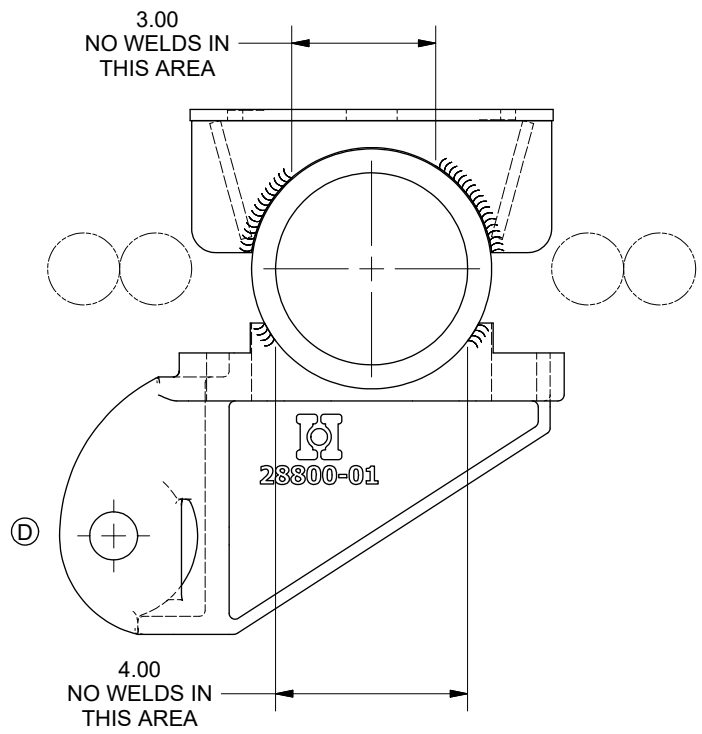
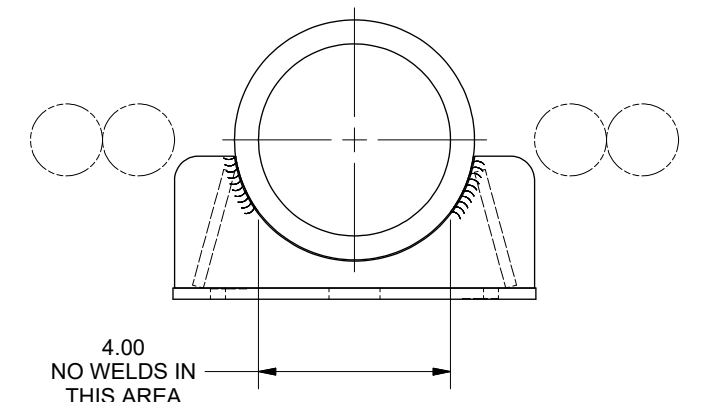


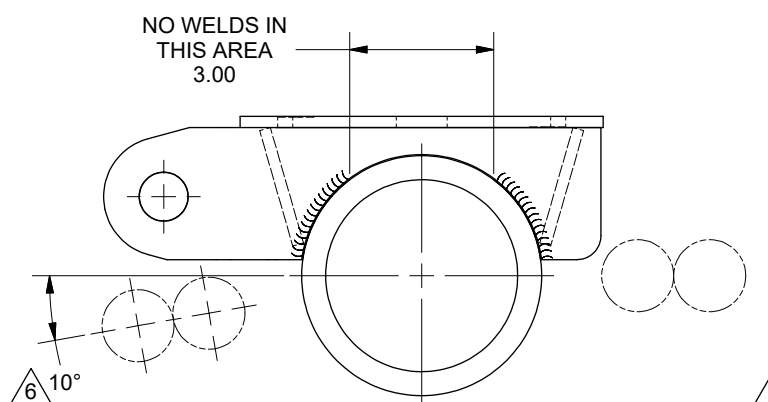
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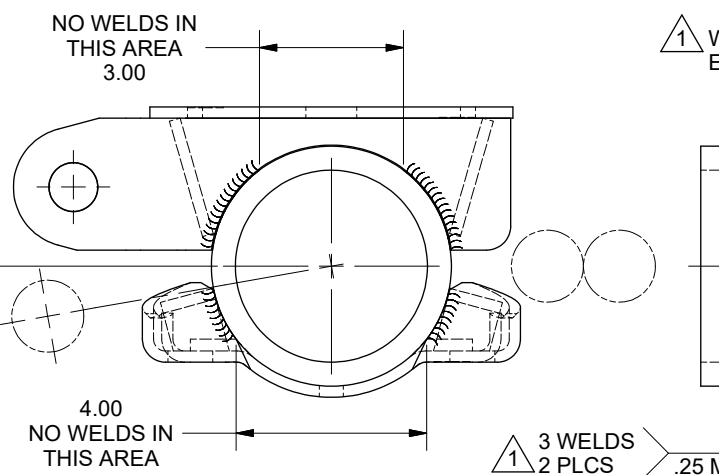
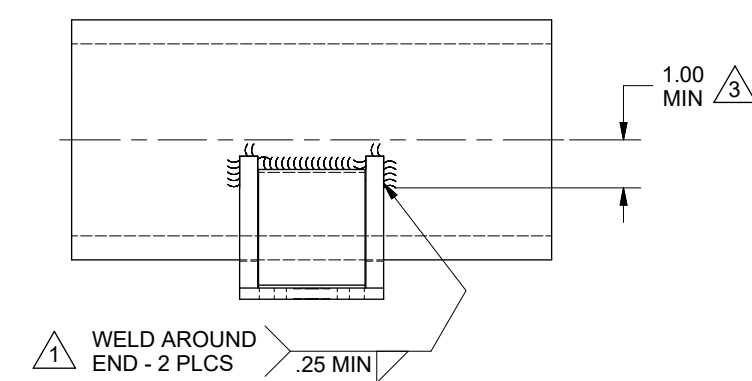
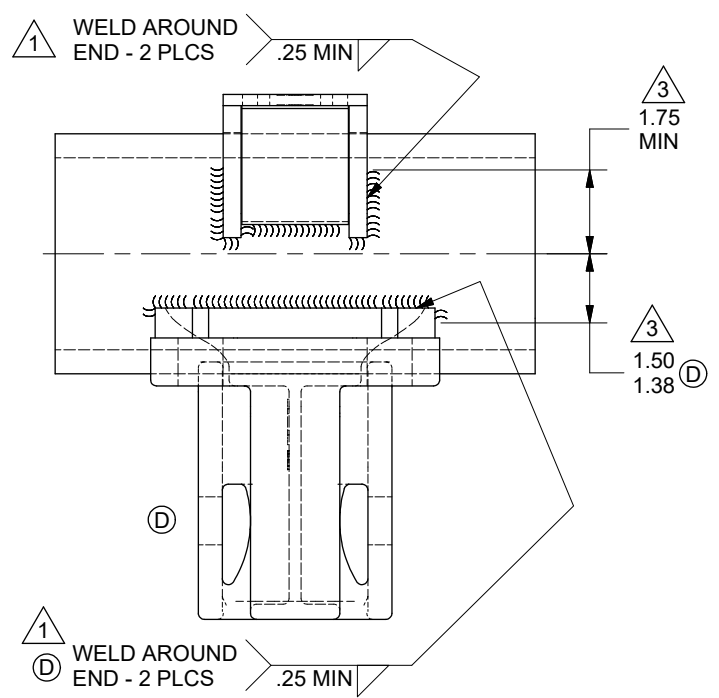
OPTIONAL NO-HOP CONFIGURATION
9700



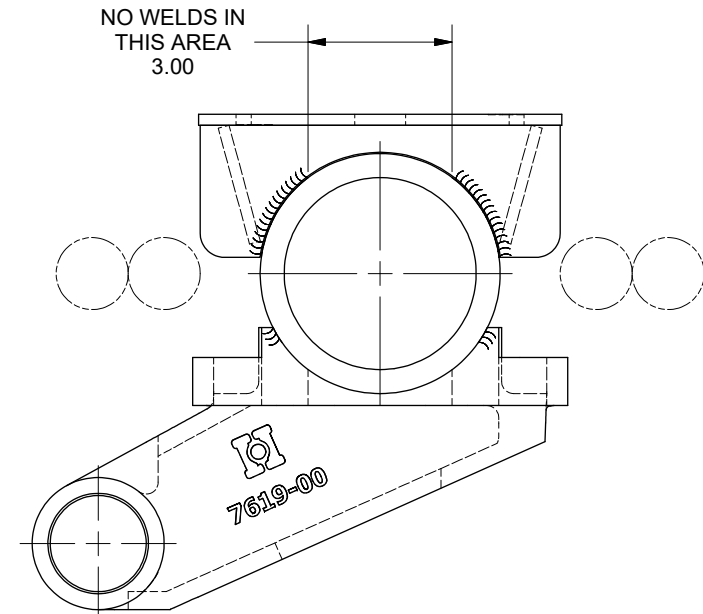
OPTIONAL UNDERSLUNG CONFIGURATION



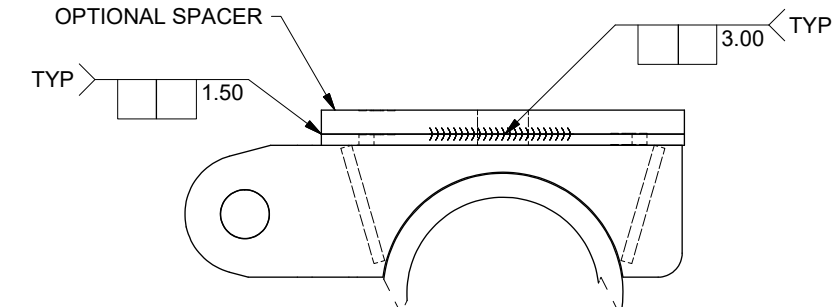
OPTIONAL INVERTED
U-BOLT CONFIGURATION



STANDARD OVERSLUNG CONFIGURATION



OPTIONAL CAST BOTTOM PLATE AND NO HOP CONFIGURATION
9600



SPRING SEAT SPACER INSTALLATION

7. WELD SEATS AND BOTTOM PLATES TO AXLE PRIOR TO INSTALLING SPRINGS.
6. FOR CAMS FORWARD APPLICATIONS POSITION CAMSHAFT 10° BELOW AXLE CENTERLINE WHEN USING SPRING SEATS SHORTER THAN 1.75"
5. ALL SPRING SEATS AND BOTTOM PLATES MUST BE PARALLEL WITHIN .032" TO INSURE PROPER INSTALLATION OF THE U-BOLTS AND POSITIONING OF SPRINGS AND AXLES.
4. ALL HUTCHENS COMPONENTS ARE WELDABLE USING E70XX OR ER70S-3/6 WELDING MATERIALS AND PRACTICES.
3. WELDS ARE NOT PERMITTED FURTHER THAN 2" ABOVE OR 1.5" BELOW THE HORIZONTAL CENTER LINE OF THE AXLE BEAM.
2. BE CERTAIN AXLE SEATS FIT AXLE PROPERLY BEFORE WELDING.
1. CHECK AXLE MANUFACTURER FOR ELECTRODE SPECIFICATION, WELD SIZE, PRE-HEAT AND POST-HEAT REQUIREMENTS, ETC.

2018109	D	REVISED 9700 NO HOP CONFIGURATION WAS SHOWING FABRICATED NO HOP, NOW CAST NO HOP.	07/18	ML	CJP	RSB
2016076	C	REVISED DIMENSIONS WERE "MAX" DIMENSIONS, NOW "MIN" DIMENSIONS.	04/16	JAJ	SNM	RSB
2011108	B	REDRAWN - UPDATED DEFAULT DRAWING TOLERANCE.	06/11	JAJ	SNM	RSB
ER NO.	SYM	REVISIONS	DATE	BY	CHK	APPD

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.	DRAWN: DAN DATE: 9/26/1994 CHECKED: DC DATE: 1/9/1995 APPROVED: RSB DATE: 1/9/1995 MFG APPL: N/A DATE: XX/XX/XX ER: 9335 DATE: 1/13/1995 PROJECT OR FILE REFERENCE NO.: REC.# 923900-01 REC.# 923900-01	HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI	TITLE: AXLE INSTALLATION 5" RD STANDARD, UNDERSLUNG, & NO-HOP 9600 & 9700
SCALE: D SIZE - 1/2 B SIZE - 1/4	SHEET 1 OF 1	D	DRAWING NO.: 16834

DRAWING NO. 16834
 REV. D 1 OF 1