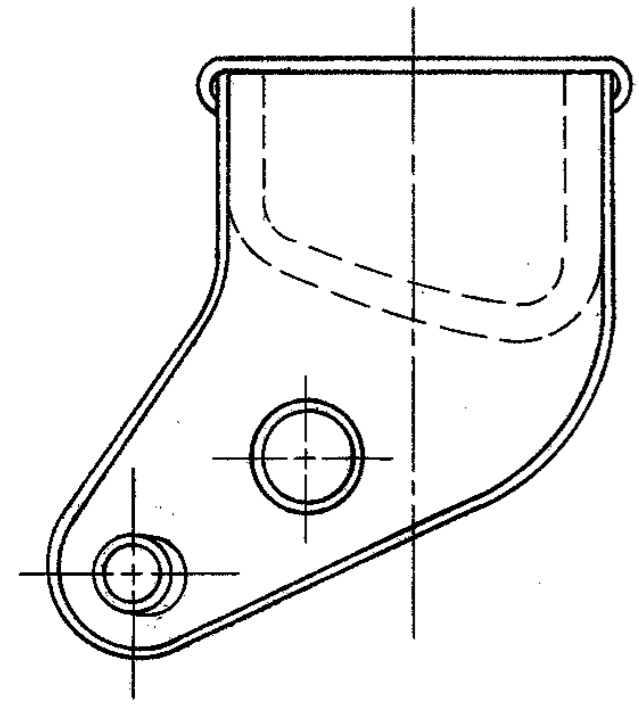
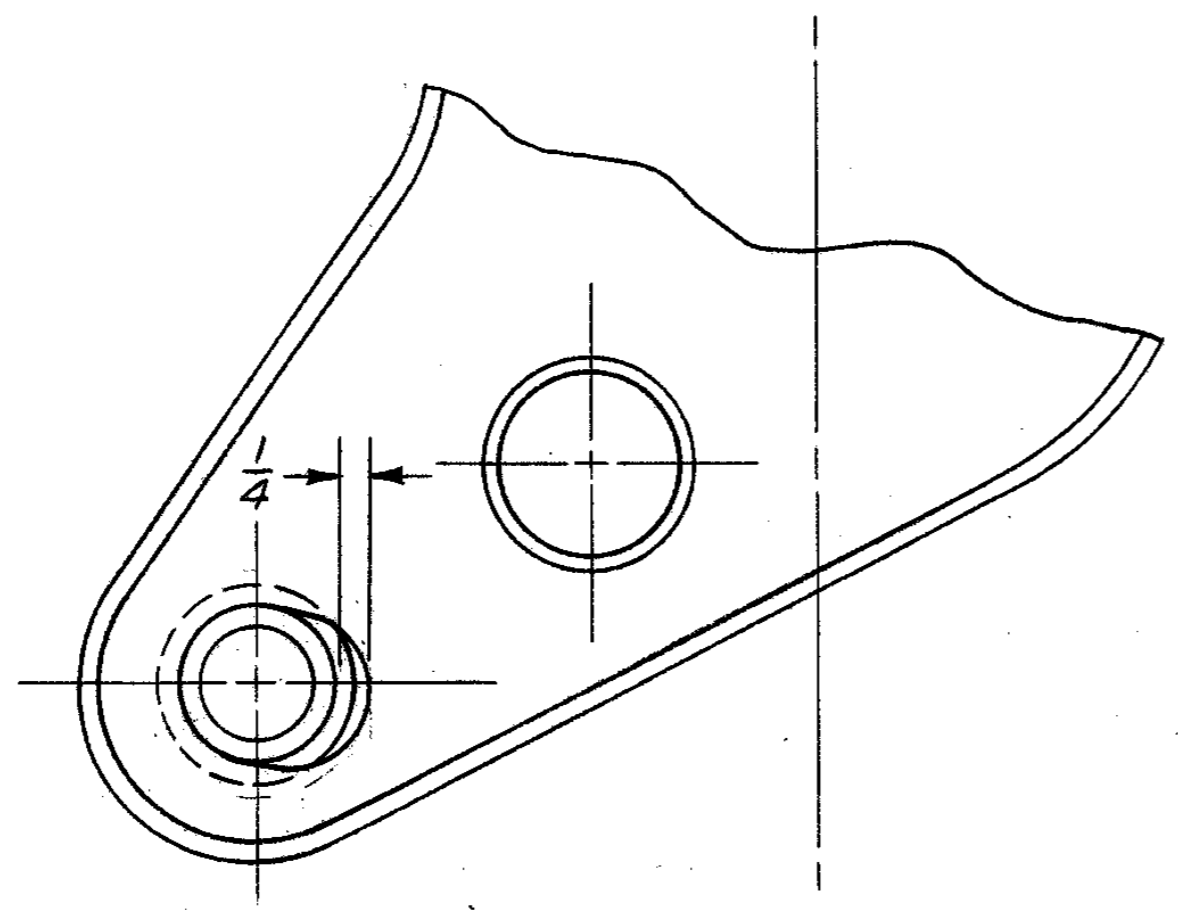


REQD.	PART NO.	ITEM	DESCRIPTION
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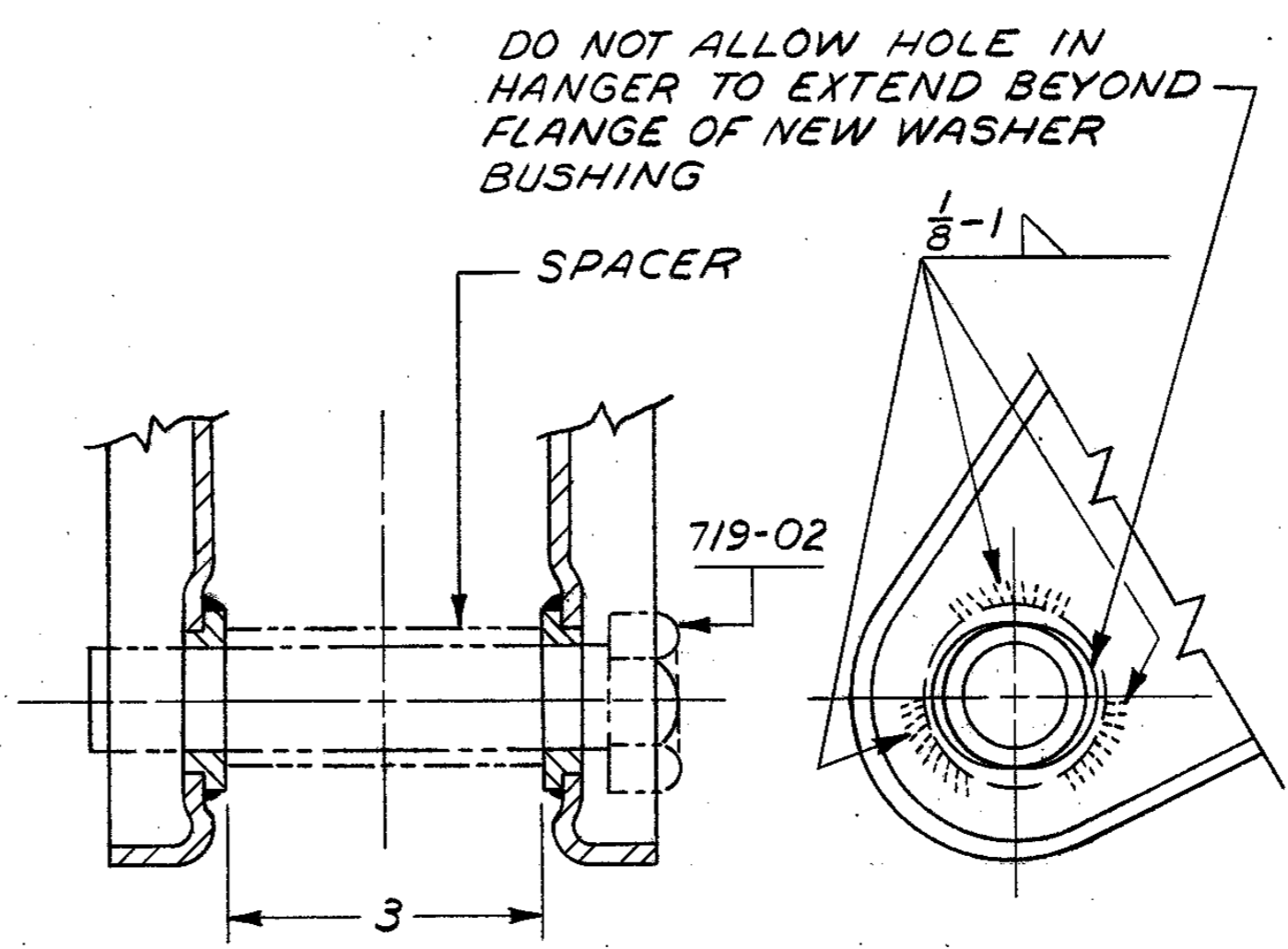
STEP 1

