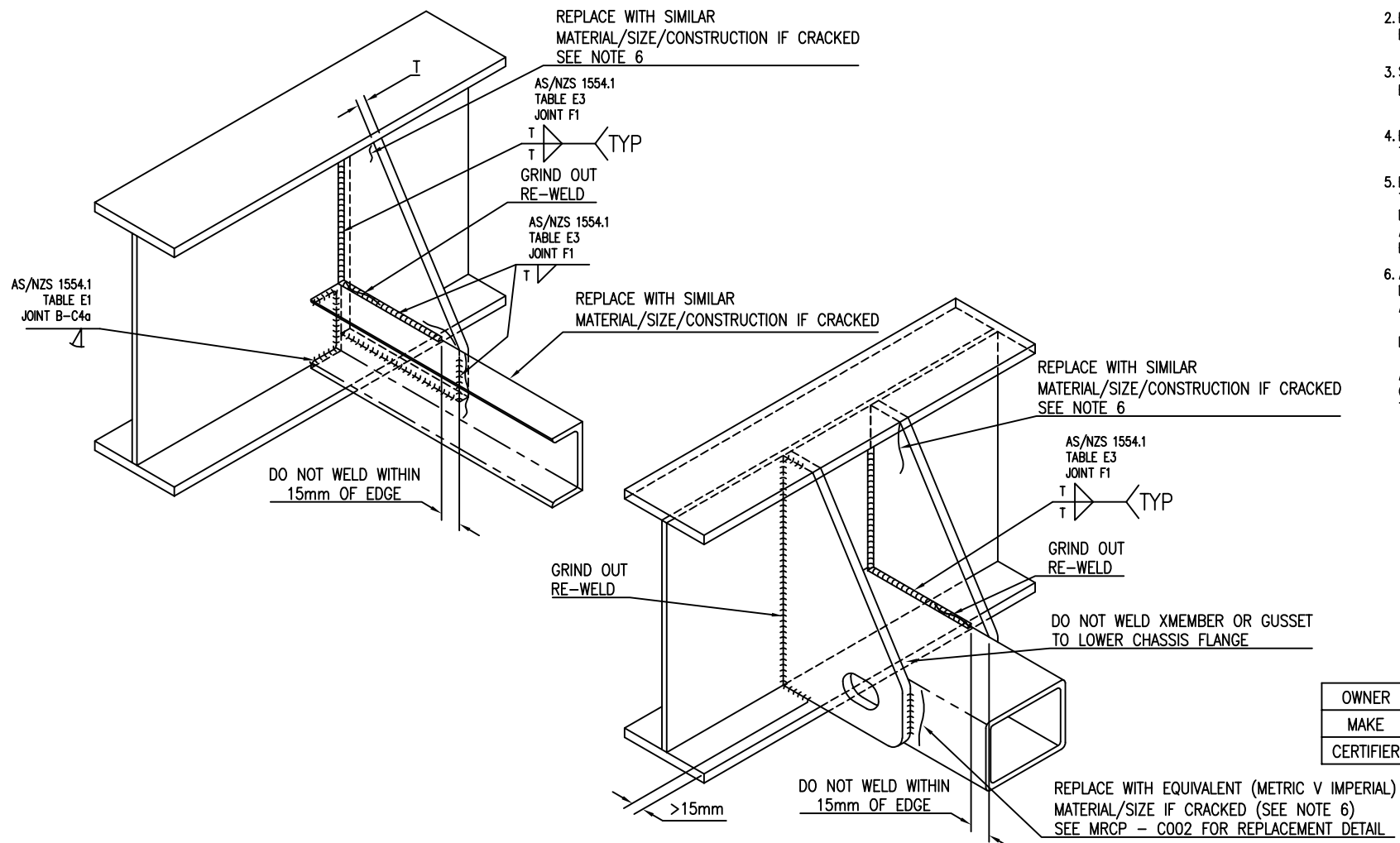


DO NOT SCALE – IF IN DOUBT ASK

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

DRAWING LIMITATIONS:

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



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.
 - 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. RHS TO COMPLY WITH AS 1163, GRADE 350 OR EQUIVALENT
3. STEEL SECTIONS MEET AS/NZS 3678 &/OR 3679, OR EQUIVALENT. (UNLESS SPECIFIED)
4. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
5. 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
6. 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	05/09/24	UPDATED	
B	09/07/19	UPDATE FOR ISSUE IN NZTA VIRI	
A		FIRST ISSUE TO CLIENT	
ISSUE DATE	CHANGES MADE	BY	

ttmf

NZ Truck Trailer Manufacturers Federation Inc.

CHASSIS CROSSMEMBER OR GUSSET CRACK MATERIAL YIELD < 350 MPa

4 – MRCP – C004

Sheet: 1/1

Drawn: R.F.	Issue: B	Chkd:
Scale: NTS	Date: 8/4/2014	Date:

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