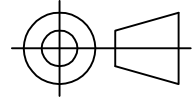


DRAWING LIMITATIONS:

CRACKS IN CHASSIS WEB ONLY
CRACK LENGTH < 30mm



DO NOT SCALE – IF IN DOUBT ASK

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

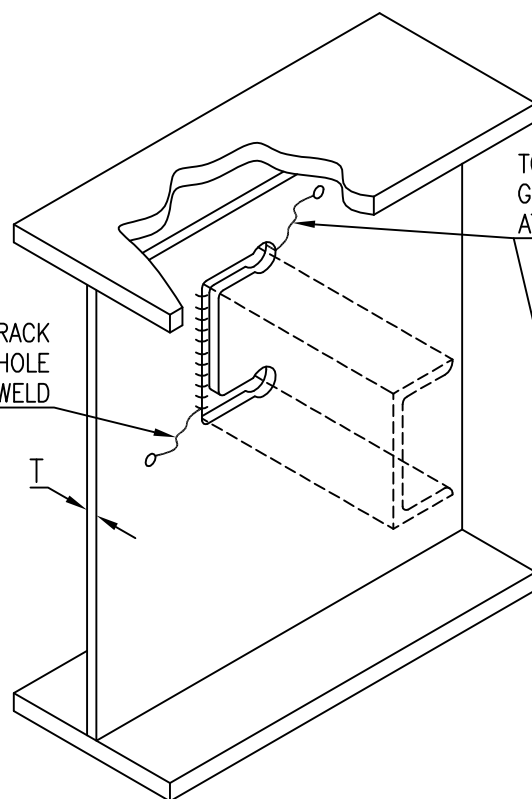
NOTES:

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. CHASSIS MATERIAL TO BE IDENTIFIED BEFORE REPAIR
ADDITIONAL MATERIAL TO BE EQUIVALENT
3. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
4. ENSURE WELDING COMPATIBILITY OF MATERIAL.
THIS REPAIR IS ONLY SUITABLE FOR CHASSIS MATERIAL UP TO 350 MP_a YIELD. CONSULT AN ENGINEER WITH THE CHASSIS CATEGORY IF HIGHER YIELD MATERIAL IS USED
5. STEEL PLATE TO MEET AS/NZS 3678 &/OR 3679 OR EQUIVALENT (UNLESS SPECIFIED)

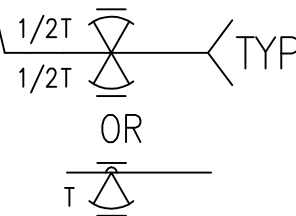
WELD SYMBOLS TO AS/NZS 1554.1

SYMBOL	JOINT	TABLE
	B-C2a	E1
	B-C3	E1
	F1	E3

HEEL CRACK
GRIND OUT, DRILL $\phi 3$ mm HOLE
AT END OF CRACK AND RE-WELD

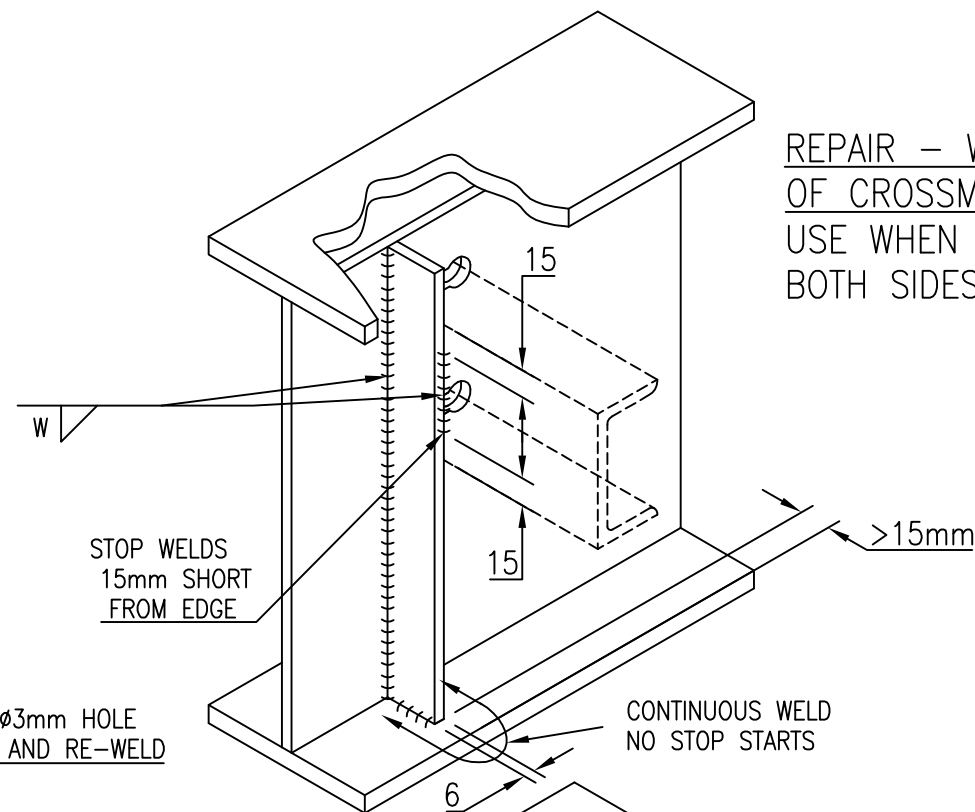


TOE CRACK
GRIND OUT, DRILL $\phi 3$ mm HOLE
AT END OF CRACK AND RE-WELD



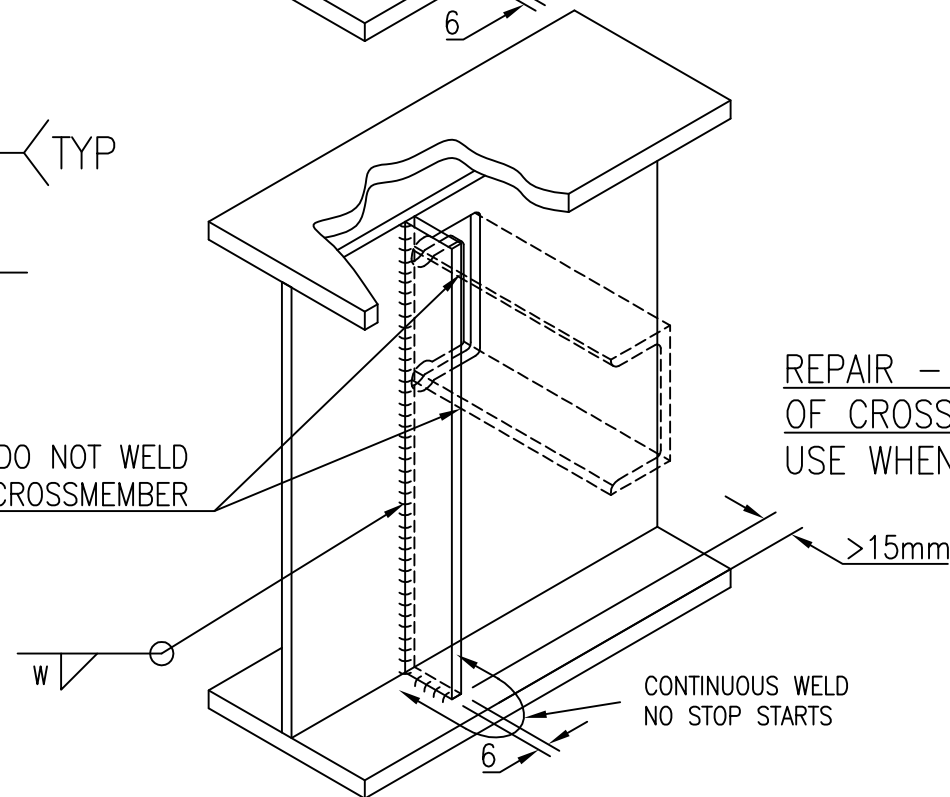
CRACK DETAIL – HEEL OR TOE
INSTALL STIFFENER ON ONE SIDE ONLY
T = THICKNESS OF WEB (mm)
W = MIN = 4mm
MAX = 1.5 X T

STOP WELDS
15mm SHORT
FROM EDGE



REPAIR – WEB SIDE
OF CROSSMEMBER
USE WHEN WEB OR
BOTH SIDES CRACKED

DO NOT WELD
TO CROSSMEMBER



REPAIR – WEB SIDE
OF CROSSMEMBER
USE WHEN ONLY TOE SIDE CRACKED

WORKSHOP	
OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.
JOB #	

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

ttmf
N7 Truck Trailer Manufacturers Federation Inc.

WEB CRACKS AT X-MEMBER CUTOUTS
CHANNEL CROSSMEMBER AND CUTOUT. MATERIAL YIELD < 350 MP_a

4 – MRCP – C003

Sheet:
1/3

Drawn: R.F.

Issue: B

Chkd:

THIS DRAWING IS THE SOLE PROPERTY OF THE NZ TRUCK TRAILER MANUFACTURERS FEDERATION LTD. IS LOANED WITH THE EXPRESS CONDITION, IT IS NOT TO BE USED IN ANY WAY DELETERIOUS TO THE INTEREST OF NZ.T.T.M.F LTD. IT MUST NOT BE LOANED, COPIED, OR REPRODUCED WITHOUT WRITTEN CONSENT AND SHALL BE RETURNED UPON REQUEST

Job: 12726

Ref: MRCP-C003

Scale: NTS

Date: 2/11/2015

Date: