



# TRAIL KING Industries, Inc.

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## TECHNICAL SERVICE BULLETIN

**DATE: 11/21/2018**

**TSB # TSB201803**

**RE: Slider Mud Flap Mounts**

**Model years: 2015 - 2018**

**This Technical Service Bulletin relates to ACS/AACS models with a sliding axle. Model Numbers TK70/80/85ACS/AACS.**

**Trail King has inspected a sample of the Unit population, and observed in some instances cracking in the slider pan where the mud flaps mount.**

**Where cracking is present, the bracket should be reinforced to remedy the cracking. This repair will be made to your customer at no charge.**

**The repair will take approximately 3 hours. Please inspect trailers in your respective territory and contact Trail King Customer Service for authorization for repair. Trail King Customer Service can be reached at 1-800-762-5557**

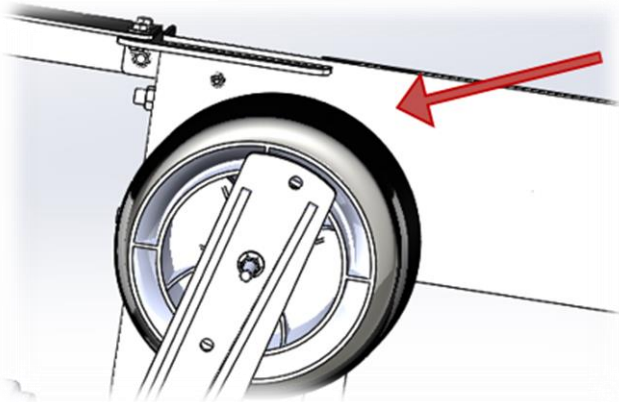
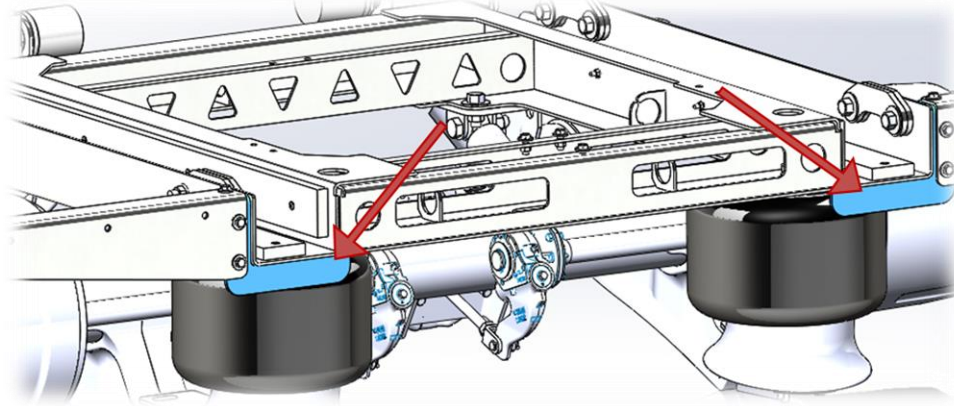
**Please see the Technical Service Bulletin attached for the instructions for the repair.**

**Ty Hanten**

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

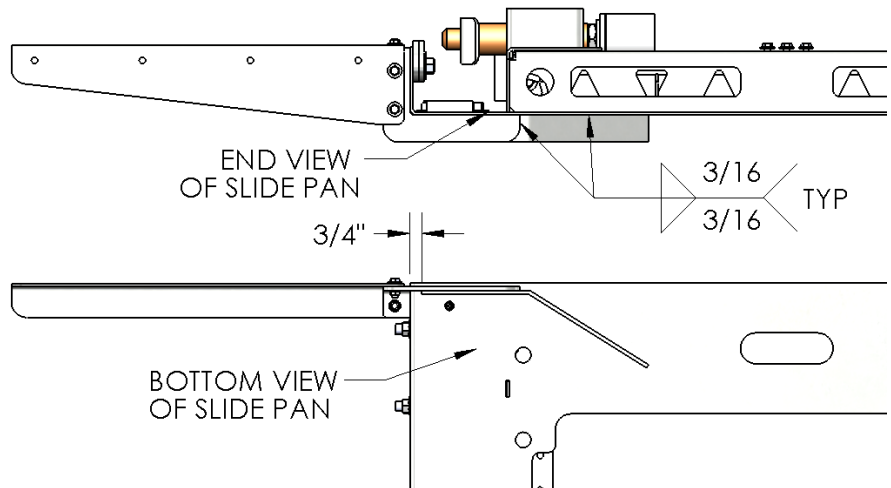
Below are the instructions for adding reinforcement plates to existing mud flap brackets.

- Locate mounting brackets at rear of slide pan.



- Clean and prep area for adding reinforcements. (Repeat for both sides of slide pan assembly.)

- Weld new brackets in place as shown to the right. (Repeat for both sides of slide pan at rear.)





## Process to Change Mud Flap Brackets

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- **Trail King Industries recommended weld settings:**

**WELDING:**

AMPERAGE: 270-330

VOLTS: 25-32

WIRE SPEED: 320-370

pass

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

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

WIRE DIA: .045-.052

SHIELD GAS: 95% ARGON, 5% O<sub>2</sub>

OPTION: 90% ARGON, 10% CO<sub>2</sub>

\* The number and sequence of weld passes shall be dictated by material thickness. All welds shall be minimum ¼" fillet weld. When the thinnest material being joined is equal to or greater than 3/8", triple

welding shall be required, except in dual wire sub-arc welding process. Unless otherwise specified.

- **Prime and top coat repaired areas to protect from oxidation.**