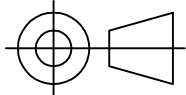


DRAWING LIMITATIONS:

CRACKS IN CHASSIS WEB ONLY
CRACK LENGTH < 30mm



DO NOT SCALE – IF IN DOUBT ASK

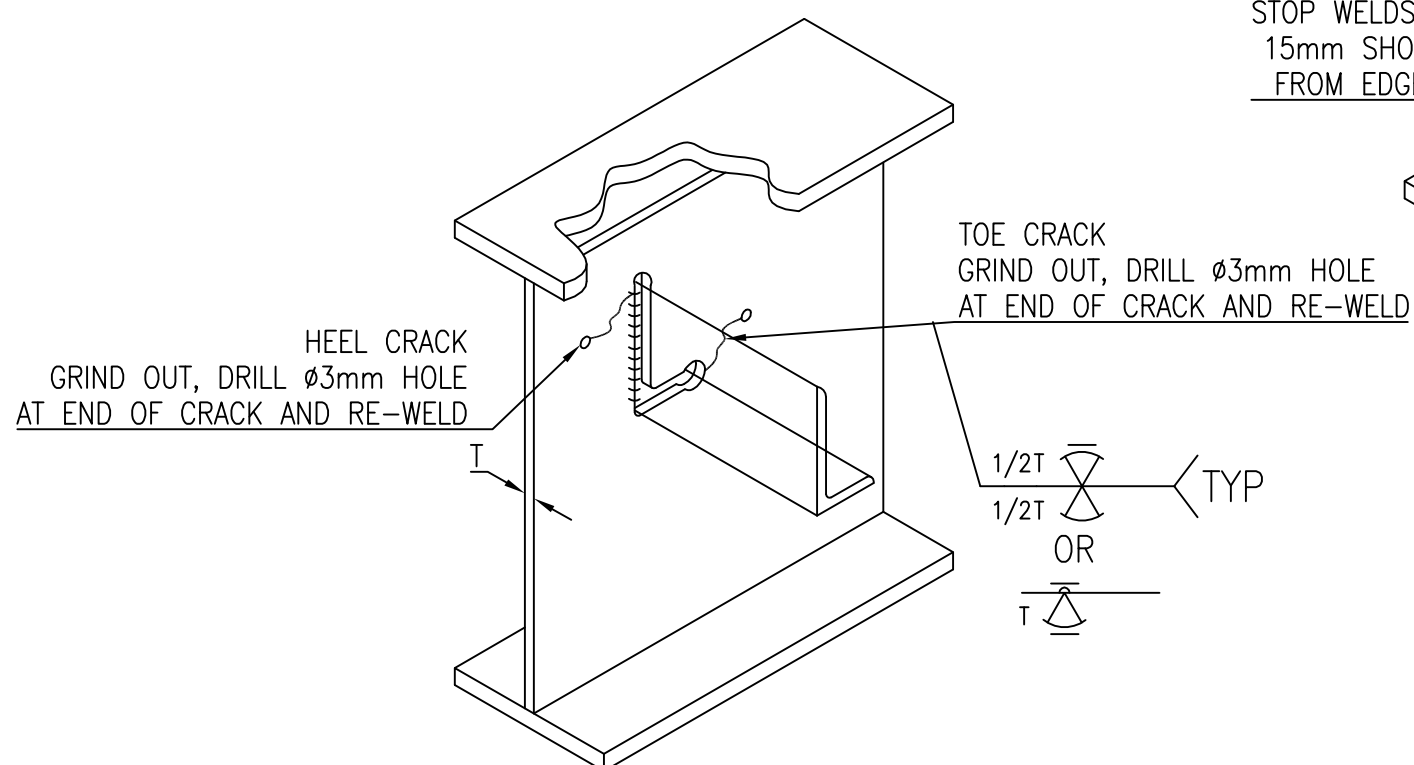
ALL DIMENSIONS IN MILLIMETRES
TOLERANCES CLASS II UNLESS
OTHERWISE SPECIFIED
WELD SYMBOLS TO AS1101.3-1987

NOTES:

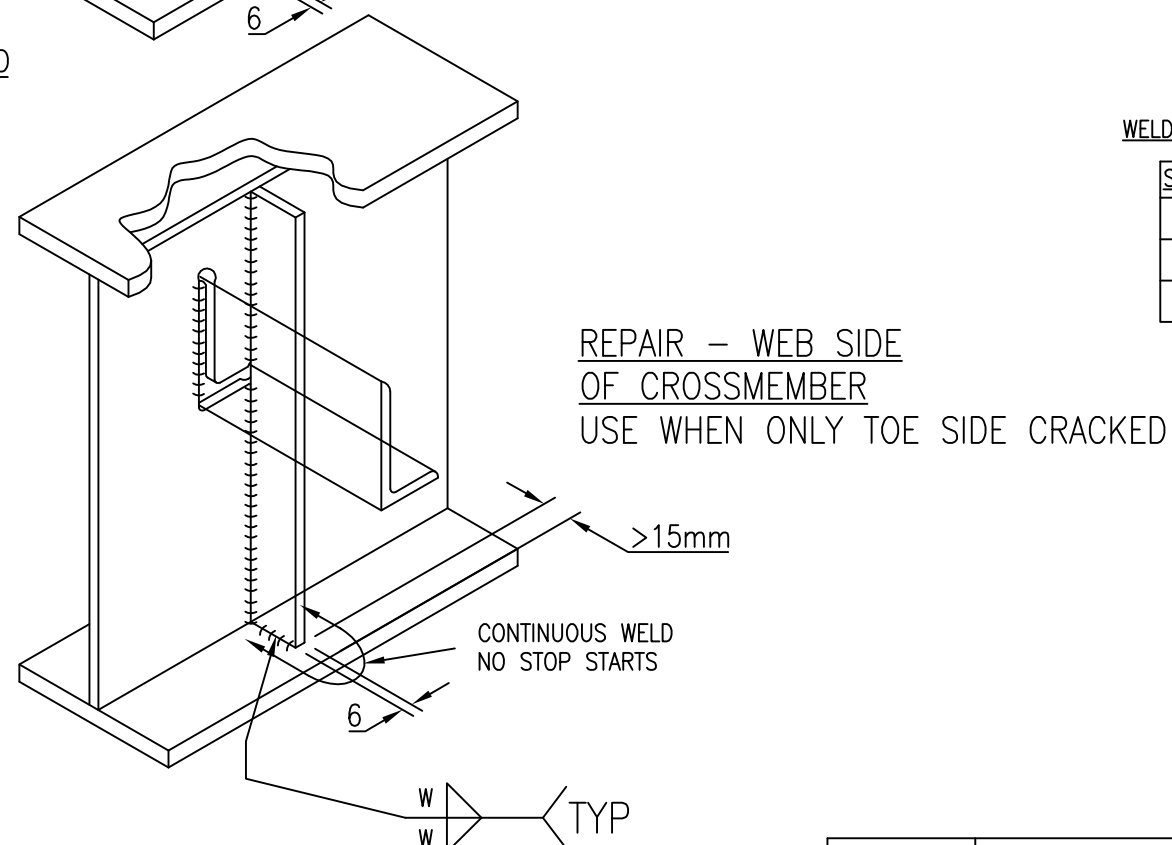
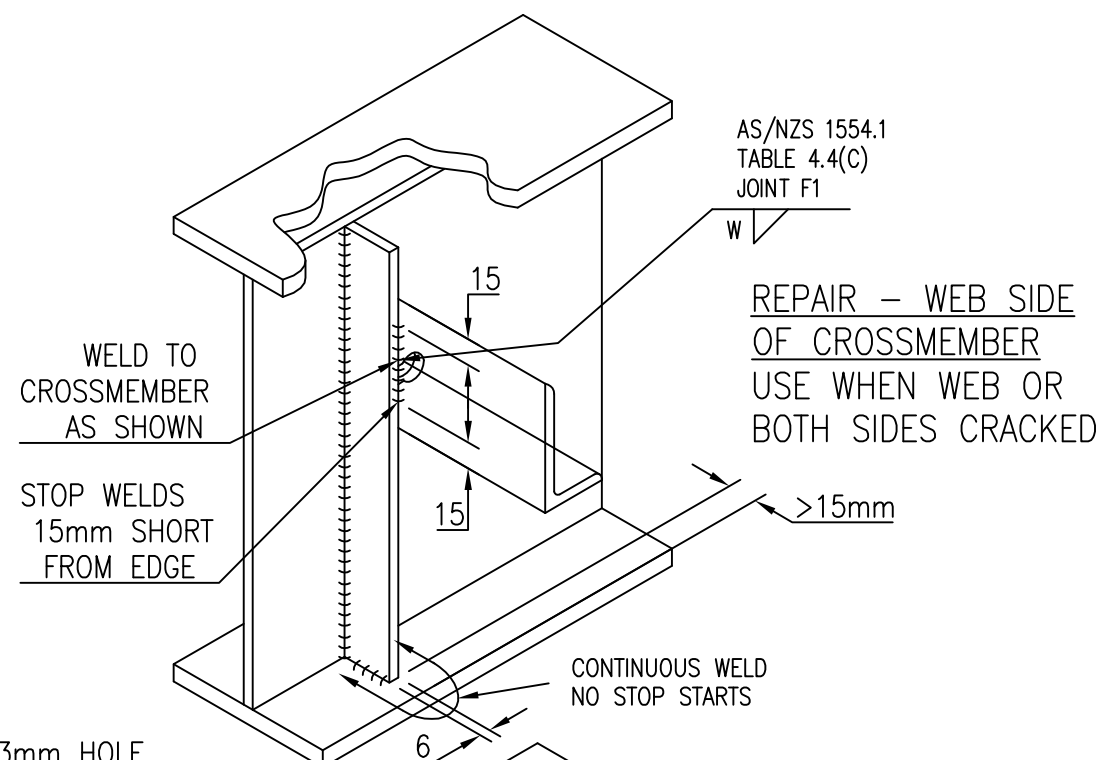
- WELDING OF STEEL SECTIONS TO COMPLY WITH AS/NZS1554 PART 1(CATEGORY SP)
 - WELDING AND JOINT PREP. TO COMPLY WITH SECTION 4.
 - WELDER TO BE CURRENTLY CERTIFIED TO CLAUSE 4.11.2 IN APPROPRIATE POSITIONS AND TECHNIQUES USED. (ALL POSITIONS AND STEELS UP TO CLASS 3 MIN.)
 - WELDING CONSUMABLES TO COMPLY WITH SECTION 4.5 FOR THE TYPE AND GRADE OF MATERIALS USED.
 - INSPECTION TO BE CARRIED OUT AS PER SECTION 7.
- CHASSIS MATERIAL TO BE IDENTIFIED BEFORE REPAIR
ADDITIONAL MATERIAL TO BE EQUIVALENT
- 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 MP_a YIELD. CONSULT AN ENGINEER WITH THE CHASSIS CATEGORY IF HIGHER YIELD MATERIAL IS USED
- 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



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



C			
B	09/07/19	UPDATED 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
ANGLE CROSSMEMBER AND CUTOUT. MATERIAL YIELD < 350 MP_a

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Job: 12726

Ref: MRCP-C003

Scale: NTS

Date: 2/11/2015

Date:

WORKSHOP	
OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.
JOB #	

4 – MRCP – C003

Sheet:
2/3

Drawn: R.F.

Issue: B

Chkd: