

Headlamp Aiming Device for Mechanically Aimable Sealed Beam Headlamp Units – SAE J602 OCT80

SAE Standard
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**HEADLAMP AIMING DEVICE FOR
MECHANICALLY AIMABLE SEALED
BEAM HEADLAMP UNITS—SAE J602 OCT80**

SAE Standard

Report of the Lighting Committee, approved October 1957, last revised October 1980.

1. Scope—This specification applies to the requirements of a device used in the field and inspection stations to aim the mechanically aimable type of sealed beam headlamp units.

The purpose of this specification is to provide a laboratory test procedure to determine whether the devices under test are capable of accurately positioning sealed beam headlamp units from their aiming pads and maintaining their accuracy in service within the tolerances designated in this specification.

2. Definitions

2.1 Headlamp Aiming Device—A device used to adjust and inspect the aim of mechanically aimable headlamp units consisting of one or more fixtures designed to seat against the three aiming pads (aiming plane) on mechanically aimable headlamp units installed on a vehicle to facilitate accurate aiming of such units, vertically and laterally.

2.2 Mechanically Aimable Headlamp Units—A unit having three pads on the face of the lens forming a mechanical aiming plane used to adjust and inspect the aim of the unit when installed on a vehicle.

2.3 Aiming Plane—A plane through the three aiming pads on the face of the lens.

3. Samples for Test—Sample devices submitted for laboratory tests shall be representative of the devices as regularly manufactured and marketed. Each sample shall include all accessory equipment peculiar to the device. Full assembly and operating instructions shall be provided, including information on how to check accuracy and maintain the device in calibration.

4. Laboratory Facilities—The laboratory shall be equipped with all facilities necessary to make the tests required in this standard.

5. General Requirements

5.1 The device shall be of such design that the seating portion will register only on the three aiming pads on the sealed beam units as covered by SAE J571.

5.2 No part of the device, except those parts (strings, sighting devices, scales, etc.) required for referencing lateral alignment between devices, shall extend beyond the dimensional limits of the headlamp aiming device locating plate (Fig. 1, dimension C; Fig. 2, 4.05 in (102.9 mm) maximum diameter dimension; and Fig. 3, 4.05 in (102.9 mm) maximum diameter dimension).

5.3 A device which uses adapters to fit more than one size sealed beam unit shall meet all of the requirements of this recommended practice with and without adapters.

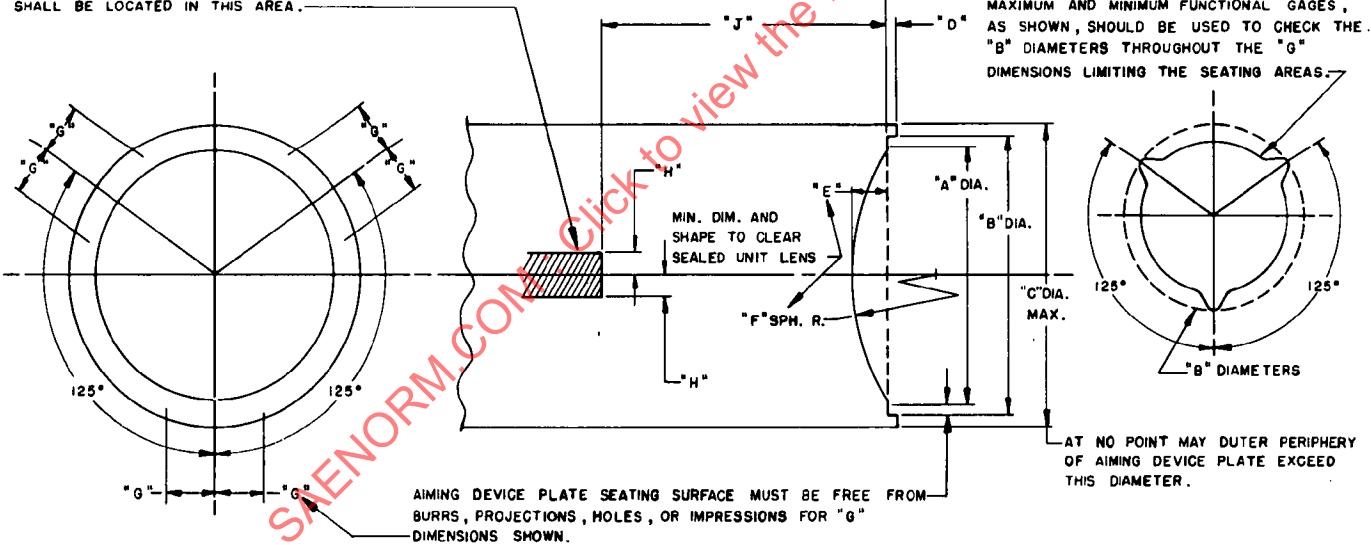
5.4 The seating plane of the device shall meet the dimensions shown in Fig. 1, Fig. 2, or Fig. 3.

5.5 When aiming headlamp units spaced 90 in (2300 mm) apart, the torque exerted by the device at the aiming plane shall not exceed 18 lbf-in (2.0 N-m) vertically and 12 lbf-in (1.4 N-m) laterally.

5.6 The means of securing the device to the sealed beam unit shall retain the device against the three aiming pads when an axially centered tensile force of 4.0 lbf (17.8 N) minimum is applied to the device.

5.7 The device shall be capable of being calibrated and shall have avail-

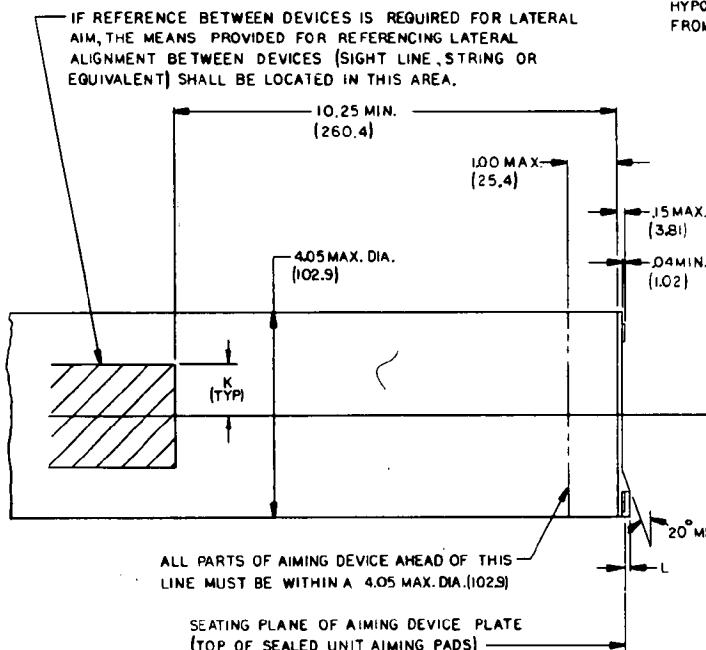
IF REFERENCE BETWEEN DEVICES IS REQUIRED FOR LATERAL AIM,
THE MEANS PROVIDED FOR REFERENCING LATERAL ALIGNMENT
BETWEEN DEVICES (SIGHT LINE, STRING, OR EQUIVALENT)
SHALL BE LOCATED IN THIS AREA.



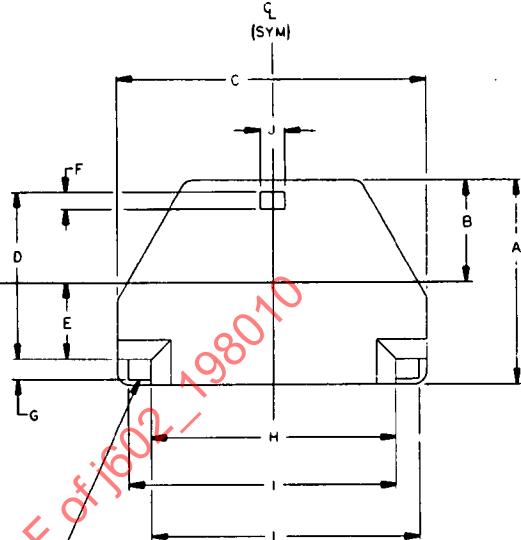
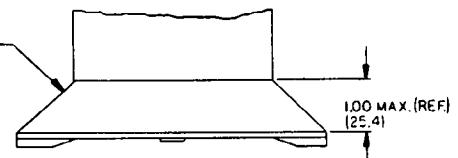
NOTE: THERE SHALL BE NO PROJECTIONS, TANGS, LUGS, ETC., ON THIS LOCATING PLATE WHICH WILL PERMIT LOCATING THE AIMING DEVICE ON ANY PART OF THE HEADLAMP OTHER THAN THE AIMING PADS ON THE MECHANICALLY AIMABLE SEALED BEAM UNIT.

Locating Plate	Unit of Measure	Dimensions										
		A		B		C	D		E	F	G	H
		Max	Min	Max	Min	Max	Max	Min	Ref	Ref	Min	Max
5-3/4 in (146 mm)	in mm	4.830 122.7	4.770 121.2	5.375 136.5	5.345 135.8	5.700 144.8	0.165 4.19	0.145 3.68	0.70 17.8	4.40 111.8	0.70 17.8	1.00 25.4
7 in (178 mm)	in mm	6.140 156.0	6.080 154.4	6.710 170.4	6.680 169.7	7.031 178.6	0.180 4.57	0.160 4.06	0.96 24.4	5.60 142.2	0.70 17.8	1.00 25.4

FIG 1—DIMENSIONAL SPECIFICATIONS FOR HEADLAMP AIMING DEVICE LOCATING PLATE



HYPOTENUSE BLENDING PERMISSIBLE FROM MAX. PERIPHERY TO 4.05 DIA. (102.9)



THESE AREAS MUST BE FREE OF BURRS, PROJECTIONS, HOLES OR IMPRESSIONS REGARDLESS OF SIZE OF AIMING DEVICE PLATE SEATING SURFACE.

NOTE—THERE SHALL BE NO PROJECTIONS, TANGS, LUGS AND ETC., ON THIS LOCATING PLATE WHICH WILL PERMIT LOCATING THE AIMING DEVICE ON ANY PART OF THE HEADLAMP OTHER THAN THE AIMING PADS ON THE MECHANICALLY AIMABLE SEALED BEAM UNIT.

ALL DIMENSIONS ENCLOSED (XXX) ARE IN MM.

Locating Plate	Unit of Measure	Dimensions																							
		A		B		C		D		E		F		G		H		I		J		K		L	
		Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min		
4 x 6 $\frac{1}{2}$ 100 x 165	in mm	3.935 99.95	3.925 99.60	1.975 50.17	1.963 49.66	6.001 152.42	5.991 152.17	3.320 84.33	3.300 83.82	1.550 39.37	1.540 39.12	.370 9.40	.350 8.89	.330 8.38	.310 7.87	5.088 129.24	5.018 128.98	— —	5.421 137.20	— —	.400 10.16	1.000 25.40	— —	.080 2.03	.060 1.52

φ FIG. 2—DIMENSIONAL SPECIFICATIONS FOR HEADLAMP AIMING DEVICE LOCATING PLATE (100 x 165)

able for immediate use an independent calibration fixture and/or instructions to immediately recalibrate the device.

5.8 If a suction cup is used to retain the device to the headlamp unit, the effective diameter for 5 $\frac{1}{4}$ in (146 mm) and 7 in (178 mm) shall not exceed 3.5 in (90 mm) and the effective diameter for 4 x 6 $\frac{1}{2}$ in (100 x 165 mm) and 5 x 8 in (142 x 200 mm) shall not exceed 2.8 in (71 mm) when installed.

5.9 Means shall be provided in the device for compensating within ± 0.1 deg through a slope range of ± 1.5 deg from horizontal. The method for device compensation shall be clearly explained in the operating instructions.

5.10 If the lateral aim is to be accomplished by reference between devices on opposite sides of the vehicle, the means provided for referencing lateral alignment between devices (sight line, string, or equivalent) shall be located as shown in Fig. 1, Fig. 2, and Fig. 3.

5.11 The spirit level or other means provided for indicating vertical aim shall be capable of showing at least a 0.1 in (2.5 mm) deviation with a 1 in (25 mm)¹ change in level.

5.12 A lateral aim scale shall be provided with graduations in steps of not more than 2 in (51 mm)¹ from straight ahead to at least 8 in (203 mm) left and right.

5.13 The instructions covering use of the device shall include those items shown in Section 3 of SAE J599.

5.14 The vertical aim scale shall be marked O with the aiming plane vertical.

5.15 The vertical aim scale shall be provided with numerical graduations in steps, each of which represents 1 in (25 mm)¹ to provide for variations in vertical aim from at least 8 in (203 mm)¹ above O to 8 in (203 mm)¹ below O.

6. *Test Procedure*—Assuming that the devices comply with the general requirements, they shall be considered acceptable if they comply with additional test requirements as follows:

Note 1—All tests are to be made in an ambient temperature of 75 ± 5 °F (24 ± 3 °C) unless otherwise specified.

Note 2—If a vertical indication means other than a spirit level is used, an equivalent accuracy shall be maintained.

6.1 With the aiming plane vertical and with the vertical scale on the device set at O, the angle through which the aiming plane must be rotated vertically to center the bubble in the spirit level, or equivalent, shall not exceed 0.5 in (13 mm)¹.

6.2 With the aiming planes in the same vertical plane and with the means provided for adjusting lateral aim in use, the angle through which the aiming plane must be rotated laterally to indicate straight ahead shall not exceed ± 1 in (25 mm)¹ with the lamps 24 and 90 in (610 and 2300 mm) apart.

6.3 With the aiming planes initially in the same vertical plane and sub-