

DO NOT SCALE - IF IN DOUBT ASK

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

NOTES:

1. DO NOT SCALE OFF DRAWING
2. 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.

3. STEEL SECTIONS MEET AS/NZS 1163 GRADE 350,
& AS/NZS 3968 FOR PLATE OR EQUIVALENT.

4. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS

5. 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)

6. DO NOT WELD ON VERTICAL FACE OF TOWEYE OR WITHIN 10mm OF FRONT EDGE.

FOLLOW MANUFACTURERS FITTING/WELDING INSTRUCTIONS

7a. 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 THE TOWEYE SHANK SHALL BE ON THE PARALELL 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.

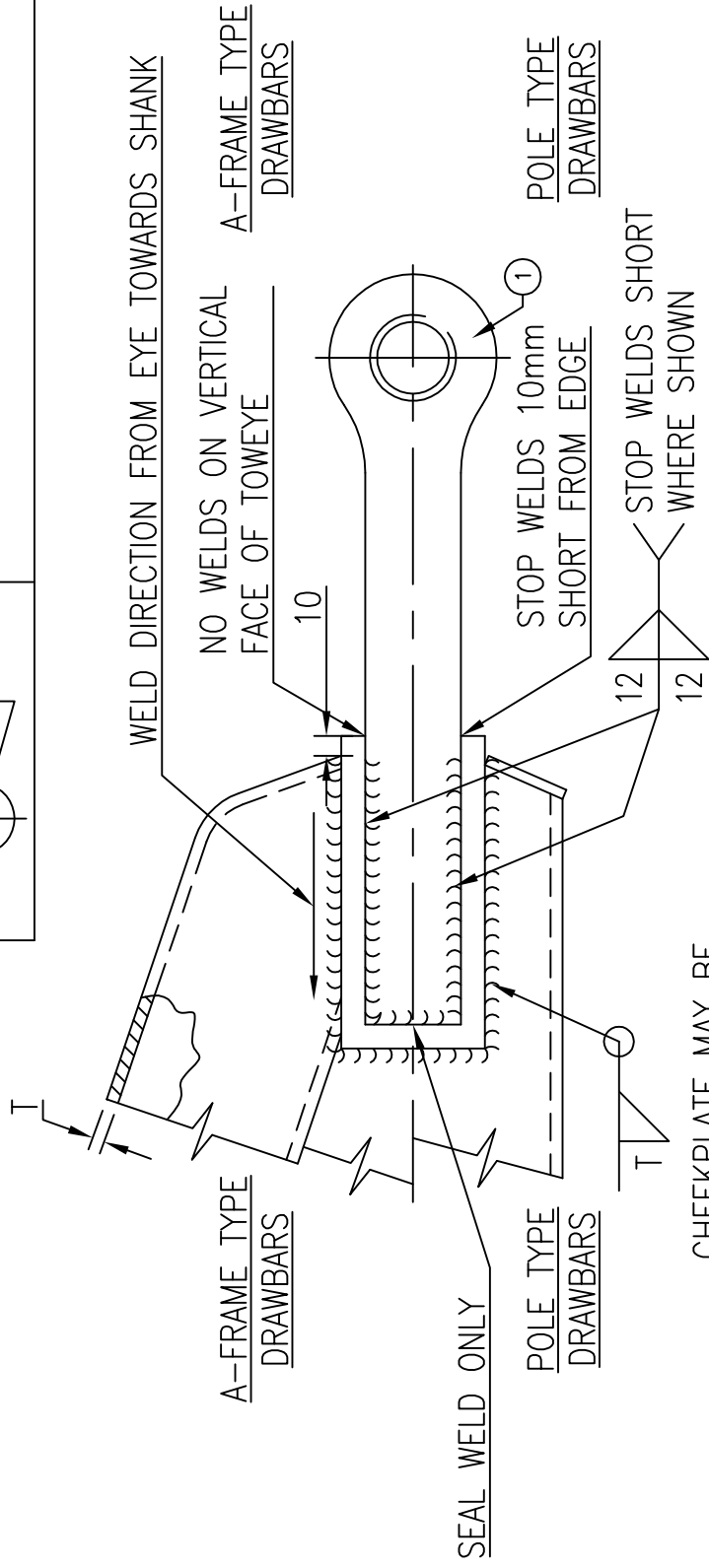
8. FOR OTHER VARIANTS OF TOWEYE ATTACHMENT, CONSULT ORIGINAL MANUFACTURER OF DRAWBAR FOR REPAIR INSTRUCTION OR CERTIFYING ENGINEER TO PROVIDE REPAIR DETAIL.

OWNER			
MAKE		MODEL	
CERTIFIER		CERT. No.	
EXPIRY		LENGTH	

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

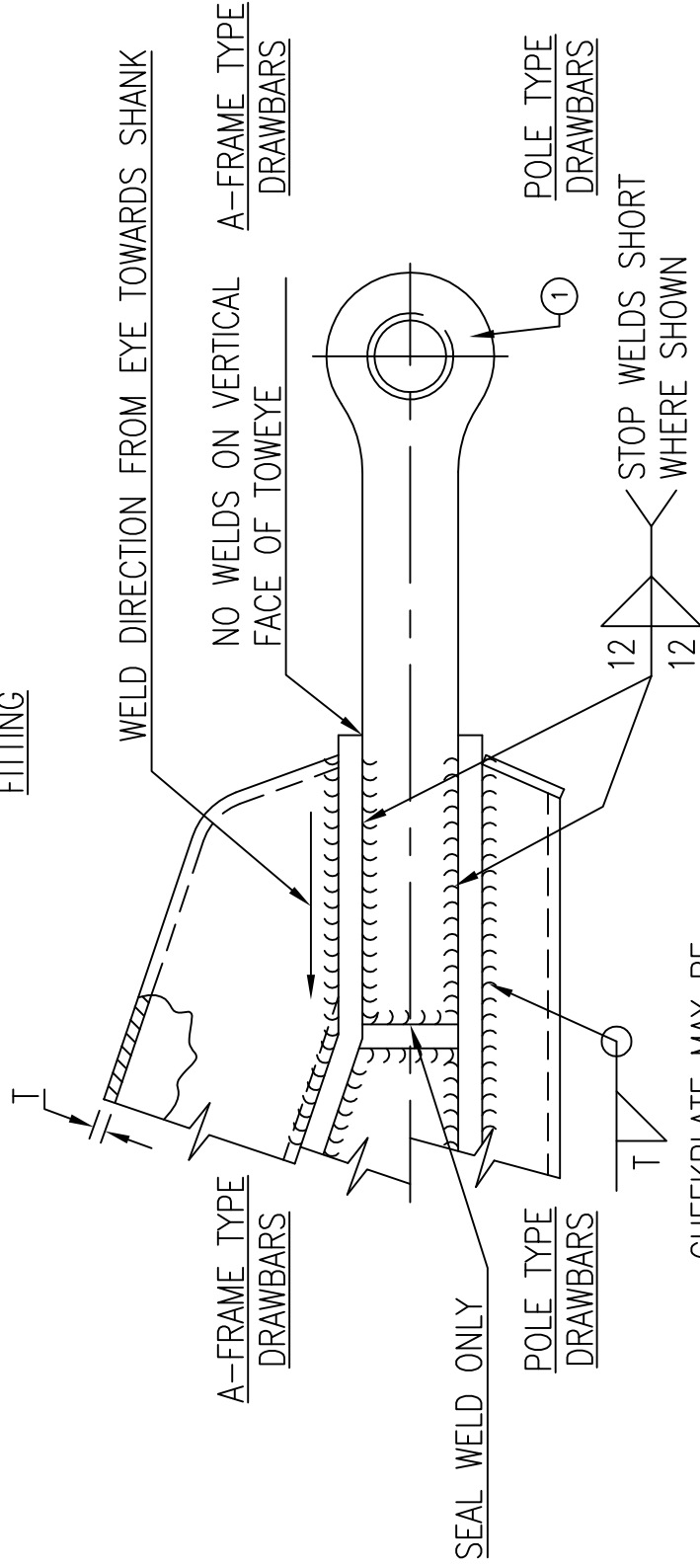
TOWEYE REPLACEMENT -- A FRAME / POLE TYPE
CLIENT

Drawn: R.F.	Issue: B	Chkd:
Scale: NTS	Date: 2/11/2015	Date:



CHEEKPLATE MAY BE
REPLACED IF NECESSARY

U - TYPE FITTING



CHEEKPLATE MAY BE
REPLACED IF NECESSARY

H - TYPE FITTING

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

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

ttmf

N7 Truck Trailer Manufacturers Federation Inc.

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