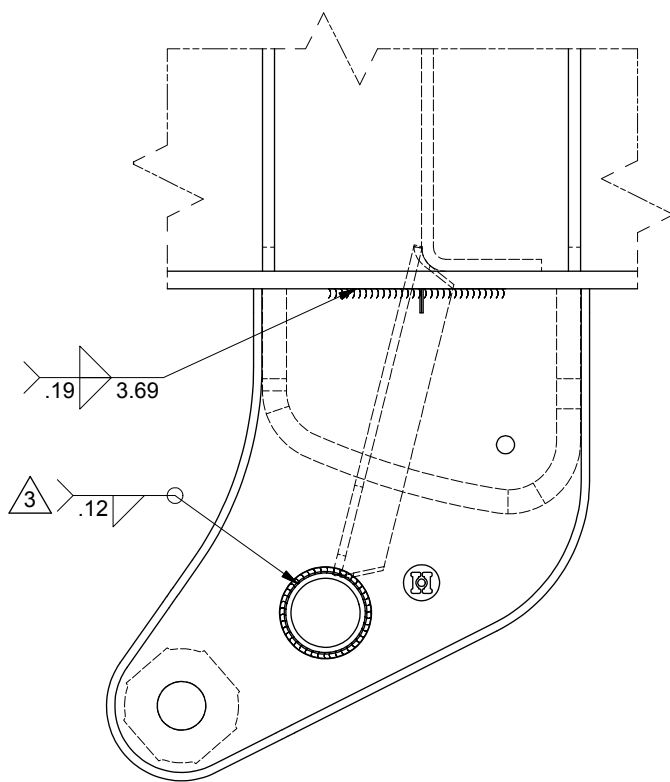
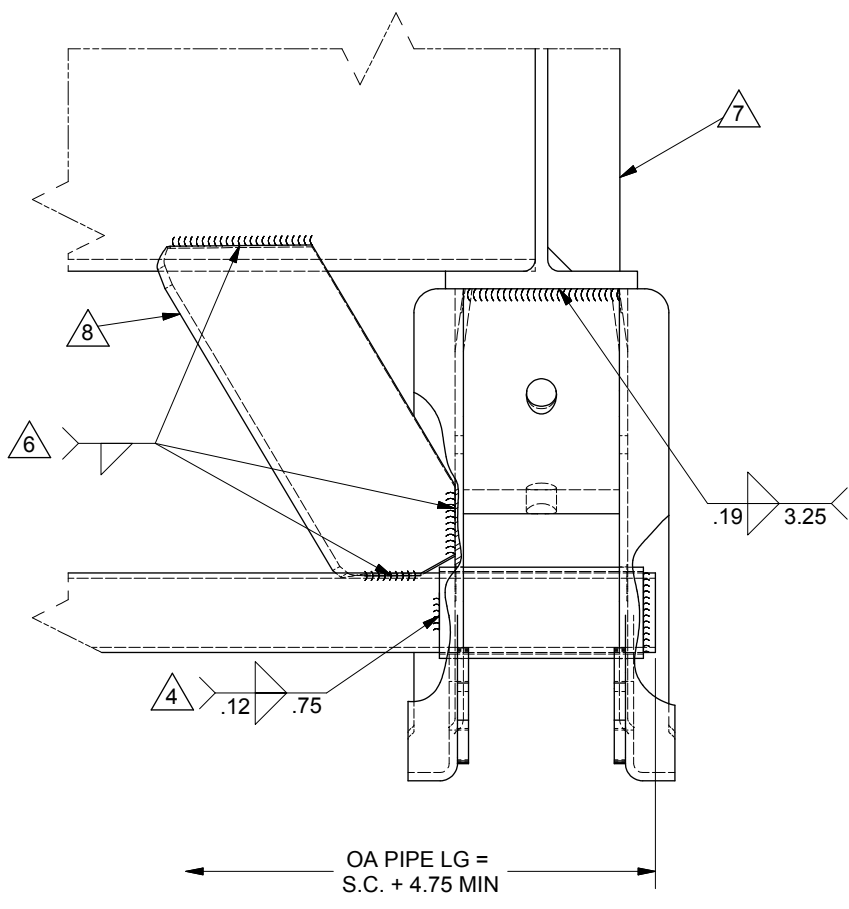
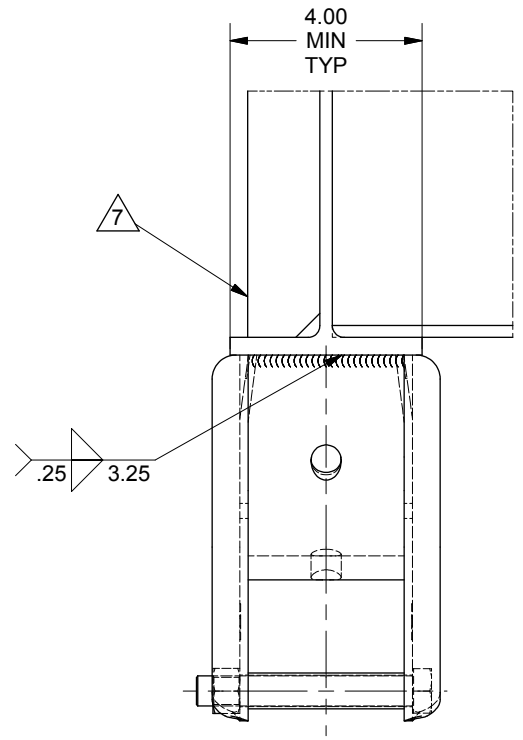
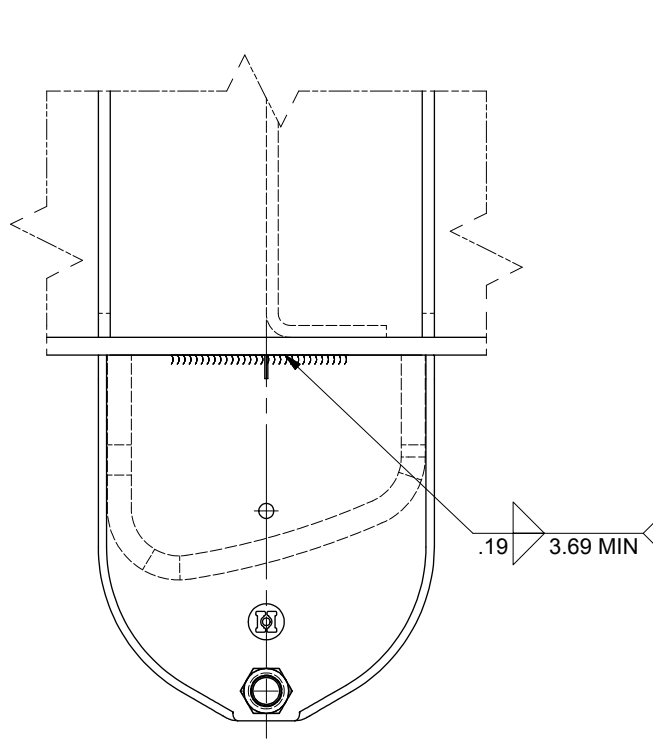



This confidential drawing is the property of Hutchens Industries, Inc. Hutchens Industries makes no warranties regarding the information on this document. Nothing herein may be transmitted or disclosed in whole or in part to other parties. The recipient of this drawing agrees not to use the information for manufacturing, nor will they modify, distribute, reverse engineer, or create derivative works based on the information contained on the print without the prior written permission of Hutchens Industries, Inc. 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.



OA PIPE LG =
S.C. + 4.75 MIN

9. 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.
8. EXCEPT AS NOTED GUSSET PROPORTIONS SHOWN ARE FOR REFERENCE ONLY. THE FINAL SIZE AND ORIENTATION OF THE LATERAL HANGER GUSSET SHOULD BE DESIGNED FOR THE SPECIFIC MAIN BEAM AND CROSSMEMBER CONFIGURATION USED ON THE TRAILER. TAKE STEPS TO AVOID INADEQUATE LATERAL GUSSETING.
7. STIFFENERS MAY BE REQUIRED BOTH SIDES OF WEB DEPENDING ON FLANGE WIDTH AND THICKNESS.
6. WELD GUSSET TO PIPE, INSIDE OF FRONT HANGERS, AND CROSSMEMBER WEB.
5. TERMINATE WELD .50" FROM FLANGE FREE EDGE UNLESS PRESCRIBED OTHERWISE BY TRAILER MANUFACTURER.
4. WELD PIPE BRACE INSIDE WITH TWO .75" WELDS ON HORIZONTAL CENTERLINE ON 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-3/6 WELDING MATERIALS AND PRACTICES.
1. THIS RECOMMENDATION IS INTENDED TO PROVIDE A GENERAL GUIDELINE FOR THE INSTALLATION OF THE FABRICATED UNDERMOUNT I-BEAM 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.

2011108	C	REDRAWN - REMOVED METRIC EQUIVALENTS. UPDATED GUSSET QTY FROM 1 GUSSET TO 2 GUSSETS AT EACH HGR	07/11	JAJ	SNM	RSB
ER NO.	SYM	REVISIONS	DATE	BY	CHK	APPD
DRAWN:	KC	DATE:	6/23/1992	 HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI		
CHECKED:	SNM	DATE:	8/5/1992			
APPROVED:	RSB	DATE:	8/12/1992			
MFG APPL:	CB	DATE:	7/21/1993			
ER:	9218	DATE:	8/12/1992	TITLE: INSTALLATION DRAWINGS UNDERMOUNT I-BEAM HANGERS FABRICATED 9600 & 9700		
PROJECT OR FILE REFERENCE NO.			PROJ.# 91-3100 REC.# 913100-02			
SCALE:			D SIZE - 1/2 B SIZE - 1/4			
NEXT ASSY:			SHEET 1 OF 1		DRAWING NO. 16487	
TOLERANCES (UNLESS OTHERWISE SPECIFIED)			REV. C 1 OF 1			
DECIMAL .XX ± .03 DECIMAL .XXX ± .010 ANGULAR ± 1°			REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.			