



BULLETIN

<u>Subject:</u>	Forklift Kit Wheel Stops		
Date:	11/11/2020	Rev.: B	No.: B20016
Re.:	Forklift Wheel Stop Weldment		Type: Safety
Priority:	As soon as possible		
Units Affected:	Transcraft Forklift Kits with Adjustable Wheel Stops		

Background:

Inadequate welding of forklift mounting plates for wheel stops.

Materials

Item	Part Number	Qty
Spacer Block	4370-0110	6
Spacer Plate	9100-0201	4
Gusset	9100-0202 (Depending on model)	3
Gusset	9100-0203 (Depending on model)	3

Tools

1.1/8" Socket	1
1.1/8" Wrench	1
Impact	1
Welder	1
Flashlight/Drop-light	1



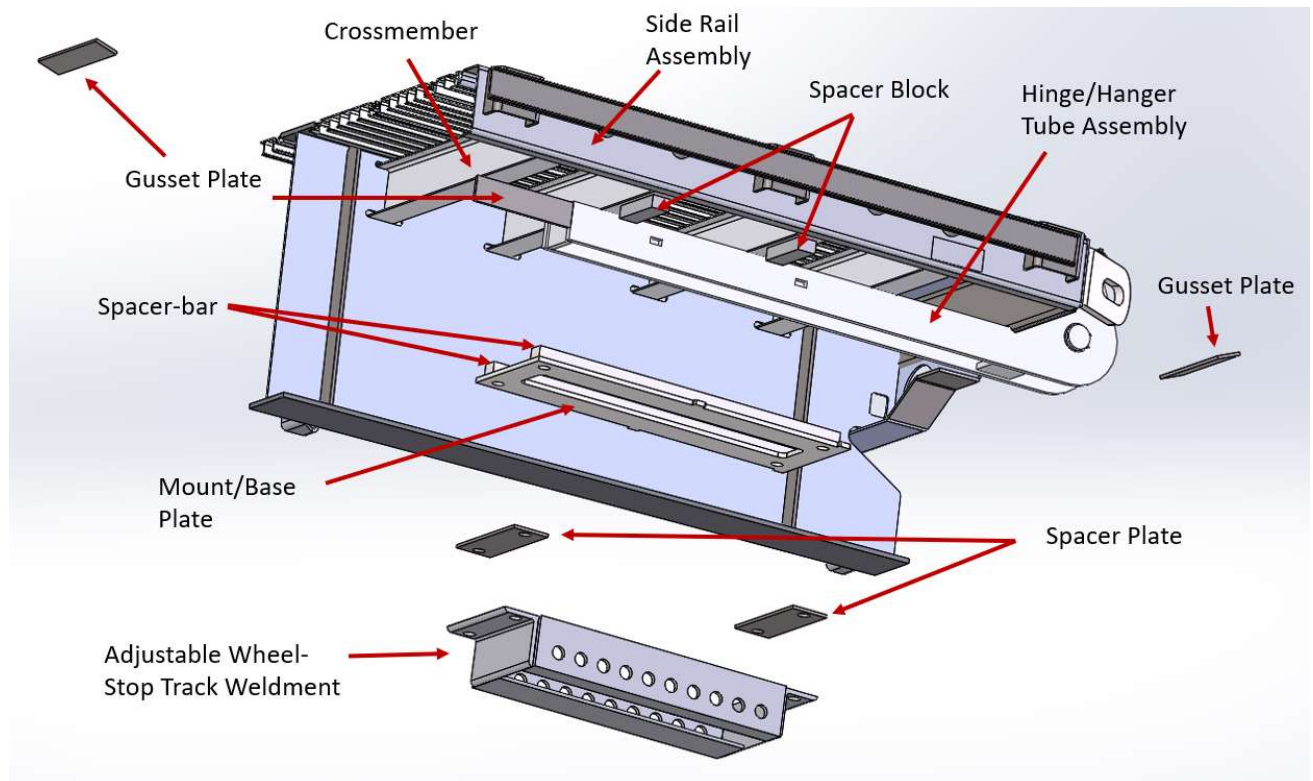
CAUTION!

- Wear appropriate personal protective equipment [PPE] like gloves, safety glasses and hard hat for example, when carrying out the following procedure.
- Should welding or cutting be needed, do so in a well ventilated area and wear appropriate head/face/eye protection, welding gloves and clothing.
- Refer to adhesive and chemical manufacturer's MSDS for safe use and handling instructions if applicable.
- Follow your company's safety procedures in addition to these recommendations.
- Follow industry standards for installation and tightening of all fasteners where torque values are not called out

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Forklift Kit Wheel Stop Model:

The below expanded view shows some of the parts for the Adjustable Wheel Stop kit assembly along with the shipped parts for assembly modification. The naming convention indicated here will be used throughout the guide.



Basic Guidelines:

- Follow AWS D1.1 weld standards.
- The filler wire used must conform to ANSI / AWS A5.18 standards. (ER70S-3 or ER70S-6 is preferred)
- All welds are overhead, use proper gear and caution.
- Remove paint and weld on a clean surface.
- If weld removal is necessary, use proper tools but do not remove base metal.
- Refer to Engineering Weld Prints at the end of the bulletin.
- Use primer and paint on all new weld surfaces.

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Procedure:

1. Disconnect 7-way wiring from R/S wheel stop



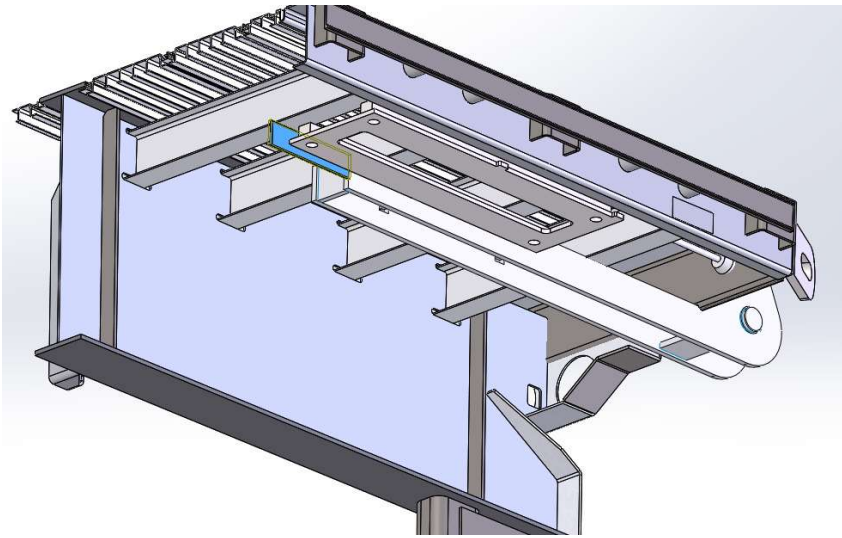
2. (If applicable) disconnect back-up camera wiring from R/S wheel stop
3. Support adjustable wheel stop for removal. Use a 1.1/8" Wrench with 1.1/8" socket and impact to remove adjustable wheel stop bolts on R/S & C/S (4 bolts per wheel stop)



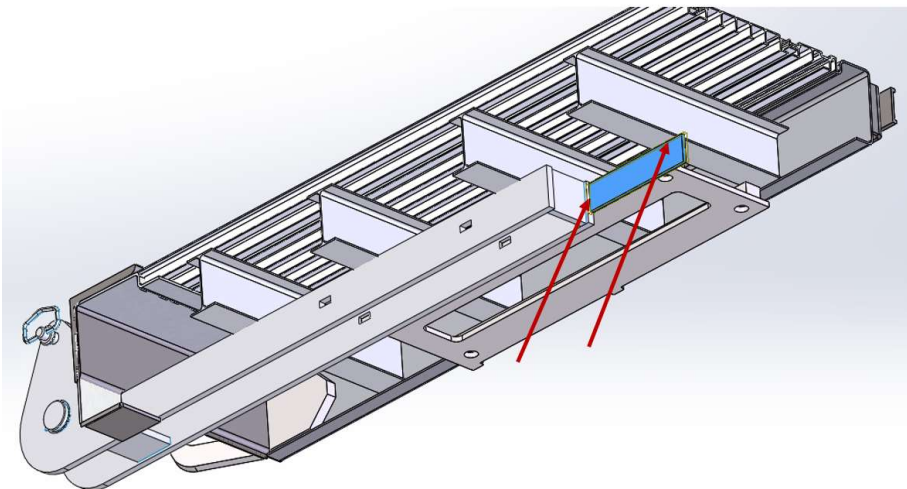
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Note: If your unit is not equipped with the Hinge / Hanger Tube Assembly follow steps 7 through 12 and 17 through 19.

4. Tack weld the provided gusset (9100-0202 for 102" and 9100-0203 for 96" wide trailers) to the crossmember and the hinge tube weldment. If multiple gussets are provided, use the longer gusset in this location. (Refer to the expanded view at the end of the bulletin for the naming convention of each part)

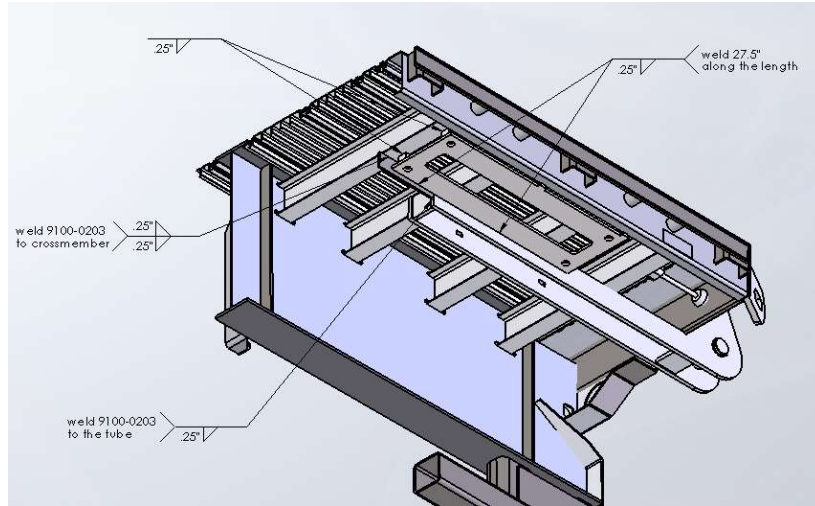


5. Weld the gusset plate to both sides of the crossmember and the inside edge of the tube weldment. (Weld drawings at the end of the bulletin)



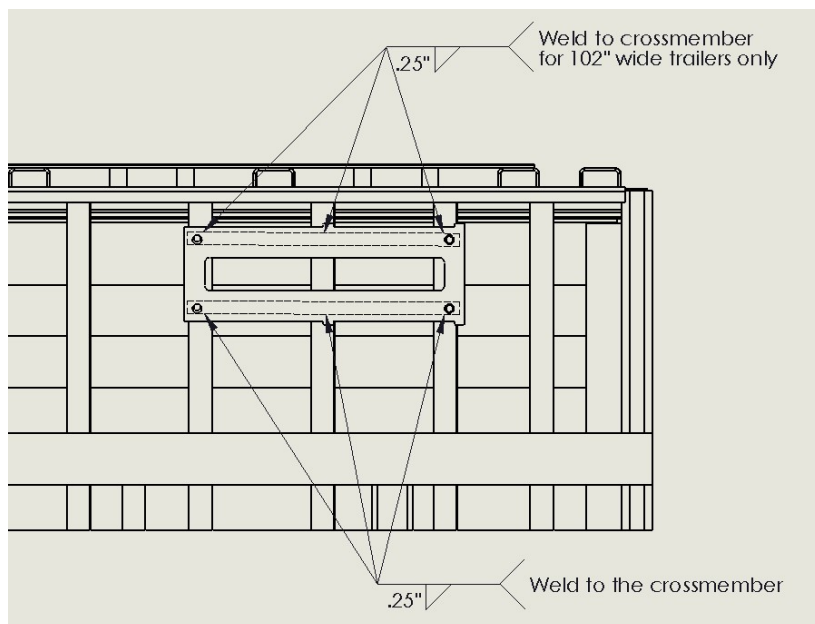
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6. Weld base plate along the length to the tube weldment and the gusset. Make sure the base plate or the spacer bar are not welded to the side rail.



