Great Dane K-Brace Weld Inspection Criteria

External Visual Inspection of K-Brace Assemblies – Rev. 03 – October 27, 2026

1 Purpose

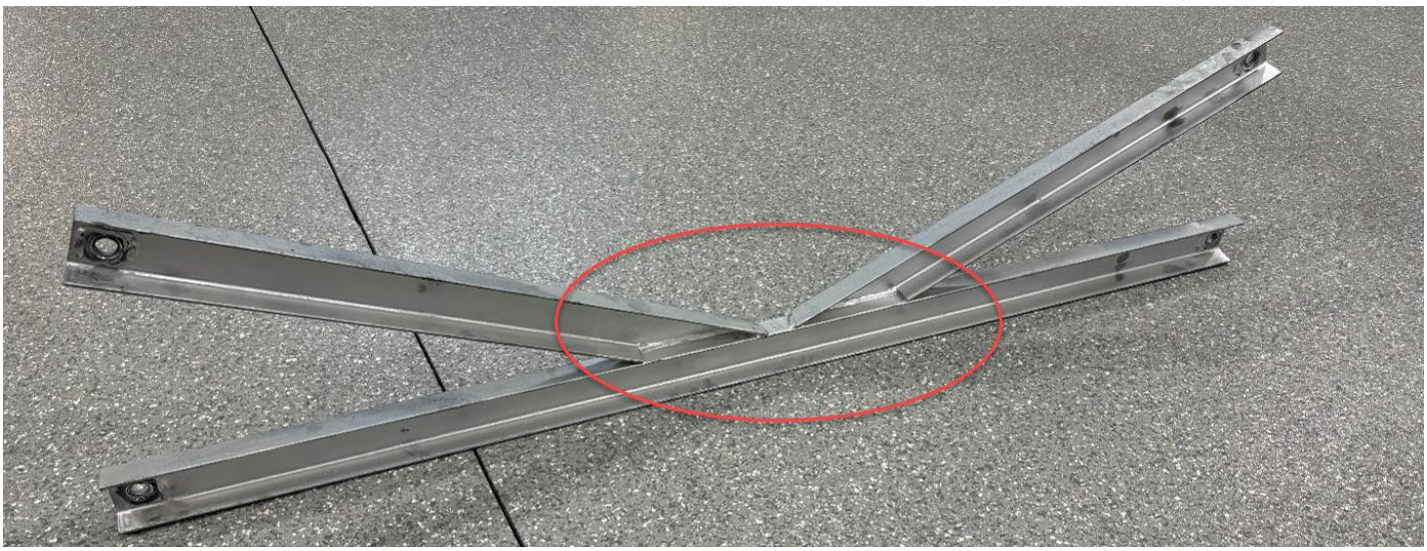
To define the inspection locations and acceptance criteria used to determine whether welds on K-Brace assemblies meet Great Dane engineering requirements. This procedure covers visual weld inspection, and applies to production welds joining diagonal and horizontal C-Channel crossmembers that comprise the K-Brace assembly of the landing gear.

2 Scope

- This inspection procedure shall be performed on trailers manufactured between October 2025 and October 2026 at Brazil, Terre Haute, Jonesboro, Kewanee, Danville, Elysburg, and Statesboro Great Dane manufacturing plants.

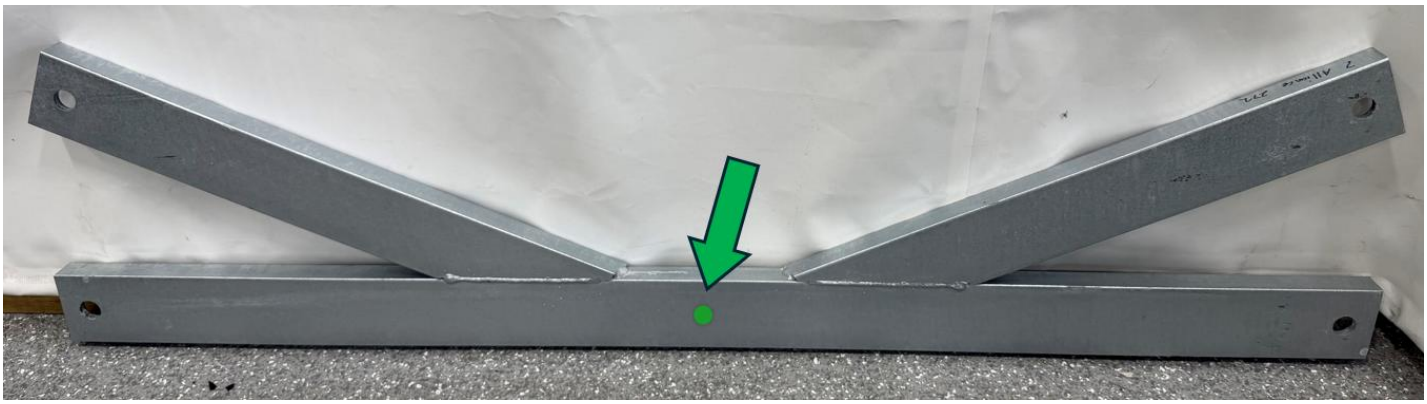
3 Field Inspection Instructions

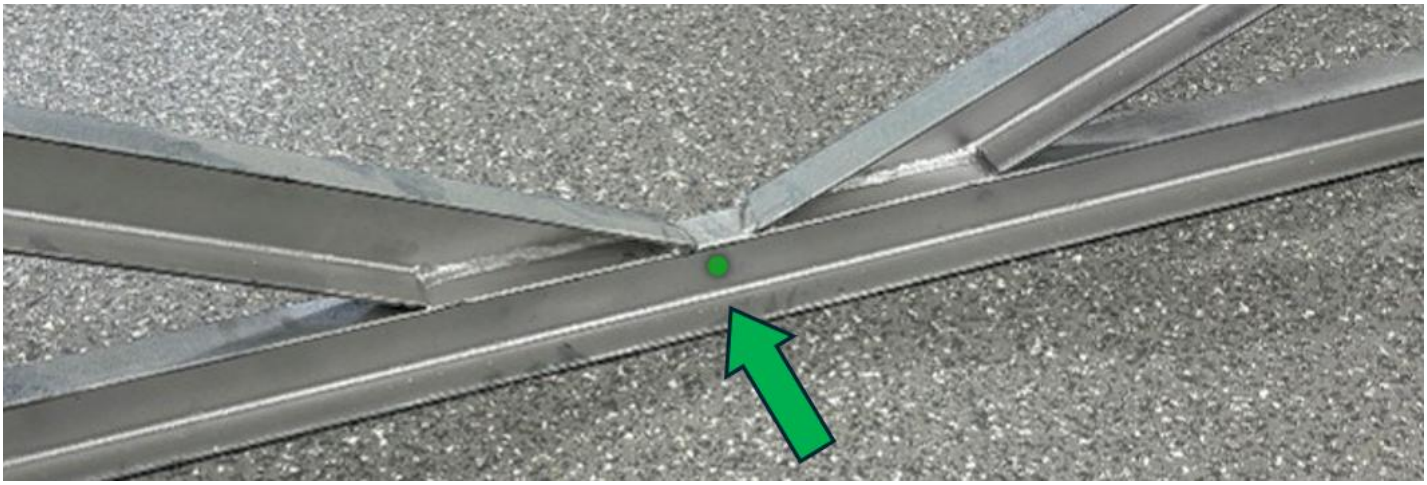
- All requirements in Sections 6 through 9 must be met for all welds on the K-Brace assembly. Any assemblies that do not meet all criteria of this document shall be replaced.
- Visual inspection of welds shall be performed by a trained/qualified welder.
- Before inspecting K-Brace, ensure trailer brakes are set, and support jacks are properly placed.
- All required Great Dane PPE and safety rules shall be adhered to during inspection.
- All inspected trailer VINs should be reported to the **Great Dane Warranty Hotline** at **877-369-3493**, pass or fail.
- If replacement K-Brace is required, contact the **Great Dane Warranty Hotline** at **877-369-3493** for replacement components in accordance with trailer VIN.



4 K-Brace Assembly Paint Marking

- Great Dane Quality will begin adding green paint dots at the center of the horizontal C-Channel, on the front and rear face of new K-Brace assemblies produced after October 2026.
- If green paint dots are present as shown in the images below, then the K-Brace does not require re-inspection.
- For K-Braces that PASS inspection on trailers manufactured between October 2025 and October 2026, ensure green paint dots are applied to the front and rear of the assembly as shown below, to aid in quick identification that the K-Brace passed inspection.



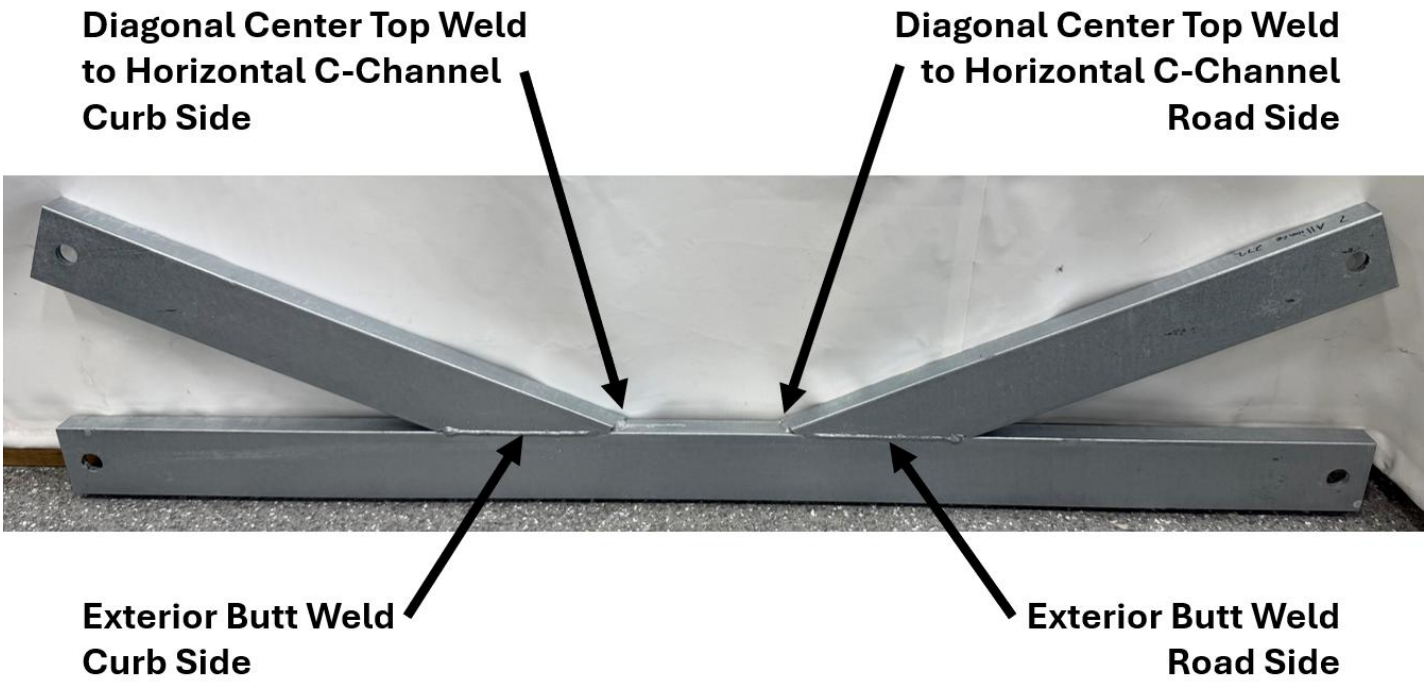


- For K-Braces that FAIL inspection on trailers manufactured between October 2025 and October 2026, a red 'X' should be painted in the location shown below to aid in quick identification that the K-Brace failed inspection.

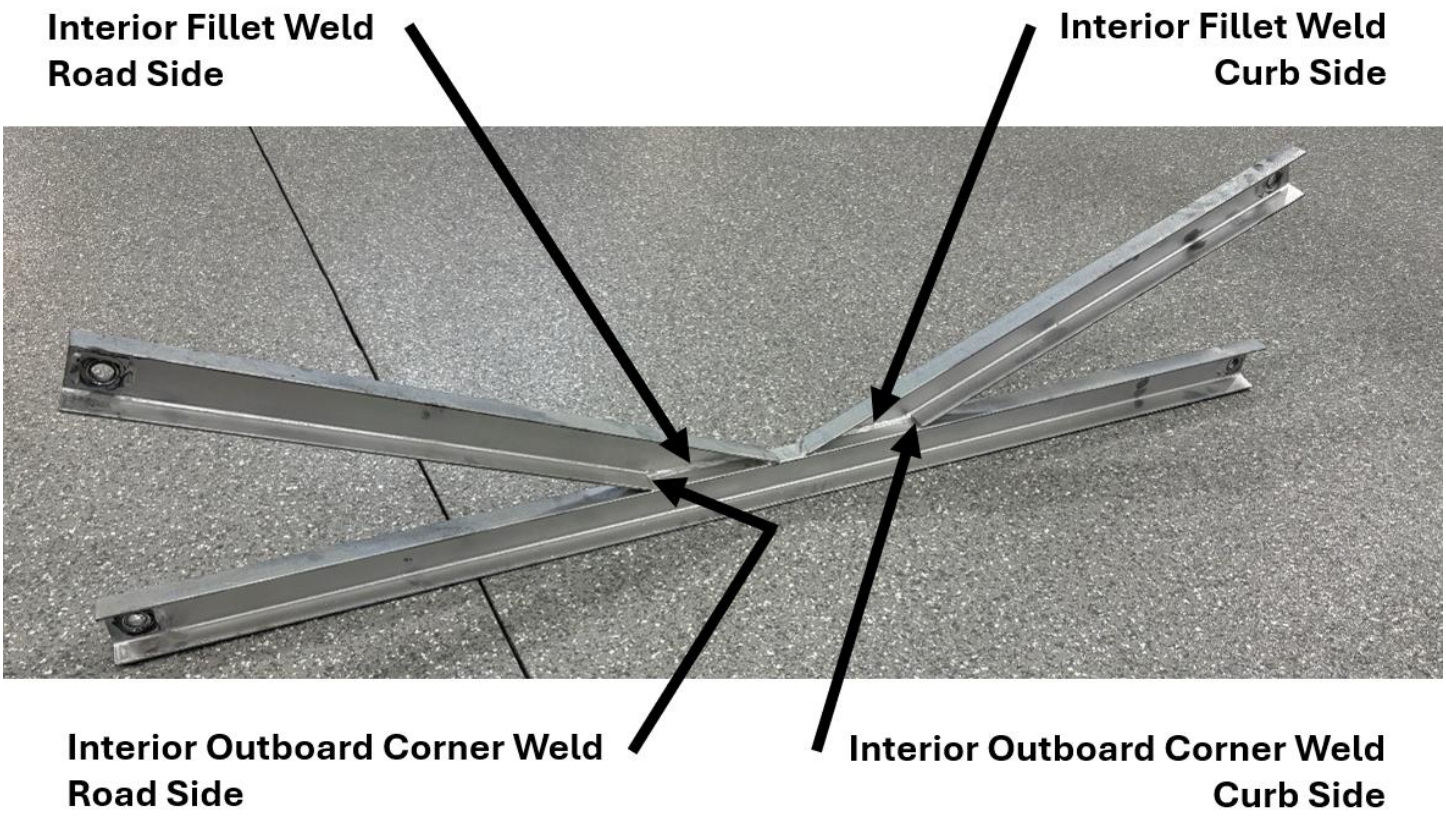


5 Weld Location Overview

- Front view of K-Brace assembly.



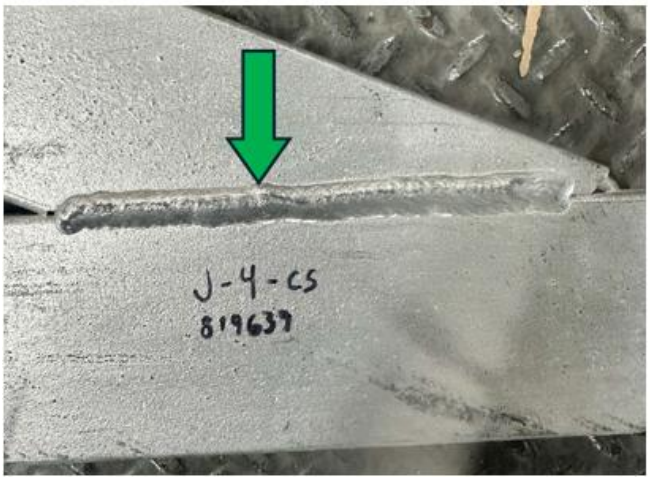
- Rear view of K-Brace assembly.



6 Exterior Butt Weld Inspection

- Inspect that butt welds are centered on seam between diagonal and horizontal C-Channels.
- Inspect for red rust or black lines along the edges of the welds, which would indicate a lack of fusion.
- If any weld is mislocated above or below seam between diagonal and horizontal C-Channels, assembly must be replaced.

Acceptable ✓



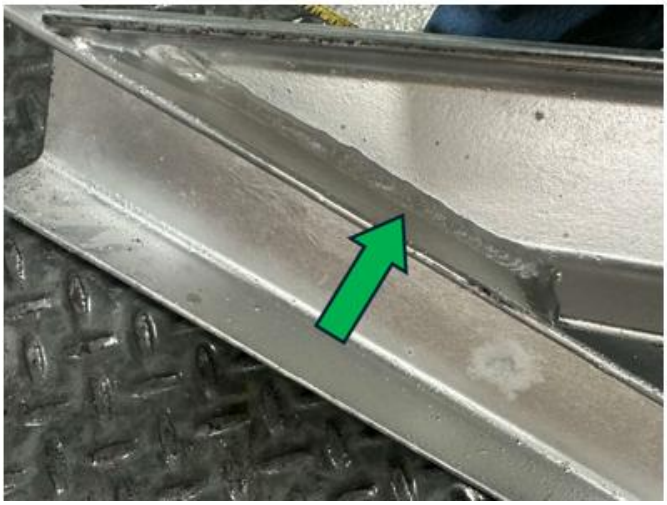
Not Acceptable, Replace Assembly ✗



7 Interior Fillet Weld Inspection

- Inspect that fillet welds are centered on seam between diagonal and horizontal C-Channels.
- Inspect for red rust or black lines along the edges of the welds, which would indicate a lack of fusion.
- If any weld is mislocated above or below seam between diagonal and horizontal C-Channels, or if a lack of fusion is observed, assembly must be replaced.

Acceptable ✓



Not Acceptable, Replace Assembly ✗



8 Interior Outboard Corner Welds

- Inspect for red rust or black lines along the edges of the welds, which would indicate a lack of fusion.
- If a lack of fusion is observed, assembly must be replaced.

Acceptable



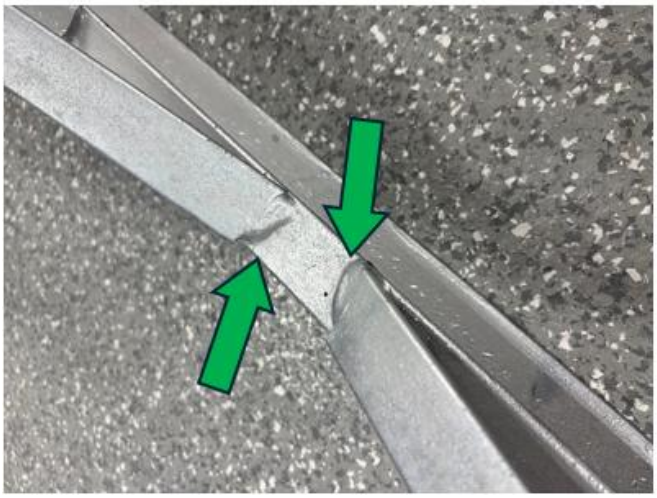
Not Acceptable, Replace Assembly



9 Diagonal Center Top Welds to Horizontal C-Channel

- Inspect for red rust or black lines along the edges of the welds, which would indicate a lack of fusion.
- If a lack of fusion is observed, assembly must be replaced.

Acceptable



Not Acceptable, Replace Assembly



** Note that this specific photo is not of the diagonal center top welds to the Horizontal C-Channel, but is representative of a lack of fusion.*

10 Revision History

Rev.	Date	Chapter	Change
01	10/22/2026	–	Initial release
02	10/22/2026	–	Revised Section 3 title to Field Inspection Instructions. Revised Section 4 to add paint marking for K-Braces that fail field inspection. Added Section 5 Weld Location Overview
03	10/27/2026	–	Revised Section 4 to add additional green paint marking on front face of C-Channel for K-Braces that PASS inspection