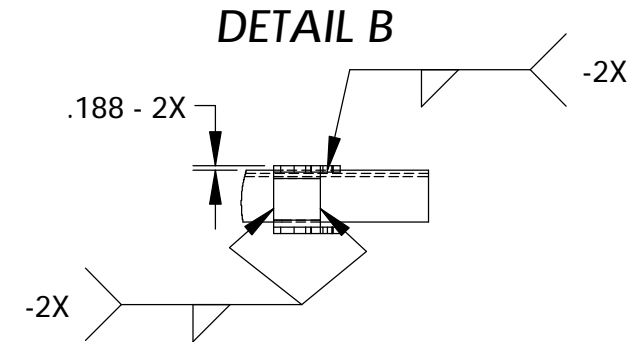
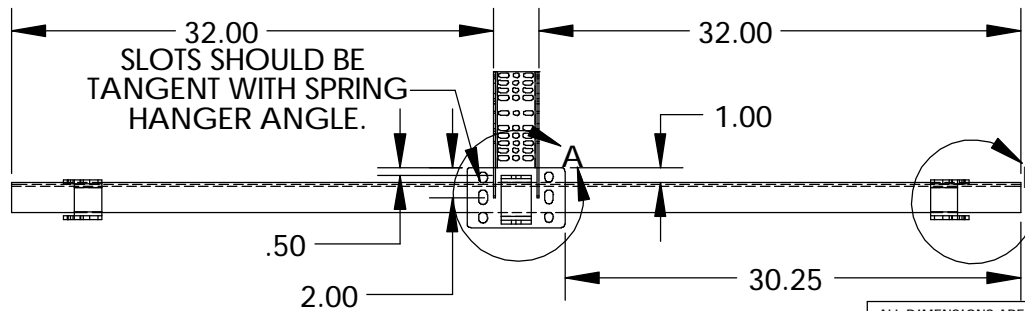
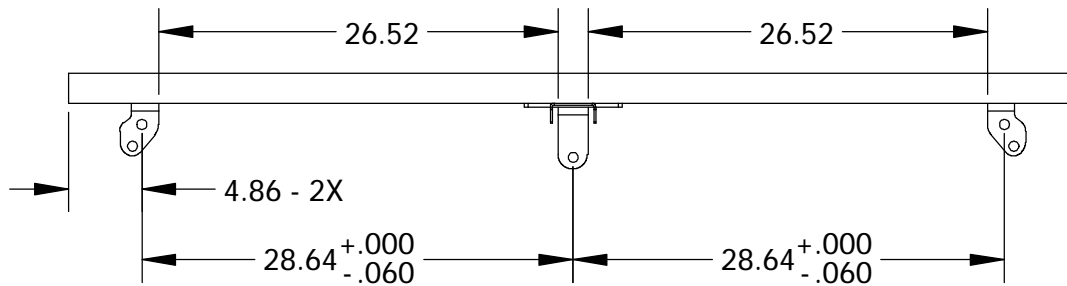
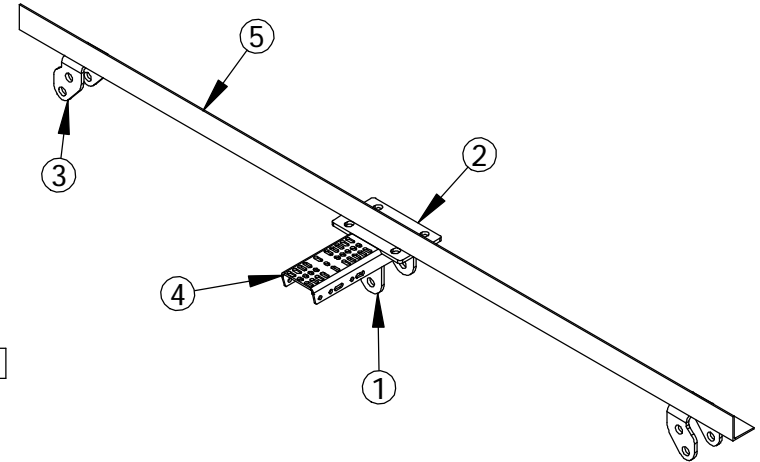


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	100-00713	EQUALIZER HANGER BRACKET	1
2	100-01496	TANDEM HANGER PLATE	1
3	100-05651	SPRING HANGER	2
4	100-05870	FENDER BRACKET	1
5	221-00022	ANGLE	1



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:
±1°
ALL FORMED ANGLES
EQUAL 90° UNLESS
NOTED OTHERWISE

() INDICATES REFERENCE

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INC. IS PROHIBITED.

APPROVED BY:

DRAWN BY:
Mile Stansbery

DATE:
09-16-2014

SHEET:
1 OF 1

SCALE:
N/A

KARAVAN

TITLE: SPRING HANGER TANDEM
WELDMENT (12"/F13"
AND 13"/F14")

MAT'L: SEE B.O.M.

FINISH: -BT, -GL

DWG. #: 300-03307-B

DWG. REV.	ECR/NDR NUMBER	REVISED BY	DATE	DESCRIPTION
B/1	15801	MCS	12-04-15	UPDATED WELD SYMBOLS
B	15801	MCS	10-27-14	REMOVED 100-05869-2X

First Piece - In Process Inspection Sheet

Vendor _____

Description: **Spring Hanger Weldment, Tandem**

Part # **300-03307**

Rev. **B/1**

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:
WELD																		1 /
26.52 - 2X	±.060	Tape	2X Per Shift															2 /
4.86 - 2X	±.060	Tape	2X Per Shift															3 /
28.64 - 2X	+ .000 - .060	Tape	2X Per Shift															4 /
32.00 - 2X	±.060	Tape	2X Per Shift															5 /
Slots should be tangent with spring hanger angle.	NA	Visual	Every piece															6 /
1.00	±.060	Tape	2X Per Shift															7 /
.50	±.060	Tape	2X Per Shift															
2.00	±.060	Tape	2X Per Shift															
30.25	±.060	Tape	2X Per Shift															
DETAIL A																		
.25	±.060	Tape	2X Per Shift															
2.25	±.060	Tape	2X Per Shift															
DETAIL B																		
.188 - 2X	±.030	Tape	2X Per Shift															
Weld per print	NA	Visual	Every piece															
Remove all visible weld spatter	NA	Visual	Every piece															