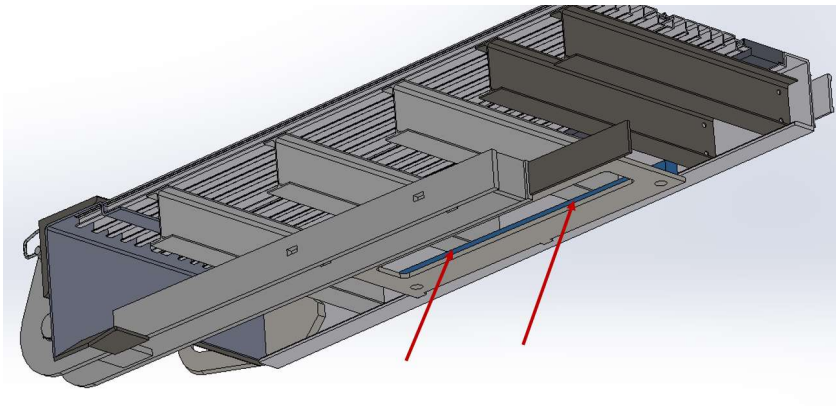
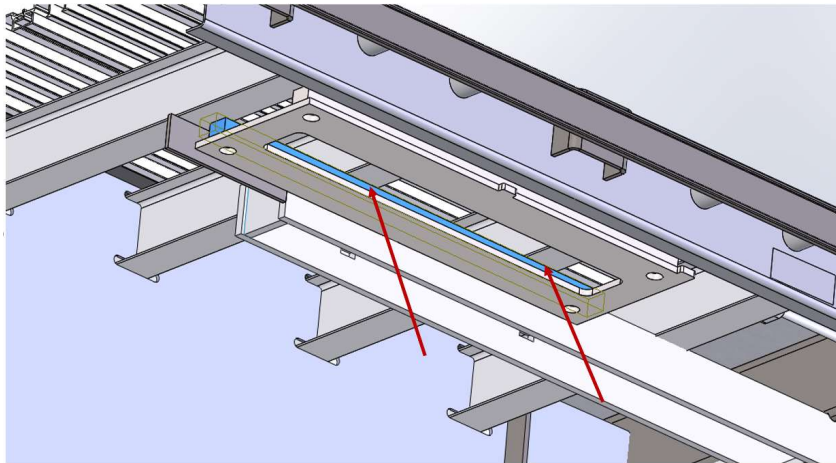
Note: If you have performed steps 4 through 6 please skip step 7.

7. For the units without the hinge/hanger tube weldment assembly, follow steps 7 through 12. Then steps 17 through 19. Inspect and make sure welds exist in the below locations.



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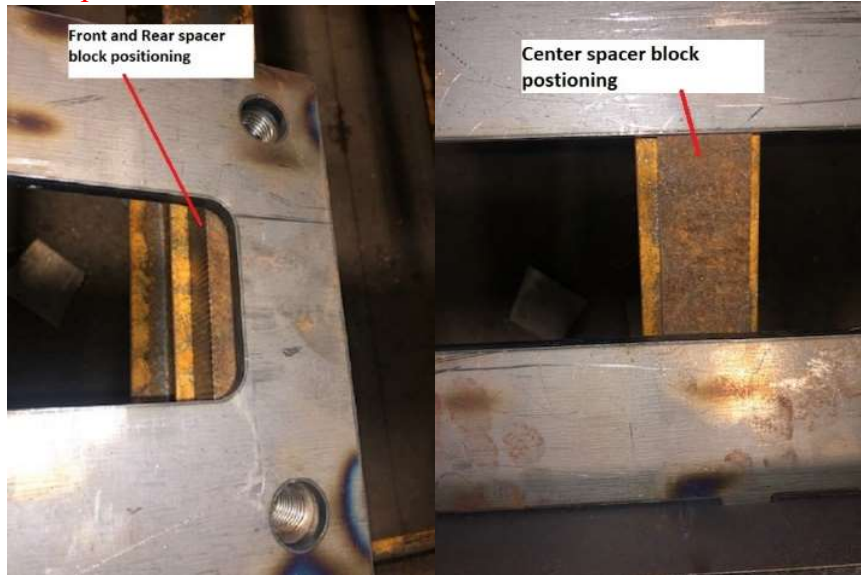
8. Weld both spacer-bars to the bottom flange of the crossmembers in the shown locations. In some cases, you will have weld access for one crossmember only.



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9. Insert spacer blocks (4370-0110) between the wheel stop mounting plate and crossmember centered on bottom of the crossmember.

Note: Depending on floor sill layout some units will only require 2 spacer blocks per wheel stop.



