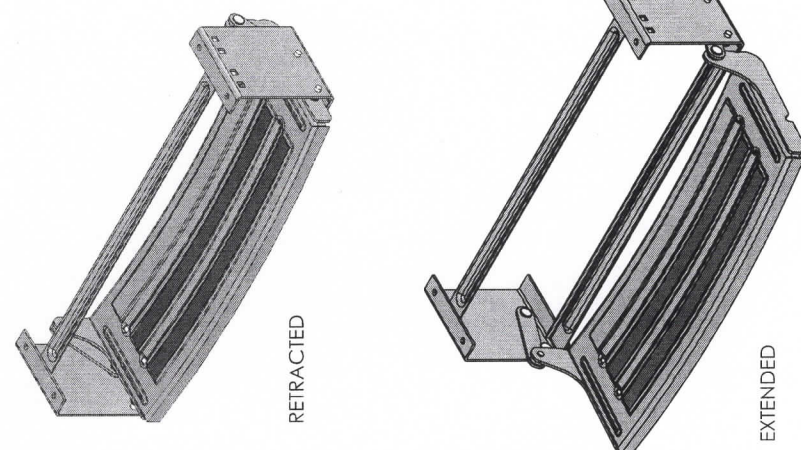
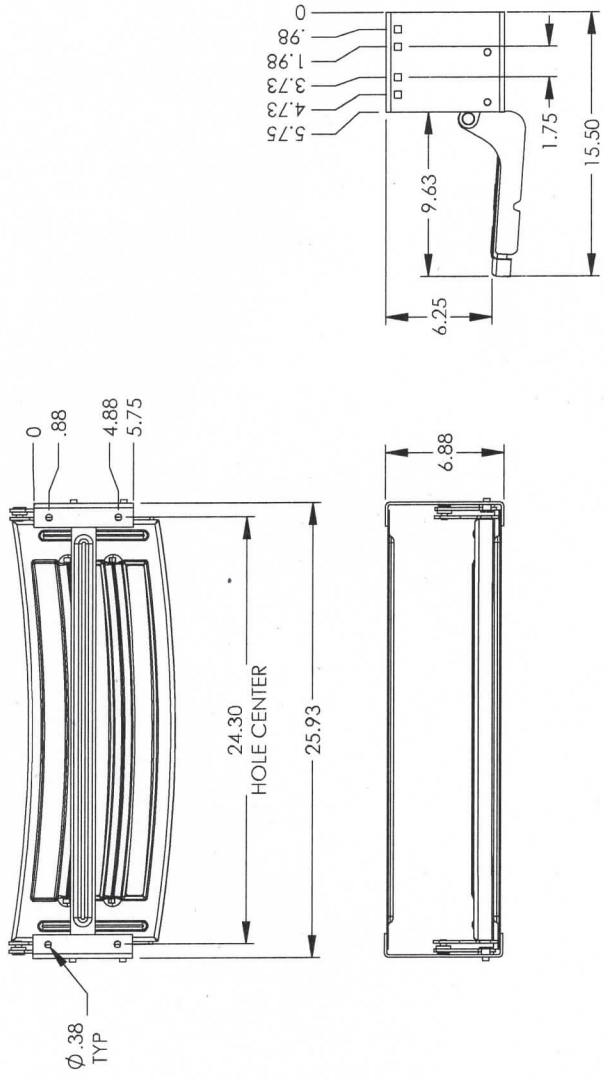


**NOTES:**

- STEPS MUST OPEN WITH MINIMAL EFFORT (TORQUE RESISTANCE SHOULD BE MINIMAL AT PIVOT POINTS)  
MAXIMUM OPEN FORCE (LBF) REQUIREMENT:  
BOTTOM TREAD - 10 LBS
- ASSEMBLY MUST BE FREE OF SCRATCHES & DENTS
- TREAD TO BE  $2^{\circ} \pm 1^{\circ}$
- TREADS TO MEET 200 MM MIN. PROTRUSION PER CSA 3.2
- MAXIMUM ALLOWABLE TIMING GAP FROM SIDE TO SIDE IS 1.2 MM
- LOAD RATING: 300 LBS
- CYCLE TEST  
20,000 CYCLES MINIMUM (400 LB LOAD ON EACH TREAD, UP AND DOWN THE STEP = 1 CYCLE)  
LOAD APPLIED FOR 0.8 SEC, DWELL TIME OF 1.0 SEC BETWEEN LOADING WITHIN CYCLE  
STEP MUST RETAIN FUNCTIONALITY AFTER TEST, INCLUDING ABILITY TO OPEN/CLOSE  
LOAD TESTING  
PROVIDE 4-STAGE POINT LOADING (SIMULATED FOOTPRINT) AT MIDDLE OF BOTTOM TREAD  
FOUR STAGES ARE AS FOLLOWS: 300 LB/600 LB/900 LB/ULTIMATE FAILURE  
STEP IS TO REMAIN FUNCTIONAL THROUGH 1ST 3 STAGES OF TESTING  
STEP IS TO REMAIN IN TACT AFTER ULTIMATE FAILURE (CAN HAVE SIGNIFICANT DEFORMATION)  
PERMANENT DEFLECTION IS TO BE MEASURED FROM BOTH BOTTOM FRONT TREAD CORNERS  
(AFTER LOAD REMOVAL) FOR EACH STAGE IS AS FOLLOWS:  
300 LB 0.0625 IN  
600 LB 0.1875 IN  
900 LB 0.3750 IN



REV	DATE	DESCRIPTION	CA	DWR	APVD
E	4/22/2011	CHANGED SQUARE HOLE LOCATIONS; CONVERTED ASSY TO PART; REMOVED BOM		DAL	EGR
F	1/19/2015	UPDATE DESCRIPTION	ECN-SP-DE-13840	RAW	RW
G	11/21/2016	ADDED DECAL NOTE	CA-0054818	RAW	JW
H	10/11/2017	UPD: NOTE, DIMS, DESCRIPTION; CHANGED FROM PART TO ASSEMBLY	CA-0091548	DSB	TC

**STEP SGL 24.59 STL RAD 6.25 9.63 MAN TAPE**

UNLESS OTHERWISE SPECIFIED  
1. ALL DIMENSIONS ARE IN INCHES  
2. BREAK SHARP EDGES & DEBURR  
3. DIMENSIONS TO BE AS SHOWN  
OR SUBSTITUTED WITH APPROVED  
AND TESTED EQUIVALENT

FINISH:  POLISH  ANODIZE

THIRD ANGLE PROJECTION

REFERENCE NUMBER: \_\_\_\_\_  
MATERIAL TYPE: \_\_\_\_\_  
SURFACE QUALITY: \_\_\_\_\_  
DECIMAL: \_\_\_\_\_  
FINISH GOOD WEIGHT: 14.555  
FINISH LIGHT: \_\_\_\_\_  
BLANK SIZE: \_\_\_\_\_

TOLERANCES (EXCEPT AS NOTED)  
DECIMAL: X ± 1  
XX ± 0.03  
XXX ± 0.05  
FRACTIONAL: ± 1/16  
ANGULAR: ± 1°

DWG. NO. 177438  
DATE: 1/12/2011  
SCALE: 1:7  
REV. H

DESIGNED BY: JMM  
CHECKED BY: JMM  
APPROVED BY: \_\_\_\_\_  
SHEET 1 OF 1