REMOVE TORQUE ARMS AND INSPECT ALL TORQUE ARM BOLT HOLES FOR LOOSE OR WORN WASHER BUSHINGS. (FRONT HANGER SHOWN... TREAT CENTER HANGER SAME).



STEP 2

IF THE HOLE IS ELONGATED MORE THAN 1/4" IT IS RECOMMENDED THAT THE HANGER BE REPLACED.



STEP 3

ASSUMING THAT HOLES ARE REPAIRABLE (SEE STEP 2), REMOVE AND DISCARD OLD LOOSE WASHER BUSHINGS. REPLACE WITH NEW 7717-01 HARDENED WASHER BUSHINGS. USING 1 3/4" OD x 3" LONG SPACER TUBE & TORQUE ARM BOLT, CLAMP UP NEW WASHER BUSHING AS SHOWN AND WELD IN PLACE USING 1/8" AWS E 7016 OR E 7018 LOW HYDROGEN ELECTRODE.

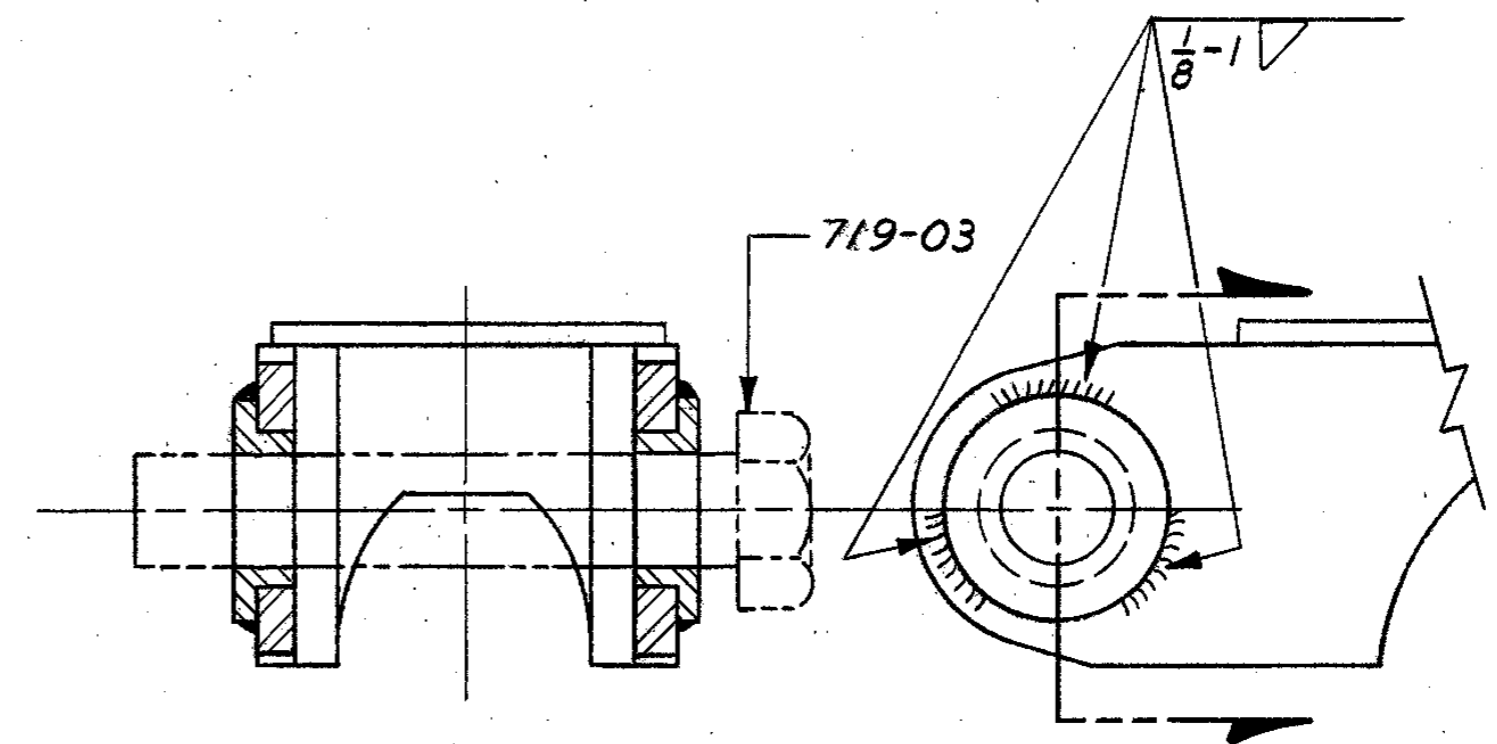
REMOVE BOLT & SPACER. CLEAN WELDS AND TOUCH UP PAINT INSIDE & OUT. DO NOT APPLY PAINT TO INSIDE FACE OF WASHER BUSHING.

STEP 4

RE-ASSEMBLE TORQUE ARM JOINT REPLACING WORN RADIUS RODS (OR BUSHINGS), USING NEW BOLTS, AND NUTS.

IMPORTANT

TORQUE TO PROPER SPECIFICATIONS - REFERENCE DECAL 16088-01.



STEP 6

ON CASTINGS OR OTHER PARTS WITH 3/8" WALL THICKNESS, INSERT WASHER BUSHING 6978-00 FROM OUTSIDE AND PLACE 1" DIA. BOLT THROUGH BOTH BUSHINGS TO ASSURE CORRECT BUSHING ALIGNMENT. WELD EACH BUSHING AS INDICATED (3 PLCS) WITH BOLT AND SPACER TUBE IN PLACE. WHEN THE 6978-00 HARDENED INSERT IS USED AS DESCRIBED ABOVE, THE STANDARD TORQUE ARM BOLT MUST BE REPLACED WITH THE 719-03 BOLT WHICH IS 5 3/8" LONG.

STEP 5

				REMOVE ALL BURRS AND SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY APPEARANCE OR OPERATION				MATERIAL TREATMENT		NO. REQ'D
								DRAWN DATE 11-16-73		NEXT ASSY.
								CHECKED BH		HUTCHENS & SON METAL PRODUCTS INC. SPRINGFIELD, MISSOURI
								APPROVED DATE 11/19/73		
								TOLERANCES UNLESS SPECIFIED FRACTIONAL ± 1/32 DECIMAL .XX ± .03 ANGULAR ± 1°		NAME
				9852 A RELEASED DRAWING INTO PROD REV. TITLE UPDATED DWT NOS				SCALE WEIGHT		RADIUS ROD BOLT HOLE REPAIR
				E.C. NO. SYM. REVISIONS DATE BY				REF. DATED DWG. NO.		FAB HANGERS W/ 222-00 BUSHING
				ER				LETTER TO CLARK 11-16-73		19068 A