

Felling FT 7-2/Avtron D40548 Axle Inspection & Repair Procedure

Felling Trailers Model FT-7-2 Deck Over Trailers manufactured for Avtron Power Solutions with Part Number designation D40548 may have been produced with Off-set axle brackets, which may increase stress to the bracket.

Visually inspect the Axle to Frame connection to ensure alignment of the Axle bracket to tube frame. Please document via picture the alignment of frame to axle connection and send images to Felling POC listed below before beginning any work on the trailer. Identify each unit with a picture of its respective VIN tag. Based on axle offset on the affected unit please follow one the procedures listed below.

Any shop performing repairs will be sent a repair kit consisting of 8 gussets. If Outer axle brackets are needed 4 Outer axle brackets will be shipped to the repair shop.

1. Axles are in line with tubing as shown in Figure 1 (no repair necessary)
2. Axles are misaligned to frame no cracks in welding of axle bracket present. Figure 2 (Repair procedure 1)
3. Axles are misaligned and cracks in axle bracket or weld are found. Figure 3 (Repair procedure 2)
4. Axles brackets have failed and broken free from frame. Figure 4 (Repair procedure 2)

Felling POC for Repairs: Scott Brown P: 320-351-1299 E: Scott.Brown@felling.com

Figure 1 (Proper bracket alignment)

The vertical face of the outer axle bracket is aligned with vertical face of main frame tube. Highlighted in yellow.

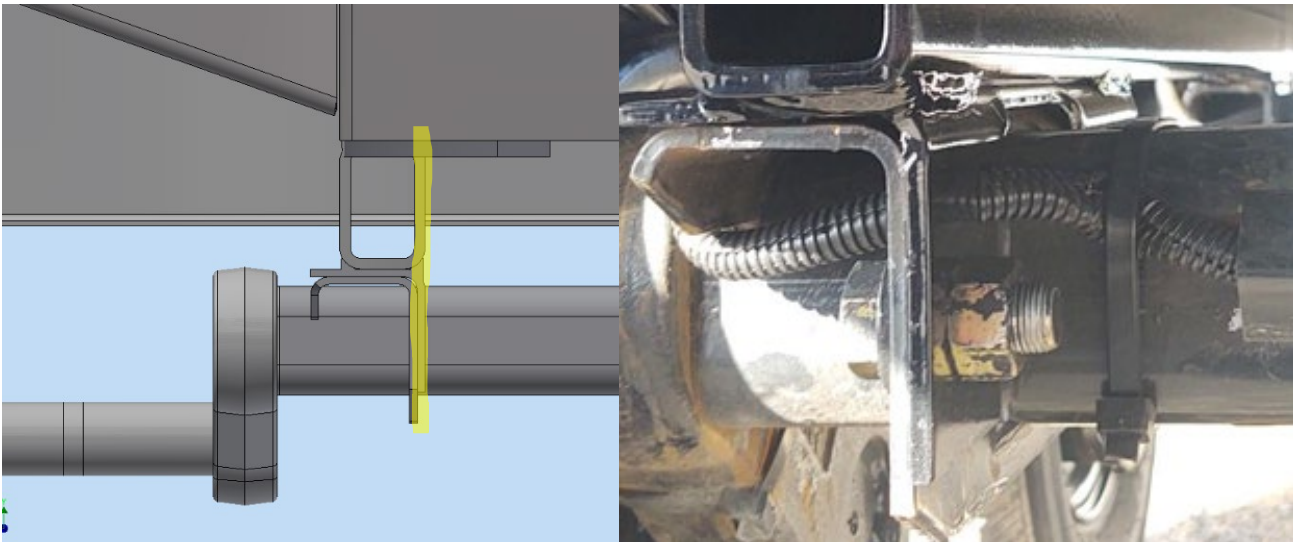


Figure 2 Bracket misaligned and in need of gusset repair- Follow Repair procedure 1

