



Service Bulletin

101 East Seneca Bancroft, IA 50517	Bulletin #: 100715	Date: 10-07-15
Prepared by: Bob Mortenson	Phone # 515-885-2398	Page: 1

Subject:

Inform Aluma dealers and owners that 5410T tilt trailer may have missing weld that may contribute to a failure of the trailer’s tongue weldment.

Solution: Add welds to rear of tongue retainer and add two gussets for additional support as shown below for trailers that are missing weld. Aluma will allow 1 hours of labor to be submitted for retrofit of trailer.

Models and VIN Numbers (if applicable) Affected:

- 5410T – Retrofit starting with VIN number B076295 – manufactured date January 4, 2011
- 5410 WD – Retrofit starting with VIN number B076293 – manufactured date January 4, 2011

Retrofit kit: To be ordered from Aluma Service Department – at no charge

Quantity	Description
2	Gussets Aluminum - part number 05-0000038

Note: The following parts are required for update and do not substitute any of these parts.

Retrofit Instructions:

Warning: Use appropriate jack and jack stands, ensure weight ratings capacity exceed weight of trailer. Park trailer on hard level surface.

- 1.0 Using the jack raise and place trailer on the four jack stands. **Warning:** Never go under your trailer unless it is on firm level ground and resting on properly located rated secured jack stands.
- 2.0 Inspect all welds and base material on tongue retainer and trailer frame to ensure no signs of damage has occurred. See Figure 1, 2 and 3. Prepare surface areas that are to be welded. Person performing retrofit should be qualified and proficient aluminum welder. **Caution:** Use appropriate PPEs when preparing surface and welding.
- 3.0 Figures 4 and 5 shows different orientation of tongue retainer. If welds are missing, then add .25” fillet welds as shown See Figure 4 and 5. **Note:** Ensure that wiring harness is not damaged during welding.
- 4.0 Add 2 gussets and .25” fillet weld as shown in Figure 6 and 7.
- 5.0 Verify work has been completed and all tools and hardware is secured. Raise trailer and remove jack stands.
- 6.0 Lower trailer and perform driving functional test to verify trailer is traveling correctly.
- 7.0 For more detailed information, always refer to Aluma Owner’s Manual.



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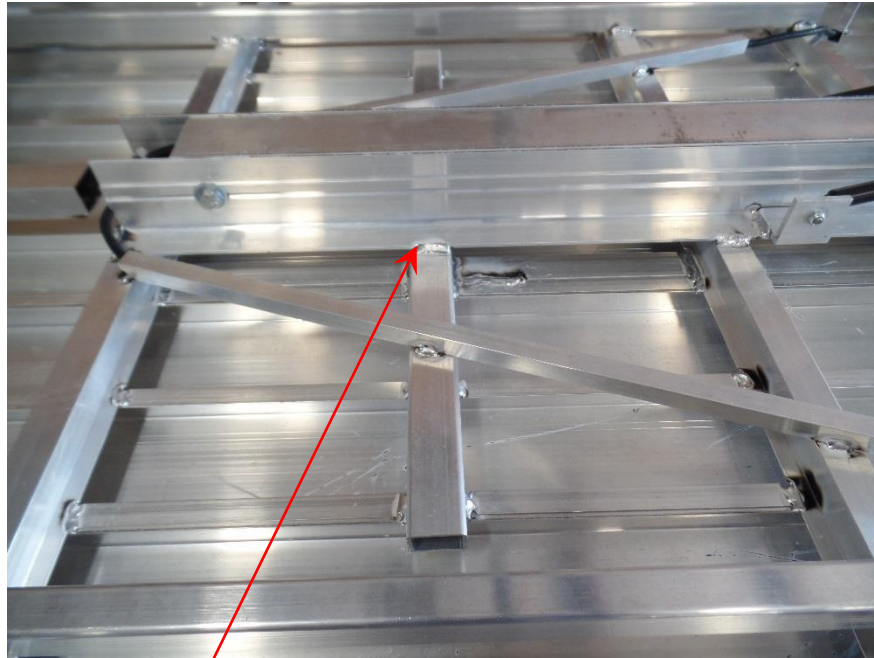


Figure 1

Inspect weld and base material

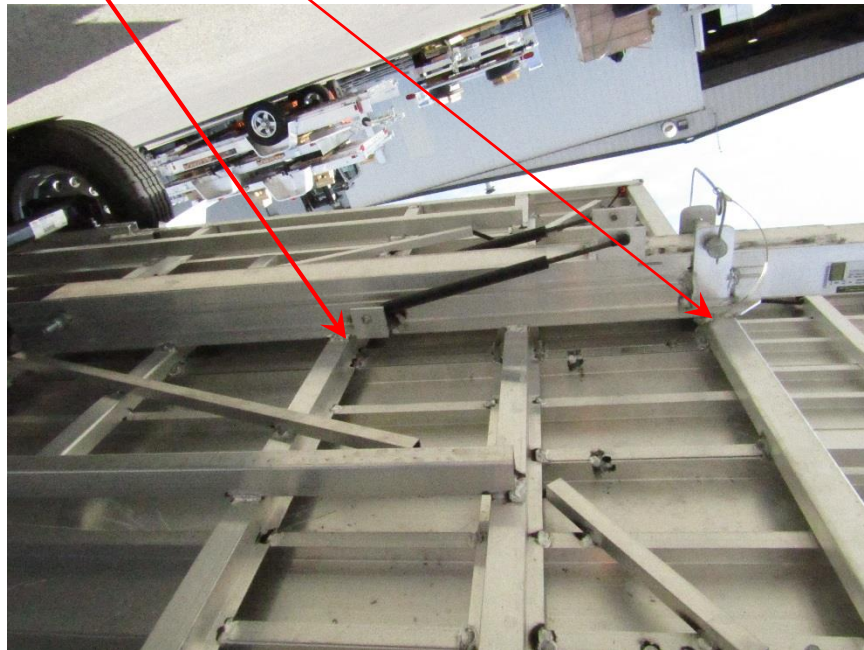


Figure 2



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Figure 3

Inspect weld and base material

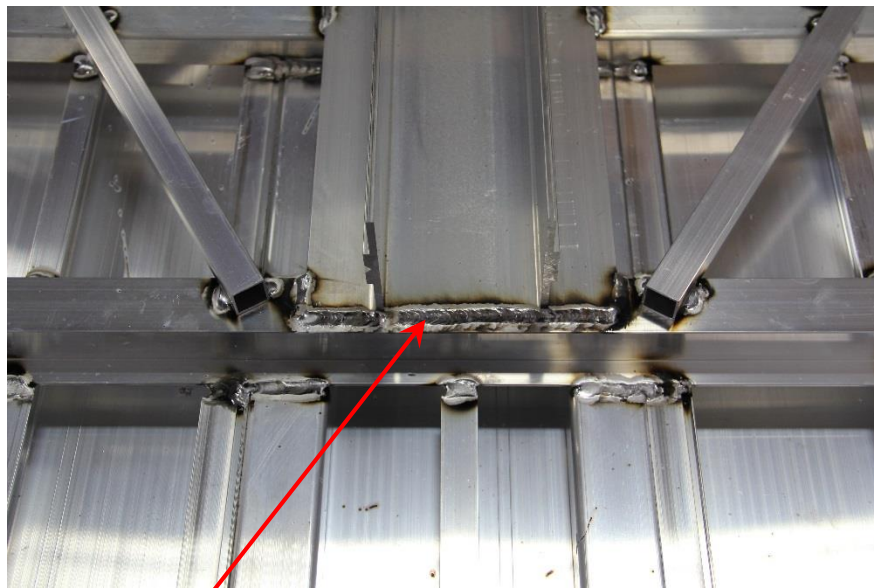


Figure 4

If weld is missing add .25" fillet welds as shown



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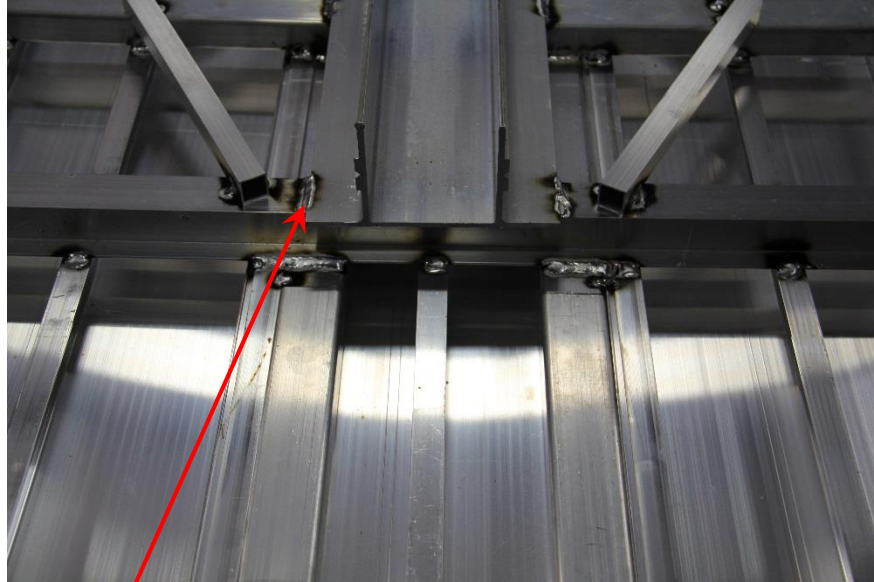


Figure 5

If weld is missing add .25" fillet welds as shown

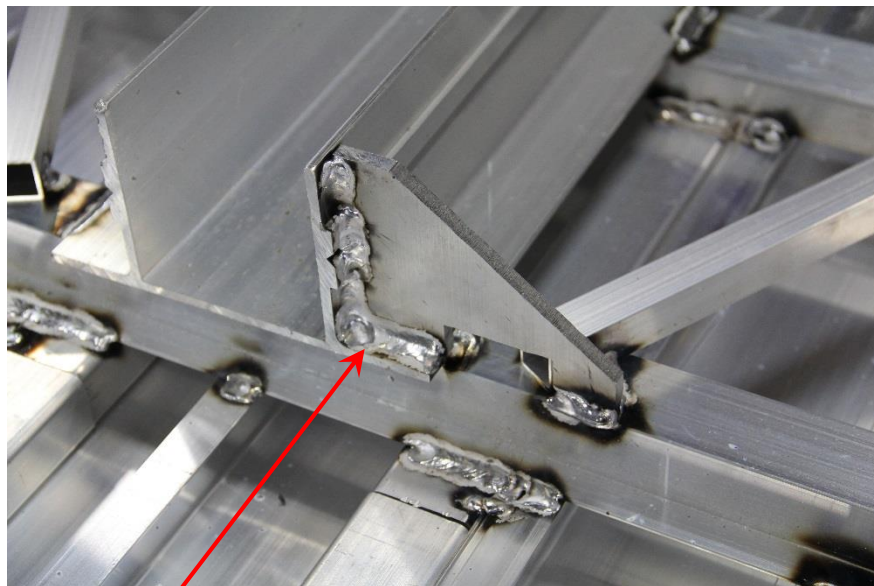


Figure 6

Add 2 gussets and .25" fillet welds as shown.
One gusset on each side of tongue retainer.



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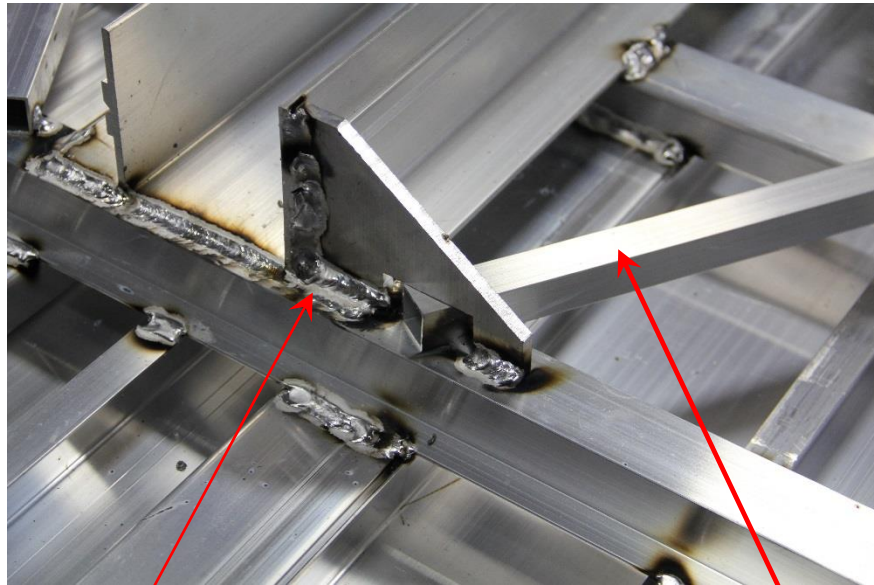


Figure 7

Add 2 gussets and .25" fillet welds as shown. One gusset on each side of tongue retainer.

Adjustment of wire tubes maybe necessary for proper gusset orientation.