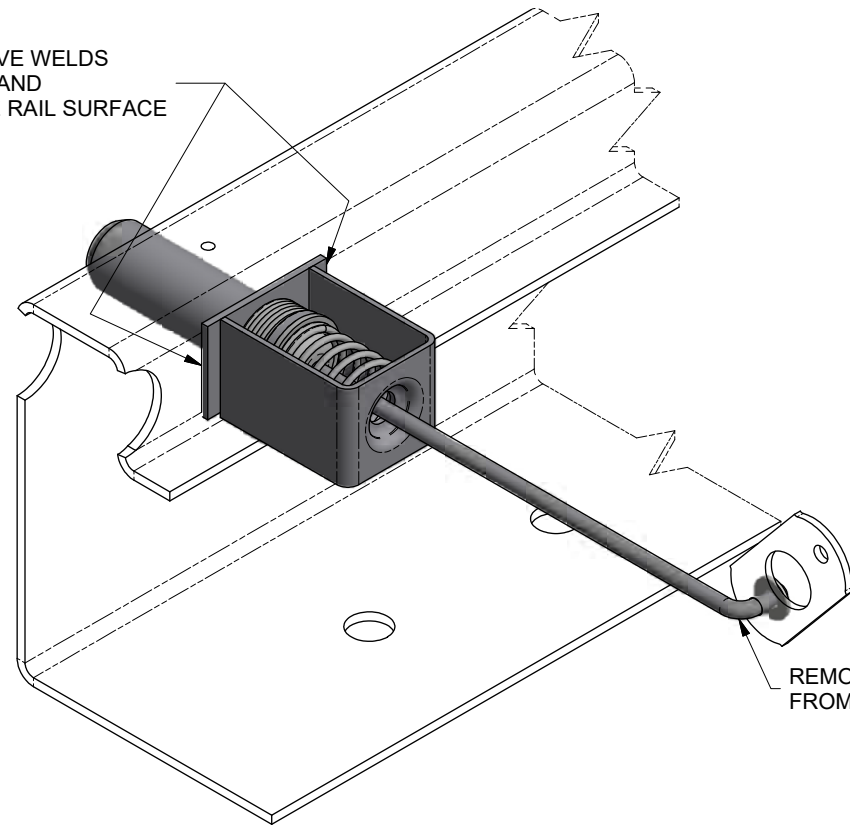


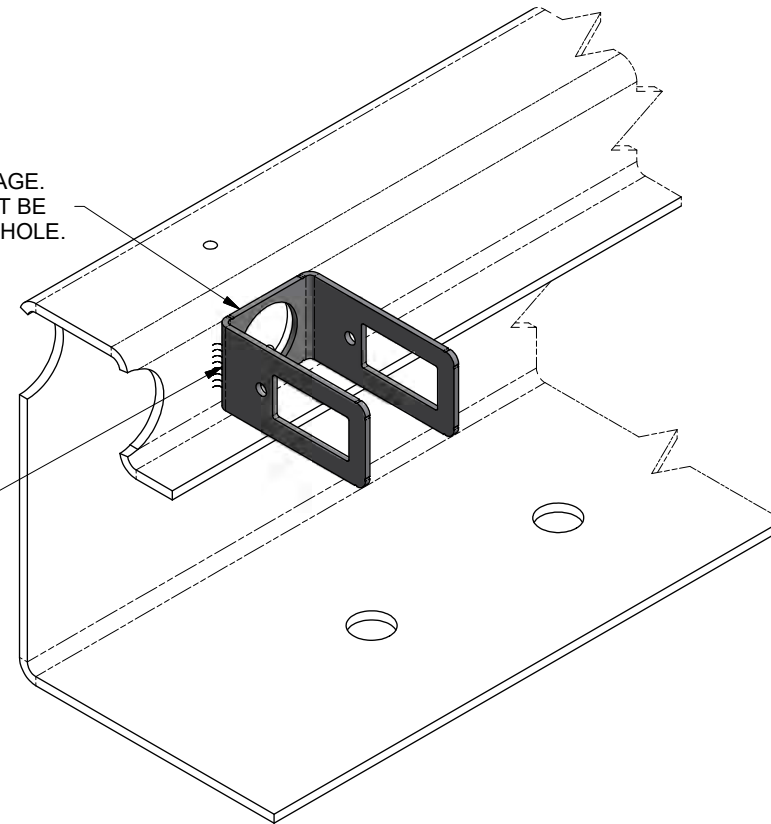
REMOVE WELDS
AND
CLEAN SIDE RAIL SURFACE



STEP 1

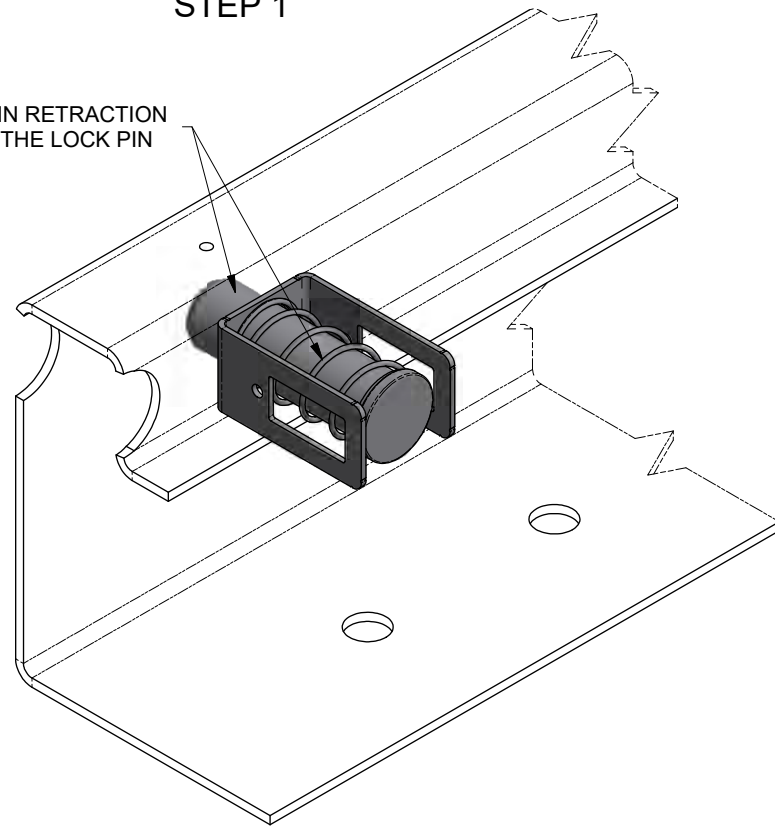
POSITION THE SPRING CAGE.
THE LOCK PIN HOLE MUST BE
INLINE WITH THE SIDERAIL HOLE.

2 PL (.19) 1.00
ALLOW WELDS TO COOL
BEFORE STEP 3.



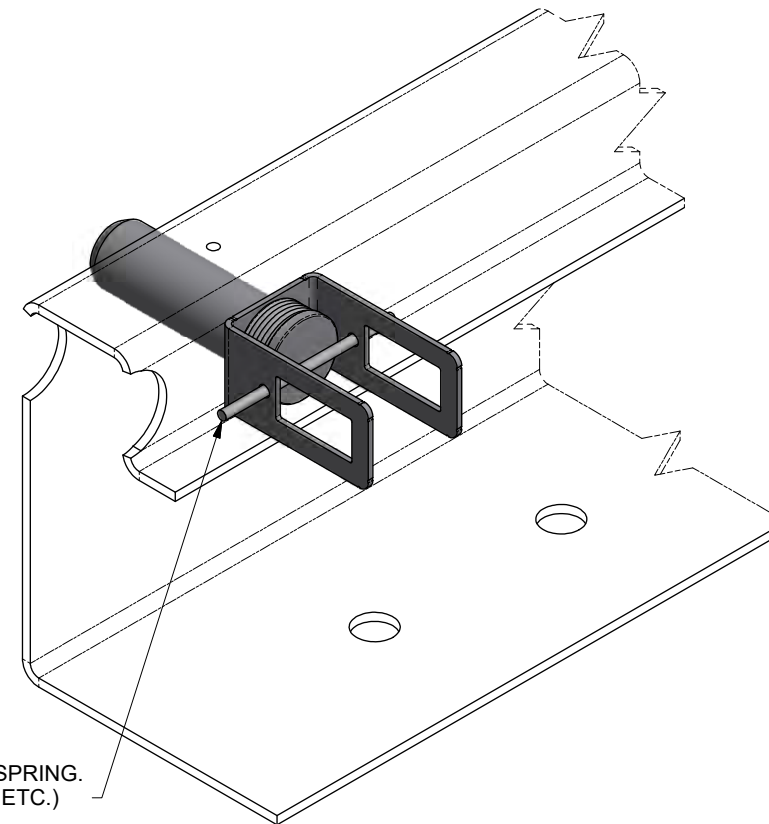
STEP 2

INSTALL THE PIN RETRACTION
SPRING AND THE LOCK PIN



STEP 3

COMPRESS THE LOCK PIN AND RETRACTION SPRING.
INSERT A RETAINER (ROD, SCREWDRIVER, ETC.)
THROUGH THE PIN CAGE HOLES.



STEP 4

3. MAKE SURE LOCK PINS EXTEND AND FULLY
RETRACT BEFORE PLACING SLIDER IN SERVICE.

2. SLIDER MODEL: H8901/H8931.

1. INSTALLATION PROCEDURE FOR KIT 29558-01,-02, AND -04.

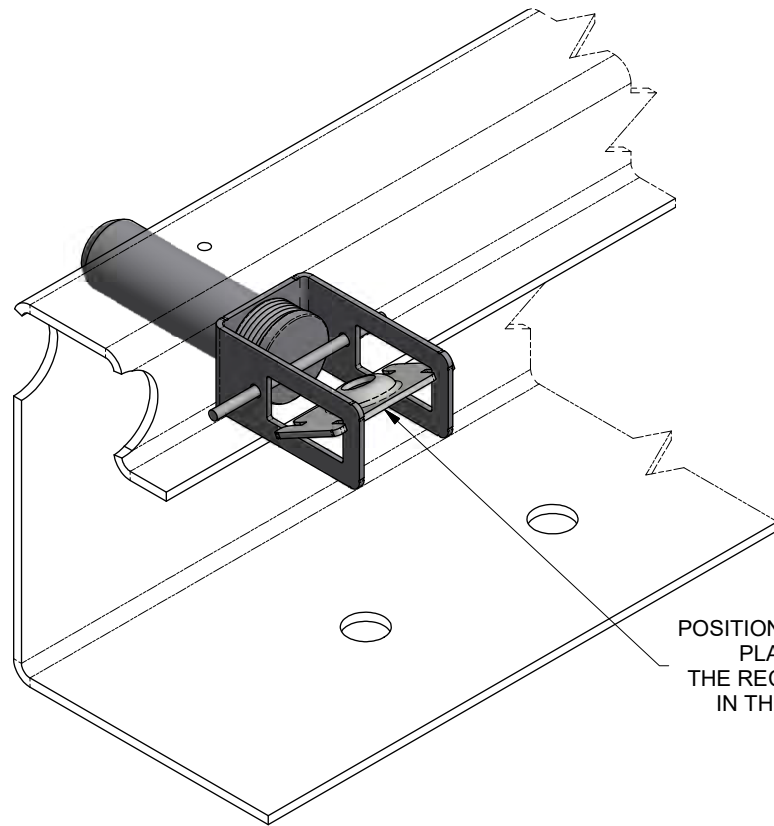
NEXT ASSY: NEXT
TOLERANCES
(UNLESS OTHERWISE SPECIFIED)
DECIMAL .X ± .1
DECIMAL .XX ± .06
DECIMAL .XXX ± .030
ANGULAR ± 1°
HOLES:
.50 DIA AND LESS: ± .007
.51 DIA AND GREATER: ± .01
REMOVE ALL SHARP BURRS & SHARP
CORNERS THAT MIGHT AFFECT
ASSEMBLY, APPEARANCE, OR
OPERATION OF OUR PRODUCTS.

ER NO.	SYM	DATE	BY	CHK	APPD
DRAWN:	ML	3/22/2018			
CHECKED:	JAJ	10/4/2018			
APPROVED:	RSB	10/4/2018			
MFG APPL:	N/A	XX/XX/XX			
ER:	2018044	10/5/2018			
PROJECT OR FILE REFERENCE NO.:	PROJ#: 20180400				
	EPR#: 20180400-01				
SCALE:	D SIZE - 1/2				
	B SIZE - 1/4				
SHEET 1 OF 2			SIZE:	D	DRAWING NO.:
					29576
			REV.:	-	1 OF 2