10. Weld front and back of spacer blocks to bottom of the crossmember

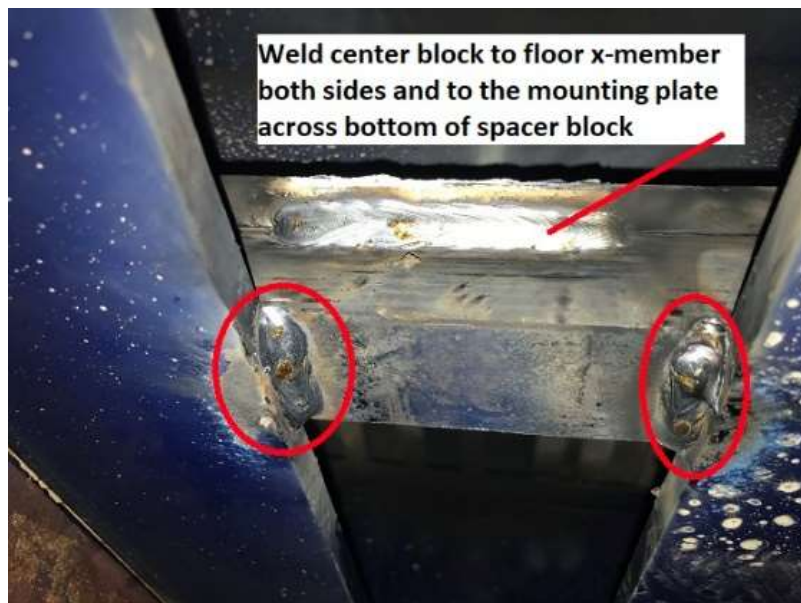


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11. Weld bottom inside edge of spacer block to mounting plate at the front and rear crossmembers

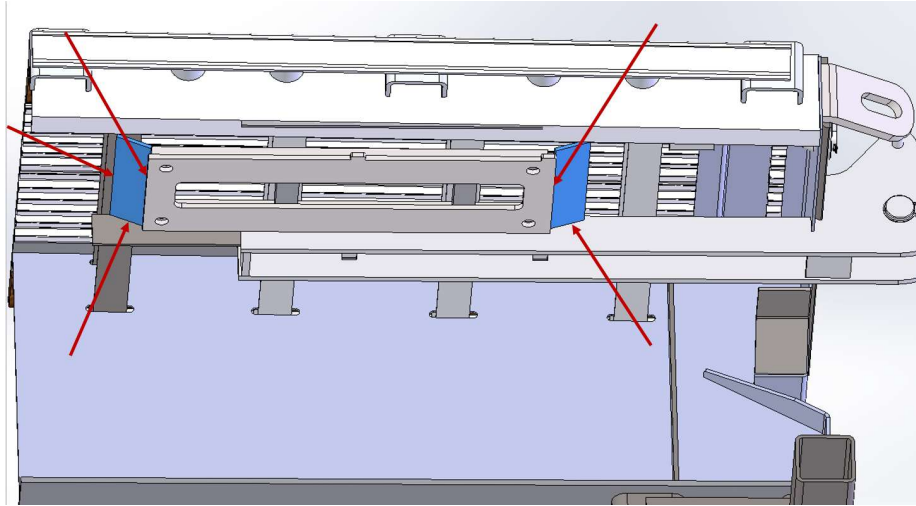


12. Weld center crossmember spacer block to inside edges of mounting plate

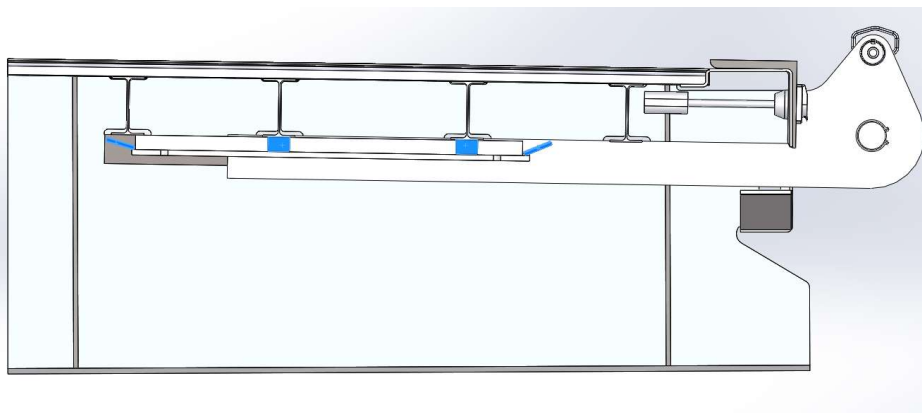


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13. Weld the remaining two gussets as shown - the arrow points to the location of the welds. In this case, the front gusset is welded to the crossmember as well. Always make sure the gusset is welded to the center of the crossmember flange and not the edge.

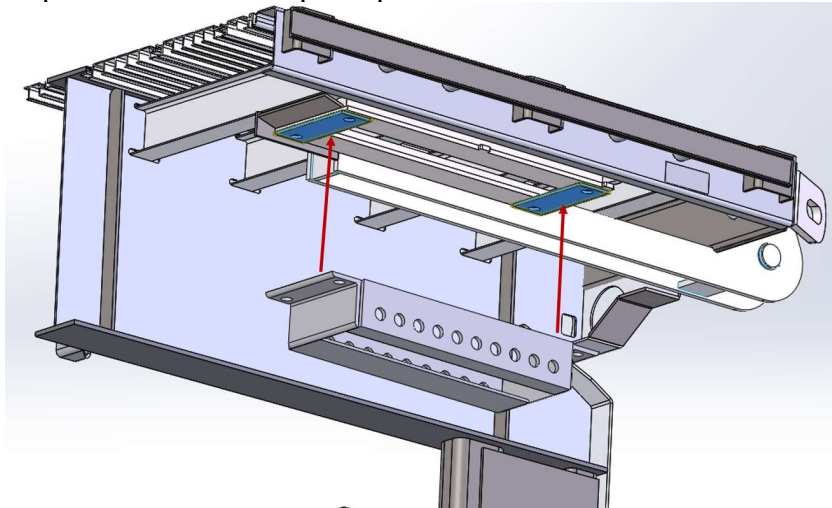


The below section view shows the two new gussets and the spacer blocks installed. Notice that in this case the front gusset is not welded to the crossmember.



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14. Install spacer plates (2) 9100-0201 when re-installing the adjustable wheel stop. Do not weld the spacer plate.



15. Make sure track weldment sits flush, and there is no weld interference.



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16. If trailer is a 96'' wide unit, grind out and remove welds from the mounting plate to bottom of the siderail.



17. Paint welded areas and spacer blocks

Note: Paint / Primer / Catalyst will need to be purchased by repair center

18. Re-install wheel stops – Torque mounting plate bolts to 125 Ft.lbs

19. Re-connect 7-way wiring

- a. (If applicable) re-connect back-up camera wire using wire labeled # 1.)

Primer and Catalyst for Sherwin Williams:

Zinc Primer – EEG0015 / Catalyst – CEC0076

Paint Codes for Sherwin Williams:

Black – KPA0602 / Paint Catalyst – 53-X145B

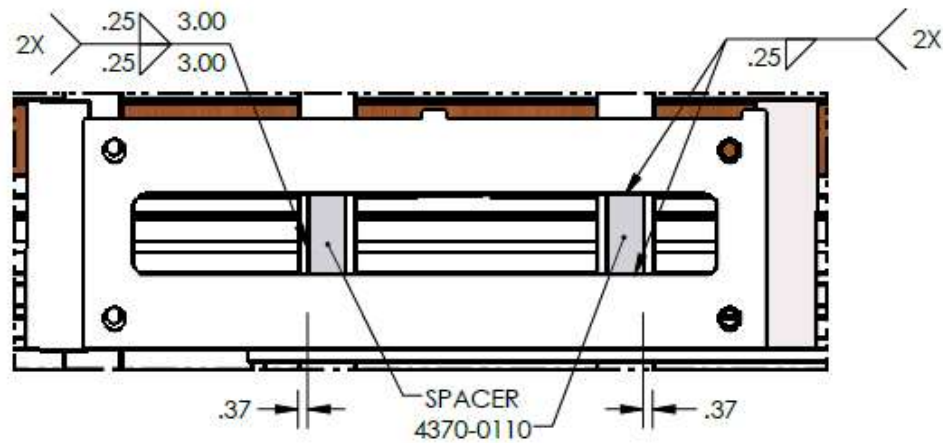
Blue – KPL0499 / Paint Catalyst – 53-X145B

Red – KPR0718 / Paint Catalyst – 53-X145B

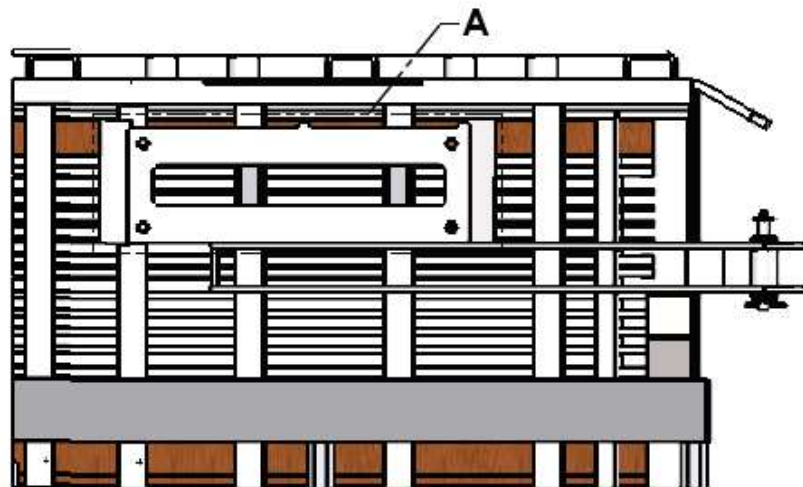


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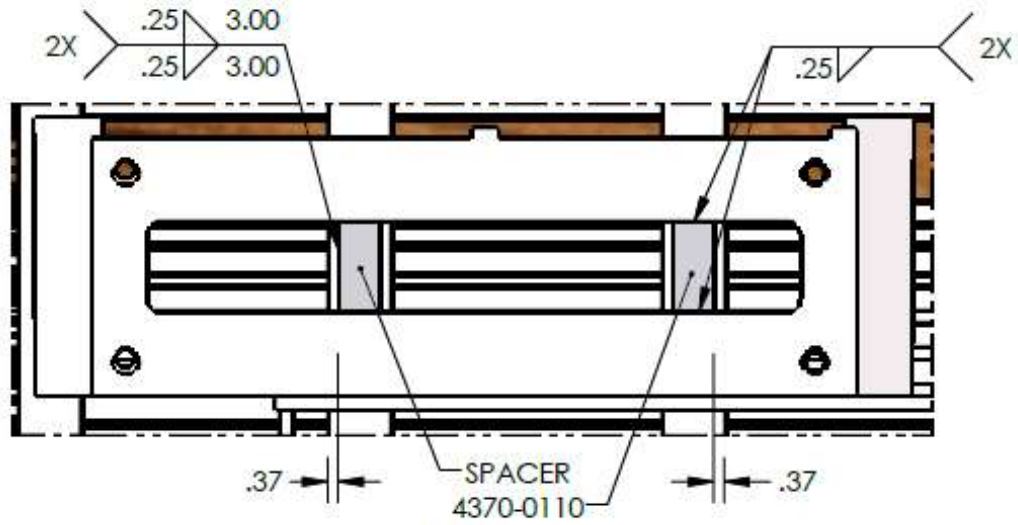
Engineering Weld Prints



