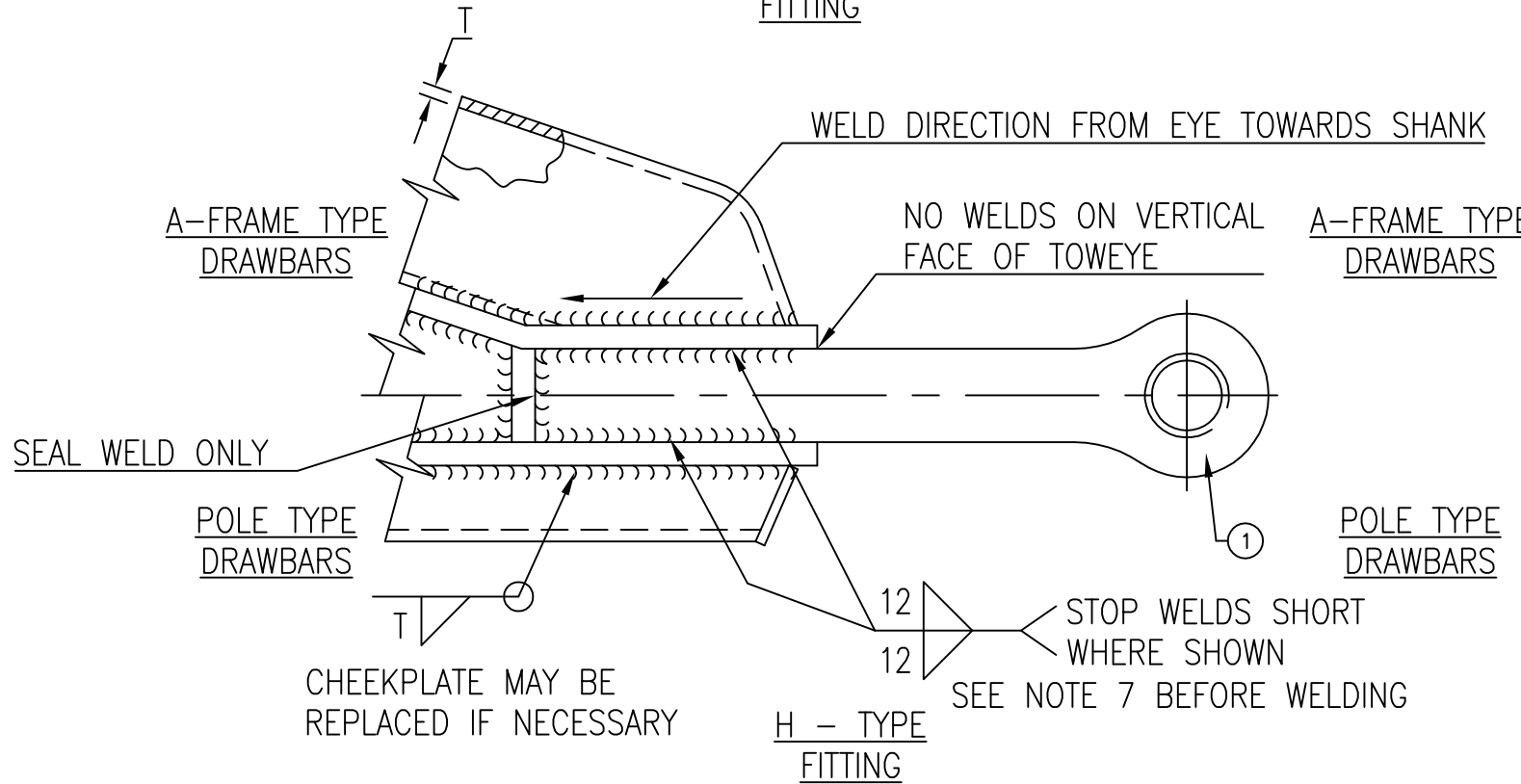
