



- 7. STIFFENERS MAY BE REQUIRED BOTH SIDES OF WEB DEPENDING OF FLANGE WIDTH AND THICKNESS.
  - 6. WELD GUSSET TO PIPE, INSIDE OF FRONT AND CENTER HANGERS, AND TO CROSSMEMBER WEB.
  - 5. TERMINATE WELD .50" FROM FLANGE FREE EDGE UNLESS PRESCRIBED OTHERWISE BY THE TRAILER MANUFACTURER.
  - 4. WELD PIPE BRACE INSIDE WITH TWO .75" WELDS ON HORIZONTAL CENTERLINE OF PIPE AS SHOWN FRONT AND CENTER HANGERS. WELD MUST PENETRATE HANGER SIDEPLATE AND PIPE BRACE.
  - 3. WELD PIPE BRACE OUTSIDE ALL AROUND AS SHOWN, FRONT AND CENTER HANGERS. WELD MUST PENETRATE HANGER SIDEPLATE AND PIPE BRACE.
2. ALL WELDING SHOULD BE PERFORMED USING AWS E70XX OR E70S-3/16 WELDING MATERIALS AND PRACTICES.
1. THIS RECOMMENDATION IS INTENDED TO PROVIDE A GENERAL GUIDELINE FOR THE INSTALLATION OF THE FABRICATED UNDERMOUNT SUSPENSION HANGERS TO A 6" I-BEAM. 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.

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. 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. CONSIDER CLEARANCE FOR 1.125" ROCKER BUSHING BOLT.

2011108	B	REDRAWN - REMOVED METRIC EQUIVALENTS - UPDATED GUSSET QTY FROM 1 GUSSET TO 2 GUSSETS AT EACH HGR	06/11	JAJ	SNM	RSB
ER NO.	SYM	REVISIONS	DATE	BY	CHK	APPD
DRAWN: DAN	DATE: 9/21/1994					HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI
CHECKED: DC	DATE: 1/9/1995					
APPROVED: RSB	DATE: 1/9/1995					
MFG APPL: MFG	DATE: XXX/XX/XX					
ER: 9335	DATE: 1/13/1995	<b>INSTALLATION DRAWING</b> <b>UN/MT HGR 6" I-BEAM</b> <b>FABRICATED 9600 &amp; 9700</b>				
PROJECT OR FILE REFERENCE NO. PROJ.# 923900 REC.# 923900-01		SCALE: D SIZE - 1/2 B SIZE - 1/4		SHEET 1 OF 1		D
REMOVE ALL SHARP BURRS & SHARP CORNERS THAT MIGHT AFFECT ASSEMBLY, APPEARANCE, OR OPERATION OF OUR PRODUCTS.		DRAWING NO. 16824		REV. 1 OF 1		B

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.