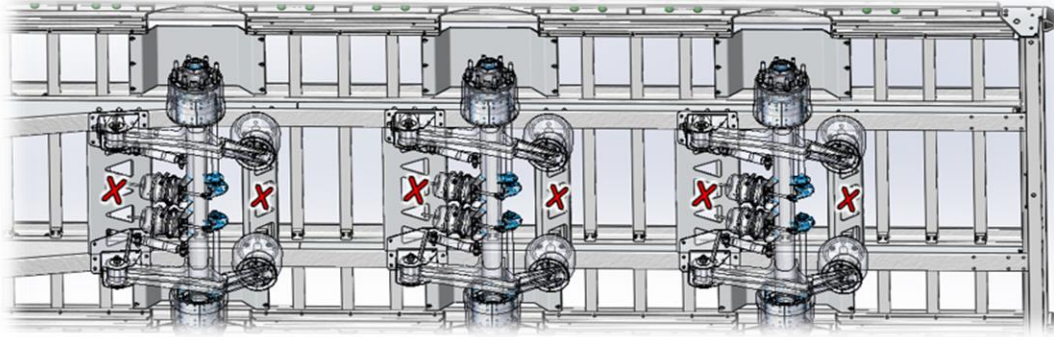


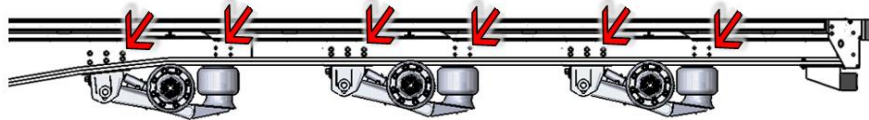
Below are the instructions for replacing aluminum cross-members above each fixed axle on the AACS trailer.

(Note: This does not include any sliding axles, it is only on the fixed axles.)

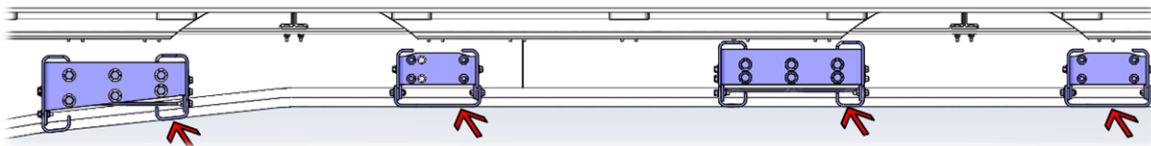
- Locate aluminum cross members in affected area below.
(Red X's below, identify the aluminum cross-members that may need to be repaired or replaced)



- Before removing existing aluminum cross-member, mark each location for ease of location and installation of new cross-members.
- Remove bolts from both sides of the trailer on the main beams as shown below.



- To finish removal of aluminum cross-members found on each fixed axle, note that the aluminum cross-members will be required to be cut in half for removal.
- Locate the bottom of the new cross-member flush with the bottom of main beam flanges - as shown below. Cross-members will be required to be assembled and located inside the frame of the trailer. (You can not preassemble cross-member assemblies)



- Align new cross-members in the same location as the old one, using the holes in the webs of the the mains, drill holes through cross-member end plates for boltin cross-members to align properly. Ensure cross-members remain flush with the bottom flanges.

