



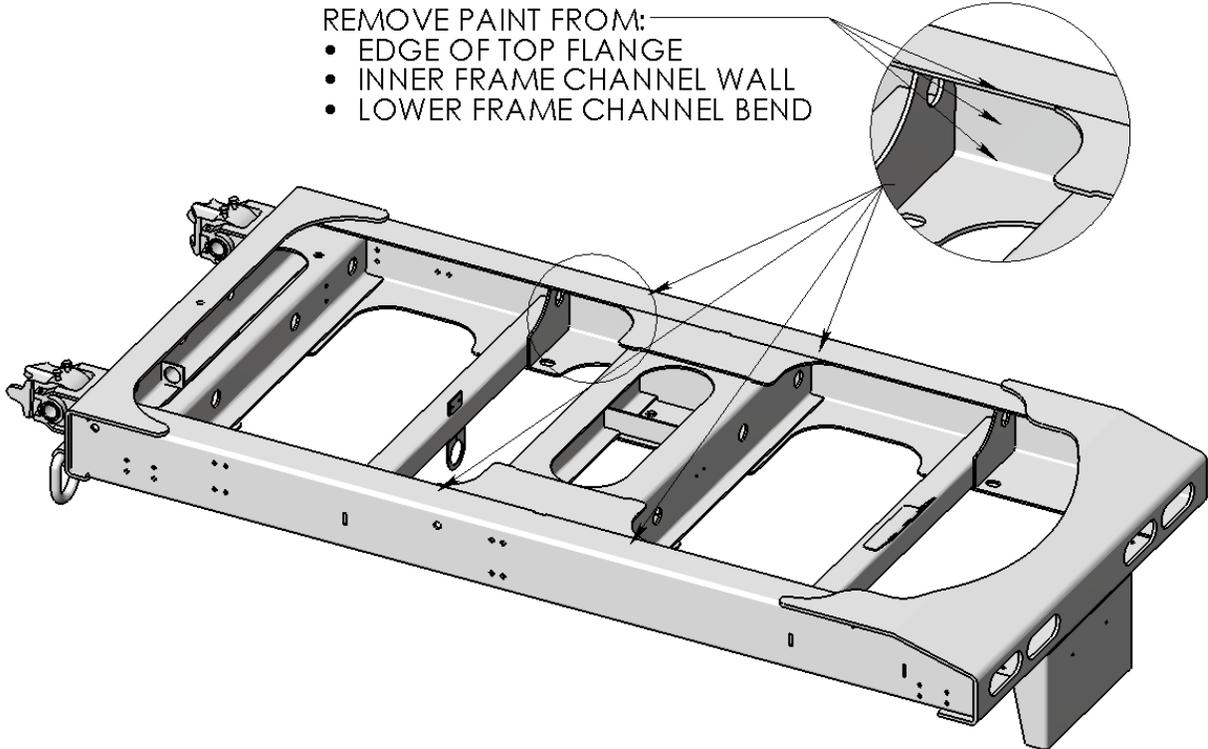
INSTRUCTIONS FOR ADDING FRAME CHANNEL REINFORCEMENT

TRAIL KING Industries, Inc.

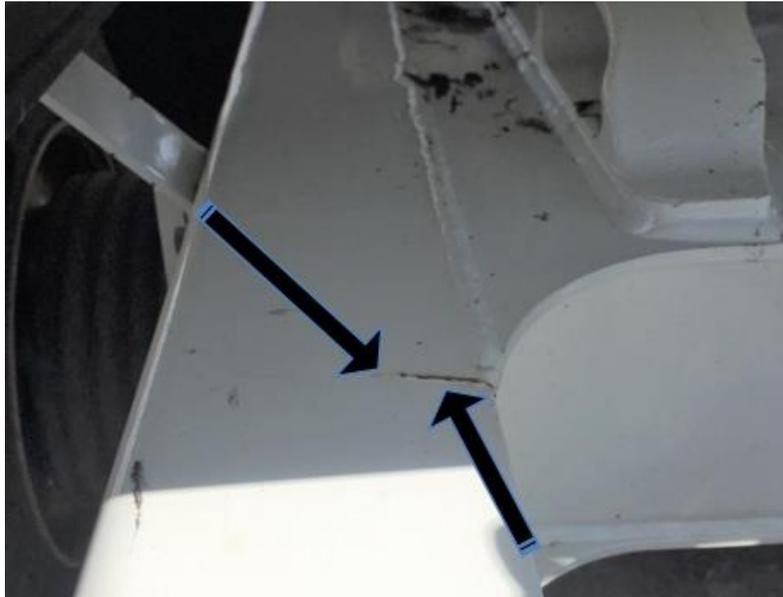
- Remove paint and clean area as needed in the areas shown below.

REMOVE PAINT FROM:

- EDGE OF TOP FLANGE
- INNER FRAME CHANNEL WALL
- LOWER FRAME CHANNEL BEND



- Drill out tip of cracked area and gouge entire length of the crack.



- Weld over all cracks on both sides of the frame flange.
- Grind the new weld flush with frame channel.

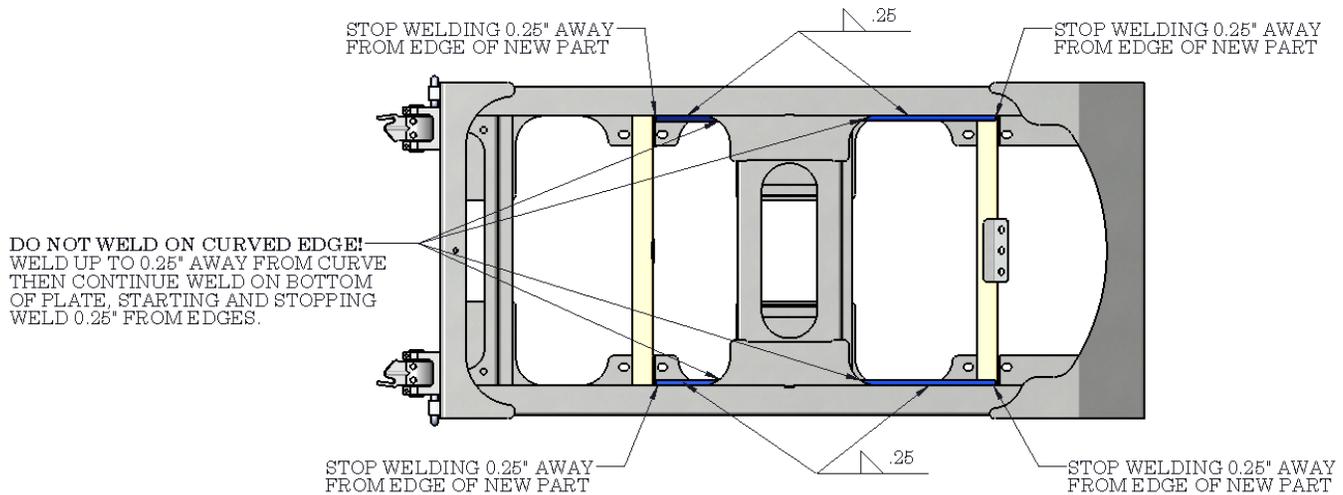


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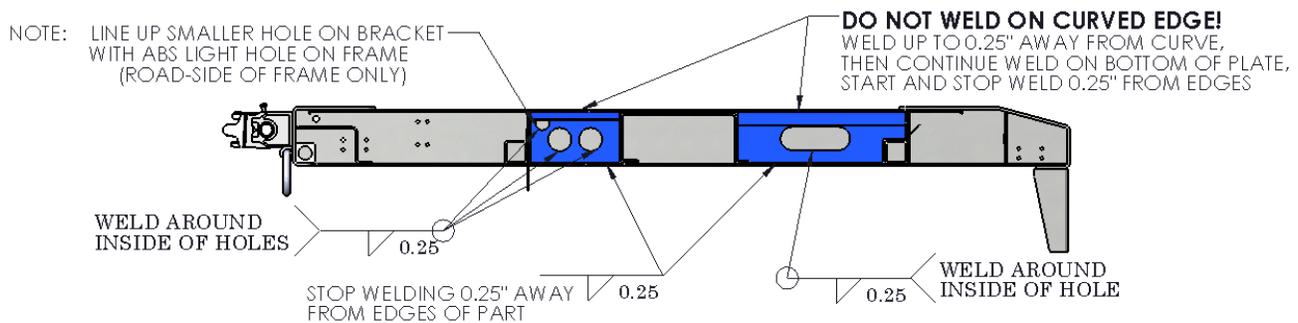
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- Install and weld channel reinforcement bracket. (As shown below) *Repeat for both sides of frame*

TOP VIEW



SIDE VIEW



- Trail King Industries recommended weld settings:

WELDING:

AMPERAGE: 270-330

VOLTS: 25-32

WIRE SPEED: 320-370

WIRE TYPE: ER-70S-6(L-56)

OPTION: ER-70S-3(L-50)

WIRE DIA: .045-.052

SHIELD GAS: 95% ARGON, 5% O₂

OPTION: 90% ARGON, 10% CO₂

- * The number and sequence of weld passes shall be dictated by material thickness. All welds shall be minimum ¼" fillet weld. When the thinnest material being joined is equal to or greater than 3/8", triple pass welding shall be required, except in dual wire sub-arc welding process. Unless otherwise specified.

- Clean, prime and paint all affected repair areas to prevent oxidation (rust).