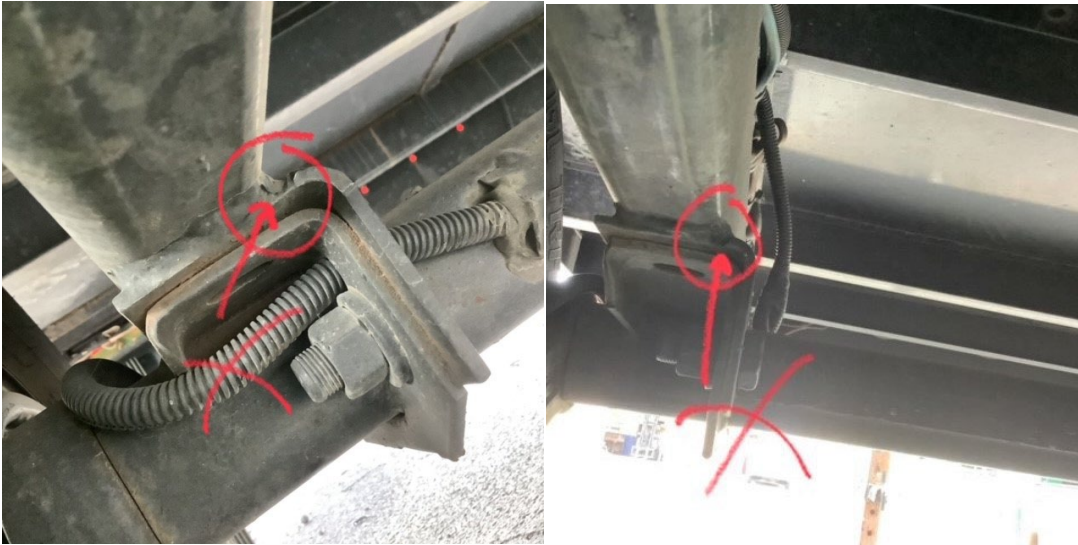


Figure 3 Crack in axle bracket -Follow Repair procedure 2



Figure 4 (Axle bracket failure) Follow Repair procedure 2



Repair Procedure 1

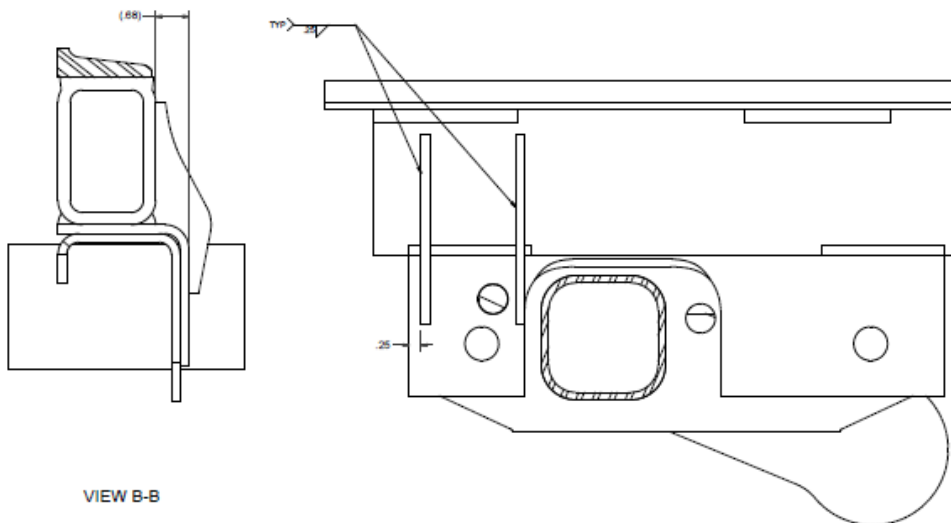
Place trailer on safety stands and block tires.

Relocate wiring and any other obstructions around axle brackets.

Ground of welder must be connected to tube frame closest to the axle being repaired to eliminate any current from going thru load bank

Clean and prep area to be welded for Field installed gussets 2 per side on each axle bracket (P/N)1100128

Weld size is to be ¼" fillet



After repair is completed repaint welded surfaces and relocate and connect any wiring

Repair Procedure 2

Place trailer on safety stands and block tires.

Remove/Cut wires for electric brakes on affected trailer axle. Leaving enough wire to Butt Connect the wires after completing repair.

Remove affected outer axle brackets from frame

Clean and prep area to be welded for installation of outer axle brackets and field installed gussets(P/N)1100128

Ground of welder must be connected to tube frame closest to the axle being repaired to eliminate any current from going thru load bank

Outer frame bracket should welded to the tubular frame with 3-¼" long fillet welds as follows

2 ½" long fillet welds on each side of the hanger and a fillet weld on each end

Install gussets as showing Repair procedure 1

Reinstall axle torquing axle fasteners to 120-135 ft lbs

After repair is completed repaint welded surfaces, relocate and connect any wiring

Part identification



Axle Brackets

- Tube Frame
- Outer Axle Bracket
- Inner Axle Bracket
- Axle Bolts