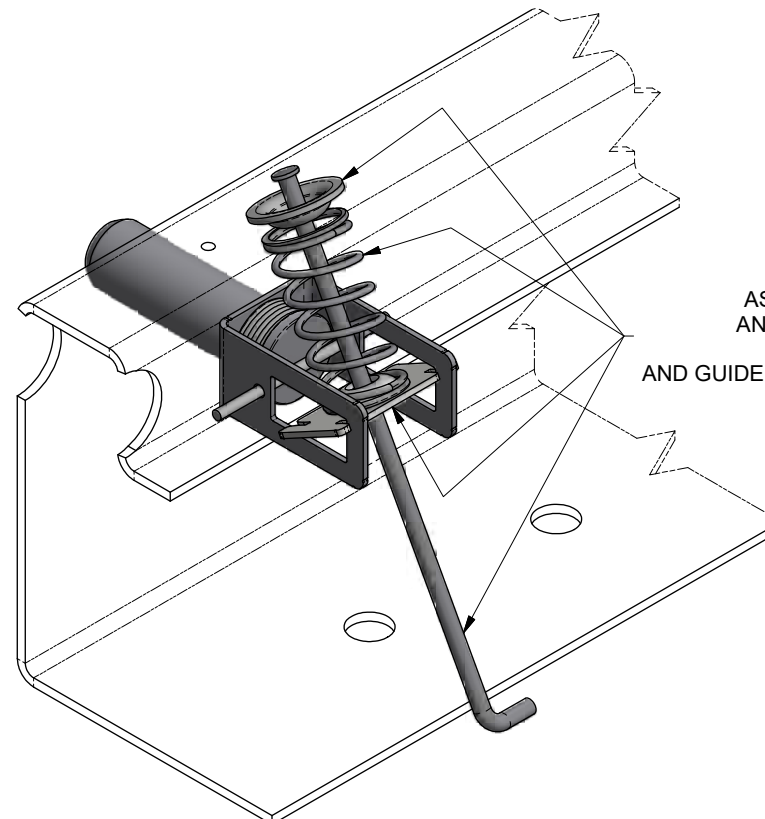
INSTALLATION PROCEDURE
FOR 29558-01,-02, & -04 KIT

This confidential drawing is the property of Hutchens Industries, Hutchens Industries makes no warranties regarding the information on this document. Nothing herein may be transmitted or disclosed in whole or in part to other parties. The recipient of this drawing agrees not to use the information for manufacturing, nor will they modify, distribute, reverse engineer, or create derivative works based on the information contained on this print without the prior written permission of Hutchens Industries. The recipient agrees not to make copies of the document or reproduce in any manner the information in the document and to return it to Hutchens Industries upon request. Any use of this document is acceptance of the terms stated above.
 DRAWING NO. 29576
 REV. 1 OF 2



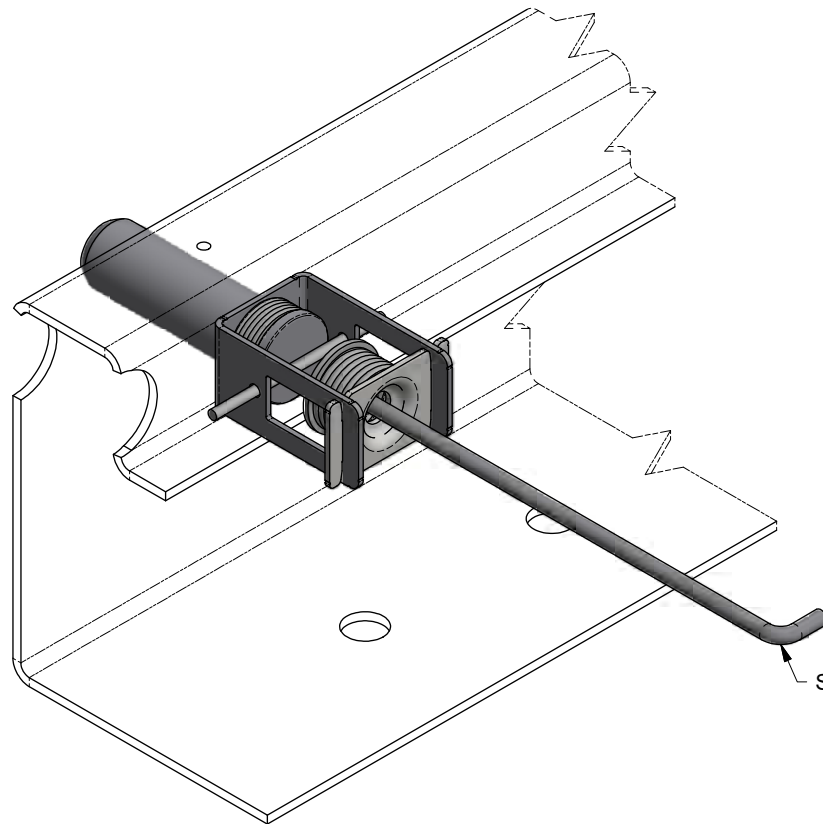
POSITION THE SPRING CAGE
PLATE BETWEEN
THE RECTANGULAR SLOTS
IN THE SPRING CAGE.

STEP 5



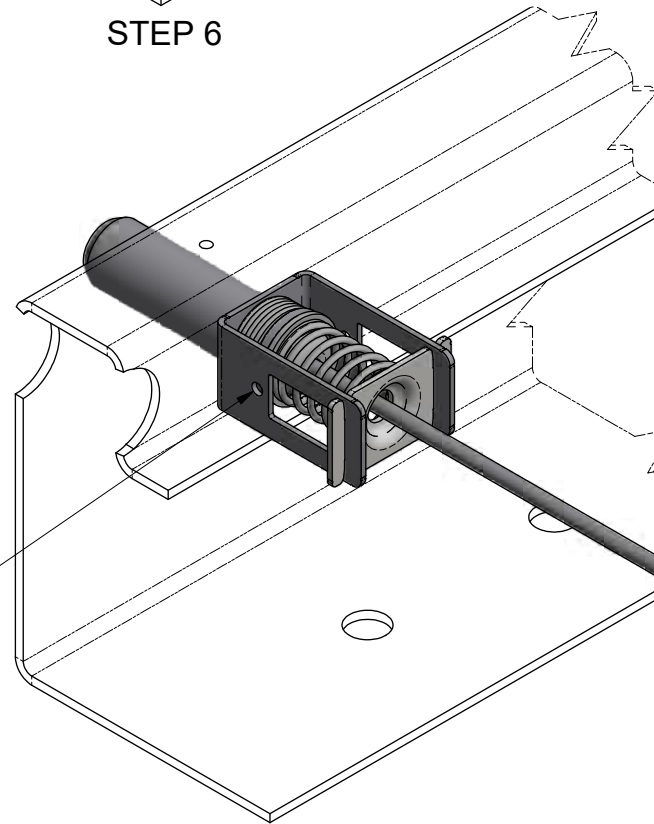
ASSEMBLE SPECIAL WASHER
AND PIN ENGAGEMENT SPRING
ONTO LINKAGE ROD
AND GUIDE THROUGH THE SPRING CAGE PLATE.

STEP 6



PULL BACK THE LINKAGE ROD.
SPRING CAGE PLATE WILL SEAT AGAINST
BACK SIDE OF THE SPRING CAGE.

STEP 7



REMOVE THE RETAINER
FROM PIN CAGE HOLES

HOOK THE END OF THE LINKAGE ROD THROUGH THE CAM.
PLACE THE WASHER ON THE LINKAGE ROD
ON THE OPPOSITE SIDE OF THE CAM.
WELD THE WASHER ON TO THE LINKAGE ROD.

STEP 8

3. MAKE SURE LOCK PINS EXTEND AND FULLY RETRACT BEFORE PLACING SLIDER IN SERVICE.
2. SLIDER MODEL: H8901/H8931.
1. INSTALLATION PROCEDURE FOR KIT 29558-01, -02, AND -04.

NEXT ASSY: NEXT		ER NO.	SYM	DATE	BY	CHK	APPD
TOLERANCES (UNLESS OTHERWISE SPECIFIED) DECIMAL .X ± .1 DECIMAL .XX ± .06 DECIMAL .XXX ± .030 ANGULAR ± 1°		DRAWN:	ML	3/22/2018			
HOLES: .50 DIA AND LESS: ± .007 .51 DIA AND GREATER: ± .01		CHECKED:	JAJ	10/4/2018			
REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.		APPROVED:	RSB	10/4/2018			
PROJECT OR FILE REFERENCE NO. PROJ#: 20180400 EPR#: 20180400-01		MFG APPL:	N/A	DATE: XXX/XX/XX			
SCALE: D SIZE - 1/2 B SIZE - 1/4		ER:	2018044	DATE: 10/5/2018			
				HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI		TITLE: INSTALLATION PROCEDURE FOR 29558-01, -02, & -04 KIT	
		SHEET 2 OF 2		SIZE: D	DRAWING NO.: 29576		REV: -

This confidential drawing is the property of Hutchens Industries. Hutchens Industries makes no warranties regarding the information on this document. Nothing herein may be transmitted or disclosed in whole or in part to other parties. The recipient of this drawing agrees not to use the information for manufacturing, nor will they modify, distribute, reverse engineer, or create derivative works based on the information contained on this print without the prior written permission of Hutchens Industries. The recipient agrees not to make copies of the document or reproduce in any manner the information in the document and to return it to Hutchens Industries upon request. Any use of this document is acceptance of the terms stated above.