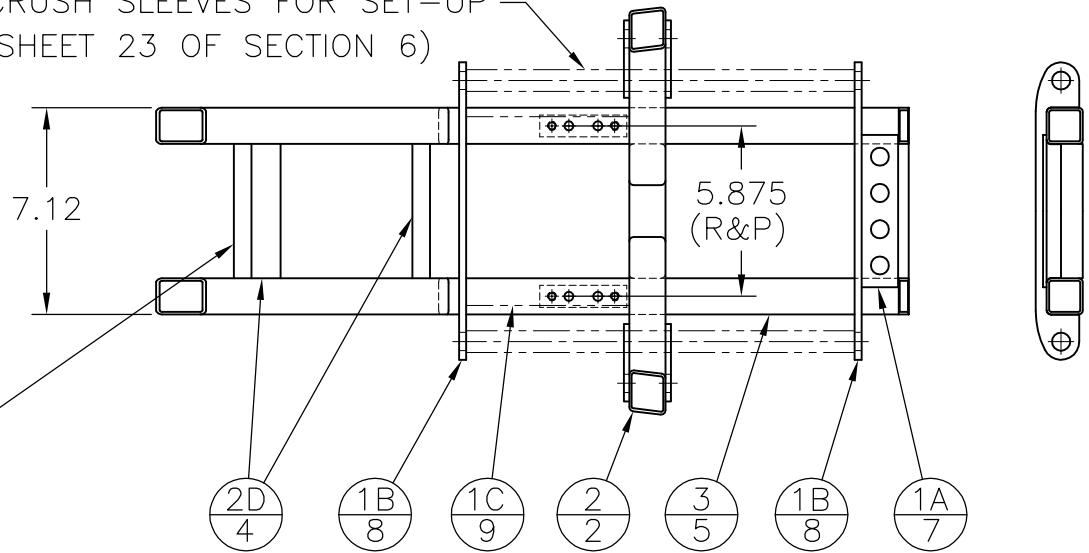


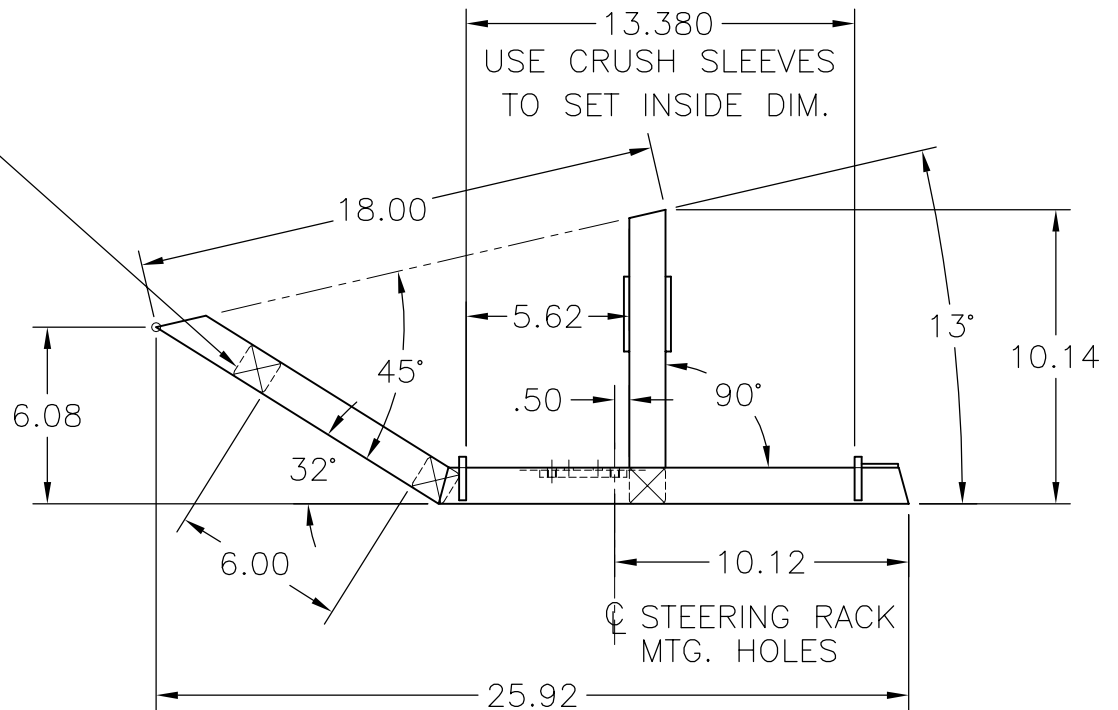
USE CRUSH SLEEVES FOR SET-UP  
(SEE SHEET 23 OF SECTION 6)



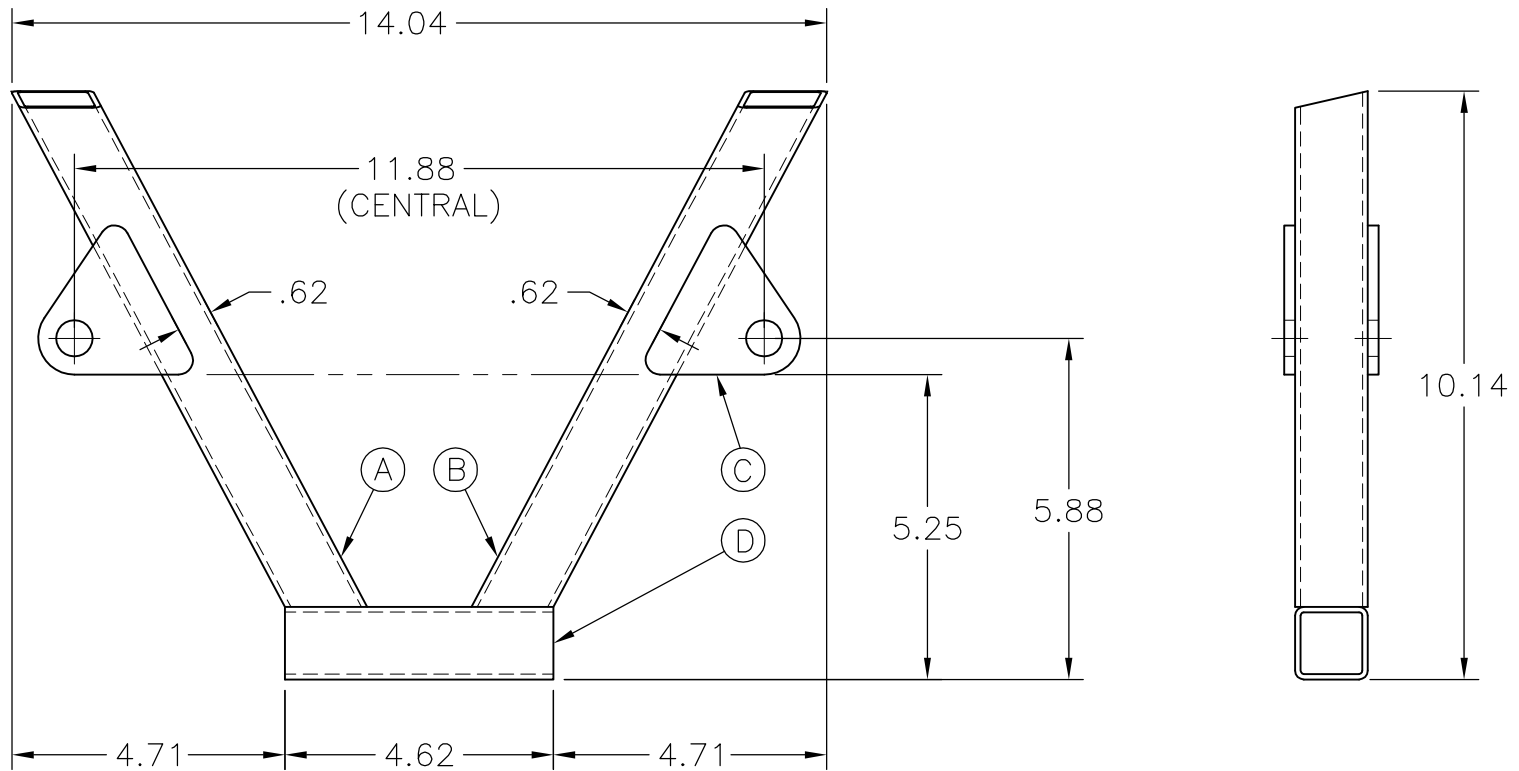
REMOVE THIS TUBE AFTER FINAL ASM. WITH UPPER FRAME. USE SMALL TACK WELDS, KEEPING ACCESS FOR GRINDING IN MIND.

- 1 LOWER FRAME ASM.  
(1) REQ'D ~ TACK WELDED CONST.  
SEE SHEETS 2 THRU 10 FOR SUB ASM'S. & DETAILS.

CLAMP COMPONENTS ON A FLAT SURFACE. TACK WELD CHECKING DIMENSIONS & SQUARE AS YOU GO. THE OPTIONAL JIG PLATE "1C" CAN BE USED TO SET THE LOCATION OF ITEMS 1B & 2



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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END LOWER FRAME ASM.	DRAWN BY R.A.S.
				SCALE NONE	SHT. 1 OF 10 SHTS.



CLAMP TO A FLAT SURFACE & CHECK ALL DIMENSIONS BEFORE TACK WELDING.

NOTE: TACK WELD ONLY AT THIS TIME

② CENTER SUPPORT ASM.  
(1) REQ'D ~ TAC WELDED CONST.

① (A) (1) REQ'D ~ SEE SHEET 3

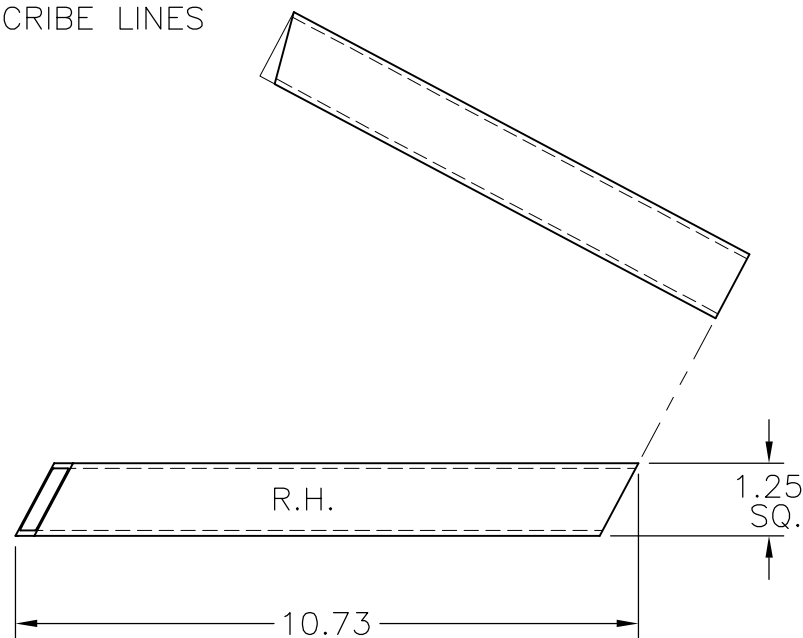
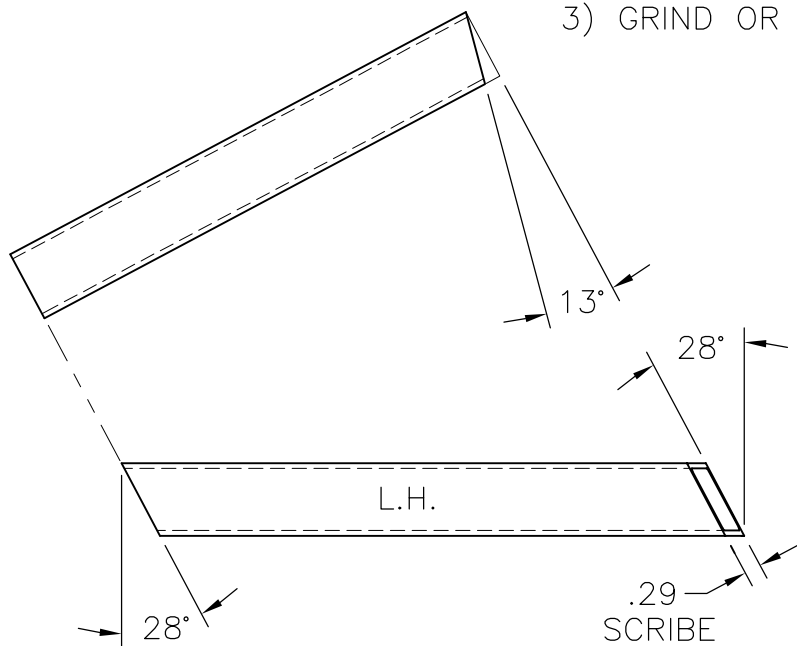
① (C) (4) REQ'D ~ SEE SHEET 4

① (B) (1) REQ'D ~ SEE SHEET 3

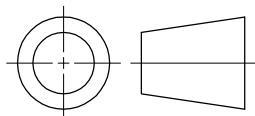
① (D) (1) REQ'D ~ SEE SHEET 4

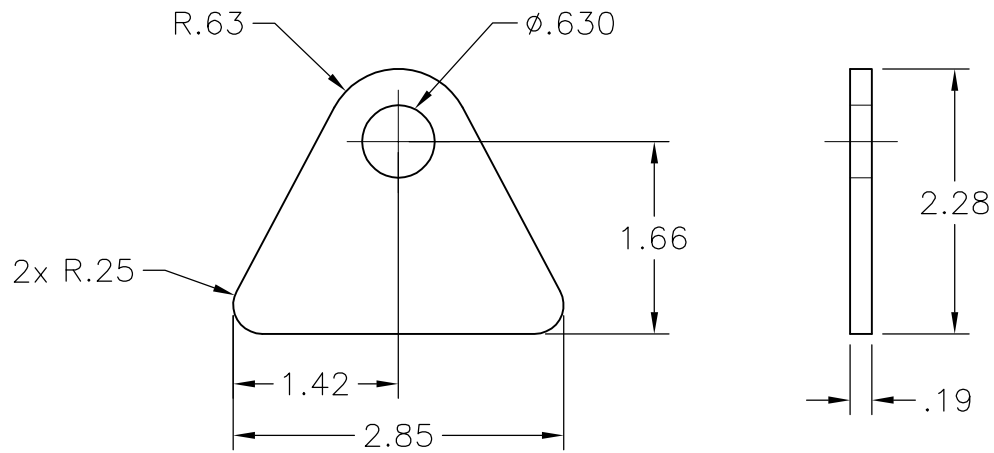
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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 <b>3RD ANGLE PROJECTION</b>		DESCRIPTION DOUBLE A ARM FRONT END CENTER SUPPORT ASM.	DRAWN BY R.A.S.
				SCALE NONE	SHT. 2 OF 10 SHTS.

- 1) MITER CUT ENDS @ 28°
- 2) SCRIBE LINES AS SHOWN
- 3) GRIND OR MACH. TO SCRIBE LINES

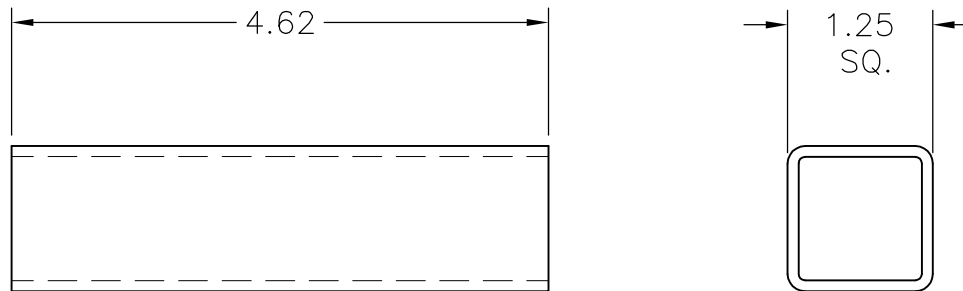


- 2A R.H. CENTER SUPPORT TUBE  
 (1) REQ'D ~ 1 1/4" SQ. x .083 WALL (14 GA.) x 10 3/4 ~ STL. TUB'G.
- 2B L.H. CENTER SUPPORT TUBE  
 (1) REQ'D ~ 1 1/4" SQ. x .083 WALL (14 GA.) x 10 3/4 ~ STL. TUB'G.

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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END R & L CENTER SUPPORT TUBES	DRAWN BY R.A.S.
				SCALE NONE	SHT. 3 OF 10 SHTS.

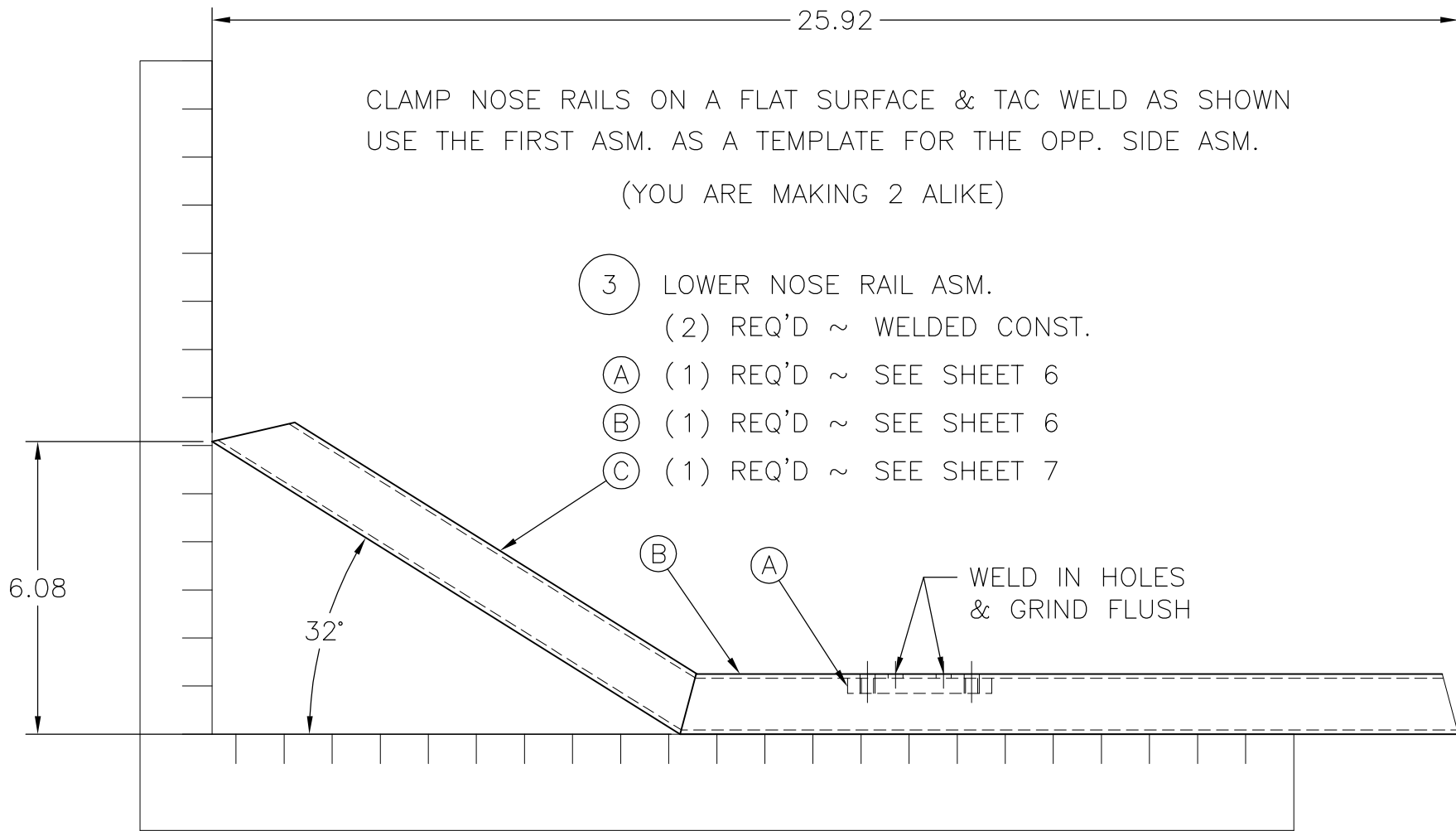


2C UPPER SUSPENSION ARM TAB  
 (4) REQ'D ~ 3/16 x 2 3/8 x 2 7/8 ~ H.R.S. (LASER CUT)



2D LOWER NOSE CROSS TUBE  
 (3) REQ'D ~ 1 1/4" SQ. x .083 WALL (14 GA.) x 4 5/8 ~ STL. TUB'G.

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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END LOWER FRAME ASM. DETAILS	DRAWN BY R.A.S.
				SCALE NONE	SHT. 4 OF 10 SHTS.



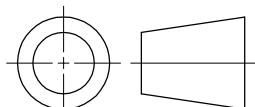
CLAMP NOSE RAILS ON A FLAT SURFACE & TAC WELD AS SHOWN  
 USE THE FIRST ASM. AS A TEMPLATE FOR THE OPP. SIDE ASM.

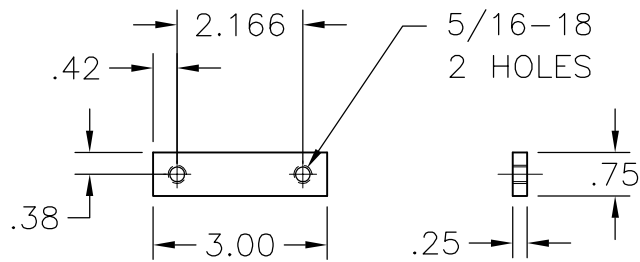
(YOU ARE MAKING 2 ALIKE)

- ③ LOWER NOSE RAIL ASM.  
(2) REQ'D ~ WELDED CONST.
- Ⓐ (1) REQ'D ~ SEE SHEET 6
- Ⓑ (1) REQ'D ~ SEE SHEET 6
- Ⓒ (1) REQ'D ~ SEE SHEET 7

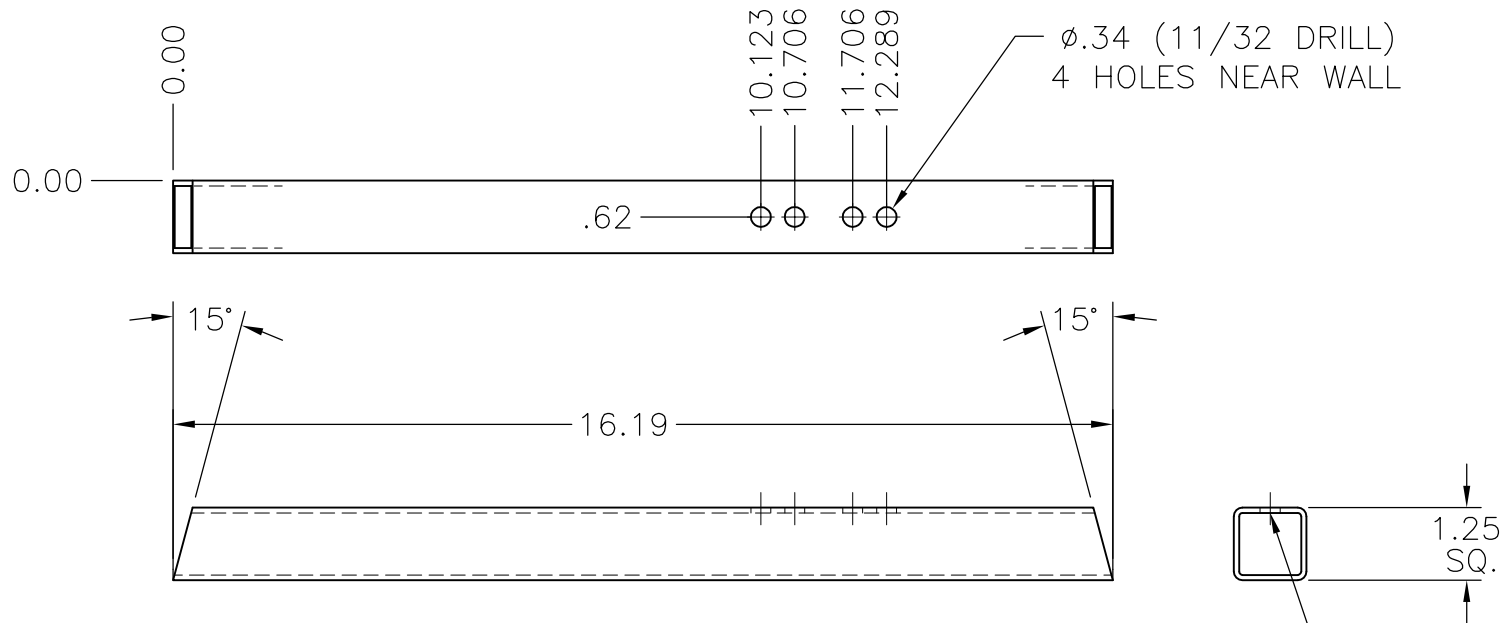
WELD IN HOLES  
& GRIND FLUSH

USE A SQUARE TO SET THE HEIGHT DIMENSION

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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2'  BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 <b>3RD ANGLE PROJECTION</b>		DESCRIPTION DOUBLE A ARM FRONT END LOWER NOSE RAIL ASM.	DRAWN BY R.A.S.
				SCALE NONE	SHT. 5 OF 10 SHTS.

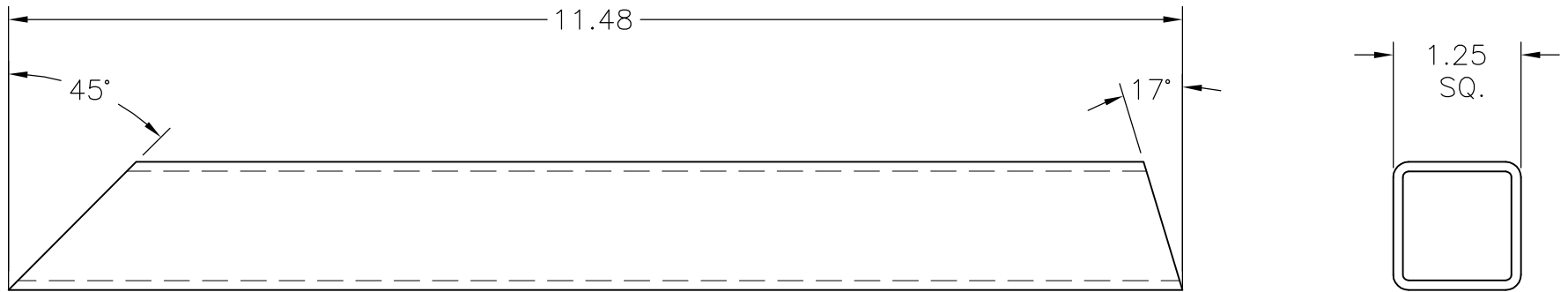


3A TAPPING PLATE  
 (2) REQ'D ~ 1/4 x 3/4 x 3 ~ C.R.S.

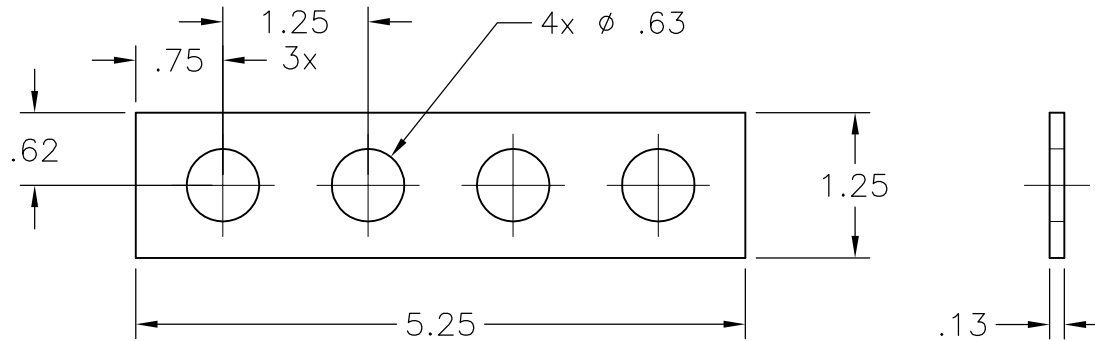


3B NOSE UPRIGHT RAIL  
 (2) REQ'D ~ 1 1/4" SQ. x .083 WALL (14 GA.) x 16 3/16 ~ STL. TUB'G. NO SEAM ALLOWED THIS SIDE

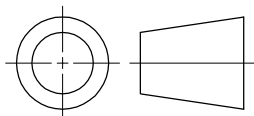
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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END LOWER FRAME ASM. DETAILS	DRAWN BY R.A.S.
				SCALE NONE	SHT. 6 OF 10 SHTS.

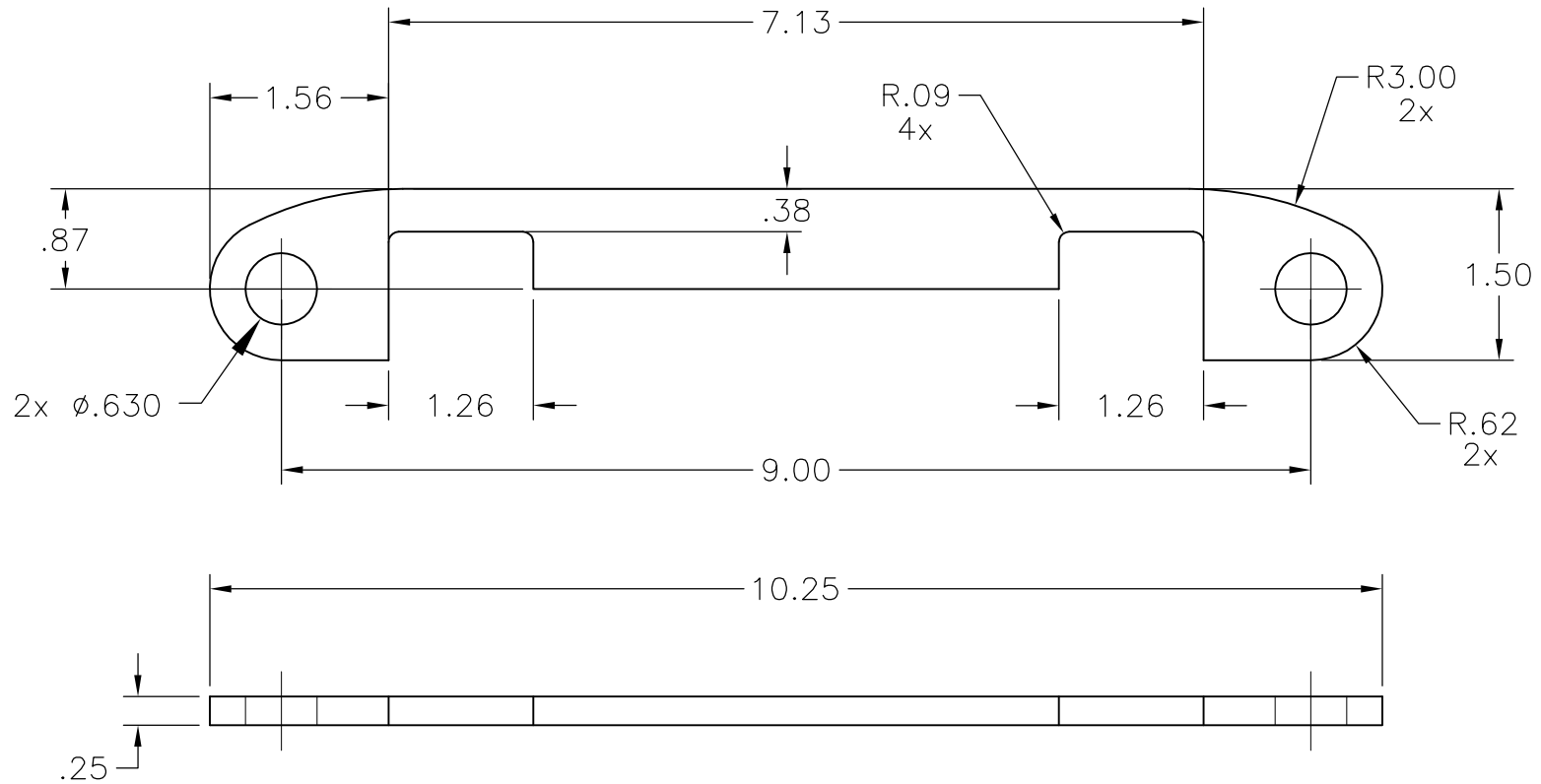


3C NOSE UPRIGHT RAIL  
 (2) REQ'D ~ 1 1/4" SQ. x .083 WALL (14 GA.) x 11 1/2 ~ STL. TUB'G.



1A FILLER PLATE  
 (1) REQ'D ~ 1/8 x 1 1/4 x 5 1/4 ~ H.R.S. (LASER CUT)

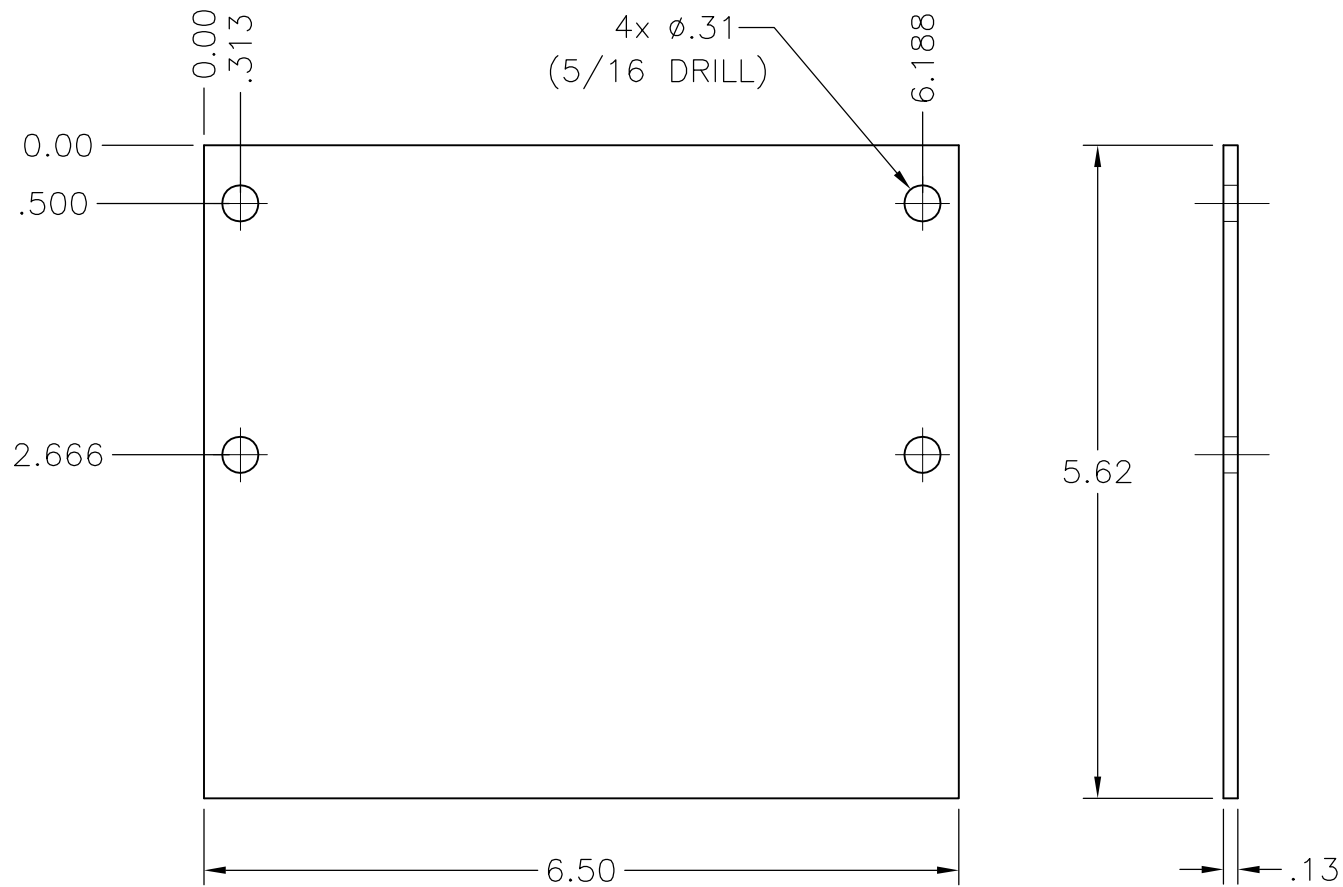
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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END LOWER FRAME ASM. DETAILS	DRAWN BY R.A.S.
				SCALE NONE	SHT. 7 OF 10 SHTS.



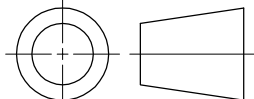
1B LOWER ARM MOUNT  
 (2) REQ'D ~ 1/4 x 1 1/2 x 10 1/4 ~ H.R.S. (LASER CUT)

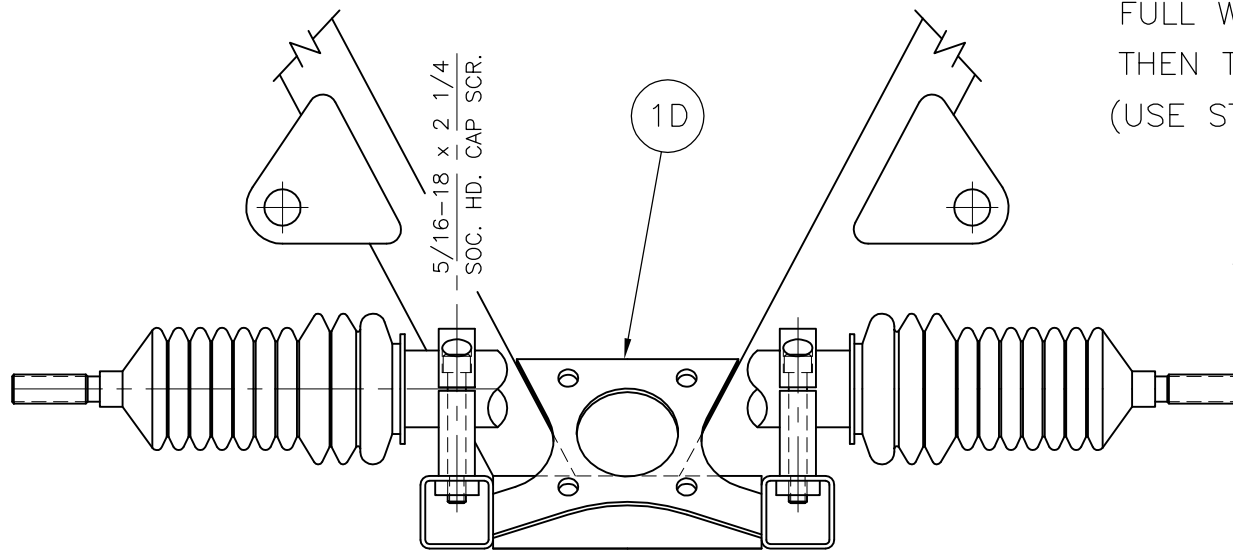
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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2'  BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END LOWER ARM MOUNT	DRAWN BY R.A.S.





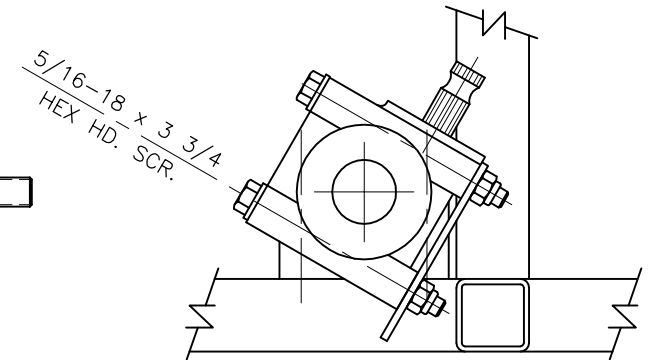
1C JIG PLATE (OPTIONAL FOR WELD SET-UP)  
 (1) REQ'D ~ 1/8 x 5 5/8 x 6 1/2 ~ H.R.S. (LASER CUT)

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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END SET-UP JIG PLATE	DRAWN BY R.A.S.
				SCALE NONE	SHT. 9 OF 10 SHTS.

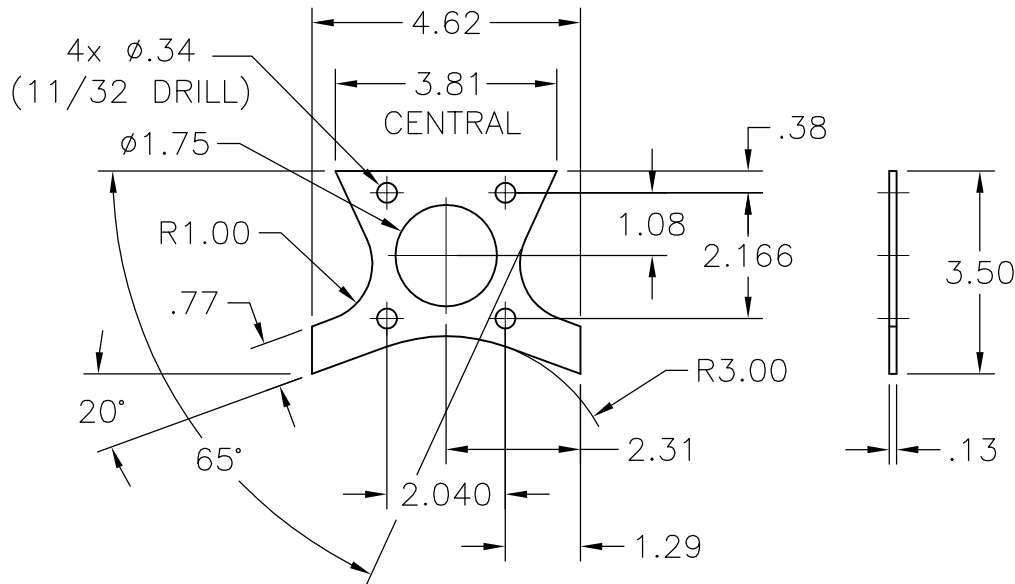


FRONT SECTION VIEW

FULL WELD CENTER SUPPORT TUBES.  
 THEN TACK WELD R & P MTG. PLATE 1D.  
 (USE STEERING R & P TO SET LOCATION.)



SIDE SECTION VIEW



1D R & P MTG. PLATE  
 (1) REQ'D ~ 1/8 x 3 1/2 x 4 5/8  
 H.R.S. (LASER CUT)

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	MACHINE .XX ±.01 MACHINE .XXX ±.005 FABRICATION .XX ±.03 ANGLES ± 2' BREAK ALL SHARP EDGES CHAMFER ALL HOLES	 3RD ANGLE PROJECTION		DESCRIPTION DOUBLE A ARM FRONT END RACK & PINION MOUNTING	DRAWN BY R.A.S.
				SCALE NONE	SHT. 10 OF 10 SHTS.