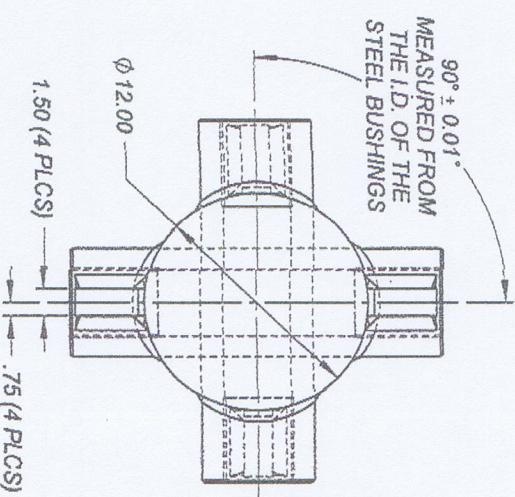
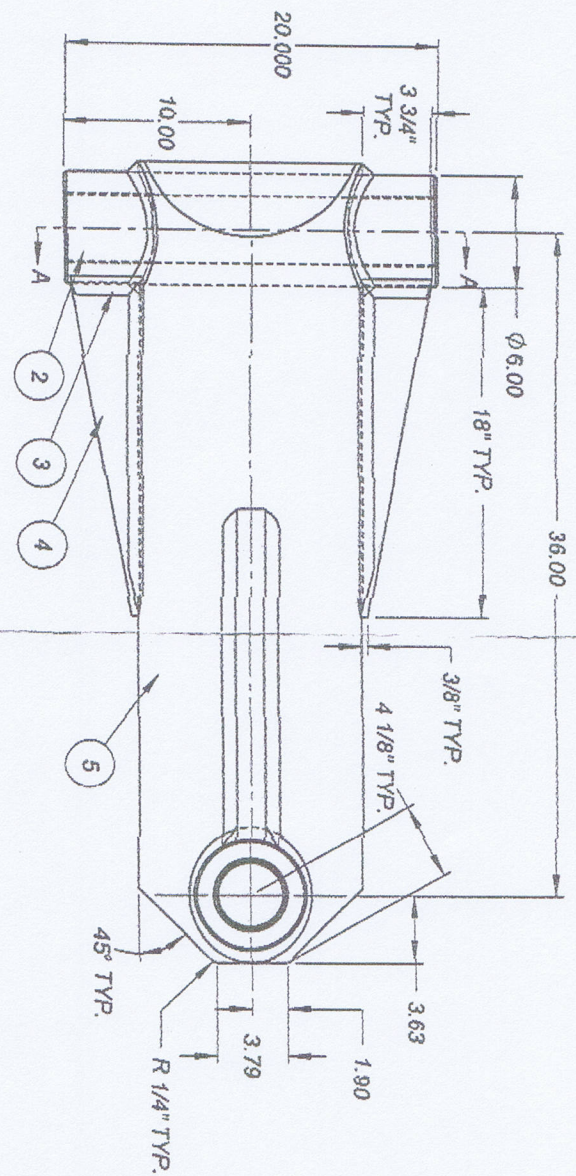
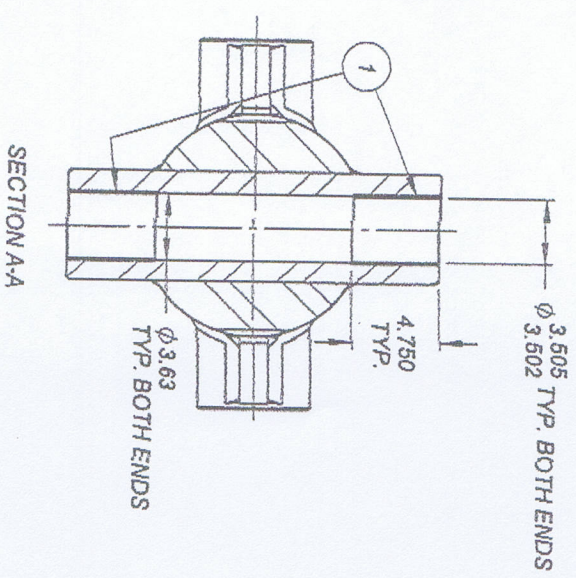
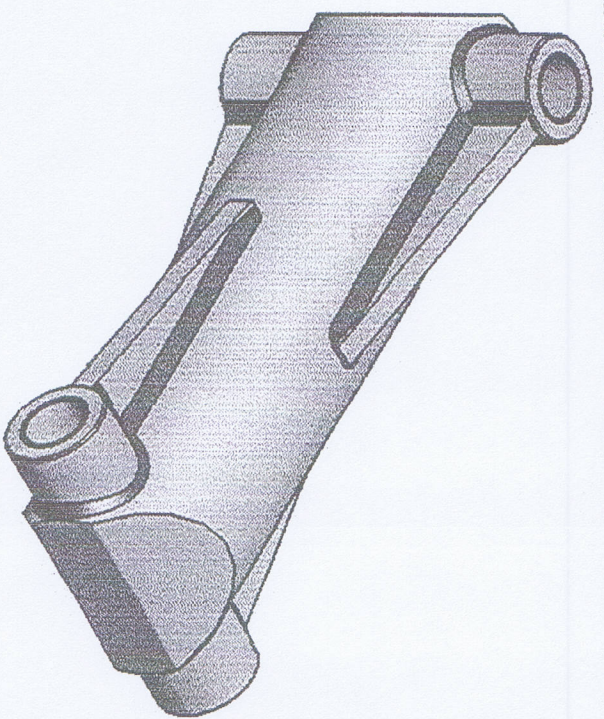
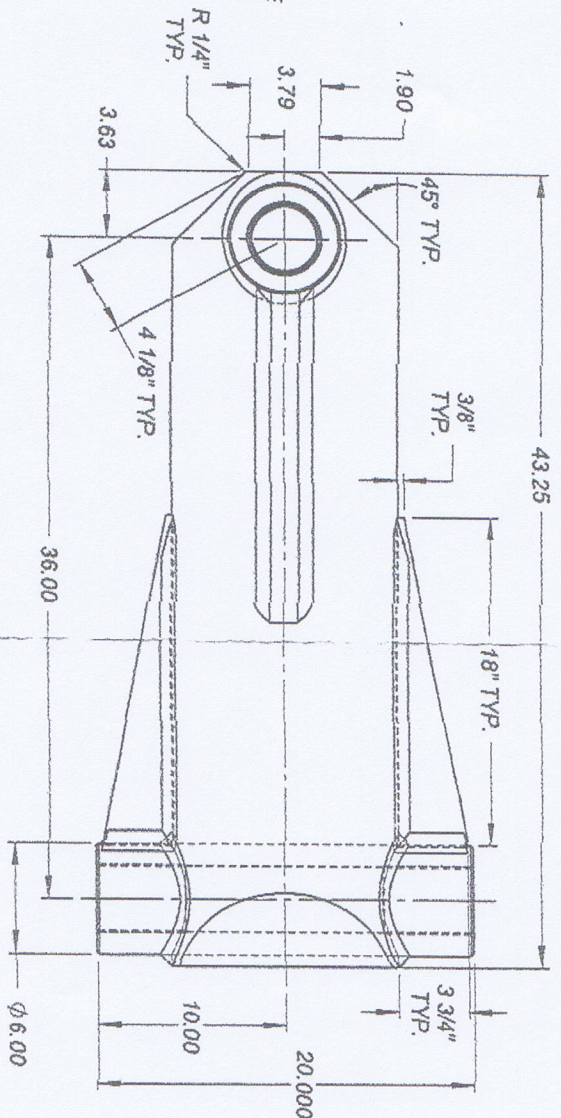


- 1 STEEL BUSHING, 1018 / 1026 COLD DRAWN STEEL 50 KSI MIN. YIELD, 60 KSI MIN TENSILE (2 EA. ON BOTH ENDS, 4 TOTAL)
- 2 CROSS TUBE, 1019 / 1026 COLD DRAWN STEEL, 50 KSI MIN. YIELD, 60 KSI MIN. TENSILE (2 PLCS)
- 3 5/8" FILLET WELDS PER AWS A5.14 USING ER70S-6 FILLER METAL (ON GUSSETS, CROSS TUBE, AND STRUCTURAL TUBE)
- 4 GUSSET, 1 1/2" THICK A572 GR 50 PLATE (4 PLCS)
- 5 LINK BODY, 12" ϕ 1045 HOT ROLLED STEEL, DAMAGED, 48 KSI MIN. YIELD, 80 KSI MIN. TENSILE



REV.	DESCRIPTION	DATE	APPRVD
2	LINK BODY WAS 8 X 8 X 8 STRUCTURAL TUBE, NOW 12 ϕ 1045 HRS. ELIMINATED COVER PLATES. EST. WEIGHT WAS 475 LBS, NOW 1425 LBS. COLOR WAS SAFETY YELLOW, NOW SEMI-GLOSS SILVER.	10-26-09	Tony O.
1	INCREASED OVERALL LENGTH 3.50" REF. 36.00" WAS 32.50". INCREASED SIZE AND DIMENSIONED THE GUSSETS. FIN TO FIN ANGLE TOLERANCE WAS 90° ± 1'. NOW 90° ± 0.01°. ADDED FINISH SPECIFICATION. ESTIMATED WEIGHT WAS 440. NOW 475. ADDED NOTES 1 THRU 7 IN ORDER TO SPECIFY MATERIAL AND WELDS. INCREASED THE LENGTH TOLERANCE ON THE CROSS TUBES FROM 2 PLACE DECIMAL TO 3 PLACE. DIMENSION LOCATION OF GUSSETS.	09-18-09	Tony O.

REV.	DESCRIPTION	DATE	APPRVD
1	ESTIMATED WEIGHT: 1425 LBS		

FINISH:
 1. ALL SOILS, OILS AND GREASE SHALL BE REMOVED FROM THE SURFACE TO BE PAINTED USING A MULTISTAGE PHOSPHATE WASH.
 2. EPOXY PRIMER - PPG PITT-GUARD-ALC WEATHER DTR (OR EQUAL)
 1 COAT AT 7-9 MILS DFT
 3. URETHANE TOPCOAT - PPG DURETHANE DTM (OR EQUAL) 2 COATS AT 5.0 - 6.0 MILS DFT EACH. COLOR - SEMI-GLOSS SILVER

TOLERANCES	TRUE POSITION	INSPECTION	BORE
DECIMAL ± .06	⊙ ±	CYL #: INSP-TOP-LINK-20	N/A
DECIMAL ± .010	⊙ ±	CUST. #: INSP-TOP-LINK-20	STROKE N/A
FRACTION ± 1/8"	⊙ ±	APPLICATION: TOP LINK - FABRICATED	ROD N/A
DEGREES ± 1°	∥ ±	DWN: Tony O.	DATE: 08-25-09
		CHKD.	APPRVD.