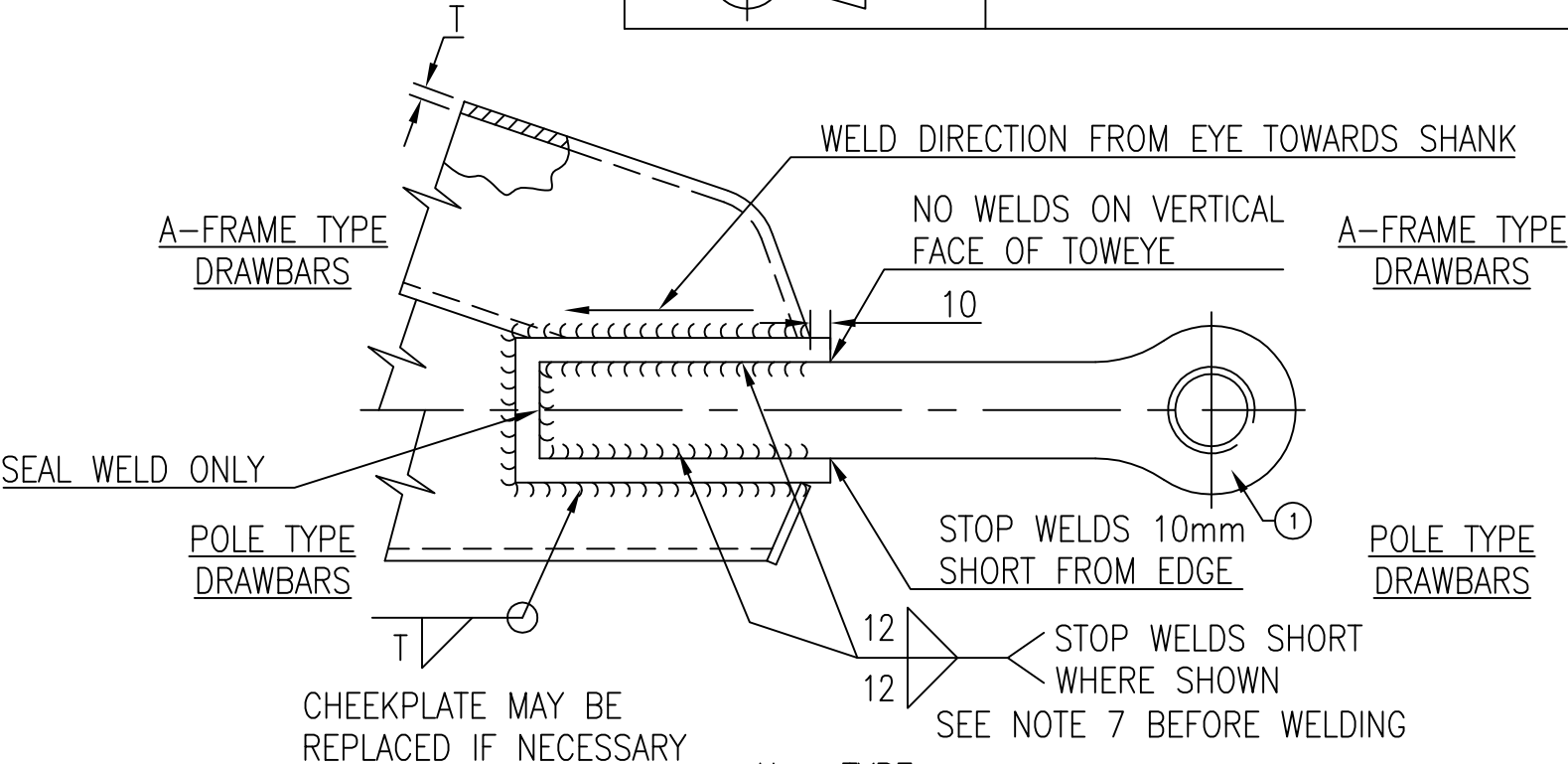


DO NOT SCALE – IF IN DOUBT ASK

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



ENSURE TOWEYE D-VALUE RATING IS EQUIVELANT  
DRAWBAR LENGTH IS NOT TO BE ALTERED  
ORIGINAL STRUCTURE MUST BE REPLICATED.  
MODIFICATIONS ARE NOT ALLOWED

NOTES:

- DO NOT SCALE OFF DRAWING
- 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. (STEELS UP TO CLASS 3 MINIMUM)
  - 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.
- STEEL SECTIONS MEET AS/NZS 1163 GRADE 350, & AS/NZS 3968 FOR PLATE OR EQUIVALENT. (UNLESS SPECIFIED)
- REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
- CERTIFICATION IS VOID IF:
  - (A) THE TOWEYE IS MANUFACTURED OR MODIFIED OUTSIDE THE SCOPE OF THIS DRAWING.
  - (B) THE DRAWBAR IS MODIFIED FROM ITS ORIGINAL CONFIGURATION (PRIOR TO TOWEYE DAMAGE)
- DO NOT WELD ON VERTICAL FACE OF TOWEYE OR WITHIN 10mm OF FRONT EDGE.  
FOLLOW MANUFACTURERS FITTING/WELDING INSTRUCTIONS
- IF THE MANUFACTURER DOES NOT PROVIDE SPECIFIC WELDING INSTRUCTIONS THE FOLLOWING INFORMATION FROM NZS5446 2007 SHALL BE USED:
  - PRE HEAT TO 250°C
  - HYDROGEN CONTROLLED ELECTRODES DRIED TO MANUFACTURERS RECOMMENDATIONS OR HYDROGEN CONTROLLED WELDING PROCESS SHALL BE USED TO MAKE ALL WELDS, INCLUDING TACK WELDS, WELDS ON COVER PLATES ETC...
  - WELDING OF THE TOWEYE SHANK SHALL BE ON THE PARALLEL SECTION OF THE SHANK ONLY, EXCEPT A SEAL WELD MAY BE APPLIED TO REAR FACE OF SHANK
  - AFTER WELDING, THE TOWEYE SHALL BE PROTECTED BY SUITABLE MEANS TO ENSURE SLOW COOLING FROM WELDING TEMPERATURES
  - IF WELDING ON THE TOWEYE SHANK IS STOPPED AND THE TEMPERATURE FALLS BELOW 250°, THE COMPONENT SHALL BE RAISED BACK TO 250° BEFORE WELDING IS RECOMMENCED.
- FOR OTHER VARIANTS OF TOWEYE ATTACHMENT, CONSULT ORIGINAL MANUFACTURER OF DRAWBAR FOR REPAIR INSTRUCTION OR CERTIFYING ENGINEER TO PROVIDE REPAIR DETAIL.

WELD SYMBOLS TO AS/NZS 1554.1

| SYMBOL | JOINT | TABLE |
|--------|-------|-------|
|        | F1    | E3    |
|        | F1    | E3    |

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

|           |           |
|-----------|-----------|
| OWNER     |           |
| MAKE      | MODEL     |
| CERTIFIER | CERT. No. |
| EXPIRY    | LENGTH    |

|      |     |                  |                              |         |
|------|-----|------------------|------------------------------|---------|
| 1    | 1   | 12T MIN. D-VALUE | TOWEYE – TO DIN. 74053/74054 |         |
| ITEM | QTY | MATERIAL         | DESCRIPTION                  | DRAWING |

**ttnmf**  
N7 Truck Trailer Manufacturers Federation Inc

WORKSHOP \_\_\_\_\_ TOWEYE REPLACEMENT – A FRAME / POLE TYPE  
CLIENT \_\_\_\_\_

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Job: 12726

Ref: MRCP-T001

Scale: NTS

Date: 2/11/2015

Date:

4 – MRCP – T001  
Sheet: 1/1

Drawn: R.F. Issue: B Chkd: