

X = TACK WELD

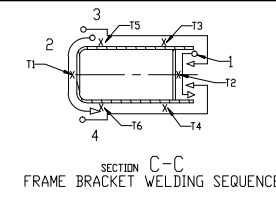
T1 FIRST
T2 SECOND
T3 THIRD
T4 FOURTH
T5 FIFTH
T6 SIXTH

WELD RUN PROCEDURE AFTER TACK WELDING

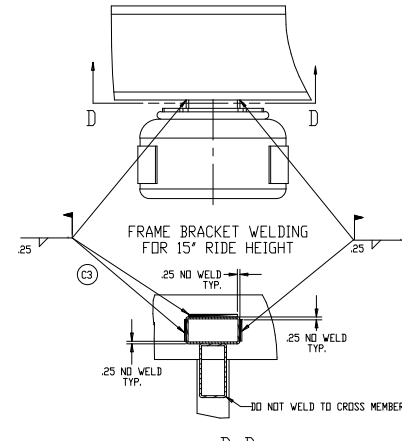
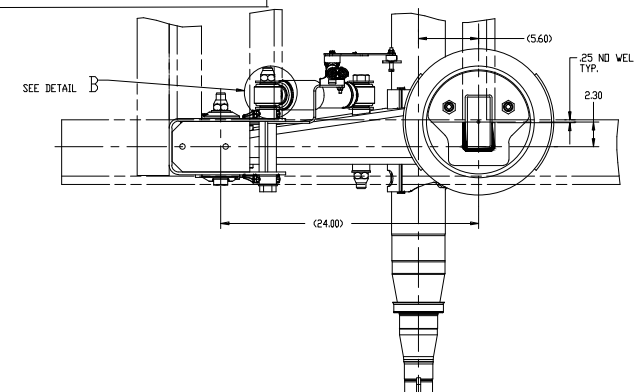
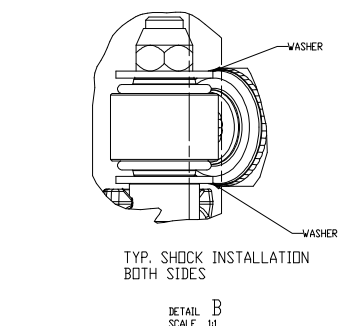
START

STOP

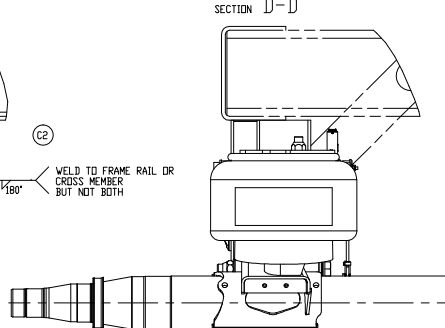
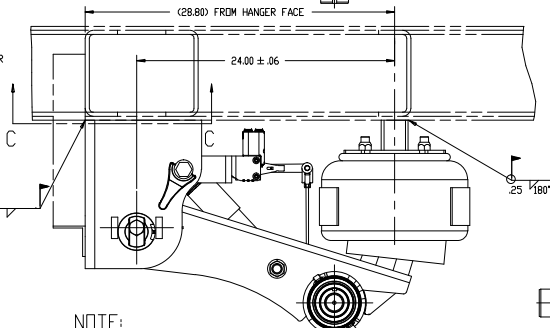
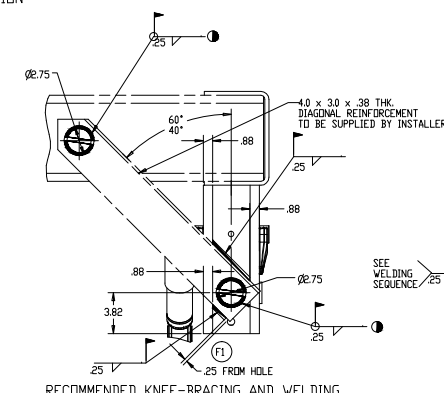
1 FIRST RUN
2 SECOND RUN
3 THIRD RUN
4 FOURTH RUN



5-66240K_01			
REVISEMENTS			
A	RELEASED 5-66240K_01 FOR PRODUCTION.	109615	CH HN 11/13/09
B	REVISED AIR SPRING PEDESTALS	11063	CH SS 12/03/09
C	ADDED NOTE 2-3-REVISED WELD	113786	CH SS 10/04/10
D	ADDED TACK WELDS AND REVISED WELDING SEQUENCE	115034	CH SS 02/23/11
E	SHOP CHART WAS 4-60559_09	115433	CH SS 04/27/11
F	D WAS .25 FROM EDGE, E WAS 1/2" FROM TOOLING HOLE	115875	CH SS 10/10/11



FILE NAME	REVISOR
5-66240K	
5-66240K	

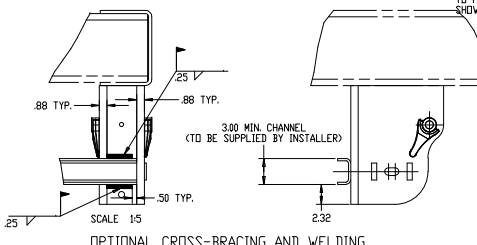


NOTE:

PROPER VEHICLE FRAME DESIGN IN THE AREA OF SUSPENSION ATTACHMENT IS THE RESPONSIBILITY OF THE INSTALLER.

ALL WELDING TO COMPLY WITH AWS STANDARDS 70 KSI MIN. WELD WIRE TENSILE STRENGTH.

NO WELDING OR DRILLING ALLOWED ON TRAILING ARMS. NO WELD WITHIN .25" OF FRAME BRACKET TOOLING HOLES.



FOR GENERAL ARRANGEMENT INFORMATION SEE DRAWINGS 5-66241Q_01 & 5-66241V_01

APPLICABLE SPECIFICATIONS WELDING ENGINEERING STANDARDS 3-804		THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY HENDER AND NOTHING HEREIN MAY BE REPRODUCED, COPIED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF HENDER.		MATERIAL		SEE BILL OF MATERIAL FOR SPECIFIC INDIVIDUAL MODEL INFORMATION		109615		PART/DOC NO. 5-66240K_01		LIC. 00050	
DESIGNER	DATE	BY	CHKD BY	DATE	BY	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE
SS		HN	CH	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09	28-May-09
APP. NO.	DCR 16105-008	NTA23T	SCALE	1:4	DESIGN CONTROL GROUP	V.V. TRAILER PRODUCTS	PRINT NO.						

DO NOT CHANGE MANUALLY