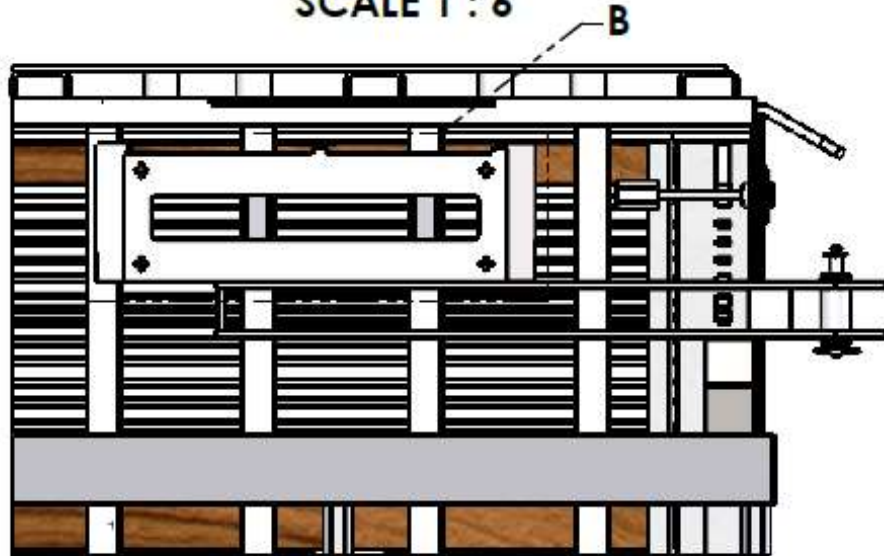
DETAIL A
SCALE 1 : 6



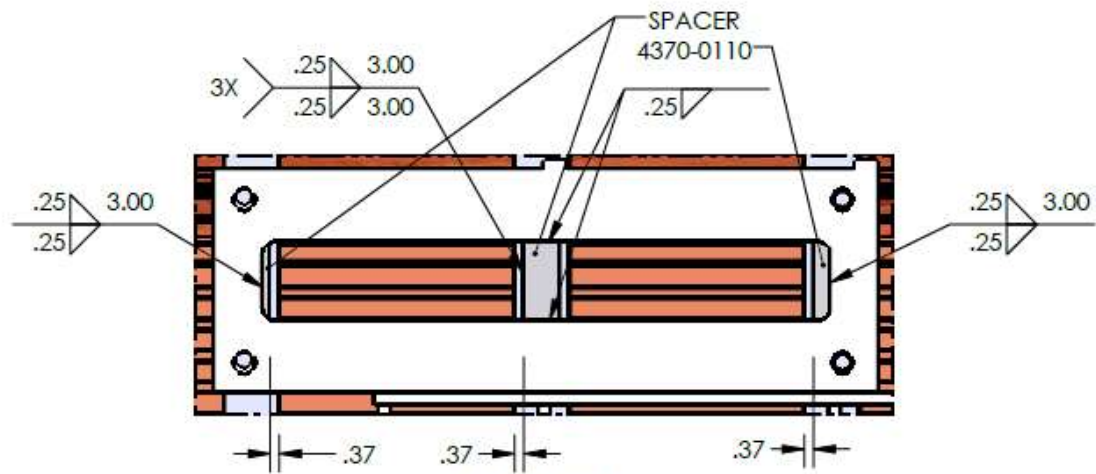
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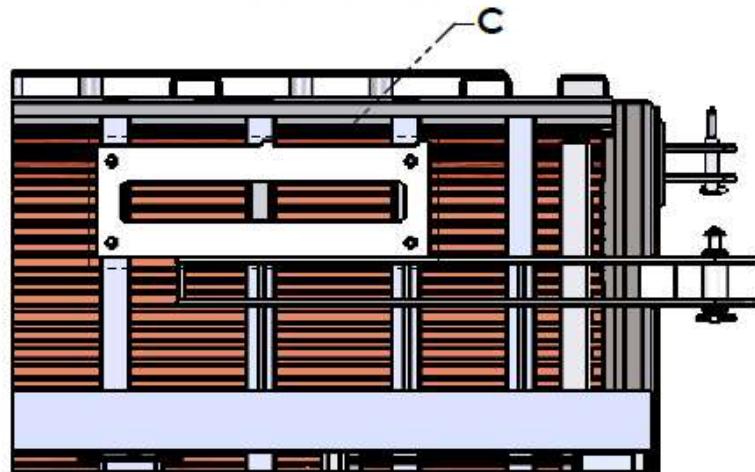
DETAIL B
SCALE 1 : 6



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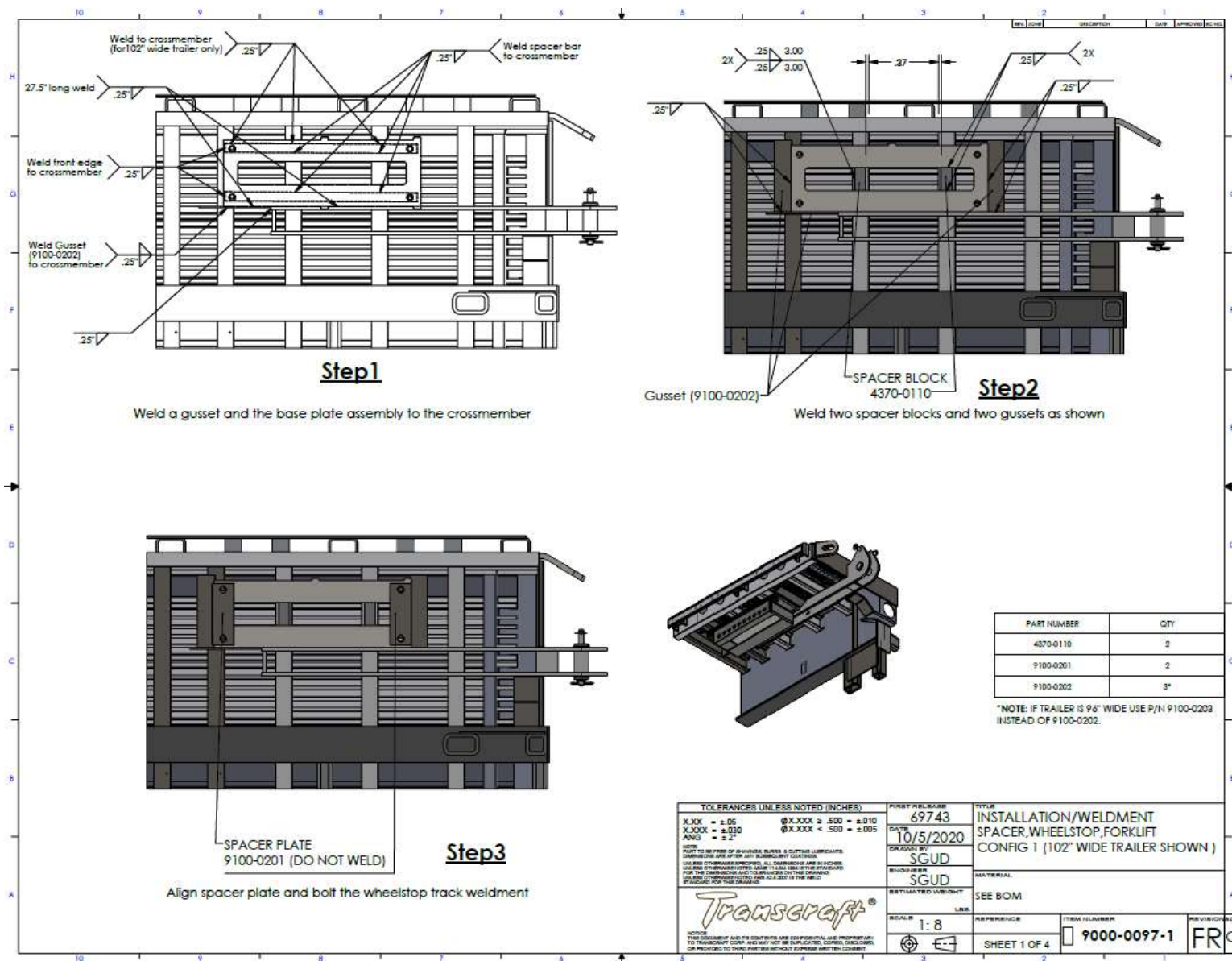


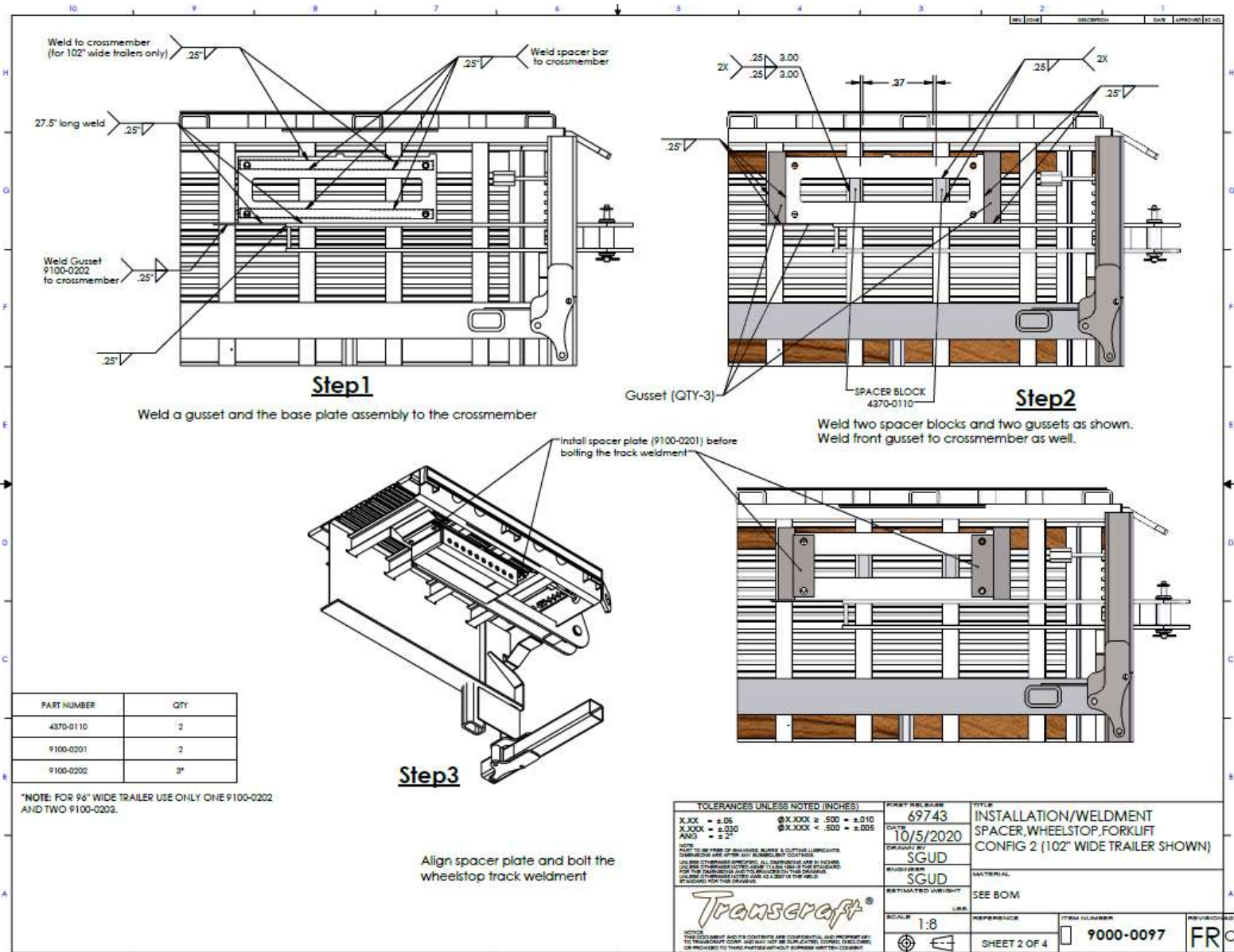
DETAIL C
SCALE 1 : 6



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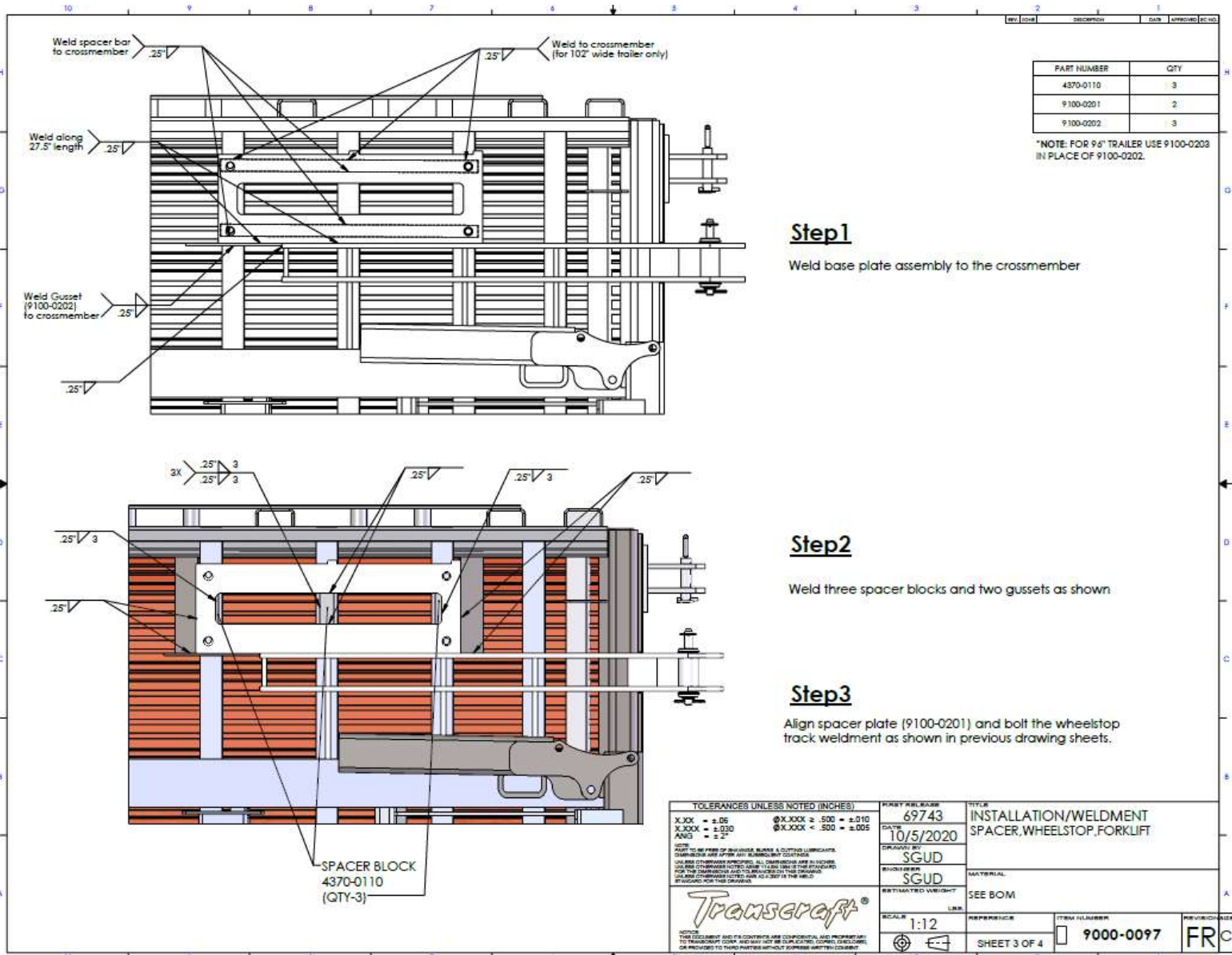
The below drawings represent the weld requirements for the wheel stop assembly on the Transcraft trailer designs for the past few years. Select the drawing that applies to your trailer design and use other drawings as a reference.







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Step1

Step2

Step3

Step4

Part numbers	Quantity
4370-0110	2
9100-0201	2
9100-0203	3*

*NOTE: FOR 102" WIDE TRAILER USE 9100-0203 IN PLACE OF 9100-0202.

TOLERANCES UNLESS NOTED (INCHES)

X.XXX = ±.05
X.XXX = ±.030
ANG = ±.2°

NOTES:
1. ALL DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED.
2. DIMENSIONS ARE GIVEN IN PARENT PARENS.
3. DIMENSIONS ARE GIVEN IN PARENT PARENS.
4. DIMENSIONS ARE GIVEN IN PARENT PARENS.
5. DIMENSIONS ARE GIVEN IN PARENT PARENS.

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FIRST RELEASE

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REVIEWED BY: SGUD

ESTIMATED WEIGHT: - LBS

SCALE: 1:12

REFERENCE: SHEET 4 OF 4

ITEM NUMBER: 9700-0097

PREVIOUS EDITION: FR

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Location Significance	Fillet	Plug or Slot	Spot or Projection	Stud	Seam	Back or Backing	Surfacing	Flange Corner	Flange Edge
Arrow Side									
Other Side				Not used			Not used		
Both Sides		Not used	Not used	Not used	Not used	Not used	Not used	Not used	Not used
No Arrow Side or Other Side Significance	Not used	Not used		Not used		Not used	Not used	Not used	Not used

Location Significance	Groove							Scarf for Brazed Joint
	Square	V	Bevel	U	J	Flare-V	Flare-Bevel	
Arrow Side								
Other Side								
Both Sides								
No Arrow Side or Other Side Significance		Not used	Not used	Not used	Not used	Not used	Not used	Not used

Supplementary Symbols						
Weld-All Around	Field Weld	Melt-Thru	Consumable Insert	Backing Spacer	Contour	
					Flush	Convex

Location of Elements of a Welding Symbol

Basic Joints	
Identification of Arrow Side and Other Side of Joint	
Butt Joint	Corner Joint
T-Joint	Lap Joint

Edge Joint	Process Abbreviations
	<p>Where process abbreviations are to be included in the tail of the welding symbol, reference is made to Table 1, Designation of Welding and Allied Processes by Letters, of AWS A2.4-86.</p>

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SRT – 5HRS