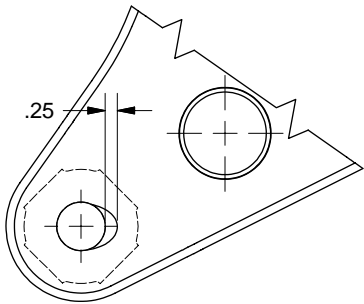


STEP 1

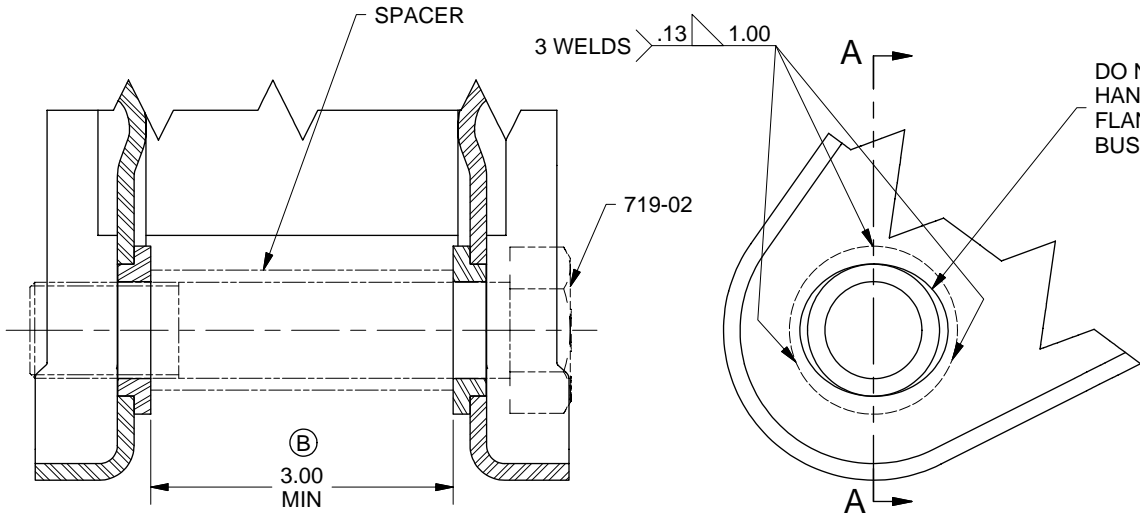
REMOVE TORQUE ARMS AND INSPECT ALL TORQUE ARM BOLT HOLES FOR LOOSE OR WORN WAHSER BUSHINGS

(FRONT HANGER SHOWN... TREAT CENTER HANGER SAME).



STEP 2

IF THE HOLE IS ELONGATED MORE THEN .25" IT IS RECOMMENDED THEN THE HANGER BE REPLACED.



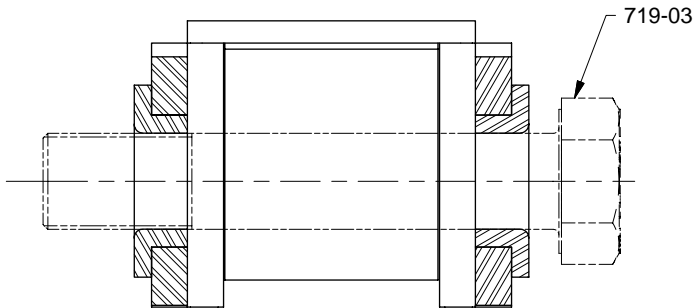
STEP 3

ASSUMING THAT HOLES ARE REPAIRABLE (SEE STEP 2). REMOVE AND DISCARD OLD WASHER BUSHINGS. REPLACE WITH NEW 7717-01 HARDENED WASHER BUSHINGS. USING 1.75" O.D. X 3" LONG SPACER TUBE AND TORQUE ARM BOLT, CLAMP UP NEW WASHER BUSHING AS SHOWN AND WELD IN PLACE USING AWS E70XX WELDING MATERIALS AND PRACTICES.

DO NOT ALLOW HOLE IN HANGER TO EXTEND BEYOND FLANGE OF NEW WASHER BUSHING

STEP 4

REMOVE BOLT AND SPACER. CLEAN WELDS AND TOUCH UP PAINT INSIDE AND OUT. DO NOT APPLY PAINT TO INSIDE FACE OF WASHER BUSHING.

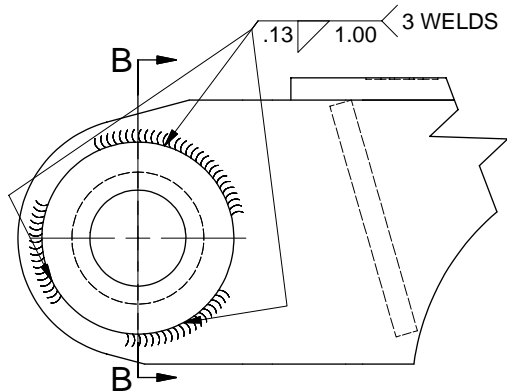


STEP 5

RE-ASSEMBLE TORQUE ARM JOINT REPLACING WORN RADIUS RODS (OR BUSHINGS), USING NEW BOLTS, AND NUTS.


IMPORTANT

TORQUE TO PROPER SPECIFICATIONS - REFERENCE DECAL 16088-01.



STEP 6

ON CASTINGS OR OTHER PARTS WITH 3/8" WALL THICKNESS. INSERT WASHER BUSHING 6978-00 FROM OUTSIDE AND PLACE 1" DIA. BOLT THROUGH BOTH BUSHINGS TO ASSURE CORRECT BUSHING ALIGNMENT. WELD EACH BUSHING AS INDICATED (3 PLCS) WITH BOLT AND SPACER TUBE IN PLACE. WHEN THE 6978-00 HARDENED INSERT IS USED AS DESCRIBED ABOVE, THE STANDARD TORQUE ARM BOLT MUST BE REPLACED WITH THE 719-03 BOLT WHICH IS 5 3/8" LONG.

2010015		B	REDRAWN, ADDED "MIN" TO 3.00 DIM. REVISED TITLE WAS "722-00 BUSHING" NOW "722-00 BUSHING"				01/10	JAJ	SNM	RSB
ER NO.	SYM	REVISIONS				DATE	BY	CHK	APPD	
DRAWN: BH		DATE: 11/16/1973	 <div>HUTCHENS INDUSTRIES, INC. SPRINGFIELD, MISSOURI</div>							
CHECKED: FR		DATE: 11/21/1973								
MFG APPL:		DATE:								
ER:		DATE:								
PROJECT OR FILE REFERENCE NO.			RADIUS ROD BOLT HOLE REPAIR FAB HANGERS W/722-00 BUSHING							
SCALE: N/A		SHEET 1 OF 1	SIZE: D	DRAWING NO.: 19068		REV. B		1 OF 1		