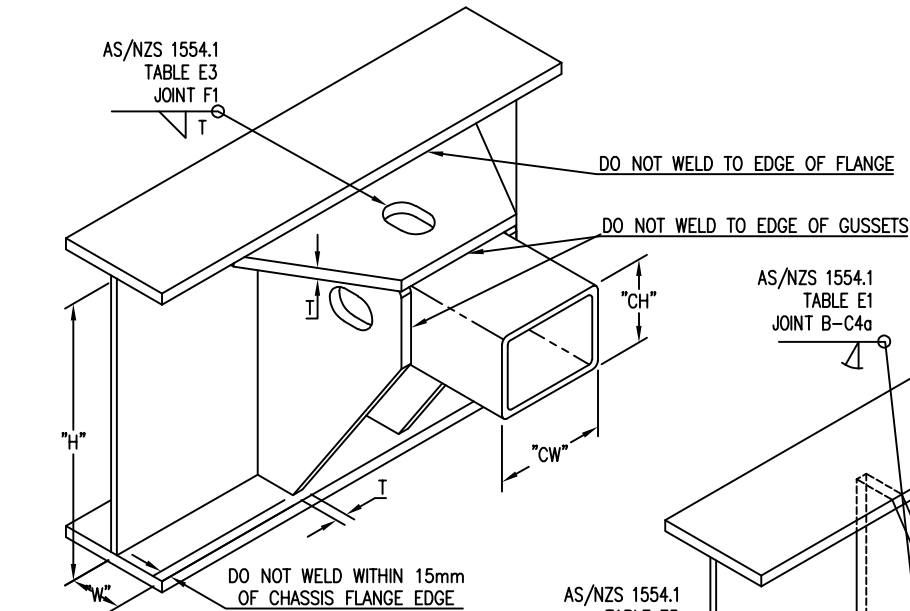


DO NOT SCALE – IF IN DOUBT ASK

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



DRAWING LIMITATIONS:

CROSSMEMBER AND GUSSET CRACKS ONLY
OR CROSSMEMBER REPLACEMENT
CHASSIS WEB, CHASSIS FLANGE OR CHASSIS
WELDS ARE EXPRESSLY EXCLUDED

NOTES:

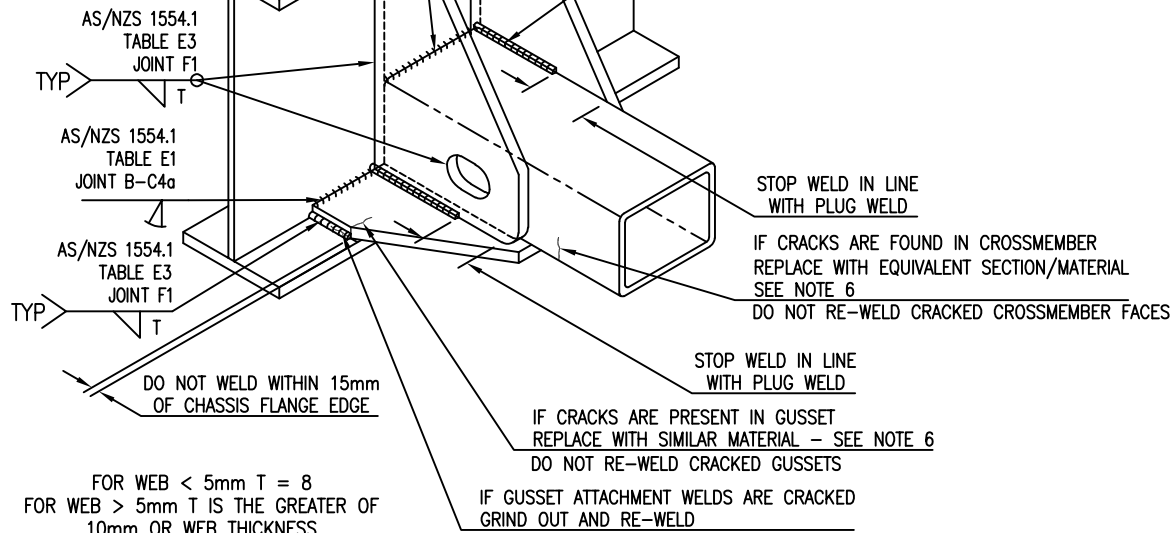
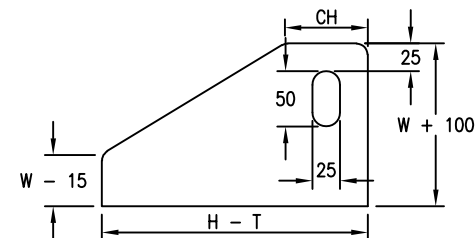
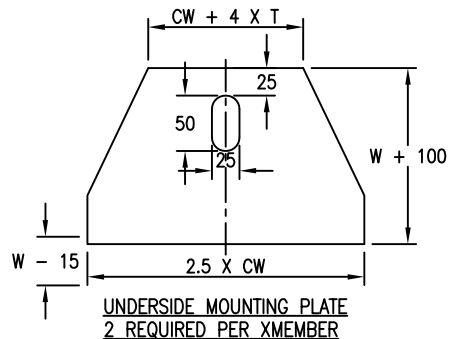
- WELDING OF STEEL SECTIONS TO COMPLY WITH AS/NZS1554 PART 1 (CATEGORY SP)

MATERIAL YIELD STRENGTH < 1000Mpa, > 500Mpa TO COMPLY WITH: PART 4[CATEGORY SP OR FP(SPECIFIED)]

-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.
-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.
- RHS TO COMPLY WITH AS 1163, GRADE 350 OR EQUIVALENT, AND TO MEET CHARTY IMPACT REQUIREMENTS AS STATED IN NZS 5446:1987 APPENDIX A2. (UNLESS SPECIFIED)
- STEEL PLATE MEET AS/NZS 3678 &/OR 3679 OR EQUIVALENT. (UNLESS SPECIFIED)
- REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
- 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
- ANY WELDED COMPONENT REMOVED FROM THE CHASSIS MUST BE REMOVED USING A CUTTING WHEEL, DISC OR OTHER ABRASIVE CUTTING DEVICE

LIMIT DAMAGE TO CHASSIS WEB/FLANGE

ATTACHMENT AREA SURFACE TO BE CAREFULLY EXAMINED FOR CRACKS AFTER REMOVAL. ANY CRACKS FOUND TO BE REFERRED TO AN ENGINEER WITH THE CHASSIS CATEGORY



OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.

C	06/09/24	UPDATED	K.H.
B	09/07/19	UPDATE FOR ISSUE IN NZTA VIRM	
A		FIRST ISSUE TO CLIENT	
ISSUE DATE	CHANGES MADE	BY	

tmmf
NZ Truck Trailer Manufacturers Federation Inc.

REPLACEMENT OR REPAIR OF TRAILER CROSSMEMBER
 $F_y < 350 \text{ MPa}$

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ITEM	QTY	MATERIAL	DESCRIPTION	DRAWING
4 – MRCP – C002				Sheet: 1/1
Drawn: R.F.		Issue: B		Chkd:
Scale: NTS		Date: 16/9/2015		Date:

Job: 12726

Ref: MRCP-C002