

C.) Add new crossmember assembly at rear of saddle assembly

12. Locate rear saddle crossmember on body. See Illustration 4
13. Center crossmember assembly (PN 016-20036-01) under rear saddle crossmember. Weld the hold down pin plate (PN 016-10171-01) in place. See Illustration 4 for weld pattern
14. **VERY GENTLY** lower the body until the crossmember assembly is slightly touching the draft arms. Use extra care to not push the crossmember down into the draft arms. See Illustration 5
15. Mark and trim hold down crossmember assembly to fit inside the draft arm width. See Illustration 5
16. Using the included shims (PN 016-10179-00), space the upper coupler plate ¼” from the saddles. Make sure the upper coupler plate is supported and tight against the shims and saddles. See Illustration 6
17. After the hold down crossmember assembly has been trimmed to fit, lower into position. Locate gusset assembly (PN 016-20037-00) on top of the crossmember assembly, with the shim facing the crossmember. Center and clamp into place. Tack weld the gusset assembly to the draft arm. For placement See Illustration 7
18. Drill two ½” holes completely through the crossmember, using the gusset assembly as a template.
19. Align the bottom gusset assembly using the bolt holes as a guide. Make sure the shim side of the gusset is towards the crossmember. Install the bolts (PN 540-15045-08) but leave loose.
20. Weld the gusset assemblies to the draft arms. See weld pattern on Illustration 7
21. Tighten the bolts (PN 540-15045-08) through the gusset assembly (PN 016-20037-00) and hold down crossmember assembly (PN 016-20036-00). Take care not to crush the hold down crossmember assembly. See Illustration 8

Illustration 4 - 8 on next pages

Please file a claim online as soon as inspections are done, so parts may be shipped as they become available. Claims must include pictures of area of concern, both sides of trailer.