

WELDING DISCLAIMER NOTES:

- I) It is the responsibility of the suspension installer and vehicle designer to provide adequate vehicle frame design, gusset support in the area of suspension attachment, and proper securing method for the suspension system. The suspension installer has the responsibility to determine the proper welding parameters for the materials being used. For specifications of suspension component materials, contact Cush.
- II) Required cross member locations are shown. Actual size and shape may vary per trailer design. It is the responsibility of the suspension installer to ensure structural adequacy of the trailer frame and related cross members.
- III) No welding of any of the suspension components is permitted, except where specified by Cush.
- IV) Any alteration of the suspension components or installation deviations must be approved, in writing, by Cush Corporation.

RECOMMENDED STEEL WELDING PROCEDURES:

WARNING: If these procedures and specifications are not followed, damage to the axle or suspension could result. The resulting axle or suspension damage could cause an accident, property damage, and/or serious injury.

NOTE: A welder qualified in 2G position per ANSI/AWS D1.1-94 Section 5 Part C "Welder Qualification" must perform the welding.

NOTE: The specification shown below is for horizontal (2F) positioning.

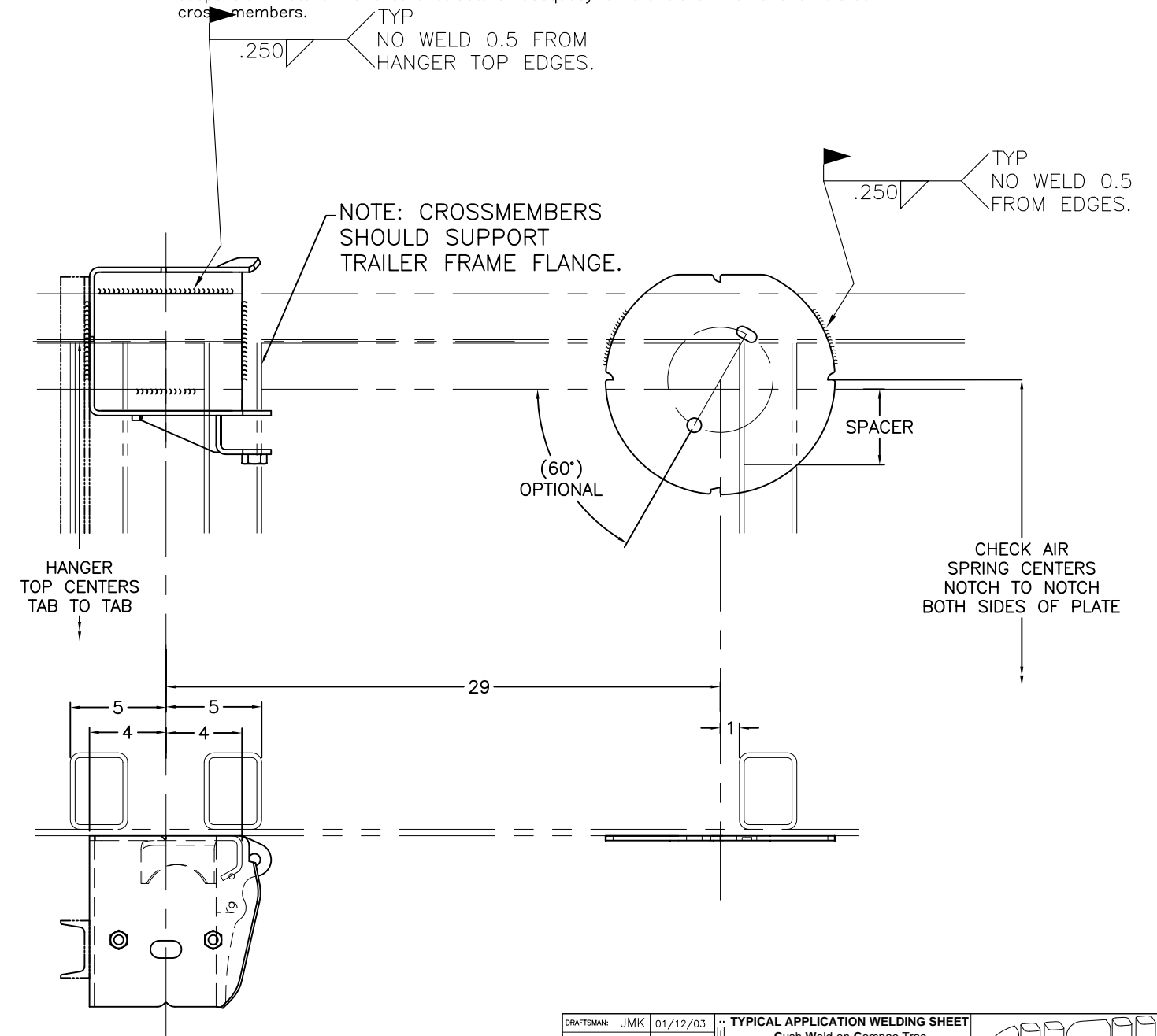
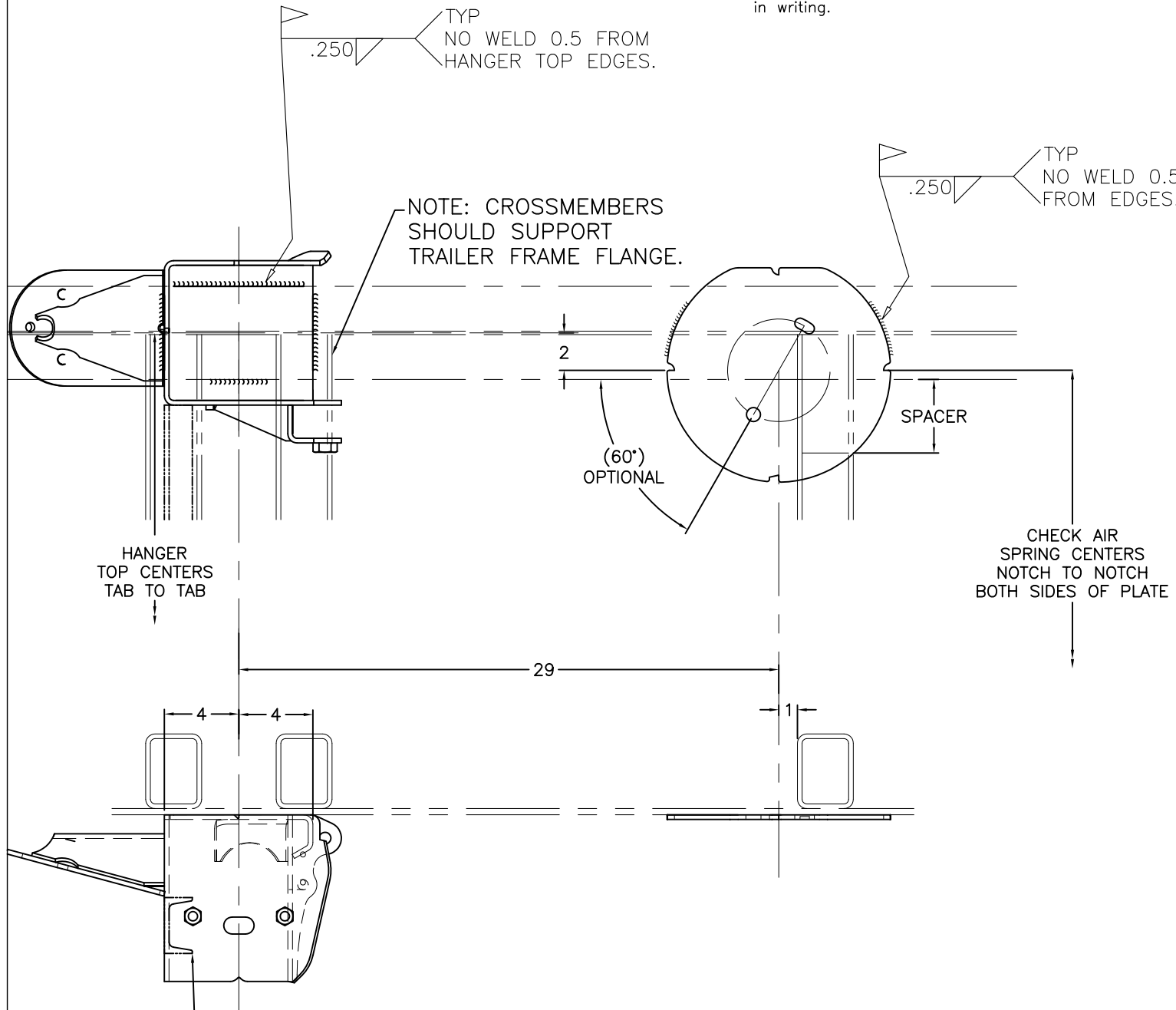
- 1) Suspension components and their mating parts must be at a minimum temperature of 60°F(15.5°C) and free from moisture, dirt, scale, paint, grease, and other contaminants.
- 2) All welds must be performed in a flat, or horizontal, position.
- 3) Achieve spray arc transfer with the following welding parameters:
Standard Electrode: AWS E-7018(Oven Dried), 0.125"DIA., 120-140 AMPS D.C., Electrode positive.
Standard Wire: AWS ER-70S-6 or AWS ER-80S-D2, 0.045"DIA
Volts: 26-30 DCRP
Current: 275-325 AMPS
Wire Feed Speed: 380-420 Inches per Minute
Electrode Extension: 0.75" to 1"
Gas: 86%AR 14%CO2 at 30 to 35 CFH
 Any deviation from these welding parameters must be approved by Cush Corporation in writing.

