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.

N) Any alteration of the suspension components or installation deviations must be approved, in writing, by Cush Corporation. WELDING DISCLAIMER NOTES:

1) 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. വ ဂ 1/4 1/4 1/2 .250 0 TYP
NO WELD 0.5 FROM
HANGER EDGES OR
FRAME FLANGE EDGE 32 3/4 HANGER
TOP CENTERS
TAB TO TAB 2) All welds must be performed in a flat, or horizontal, position.
2) All welds must be performed in a flat, or horizontal, position.
3) Achieve spray are transfer with the following welding parameters:

Standard Mire: AWS E-708-6, 0.045*DIA, 0.125*DIA, 120-140 AMPS D.C.,

Electrode positive EA-70S-6, 0.045*DIA

Valts: 26-30 DRP

Valts: 26-30 DRP

Wire: Feed Speed: 380-420 Inches per Minute

Electrode Extension: 0.75* to 1*

Gas: 865/AR 145/CO2 at 30 to 35 CFH

Any deviation from these welding parameters must be approved by Cush Corporation in writing. RECOMMENDED STEEL WELDING PROCEDURES:

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

MOIE: A welder qualified in 2G position per ANS/AWS 01.1-94 Section 5 Part C
Welder Qualification," must perform the welding.

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

1) Suspension components and their making parts must be at a minimum temperature of 60F(15.5°C) and free from moisture, dirt, scale, paint, grease, and other contaminates. CHECK AIR
SPRING CENTERS
NOTCH TO NOTCH
BOTH SIDES OF PLATE ø13/16 ₽2 NO WELD 0.5 FROM HANGER EDGES/ .250 /TYP NO WELD 0.5 FROM \FRAME FLANGE EDGE $(.250)^{I}$ 7 1/4 TYP WED NOTES. FRAME HANGER BRACKETS:
NOTE: The frame hanger brackets have alignment tabs to position the hanger brackets per the Cush suspension drawing. Inspect this alignment side—to—side reduce axle alignment requirements.

The verify that the frame hanger brackets are aligned to each other and are perpendicular, horizontally and vertically, to the trailer frame.

The verify that the frame hanger brackets per the suspension drawings. WELD NOTES. AR SPRING PLATE:

10) Position and tack weld the air spring plates onto the trailer frame flange and cross member as specified in the suspension drawing. DO NOT WELD within 1° 20) Weld the air spring plates per the suspension drawing. DO NOT WELD within 1° of trailer flange edge.

30) DO NOT ATACH the air spring mounting late or air spring to BOTH the trails of 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 50% of the air spring top plate should be supported. The trailer cross member should susport the air spring plate directly or with spacer if needed. If the oir spring plates are inboard of the frame rail, additional support gussets may be required. ____ = = _____ HANGER FRONT ·(CHECK BEAM CENTERS HERE)-11 VIEW G-G BEAM CENTERS MINTERNE, MER AMERICAN, TOTAL MARKET WEIGHT: N/A JMK 1/28/05 .. TYPICAL APPLICATION WELDING SHEET
LIJ Cush Underslung
25,000# Gross Suspension Weight Rating
9' NOMINAL RIDE HEIGHT • CU-25-E09 -TYP-DO NOT WELD EDGES Z SPEC NO: