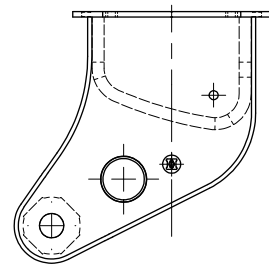


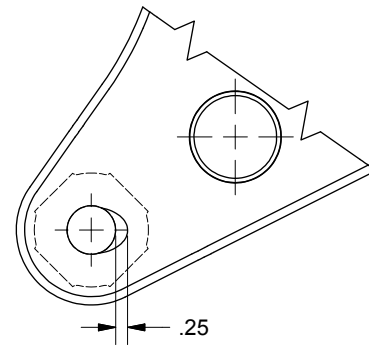
FOLLOW STEPS 1-5 FOR THE INSPECTION AND INSTALLATION OF THE 7717-01 WASHER BUSHING IN FABRICATED HANGERS. SEE STEP 3a FOR SUPPLEMENTAL INFORMATION TO INSTALL THE 6978-01 BUSHINGS IN SPRING SEATS AND CAST HANGERS.



STEP 1

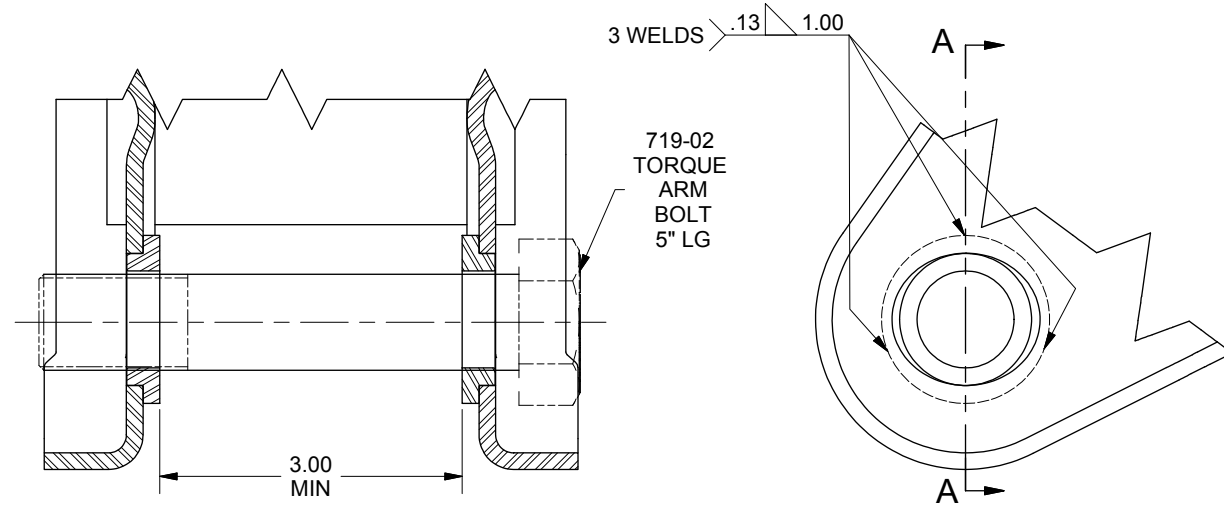
REMOVE TORQUE ARMS AND INSPECT ALL TORQUE ARM BOLT HOLES FOR LOOSE OR WORN CONNECTIONS.

(FABRICATED FRONT HANGER SHOWN... TREAT CENTER HANGER SAME).



STEP 2

IF THE ORIGINAL 1" NOMINAL DIAMETER HOLE IS ELONGATED MORE THAN .25", IT IS RECOMMENDED THAT THE HANGER BE REPLACED.



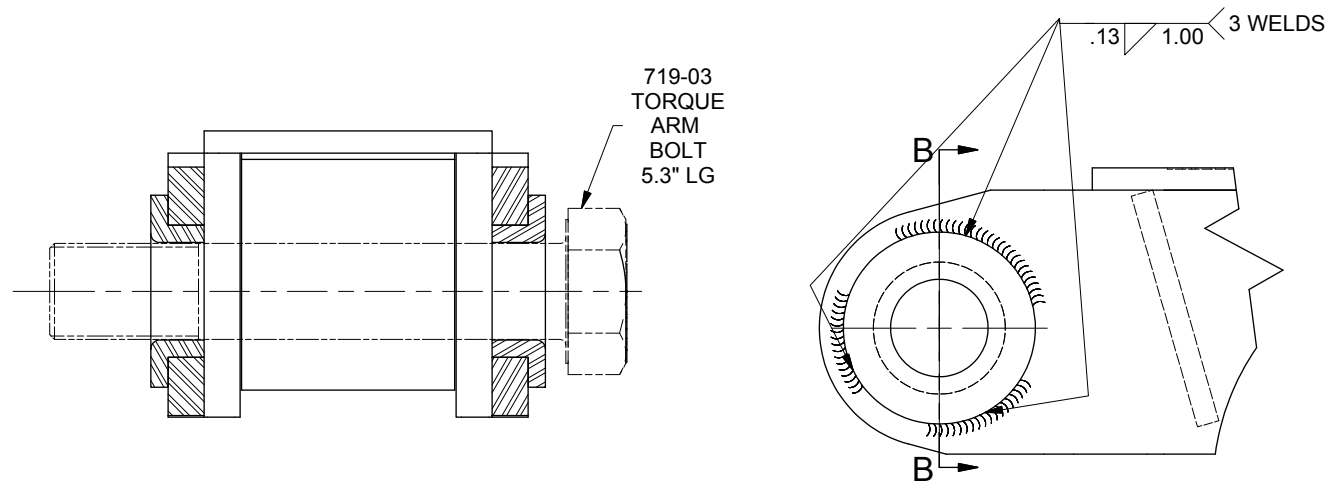
STEP 3

ASSUMING THAT HOLES ARE REPAIRABLE (SEE STEP 2), REMOVE AND DISCARD THE ORIGINAL WASHERS.

ENLARGE THE ELONGATED HOLES IN THE HANGER SIDEPLATES TO ACCEPT THE 1.38" DIAMETER BODY OF THE REPLACEMENT BUSHING.

INSTALL TWO NEW 7717-01 WASHER BUSHINGS USING A 1" TORQUE ARM BOLT (OR EQUIVALENT) TO KEEP THE BUSHINGS ALIGNED.

HOLD THE NEW WASHER BUSHING IN PLACE AS SHOWN AND WELD USING AWS E70XX/ER70 WELDING MATERIALS AND PRACTICES. DO NOT ALLOW THE WELD TO STICK UP PAST THE SURFACE OF THE WASHER BUSHING AS IT MAY INTERFERE WITH THE INSTALLATION OF THE TORQUE ARM.



STEP 3a

USE THE 6978-00 BUSHINGS AND LONGER 719-03 BOLTS TO REPAIR SPRING SEATS AND CAST HANGERS WITH 3/8" WALL THICKNESS.

FOLLOW THE DISSASSEMBLY AND INSPECTION INSTRUCTIONS IN STEPS 1-2 ABOVE.

ENLARGE THE ELONGATED HOLES IN THE SPRING SEATS OR HANGERS TO ACCEPT THE 1.38" DIAMETER BODY OF THE REPLACEMENT BUSHING. THERE WILL NOT BE AN EXISTING WASHER TO REMOVE.

INSERT THE 6978-00 WASHER BUSHINGS INTO THE PREPARED HOLE FROM THE OUTSIDE OF THE SEATS OR CAST HANGERS AND USE THE LONGER 1" TORQUE ARM BOLT (OR EQUIVALENT) PLACED THROUGH BOTH BUSHINGS TO MAINTAIN CORRECT BUSHING ALIGNMENT.

WELD EACH BUSHING ON THE OUTSIDE OF THE PARTS WITH E70XX/ER70 PROCEDURES AS INDICATED.

DO NOT LET THE WELD STICK UP PAST THE SURFACE OF THE BUSHING AS IT WILL INTERFERE WITH THE INSTALLATION OF THE BOLT AND NUT.

REMEMBER, WHEN THE 6978-00 IS USED AS DESCRIBED ABOVE THE STANDARD 5" LONG 719-02 TORQUE ARM BOLT MUST BE REPLACED WITH THE 719-03 BOLT WHICH IS 5 3/8" LONG.

STEP 4

REMOVE BOLT AND CLEAN WELDS AND APPLY TOUCH UP PAINT.

DO NOT APPLY HEAVY PAINT TO INSIDE FACES OF EITHER WASHER BUSHING, OR TO THE OUTSIDE SURFACES OF THE 6978-01. IT MAY INTERFERE WITH BOLTED JOINT.

STEP 5

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

IMPORTANT

TORQUE TO PROPER LUBRICATED SPECIFICATIONS - REFERENCE DECAL 16086-01.

2015203	D	REVISED THE INSTALLATION INSTRUCTIONS, ADDED STEP 3a FOR REPAIR TO SPRING SEATS AND CAST HANGERS.	10/15	JAJ	SNM	RSB
2012002	C	REVISED NOTE WAS REFERENCE DECAL 16088-01 NOW 16086-01	01/12	JAJ	SNM	RSB
2010015	B	REDRAWN, ADDED "MIN" TO 3.00 DIM. REVISED TITLE WAS "722-00 BUSHING" NOW "722-00 BUSHING"	01/10	JAJ	SNM	RSB
ER NO.	SYM	REVISIONS	DATE	BY	CHK	APPD

NEXT ASSY:		DRAWN: BH	DATE: 11/16/1973		HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI		
TOLERANCES (UNLESS OTHERWISE SPECIFIED)		CHECKED: FR	DATE: 11/21/1973		TITLE: RADIUS ROD BOLT HOLE REPAIR FAB HANGERS W/722-00 BUSHING		
DECIMAL .XX ± .03 DECIMAL .XXX ± .010 ANGULAR ± 1°		MFG APPL:	DATE:		SCALE: N/A		
REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.		ER:	DATE:		SHEET 1 OF 1		
		PROJECT OR FILE REFERENCE NO.		SCALE: N/A	DRAWING NO.: 19068	REV. D	

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