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TECHNICAL SERVICE BULLETIN

DATE: 4/16/18

TSB # TSB201801

RE: Side Dump Center Ribs

Model Years: 2015 - 2018

Production Build Dates: October 2014 – August 2017

We have identified on some units cracking has occurred in the center rib to top rail connection on the tub of our Side Dump models. This area will require a reinforcement installed to remedy the cracking. This repair will be made to your customer at no charge.

The repair will take 4 hours. Please inspect trailers in your respective territory and contact Trail King Material Hauling Customer Service for authorization for repair. Material Hauling Customer Service can be reached at 1-800-762-5557

Please see the Technical Service Bulletin attached for the instructions for the repair.

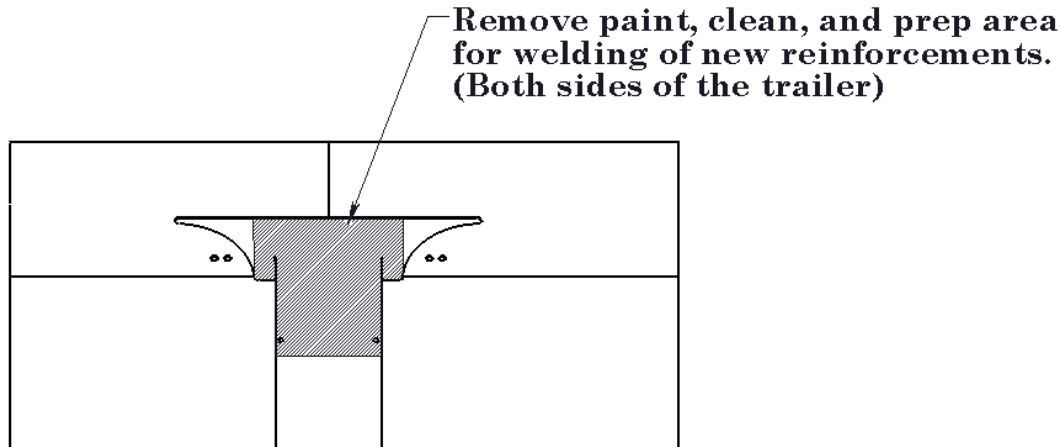
Ty Hanten

**Director of Quality
Trail King Industries Inc.
Mitchell, SD 57301**

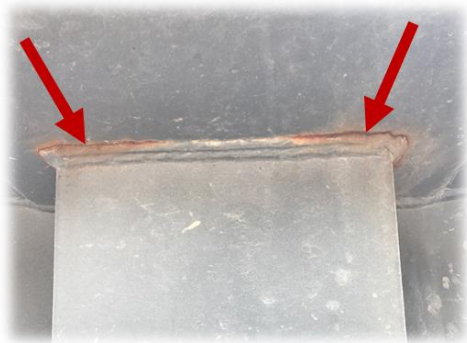


The purpose of this document is to provide instructions to repair cracks and add a new reinforcements.

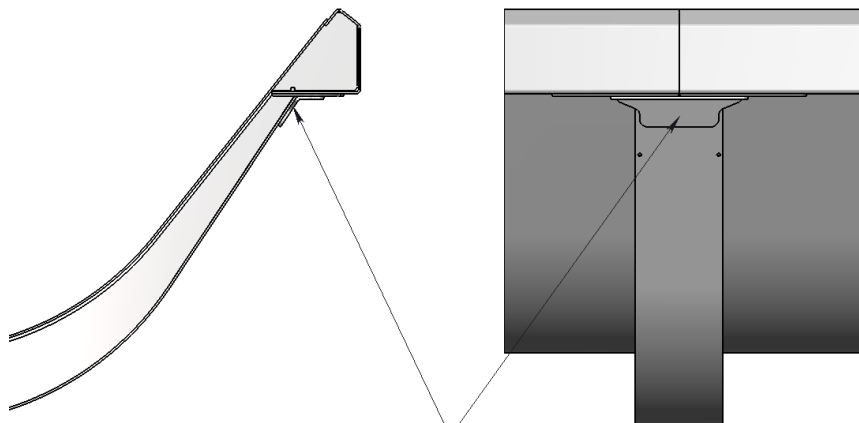
- Remove paint and prep area needed for new reinforcements. (As shown below)



- Clean and repair any cracks in welds. (See example below)



- “V” out existing weld/ cracks and re-weld to achieve 100% weld through the thickness of the material.
- Locate new reinforcement strap on outside of existing flange. Ensure tight fit to both surfaces. (Both sides of trailer)



Locate new reinforcements centered on the rib, on the outside of existing flange.

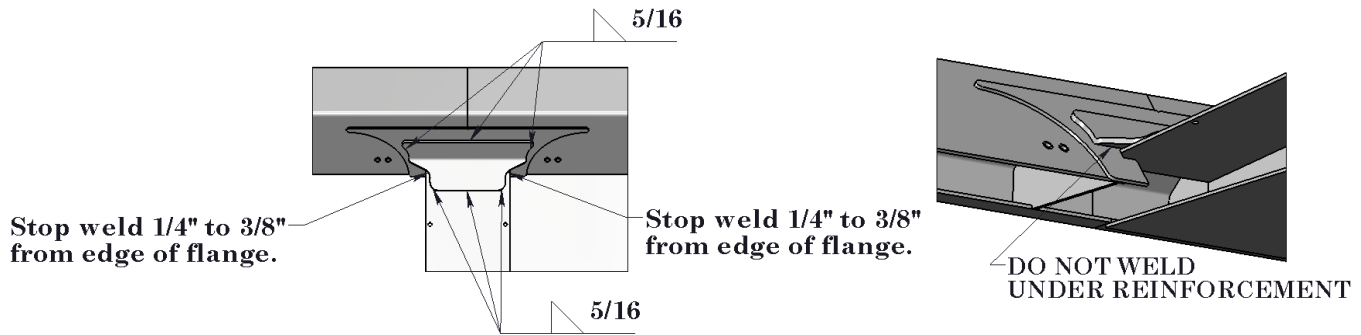


Process to Add Reinforcements - SSD

(Ref. Part numbers 100238370)

TRAIL KING Industries, Inc.

- Weld new reinforcements, always make sure to stop weld a minimum of 1/4" before edges of existing flanges. (Repeat for both sides of the trailer)



- Trail King Industries recommended weld settings:

WELDING:

AMPERAGE: 270-330

VOLTS: 25-32

WIRE SPEED: 320-370

WIRE TYPE: ER-70S-6(L-56)

OPTION: ER-70S-3(L-50)

WIRE DIA: .045-.052

SHIELD GAS: 95% ARGON, 5% O₂

OPTION: 90% ARGON, 10% CO₂

* The number and sequence of weld passes shall be dictated by material thickness. All welds shall be minimum 1/4" fillet weld. When the thinnest material being joined is equal to or greater than 3/8", triple pass welding shall be required, except in dual wire sub-arc welding process. Unless otherwise specified.

- Prime and paint repaired areas to protect from oxidation.