



- 10. LOWER END OF GUSSET TO BE .50" MAX FROM EDGE OF HANGER.
- 9. FULL LENGTH WELD ALONG HANGER TO SIDERAIL BEFORE INSTALLING GUSSET.
- 8. TERMINATE WELD .50" FROM FLANGE FREE EDGE UNLESS PRESCRIBED OTHERWISE BY THE TRAILER MANUFACTURER.
- 7. FOR PIPE BRACE USE 1.66" O.D. X .109" WALL STD MECHANICAL TUBING TO COMPLY WITH ASTM A500 GRADE B OR 1.25" SCH 40 PIPE OR BETTER.
- 6. EXCEPT AS NOTED GUSSET PROPORTIONS SHOWN ARE FOR REFERENCE ONLY. THE FINAL SIZE AND ORIENTATION OF THE HANGER GUSSET SHOULD BE DESIGNED FOR THE SPECIFIC MAIN BEAM AND CROSSMEMBER CONFIGURATION USED ON THE TRAILER. TAKE STEPS TO AVOID INADEQUATE LATERAL GUSSETING. CONSIDER CLEARANCE FOR THE 1.125" ROCKER BUSHING BOLT.
- 5. WELD GUSSET TO PIPE, INSIDE OF CENTER HANGER, AND TO CROSSMEMBER WEB.
- 4. WELD PIPE BRACE INSIDE WITH TWO .75" WELDS ON HORIZONTAL CENTERLINE OF PIPE AS SHOWN. WELD MUST PENETRATE HANGER SIDEPLATE AND PIPE BRACE.
- 3. WELD PIPE BRACE OUTSIDE ALL AROUND AS SHOWN. WELD MUST PENETRATE HANGER SIDEPLATE AND PIPE BRACE.
- 2. ALL WELDING SHOULD BE PERFORMED USING AWS E70XX OR ER70S-3/1-6 WELDING MATERIALS AND PRACTICES.
- 1. THIS RECOMMENDATION IS INTENDED TO PROVIDE A GENERAL GUIDELINE FOR THE INSTALLATION OF THE FABRICATED INTERMEDIATE WIDESPREAD CENTER SUSPENSION HANGERS. THE DESIGN AND PRODUCTION OF AN ADEQUATE STRUCTURE TO SUPPORT THE SUSPENSION IS THE SOLE RESPONSIBILITY OF THE TRAILER MANUFACTURER. THIS DOCUMENT IS NOT INTENDED TO PRESCRIBE SPECIFIC RECOMMENDATIONS FOR THE TRAILER DESIGN.

NEXT ASSY: NEXT		ER NO.	SYM	DATE	BY	CHK	APPD
TOLERANCES (UNLESS OTHERWISE SPECIFIED)		DRAWN:	JAJ	8/5/2014			
DECIMAL .XX ± .03		CHECKED:	SNM	8/7/2014			
DECIMAL .XXX ± .010		APPROVED:	RSB	8/11/2014			
ANGULAR ± 1°		MFG APPL:	MFG	8/11/2014			
REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.		ER:	2011108	8/11/2014			
		PROJECT OR FILE REFERENCE NO.:	PROJ.# 20080300 EPR.# 20080300-01				
		SCALE:	D SIZE - 1/4 B SIZE - 1/8				
		SHEET 1 OF 1		SIZE:	DRAWING NO.: 27532		
				REV.	1 OF 1		

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 DRAWING NO. 27532  
 REV. 1 OF 1