

FIGURE 1

1. THESE INSTRUCTIONS PROVIDE FOR THE REPLACEMENT OF SUSPENSION HANGERS ON SERIES 10 SLIDERS. PLEASE READ THEM IN THEIR ENTIRETY PRIOR TO PERFORMING ANY ACTION. THIS INSTRUCTION SET DOES NOT INCLUDE THE REMOVAL AND REPLACEMENT OF OTHER SUSPENSION COMPONENTS WHICH MAY BE REQUIRED FOR THE REMOVAL OF THE SPRING HANGERS.

SPRING HANGERS MAY REQUIRE REPLACEMENT DUE TO WEAR OR DAMAGE FROM COLLISION. INSTRUCTIONS FOR LEFT HAND SPRING HANGERS ARE SHOWN, RIGHT HAND HANGERS ARE SIMILAR. REFER TO SPECIAL WELDING INSTRUCTIONS, NOTES 3, 4, 5, & 6 PRIOR TO PERFORMING ANY WELDING.

2. PROCEDURES:


- A. HANGER REPLACEMENT IS POSSIBLE ONLY WHEN NO DAMAGE IS PRESENT IN THE SLIDING SUBFRAME. IT MAY BE NECESSARY TO CLEAN THE AREAS IN QUESTION PRIOR TO INSPECTION.
- B. CAREFULLY INSPECT THE SUBFRAME'S SIDERAIL, TOWER GUSSET, CROSSMEMBER, AND ATTACHMENT AREAS FOR CRACKS, BUCKLING, OR OTHER DAMAGE. IF STRUCTURAL PROBLEMS ARE NOTED IN THE SUBFRAME, STOP AND CONTACT HUTCHENS INDUSTRIES FOR FURTHER INFORMATION. IF NO SUBFRAME DAMAGE IS PRESENT, CONTINUE WITH THE REPLACEMENT PROCEDURE.

- C. REMOVE THE SPRING HANGER IN QUESTION. REMOVAL OF THE SPRING HANGER MAY BE PERFORMED USING MECHANICAL METHODS SUCH AS GRINDING OR SAWING OR THROUGH SPECIALIZED CUTTING PROCESSES SUCH AS PLASMA CUTTER, OXY-FUEL CUTTING, OR AIR CARBON ARC CUTTING. TAKE CARE TO AVOID DAMAGING THE SIDERAIL WHEN REMOVING THE SPRING HANGER.
- D. THE REPLACEMENT SPRING HANGER MUST BE ABLE TO BE POSITIONED SQUARE AND FLUSH WITH THE SIDERAIL. IF NECESSARY, REPAIR THE SIDERAIL BY FILLING WITH WELD AND/OR GRINDING FLUSH. CLEAN THE AREA IN PREPARATION FOR WELDING.
- E. LOCATE THE REPLACEMENT HANGER USING DIMENSIONS AS SHOWN IN FIGURE 1 AND TACK WELD OR CLAMP INTO PLACE. VERIFY THAT THE HANGER IS POSITIONED CORRECTLY.
- F. WELD THE SPRING HANGER AS SHOWN ON PAGE 2 OF THESE INSTRUCTIONS. TAKE NOTE THE SPECIAL WELDING INSTRUCTIONS IN NOTES 3, 4, 5, & 6.

G. CLEAN AND REPAINT THE AFFECTED AREAS TO AVOID CORROSION.

3. ALL WELDING SHOULD BE PERFORMED USING E70XX OR ER70 WELDING MATERIALS AND PRACTICES.

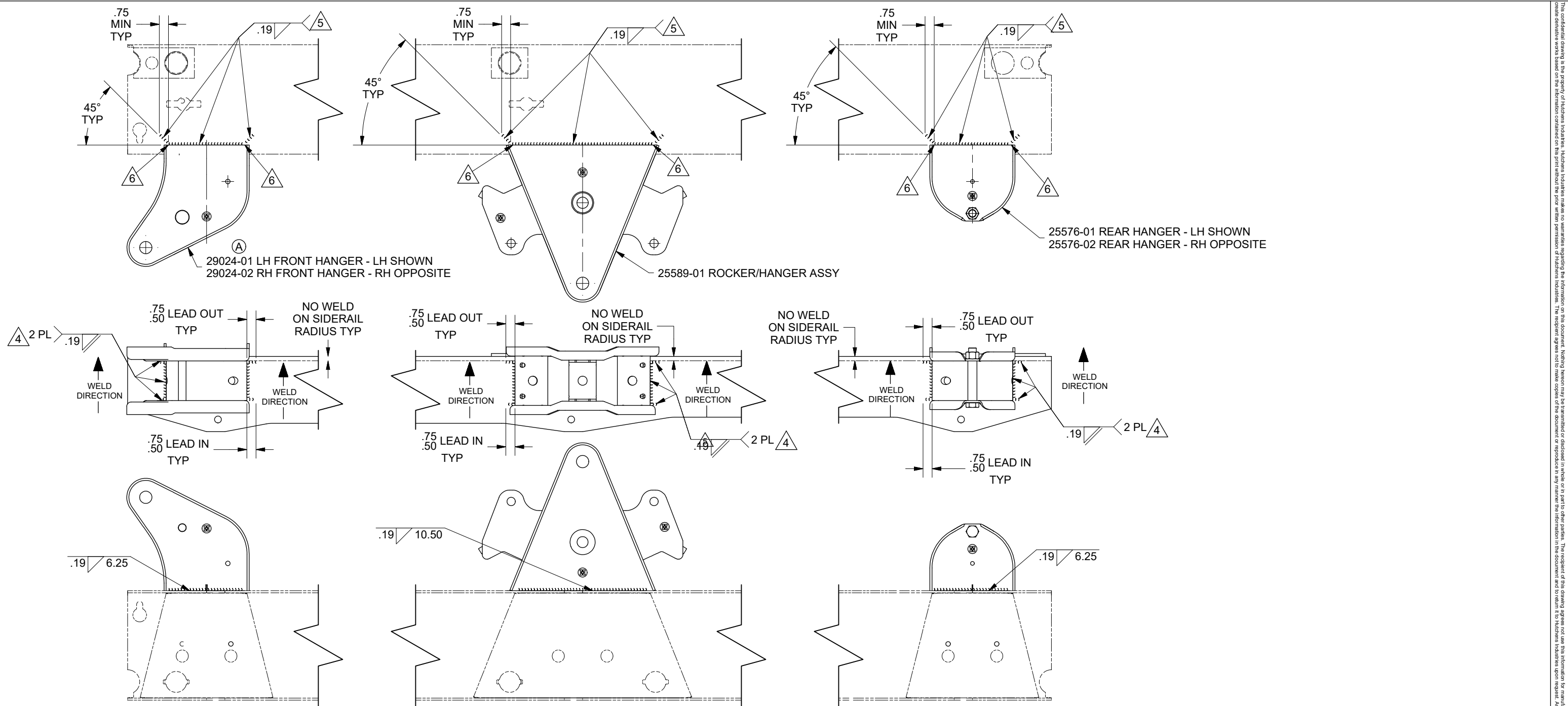
4. FRONT AND REAR HANGER WEAR PAD TO SIDERAIL WELDS AS WELL AS CENTER HANGER BUMPOUT TO SIDERAIL WELDS REQUIRE A .50" MIN/.75" MAX LEAD-IN AND LEAD-OUT AS SHOWN. WELDS TO BEGIN TOWARDS SIDERAIL FLANGE AND FINISH TOWARDS SIDERAIL WEB. .25" MAX CRATER PERMITTED AT END OF WELD. CRATER MUST NOT CONTACT MAIN BODY OF WELD AT HANGER JOINT. TIE INTO VERTICAL HANGER WELD AT TURN OF LEAD IN.
5. OUTER SIDEPLATE TO SIDERAIL WELDS REQUIRE A 45° LEAD-IN AND LEAD-OUT AS SHOWN. MAX WELD SIZE: .19 X .25. NO OVERLAP OR UNDERCUTTING ON HANGER SIDEPLATES. .50" MAX CRATER PERMITTED AT END OF WELD.
6. DO NOT NOTCH HANGER SIDEPLATES AT LEAD-IN OR LEAD-OUT OF WELDS.

2018010		A	PICTORIALLY UPDATED THE DRAWING TO SHOW THE 29024-XX FRONT HANGER INSTEAD OF THE 25575-XX FRONT HANGER				01/18	JAJ	SNM	RSB
ER NO.		SYM	REVISIONS				DATE	BY	CHK	APPRD
DRAWN:		JAJ	DATE:		7/5/2012		 HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI			
CHECKED:		CJP	DATE:		7/11/2012					
APPROVED:		RSB	DATE:		7/13/2012					
MFG APPL:		N/A	DATE:		XX/XX/XX		REPLACEMENT INSTRUCTIONS FOR SERIES 10 HANGERS			
ER:		2012109	DATE:		7/13/2012					
PROJECT OR FILE REFERENCE NO.		PROJ.#: 20122000 EPR#: 20122000-01								
SCALE:		D SIZE - 1/8 B SIZE - 1/16		SHEET 1 OF 2		SIZE:	D	DRAWING NO.:		26474
REV.		A								

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.

REPLACEMENT INSTRUCTIONS
FOR SERIES 10 HANGERS



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ER NO.		SYM	REVISIONS				DATE	BY	CHK	APPD
NEXT ASSY: NEXT			DRAWN:	JAJ	DATE:	7/5/2012	<div></div> <div>HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI</div>			
(UNLESS OTHERWISE SPECIFIED)			CHECKED:	CJP	DATE:	7/11/2012				
			APPROVED:	RSB	DATE:	7/13/2012				
			MFG APPL:	N/A	DATE:	XX/XX/XX				
DECIMAL .XX ± .06			ER:	2012109	DATE:	7/13/2012	REPLACEMENT INSTRUCTIONS FOR SERIES 10 HANGERS			
DECIMAL .XXX ± .030			PROJECT OR FILE REFERENCE NO.							
ANGULAR ± 1°			PROJ#: 20122000							
HOLES:			EPR#: 20122000-01							
.50 DIA AND LESS: ± .007			SCALE:				SHEET 2 OF 2		SIZE: D	
.51 DIA AND GREATER: ± .01										
REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.			D SIZE - 1/8				DRAWING NO.: 26474		REV. A	
			B SIZE - 1/16							