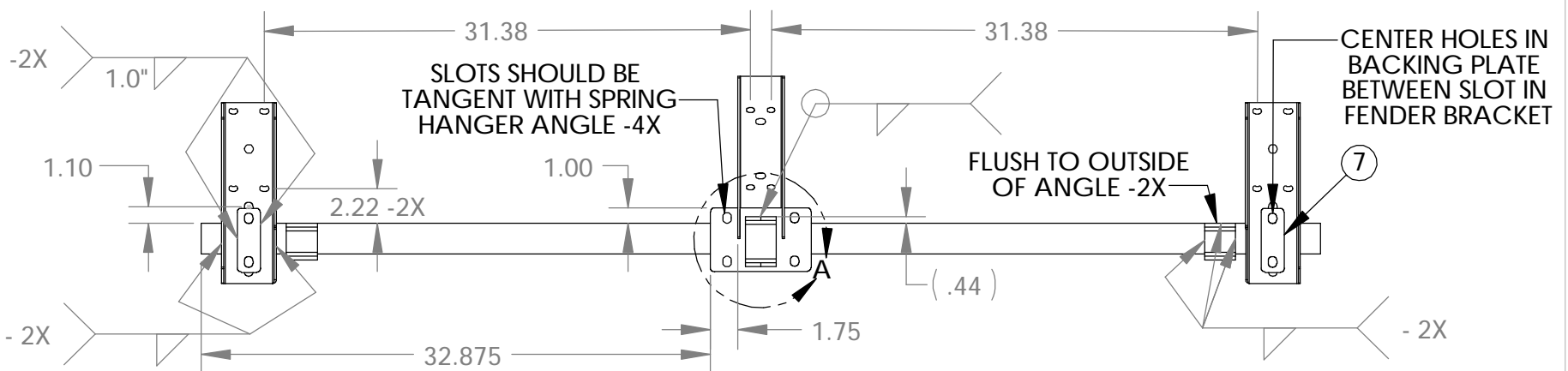
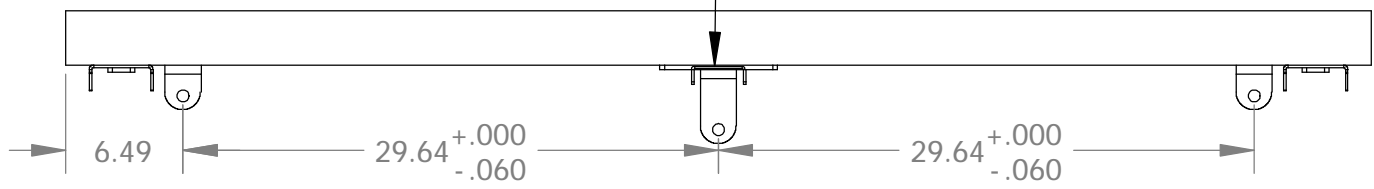


| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|-------------|--------------------------|------|
| 1 | 100-00492 | SPRING HANGER | 2 |
| 2 | 100-00713 | EQUALIZER HANGER BRACKET | 1 |
| 3 | 100-01188 | FENDER BRACKET L.H. | 1 |
| 4 | 100-01189 | FENDER BRACKET R.H. | 1 |
| 5 | 100-01190 | CENTER FENDER BRACKET | 1 |
| 6 | 100-04012 | TANDEM HANGER PLATE | 1 |
| 7 | 100-04013 | BACKING PLATE | 2 |
| 8 | 221-00054 | ANGLE | 1 |

WELD FENDER BRACKETS
FLUSH TO BOTTOM OF
ANGLE - 3X (± 0.060)



ALL DIMENSIONS ARE IN INCHES
UNLESS OTHERWISE STATED
TOLERANCES EXCEPT AS NOTED
DECIMALS:
.X ± 0.100
.XX ± 0.060
.XXX ± 0.030
.XXXX ± 0.010
ANGLES:
 $\pm 1^\circ$
ALL FORMED ANGLES
EQUAL 90° UNLESS
NOTED OTHERWISE
() INDICATES REFERENCE

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PROPERTY OF KARAVAN TRAILERS, INC. ANY
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APPROVED BY:

DRAWN BY:
DON CASTLE
DATE:
11-20-08
SHEET:
1 OF 1
SCALE:
N/A

KARAVAN
TRAILERS

TITLE:
SPRING HANGER WELDMENT

MAT'L:
SEE B.O.M.

FINISH:
N/A

DWG. #:
300-02109-B

| DWG. REV. | ECR/NDR NUMBER | REVISED BY | DATE | DESCRIPTION |
|-----------|----------------|------------|----------|---|
| B | 15093 | KMH | 04-01-10 | REPLACED 100-00089 WITH 100-04013; 100-01496 WITH 100-04012 |
| A | 14781 | DLC | 11-20-08 | DRAWING CREATED |

First Piece - In Process Inspection Sheet

Vendor _____

Description: **Spring Hanger Weldment**

Part # **300-02109**

Rev. **B**

QA Approval: K. Hopf

JOB# _____

| Characteristic | Tol. | Method | Freq. | 1st Piece | A/R | 2 | A/R | 3 | A/R | 4 | A/R | 5 | A/R | 6 | A/R | 7 | A/R | Inspected By/Date: | |
|--|-----------------|--------|--------------------------|-----------|-----|---|-----|---|-----|---|-----|---|-----|---|-----|---|-----|--------------------|-----|
| WELD | | | | | | | | | | | | | | | | | | | 1 / |
| 6.49 | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 2 / |
| 29.64 - 2X | + .000 -.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 3 / |
| 31.38 - 2X | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 4 / |
| 2.22 - 2X | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 5 / |
| 1.00 | ±.030 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 6 / |
| .44 | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | 7 / |
| 1.10 | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | |
| 1.75 | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | |
| Slots should be tangent with spring hanger angle - 4X | NA | Visual | 2X Per Shift | | | | | | | | | | | | | | | | |
| 32.875 | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | |
| Flush to outside of angle 2X | NA | Visual | 2X Per Shift | | | | | | | | | | | | | | | | |
| Weld fender brackets flush to bottom of angle | ±.060 | Tape | 2X Per Shift | | | | | | | | | | | | | | | | |
| Weld per print | NA | Visual | Every piece | | | | | | | | | | | | | | | | |
| Remove all visible weld spatter, every piece | NA | Visual | Document 4x per shift | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | |