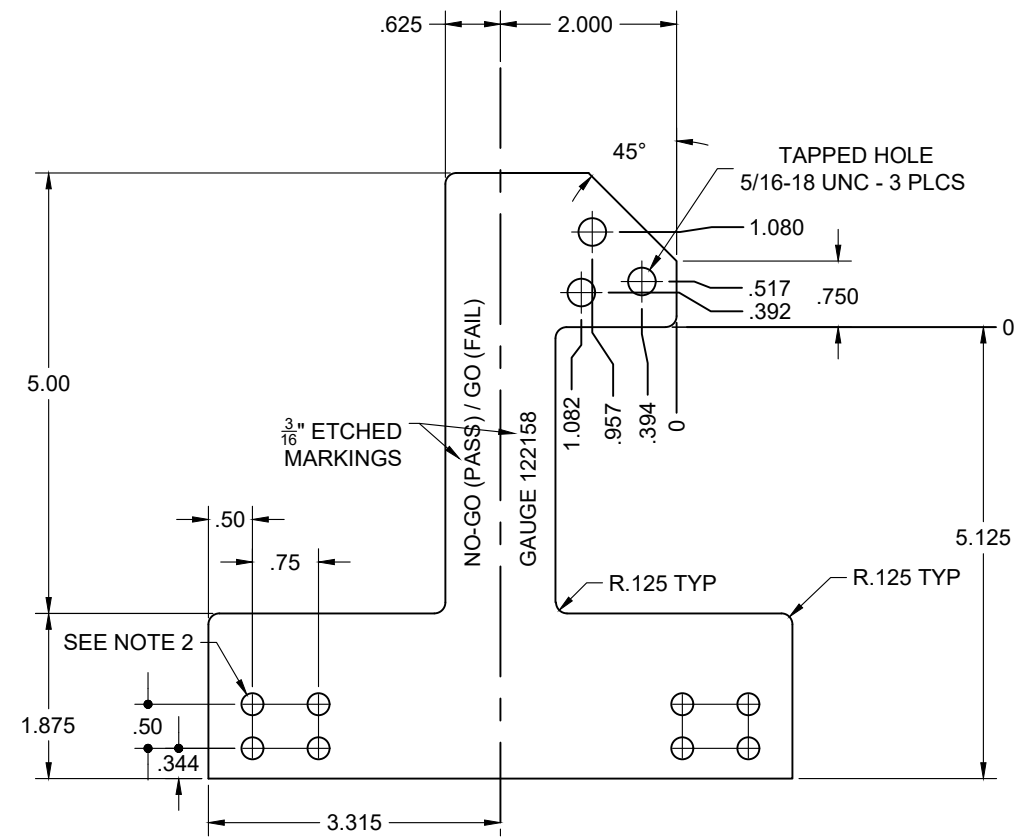
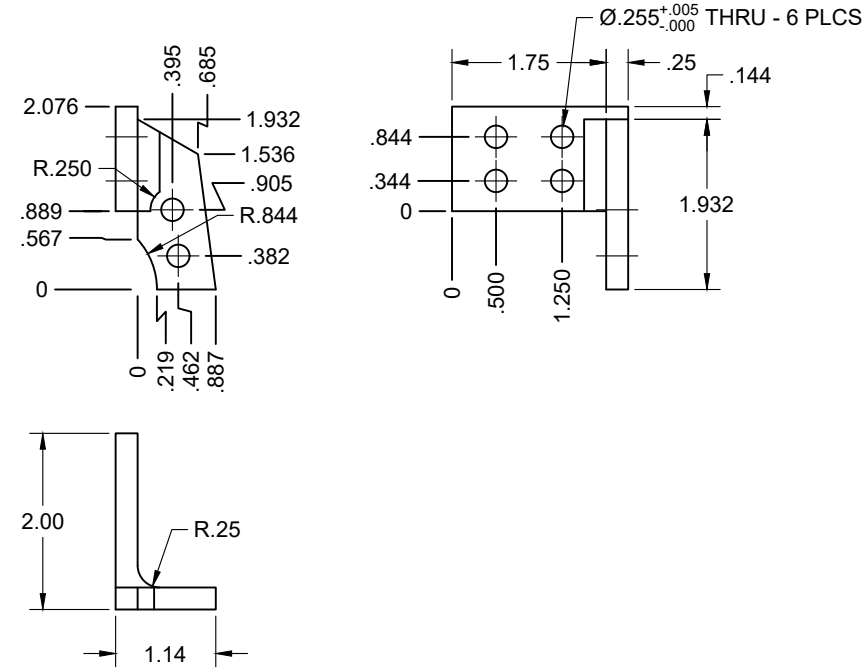


WHERE USED	LINE
E-TYPE / EF-TYPE COUPLER BODIES	-01
F-TYPE COUPLER BODIES	-02



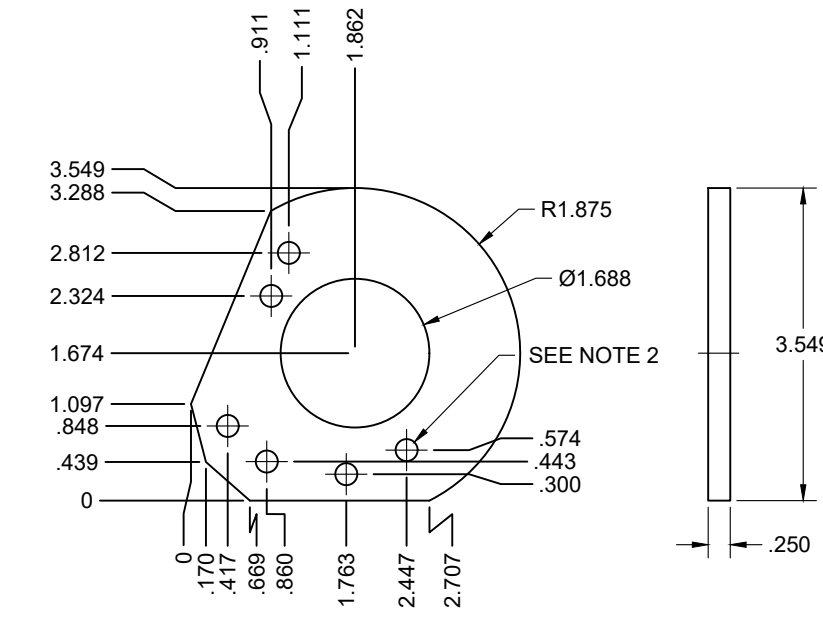
① GAUGE ARM

- NOTES:
 1. MATERIAL - STEEL PLATE, 1/4" A36
 2. TAPPED HOLE 1/2-20 UNC - 8 PLACES



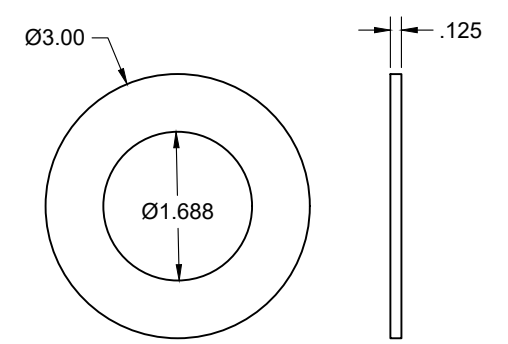
② BRACKET, GAUGE ARM

- NOTES:
 1. MATERIAL - STEEL ANGLE, L2 X 1-1/2 X 1/4" A36, MACHINED TO DIMS
 2. LOWER BRACKET SHOWN, MIRROR LAYOUT FOR UPPER BRACKET
 3. BREAK ALL SHARP CORNERS / EDGES



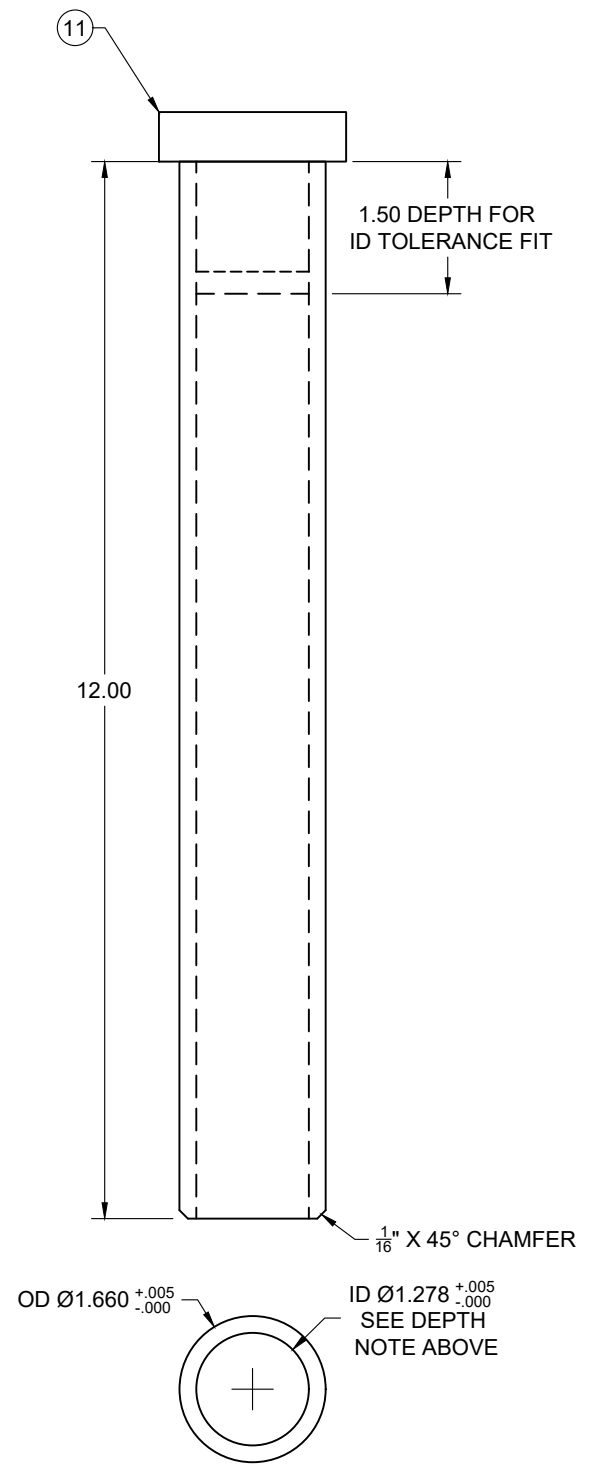
③ GAUGE PIN GUIDE

- NOTES:
 1. MATERIAL - STEEL PLATE, 1/4" A36
 2. ALL HOLES TAPPED 1/2-20 UNC - 6 PLACES



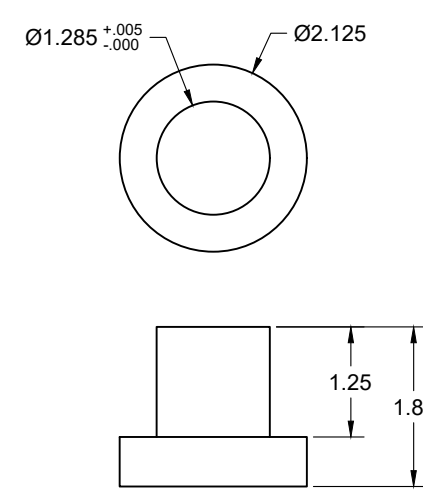
④ SPACER, GAUGE PIN GUIDE

- NOTES:
 1. MATERIAL - HARDENED STEEL, 1/8" THICK
 2. TACK WELD TO BOTTOM ITEM (3) GAUGE PIN GUIDE



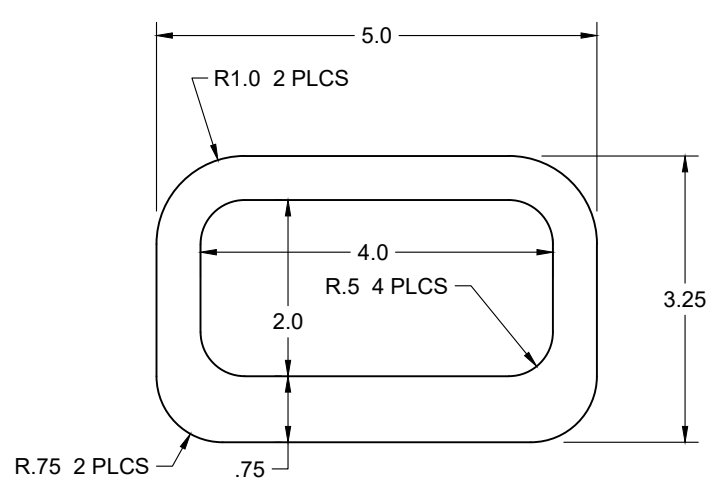
⑩ GAUGE PIN

- NOTES:
 1. MATERIAL (MACHINED TO DIMS)
 OPTION A - STEEL ROUND PIPE, Ø1 1/2" SCH 80, A53
 OPTION B - STEEL TUBING, Ø1 1/2" X 1/16" WALL, A513 DOM



⑪ TOP INSERT, GAUGE PIN

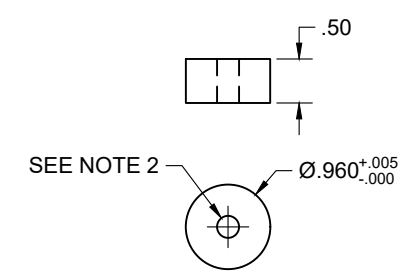
- NOTES:
 1. MATERIAL - STEEL ROUND BAR, Ø2 1/8", ASTM A576 GR 1018 HR
 2. MACHINE TO DIMENSIONS
 3. WELDS TO ITEM (12) AND PRESS FITS INTO ITEM (10). TACK WELD OPTIONAL.
 4. CHAMFER END AS REQUIRED TO PRESS FIT INTO ITEM (10).



⑫ HANDLE, GAUGE PIN

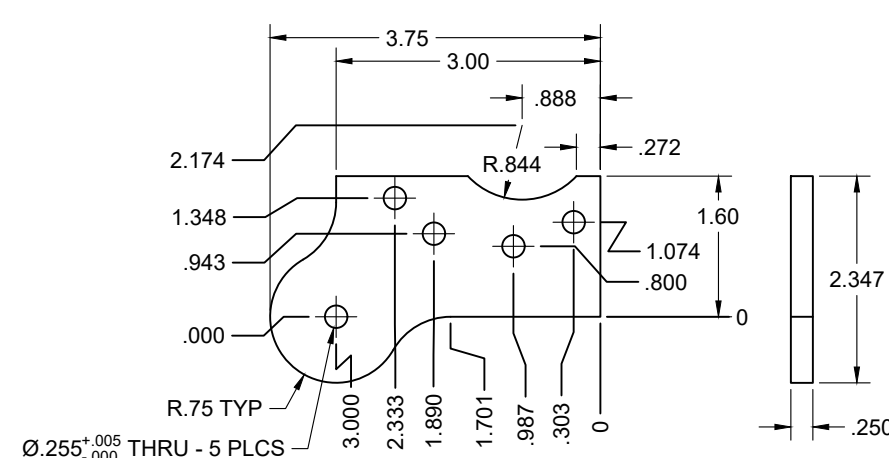
- NOTES:
 1. MATERIAL - STEEL PLATE, 1/4" A36
 2. WELDS TO ITEM (11)
 3. CONTOUR / BLEND ALL EDGES

- TOLERANCES:
 UNLESS OTHERWISE NOTED
 DECIMALS: ± 0.010"
 FRACTIONS: ± 1/32"
 ANGLES: ± 0.5°
 HOLE DIAMETERS: ± 0.005"



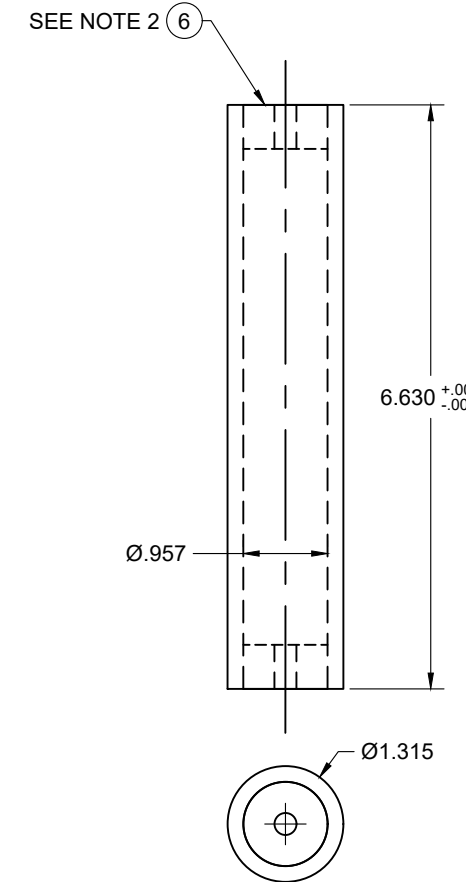
⑥ INSERT, GAUGE HANDLE

- NOTES:
 1. MATERIAL - STEEL ROUND BAR, Ø1", ASTM A576 GR 1018 HR
 2. TAPPED HOLE 1/2-20 UNC
 3. CHAMFER OD AS REQUIRED FOR PRESS FIT INTO ITEM (5)



⑦ BRACKET, GAUGE HANDLE

- NOTES:
 1. MATERIAL - STEEL PLATE, 1/4" A36
 2. BREAK ALL SHARP CORNERS / EDGES



⑤ GAUGE HANDLE

- NOTES:
 1. MATERIAL - STEEL ROUND PIPE, Ø1" SCH 80 X 6 1/8" LONG, A53
 2. ENDS GROUND AND SQUARED TO TOLERANCE AFTER PRESS FIT ITEM (6) BOTH ENDS. TACK WELD OPTIONAL

APPROVED: CSTCC	AAR M-212 COUPLER PULLING LUG GAUGE			
DATE: 11/12/21	SIZE: C	SCALE: DO NOT SCALE	SHT. 2 OF 2	DRAWING NO. 122158
NEXT ASSEMBLY NO. AAR M-212	SOLICITATION OF COMMENTS CIRCULAR			
DRAFT REV	3/4/22	DESCRIPTION OF REVISION		