

DO NOT SCALE – IF IN DOUBT ASK

ALL DIMENSIONS IN MILLIMETRES
TOLERANCES CLASS II UNLESS
OTHERWISE SPECIFIED
WELD SYMBOLS TO AS1101.3-1987

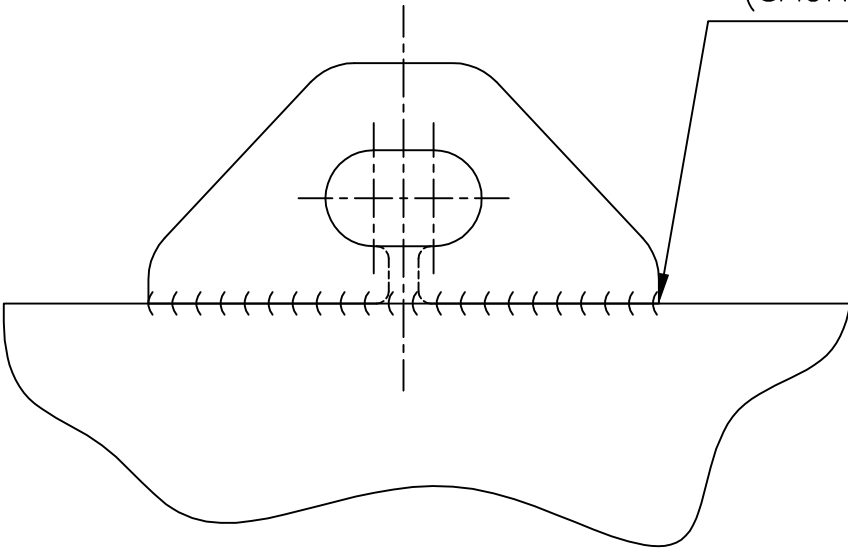
DRAWING LIMITATIONS:

REPLACEMENT OF DAMAGED/CORRODED LUG ONLY,
NOT FOR INSTALLATION OF NEW LUGS.
EXCLUDES LUGS ON SUSPENSION COMPONENTS OR AXLES
UNLESS EXPRESSLY PERMITTED BY AXLE/SUSPENSION MANUFACTURER

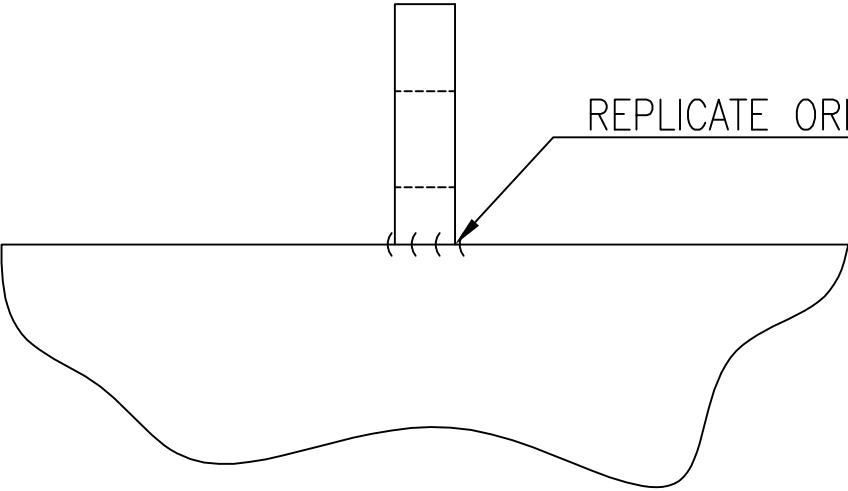
NOTES:

1. WELDING OF STEEL SECTIONS TO COMPLY WITH AS/NZS1554 PART 1(CATEGORY SP)
 - WELDING AND JOINT PREP. TO COMPLY WITH SECTION 4.
 - WELDER TO BE CURRENTLY CERTIFIED TO CLAUSE 4.11.2 IN APPROPRIATE POSITIONS AND TECHNIQUES USED. (ALL POSITIONS AND STEELS UP TO CLASS 3 MIN.)
 - WELDING CONSUMABLES TO COMPLY WITH SECTION 4.5 FOR THE TYPE AND GRADE OF MATERIALS USED.
 - INSPECTION TO BE CARRIED OUT AS PER SECTION 7.
2. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
3. ENSURE WELDING COMPATIBILITY OF MATERIAL. THIS REPAIR IS ONLY SUITABLE FOR CHASSIS MATERIAL UP TO 350 MPa YIELD. CONSULT AN ENGINEER WITH THE CHASSIS CATEGORY IF HIGHER YIELD MATERIAL IS USED
4. ATTACHMENT AREA SURFACE TO BE CAREFULLY EXAMINED FOR CRACKS AFTER REMOVAL. ANY CRACKS FOUND TO BE REFERRED TO AN ENGINEER WITH THE CHASSIS CATEGORY

GRIND OUT OR ARC-AIR EXISTING LUG
DO NOT DAMAGE MOUNTING SURFACE
(SACRIFICE THE LUG)



SIDE VIEW



END VIEW

REPLICATE ORIGINAL WELD

CONDITIONS:

REPLACE LUG IF DAMAGE OR WEAR IS GREATER
THAN 10% OF ORIGINAL DIMENSIONS

INSTRUCTIONS:

MATCH EXISTING LUGS FOR: – PROFILE
– WELD DETAIL
– MATERIAL

WORKSHOP	
OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.
JOB #	

C			
B		UPDATED FOR ISSUE IN NZTA VIRM	
A	09/07/19	FIRST ISSUE TO CLIENT	
ISSUE	DATE	CHANGES MADE	BY

ITEM	QTY	MATERIAL	DESCRIPTION	DRAWING
REPLACEMENT ANCHOR LUGS			4 – MRCP – A002	Sheet: 1/1
Fy < 350 MPa			Drawn: R.F.	Issue: B
Job: 12726			Ref: MRCP-A002	Chkd:
Scale: NTS			Date: 30/10/2015	Date: