

STEP ONE



STEP TWO



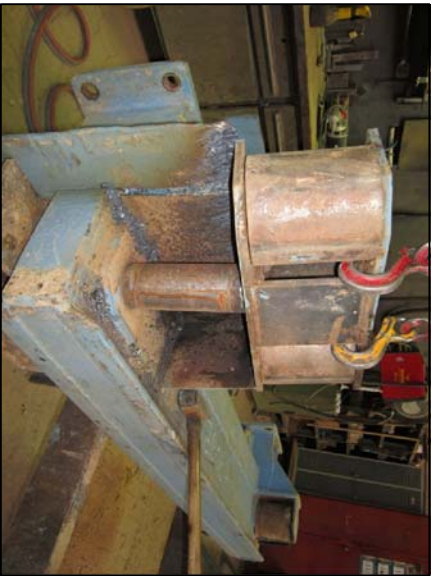
SPECIFICATIONS:

- All welding shall be performed according to the Structural Welding Code for Steel - AWS D11-90.
- A certified welder shall perform all welding.
- 70,000 psi welding rod or wire shall be used to complete the welds.
- 3/16" steel sheet with a 55,000 psi minimum yield strength shall be used to replace the skin plate cut away from the collars.

PROCEDURE:

1. Identify strut cart that needs to be repaired.
2. Carefully cut out the roller housing end plate making sure that the roller pin does not get damaged.
3. Remove the the roller assembly plate to expose the pivoting roller assembly. Prepare surfaces for welding.
4. Put new pivoting roller assembly on roller pin. Note no welding required on the pivoting roller assembly (this assembly is to move freely inside the housing unit)
5. Weld replacement housing plate to the outside of the housing unit.

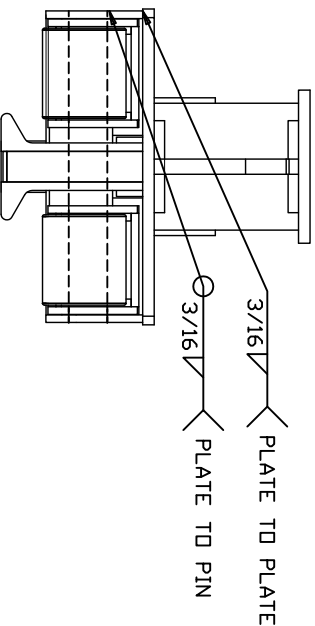
STEP THREE



STEP FOUR



STEP FIVE



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SCALE: AS SHOWN	DRWING NO. STRUT CART ROLLER REPAIR SPECIFICATION
DATE: 08/27/12	REV. NO. 0
REP. NO. 033	PAGE 1 OF 1

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