WELD NOTES, AIR SPRING PLATE:

- 1a) Position and tack weld the air spring plates onto the trailer frame flange and cross member as specified in the suspension drawing.
- 2a) Weld the air spring plates per the suspension drawing. DO NOT WELD within 1/2" of trailer flange edge.
- 3a) DO NOT ATTACH the air spring mounting plate or air spring to BOTH the trailer main rail and the trailer cross member. The air spring mounting is not designed to resist the movement between the trailer cross member and the main rail.
- 4a) Roughly 60% of the air spring top plate should be supported. The trailer cross member should support the air spring plate directly or with spacer if needed. If the air spring plates are inboard of the frame rail, additional support gussets may be required.

WELD NOTES, FRAME HANGER BRACKETS:

- 1b) Verify that the frame hanger brackets are aligned to each other and are perpendicular, horizontally and vertically, to the trailer frame.
- 2b) Use c-clamp tabs to eliminate gap between hanger top plate wings and trailer frame cross members.
- 3b) Tack and weld the frame hanger brackets per the suspension drawings.
- 4b) If the trailer frame flange is not supported it may be necessary to use a cross-member between frame hanger brackets. It is the responsibility of the suspension installer to ensure structural adequacy of the trailer frame and related cross members.



HANGER CROSSMEMBERS MOUNTS BETWEEN HANGERS WHEN LIFT KIT INSTALLED

DRAFTSMAN: JMK 01/12/03	TYPICAL APPLICATION WELDING SHEET									
CHECKED: .	Cush Weld-on Compac-Trac									
RELEASED: .	25,000# Gross Suspension Weight Rating	PO Box 3742 SPRINGFIELD, MO. USA www.cushcorp.com								
WEIGHT: N/A	Hanger weldment drawing with and without front lift kit									
MATERIAL: SEE PART DWGS.	TOLERANCE UNLESS OTHERWISE STATED:	<table border="1"> <tr> <td>ECN</td> <td>BY</td> <td>DATE</td> <td>REV</td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> </tr> </table>	ECN	BY	DATE	REV				
ECN	BY		DATE	REV						
All of the Information shown herein is the intellectual property of Cush Corp and is submitted only on a confidential basis. The recipient agrees that no disclosure of this information will be made to a third party without written consent of Cush Corp. This design protected by Cush patents or patents pending.	.X = +/- .12 .XX = +/- .062 .XXX = +/- .031 ANGLES = +/- 1°									
SHEET 3 OF 4	SCALE: A-SIZE B-SIZE 1:8 D-SIZE 1:4	REV: - PART/DRAWING NO: CLC-25-005/-005L								