | 4.00 | 3.427 | 4.030 | 0.29 | 0.19 | 0.30 | | -061 |
| 6.00 | 4.00 | 3.990 | 4.692 | 0.35 | 0.21 | 0.30 | | -062 |
| 7.00 | 4.50 | 4.932 | 5.800 | 0.38 | 0.23 | 0.30 | | -071 |
| 8.00 | 5.00 | 5.256 | 6.181 | 0.35 | 0.23 | 0.30 | | -081 |
| 8.00 | 5.00 | 5.972 | 7.023 | 0.41 | 0.25 | 0.30 | | -082 |
| 9.00 | 5.50 | 7.110 | 8.361 | 0.44 | 0.27 | 0.30 | | -091 |
| 10.00 | 6.00 | 7.352 | 8.646 | 0.41 | 0.25 | 0.40 | | -101 |
| 10.00 | 6.00 | 8.747 | 10.286 | 0.50 | 0.29 | 0.40 | | -102 |
| 12.00 | 7.00 | 9.925 | 11.672 | 0.47 | 0.29 | 0.40 | | -121 |
| 12.00 | 7.00 | 12.153 | 14.292 | 0.62 | 0.31 | 0.40 | | -122 |

* Areas listed are based on nominal dimensions.
** Weights per foot are based on nominal dimensions and a density of 0.098 pound per cubic inch which is the density of alloy 6061.

SPECIFICATIONS

1. Material: Alum 6061-T6

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| — | — | — | T #85160 |

ns

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 2-21-72 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

E-183

DRIENNE CHILBERG

| DRAWN | DAJ | TITLE | DRAWING NUMBER | |
|---|---|---|---|---|
| APPRV | DAJ | CHANNEL-AL, 6063<br>"C", SHARP CORNER | 48-00548 | |
| DATE | 02/16/98 | FREIGHTLINER CORPORATION<br>PORTLAND, OREGON | SHEET<br>1 OF 1 | CHG. LTR.<br>D |
| CATIA ORIGINAL | | | | |

Scope: This specification describes a sharp corner aluminum channel.

Application: Ornamental rather than structural, corrosion resistant, readily formable and among most readily weldable alloys.

| DEPTH WEB | WIDTH FLANGE | THICKNESS WEB & FLANGE | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| 3/4 | 3/4 | 1/8 | 48-00548-021 |
| 1-1/4 | 1/2 | 1/8 | 48-00548-110 |
| 1-1/4 | 1-1/4 | 1/8 | 48-00548-111 |
| 1-3/4 | 3/4 | 1/8 | 48-00548-130 |
| 2 | 1 | 1/8 | 48-00548-201 |
| 2-1/2 | 1-1/2 | 1/8 | 48-00548-220 |
| 1.53 | 1/2 | 1/8 | 48-00548-153 |

Engineering Notes:

1. Material: Aluminum, 6063-T52

3. Minimum Mechanical Properties:

| Minimum Properties | | |
|---|---|---|
| Tensile Ultimate (Ksi) | Yield (Ksi) | Elongation % in 2 inches |
| 22 | 16 | 8 |

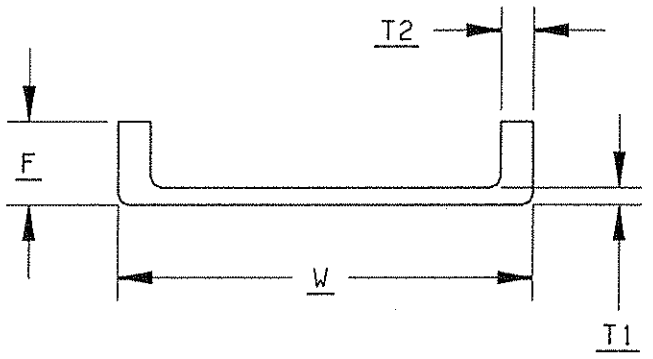
| CHG | JOB NO | DATE | BY | REVISION |
|---|---|---|---|---|
| D | PA2042-83 | 02/16/98 | DAJ | REVISED AND REDRAWN IN CATIA |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

ADRIENNE CHILBERG

| DRAWN | DAJ | TITLE | DRAWING NUMBER | |
|---|---|---|---|---|
| APPRV | DAJ | EXTR-CHANNEL ALUMINUM | 48-00549 | |
| DATE | 10/09/97 | | | |
| CATIA ORIGINAL | | FREIGHTLINER CORPORATION PORTLAND, OREGON | SHEET 1 OF 1 | CHG. LTR. A |

SCOPE: THIS SPECIFICATION IDENTIFIES A LIGHT METAL CHANNEL EXTRUSION.

APPLICATION: GENERAL STRUCTURAL USE




| W | F | T1 | T2 | MATERIAL | WEIGHT LB/FT | EXTRUSION DIE NUMBER | | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | | ALM | | | |
| 3.00 | 1.50 | .19 | .25 | 6351-T6 | 1.479 | 23010 | | | 48-00549-300 |
| 3.00 | 1.75 | .17 | .26 | 6061-T6 | 1.597 | | | | 48-00549-301 |

SPECIFICATIONS:

1. MATERIAL: SEE TABLE
2. FINISH: AS EXTRUDED

| CHG | JOB NO | DATE | BY | REVISION |
|---|---|---|---|---|
| A | P02047-13 | 10/09/97 | DAJ | REVISED AND REDRAWN IN CATIA. ADDED -301. |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

48-00550

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | CAP MOULDING, EXTRUSION | 48-00550 |
| LAST CHG LTR | | SHEET 1 OF 1 |

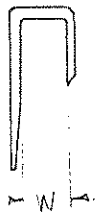
| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| - | - | - | J #60020 |

SCOPE This specification identifies a light metal panel edge moulding extrusion.

APPLICATION Edge trim for panels in cab interior.

SKETCH




SPECIFICATION NUMBERS

| W WIDTH (INCHES) | | MATERIAL (1) | EXTRUSION DIE NUMBER BRD | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| 1/4 | | "Duralloy" | 9903 | | 48-00550-025 |

SPECIFICATIONS

(1) Material: See Table.

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rolling | 10-12-72 | | | FT. |

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Portland FREIGHTLINER CORPORATION Oregon 97208

48-00551

Materials Specification

| PRINT ISSUED | TITLE | PART NO |
|---|---|---|
| | DIVIDER MOULDING, PANEL, EXTRUSION | 48-00551 |
| LAST CHG LTR | | SHEET 1 OF 1 |

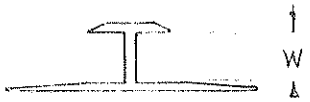
| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| - | - | - | J # 60020 |

SCOPE This specification identifies a light metal panel-divider moulding extrusion.

APPLICATION Trim, divider and support for interior door cover material.

SKETCH




SPECIFICATION NUMBERS

| W WIDTH (INCHES) | | MATERIAL (1) | EXTRUSION DIE NUMBER BRD | | FREIGHTLINER SPECIFICATION NUMBERS |
|---|---|---|---|---|---|
| 1/4 | | "Duralloy" | 9923 | | 48-00551-025 |

SPECIFICATIONS

(1) Material: See Table.

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 10-12-72 | | | FT. |

ns

Portland FREIGHTLINER CORPORATION Oregon 97208

48-00552

Materials Specification

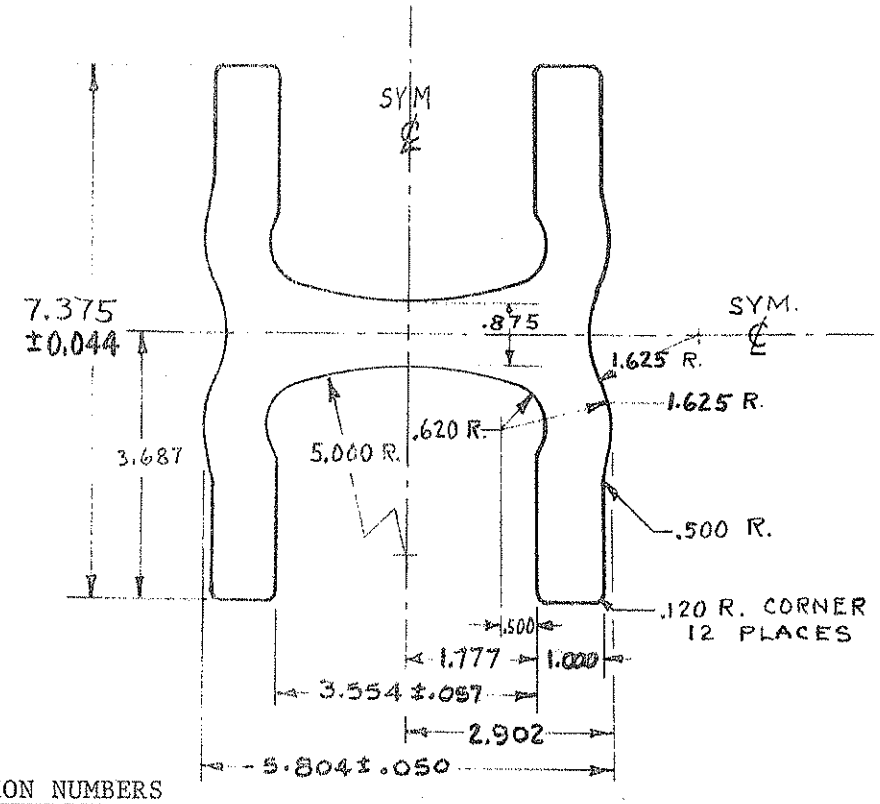
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| LAST CHG. LTR. B | EXTRUSION, SPECIAL "H" (SPRING SHACKLE, FRONT) | 48-00552 |
| | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SCOPE This specification identifies a light metal special H-section extrusion.

APPLICATION Front spring shackle.

SKETCH




SPECIFICATION NUMBERS

| | TEMPER (1) | WT LB/FT | EXTRUSION DIE NUMBER | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|
| | T6 | | Alcoa 275605 | 48-00552-000 |

| DATE | WAS |
|---|---|
| 8-16-73 | Rev. & Red. J#40720 |

SPECIFICATIONS

-00529

Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| 6/9/71 | EXTRUSION, ANGLE EQUAL LEG | 48-00529 |
| LAST CHG. LTR. A | | SHEET 1 OF 1 |

SCOPE This specification identifies equal leg angle light metal extrusions.

APPLICATION General; Cab nose stiffener, cab rear deck angle.

SKETCH



48-00554

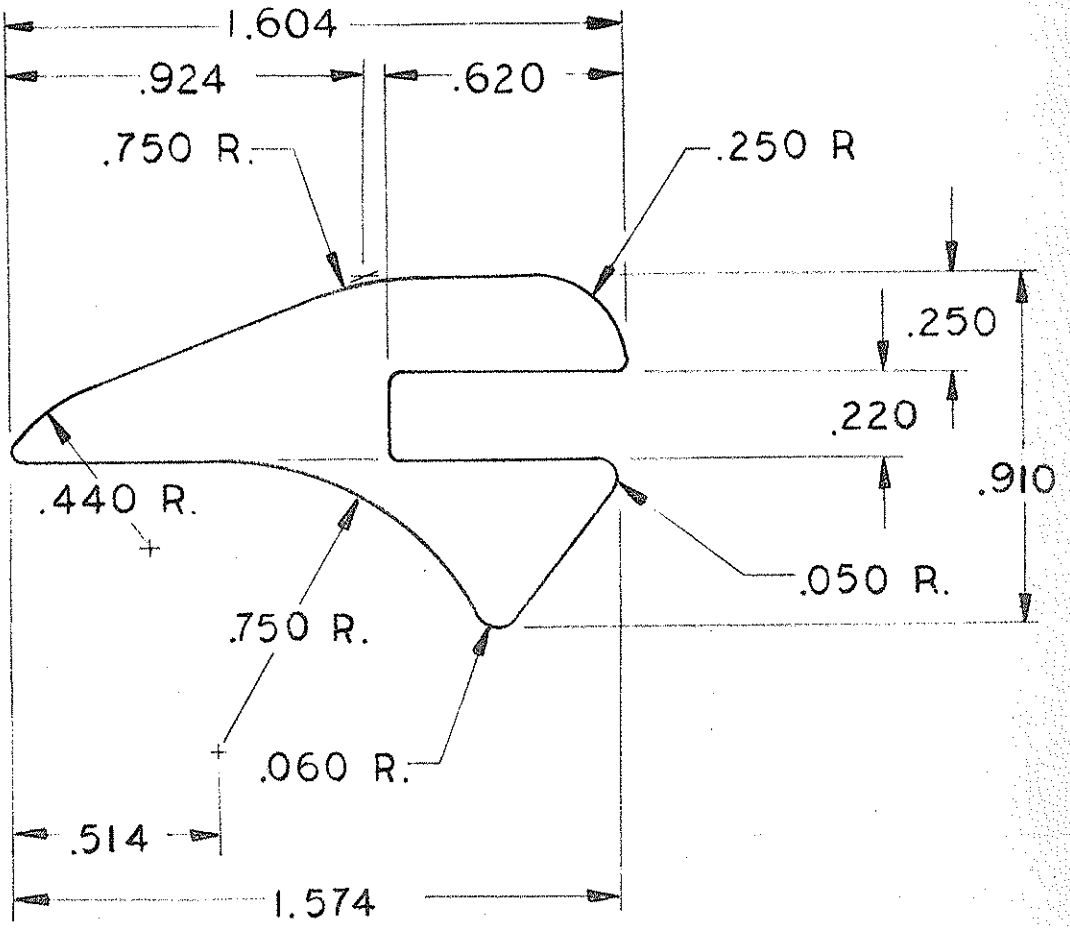
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | NOSE BEAM TRIM, EXTRUSION | 48-00554 |
| LAST CHG. LTR | | SHEET 1 OF 1 |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Specifically used for nosebeam trim.

SKETCH




UNSPECIFIED RADII: .020

SPECIFICATION NUMBERS

| | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| | ALU | | |
| | 1003-S | | 48-00554-000 |

SPECIFICATIONS

(1) Material: Aluminum 6063-T5

2. Finish: As extruded.

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |
| | | | |
| | | | |
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| - | - | - | J #A0100 |
| | | | |
| | | | |
| | | | |

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| COMPILED | DL | DATE DRAWN | | MATERIAL | |
|---|---|---|---|---|---|
| APPROVED | Rolling | 3-2-73 | | (1) | |

Portland FREIGHTLINER CORPORATION Oregon 97208

E-183

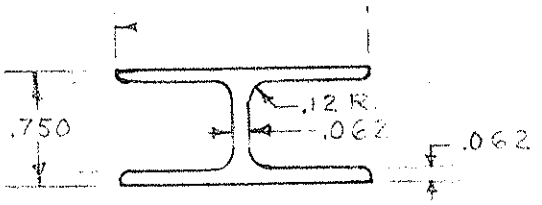
48-00556

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | EXTRUSION, H-SECTION ALUM. | 48-00556 |
| LAST CHG LTR --- | | SHEET 1 OF 1 |

SCOPE This specification identifies an H-section light metal extrusion.

APPLICATION Baggage or access door frame.

SKETCH




SPECIFICATION NUMBERS

| | MATERIAL | TEMPER | DIE NUMBERS ALU | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|
| | 6061 | T6 | 10140-0601 | | [redacted] |

SPECIFICATIONS

1. Material: See table.
2. Finish: Mill finish.

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| — | — | — | 1#A0531 |

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 9-28-73 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

E-183

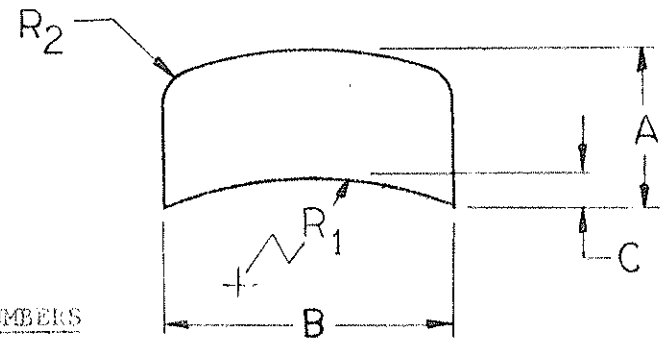
48-560

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | EXTRUSION, ALUMINUM TRIM | 48-560 |
| LAST CHG. LTR. | | SHEET 1 OF 1 |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Used as trim for the fendors of the conventional.

SKETCH




SPECIFICATION NUMBERS

| A | B | C | $R_1$ | $R_2$ | EXTRUSION DIE NUMBER PFM | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|
| .188 | .500 | .019 | .500 | .188 | 74C | 48-560-000 |
| .188 | .625 | .019 | .625 | .188 | 74A | -001 |
| .188 | .750 | .020 | .750 | .188 | 74B | -002 |
| .188 | .875 | .019 | .875 | .188 | 74H | -003 |
| .188 | 1.000 | .020 | 1.000 | .188 | 74Q | -004 |

SPECIFICATIONS

1. Material: 6063-T52
2. Finish: As extruded

ENGINEERING NOTES

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | J#A0562 |

| COMPILED | DLEL | DATE DRAWN | | MATERIAL | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Jim S | 1-4-74 | | (1) | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

Materials Specification

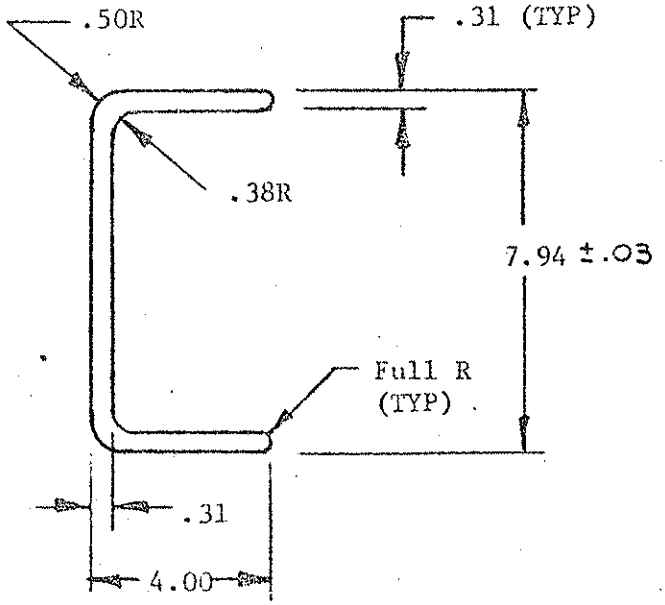
| PRINT ISSUED | TITLE | PART NO |
|---|---|---|
| | CROSSMEMBER<br>ALUMINUM EXTRUSION | 48-00562 |
| LAST CHG LTR | | SHEET OF |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Specifically used for crossmembers.

SKETCH




SPECIFICATION NUMBERS

| | EXTRUSION DIE NUMBER | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|
| | | | 48-00562-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| NEW | EL | 6/6/14 | NO BOSS |

SPECIFICATIONS

(1) Material: Alum. 6061-T6

2 Minimum properties: Tensile ultimate, 38 k.s.i.
Yield, 35 k.s.i.
Elongation, 10% in 2 inches

3 Finish: As extruded

| | | DATE DRAWN | | MATERIAL | NEXT ASSY. NO. |
|---|---|---|---|---|---|
| COMPILED | | | | (1) | |
| APPROVED | | | | | |

48-00563

Materials Specification

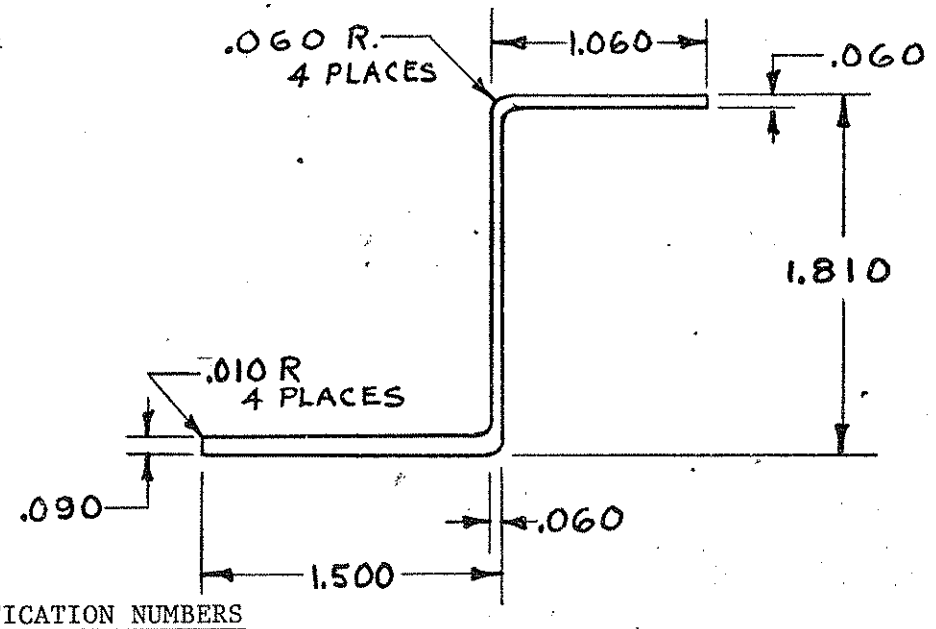
| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | EXTRUSION, ALUMINUM ZEE | 48-00563 |
| LAST CHG. LTR. | | SHEET 1 OF 1 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

SCOPE This specification identifies an aluminum extrusion.

APPLICATION Stiffener, General Use, especially for cab roof.

SKETCH




SPECIFICATION NUMBERS

| DESCRIPTION | MAT'L. (1) | H.T. (2) | EXTRUSION DIE NUMBERS ALU | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|
| Per Sketch | 6063 | T5 | * | 48-00563-000 |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | — | — | J#A0627 |

*Temporarily identified as "F/L Part Number 2"

SPECIFICATIONS

(1) Material: See Table

(2) Heat Treatment: See Table

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | J S | 5-28-74 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

M/F

48-00573

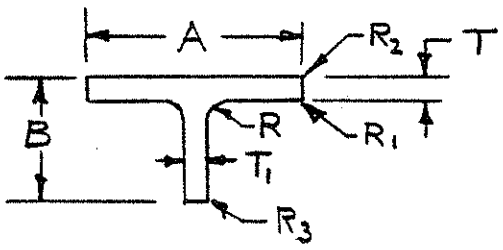
Materials Specification

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | TEE, ALUMINUM, STRUCT. | 48-00573 |
| LAST CHG. LTR. A | | SHEET 1 OF 1 |

SCOPE This specification identifies a light metal structural tee.

APPLICATION

SKETCH




SPECIFICATION NUMBERS

| A | B | T | $T_1$ | R | $R_1$ | $R_2$ | $R_3$ | MATERIAL | WEIGHT LB/FT | MFR SECTION NO. RYN | | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 1.000 | .062 | .062 | .062 | .031 | .031 | .031 | 6061-T6 | .220 | 23203 | | 48-00573-001 |
| 2.500 | 1.500 | .078 | .078 | .078 | .039 | .039 | .039 | 6061-T6 | .355 | | | 48-00573-002 |

SPECIFICATIONS

1 Material: Aluminum (See Table).
2. Finish: Plain

| JOB NO | DATE | BY | CHG |
|---|---|---|---|
| | | | |
| | | | |
| | | | |
| | | | |

| WAS | JOB NO | DATE | BY | CHG |
|---|---|---|---|---|
| | | | | |
| ——— | A0761 C1436 | —— | —— | —— |
| A0210-002 | | 6-6-79 | TC | A |

kh

| COMPILED | HJR | DATE DRAWN | | | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | | 6-27-75 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208

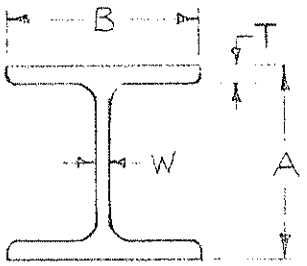
48-00576

| PRINT ISSUED | TITLE | PART NO. |
|---|---|---|
| | M-BEAM, STEEL | 48-00576 |
| LAST CHG. LTR. | | SHEET 1 OF 1 |

SCOPE This specification identifies structural steel M-Beam.*

APPLICATION General structural use.

SKETCH




SPECIFICATION NUMBERS

| DESIGNATION A x LB/FT | B | T | W | FREIGHTLINER SPECIFICATION NUMBER |
|---|---|---|---|---|
| M4 x 13.0 | 3.940 | .371 | .254 | 48-00576-040 |

SPECIFICATIONS

1. MATERIAL: Conforms to ASTM A36.

*Formerly called H-Beam.

| CHG | BY | DATE | WAS |
|---|---|---|---|
| | | | |

| CHG | BY | DATE | WAS |
|---|---|---|---|
| — | — | — | J#A0533 |

| COMPILED | RJR | DATE DRAWN | | MATERIAL | UNIT OF MEASURE |
|---|---|---|---|---|---|
| APPROVED | Rollins | 10-3-73 | | | FT. |

Portland FREIGHTLINER CORPORATION Oregon 97208