

010-1

NOTE: IF A 20AC-51 HAS A CRACK AT THE I BEAM JOINT, BOTH SCENARIO 1 PROCEDURE AND SCENARIO 2 PROCEDURE NEED TO BE COMPLETED.
IF A 20AC-51 DOESN'T HAVE ANY CRACKS AT THE JOINT LOCATION, THEN THE SCENARIO 2 PROCEDURE MAY BE APPLIED.

SCENARIO 1: CRACK IN I BEAM EXISTS AT AXLE/IBeam JOINT.

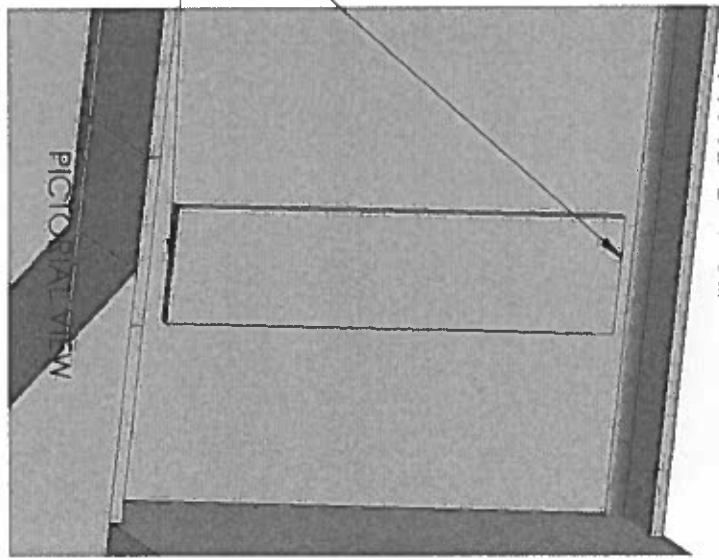
SCENARIO 1 PROCEDURE:

PICTORIAL VIEW LOCATION



- 1: DRILL 3/16" HOLE AT THE END OF THE CRACK.
- 2: WELD A 1/4" BEAD ACROSS EXISTING CRACKS. IF THERE ARE WEB CRACKS, PLACE THESE WELDS ON THE OUTSIDE OF THE IBEAM/TRAILER.
- 3: GRIND FLUSH ANY RAISED WELDS SO THAT NEW PARTS CAN LAY FLAT.
- 4: LEAVE A 1/2" GAP BETWEEN THE BOTTOM 12" IBEAM FLANGE AND PART 3040002. PLACE PART 3040002 OVER WEB CRACK LOCATION, ON THE WEB OF INNER I BEAM SIDE OF TRAILER, AND RUN A 3/16" X 2"-4" WELD AROUND PERIMETER.
- 5: CONTINUE TO SCENARIO 2:

1/4" / 2"-4"



BILL OF MATERIALS

PN	DESC	QTY
3040002	FB 3 X 1/4" X 10L	2

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UNLESS OTHERWISE SPECIFIED:	DRAWN	DATE	NAME	DATE	NAME
TOLERANCES ARE IN INCHES:	JD	2/23/16	JD	2/23/16	JD
FRACTIONS: 1/16"	CHICK				
ANGULAR TOLERANCE: 90° ± .5°	ENG APPR				
TWO PLACE DECIMAL: .01	INFO APPR				
THREE PLACE DECIMAL: .001					
INTERPRET GEOMETRIC TOLERANCES PER:	COMMENTS				
AS MEASURED					
VARIABLE					
VARIES					
PER ASH					
APPLICATION	USED ON	DO NOT SCALE DRAWING			
NEEDED					

TITLE: BIG TEX TRAILERS
20AC-51 JOINT REINFORCEMENT

SIZE DWG. NO. 20AC-51 JOINT REINFORCEMENT
1:80
REV A
SHEET 1 OF 3

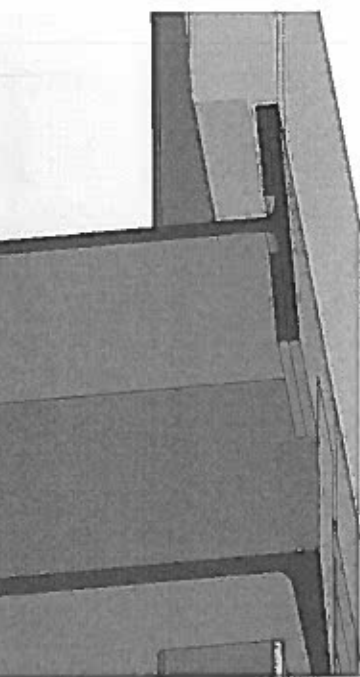
010-2

SCENARIO 2: SCENARIO 1 FIX IS COMPLETED OR TRAILER DOES NOT HAVE EXISTING CRACK. THIS FIX CAN BE APPLIED TO REINFORCE A TRAILER WITHOUT A JOINT CRACK.



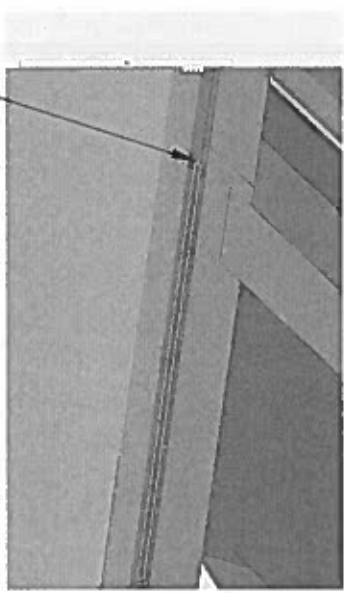
SCENARIO 2 PROCEDURE:

PICTORIAL VIEW LOCATION



CUT PICTORIAL VIEW

2970005 IS FLUSH WITH 12" CHANNEL ON INSIDE 2970005 IS ON THE TOP OF THE BOTTOM IBEAM FLANGE, AND ON THE BOTTOM OF THE TOP I BEAM FLANGE.



2970005 IS FLUSH WITH BACK OF 12" IBEAM ON OUTSIDE OF TRAILER

1. VERIFY THAT THERE IS A FULL 1/4" WELD ACROSS AT LOCATION A (JOINT) ON NEXT PAGE BEFORE ANY PARTS ARE INSTALLED AND WELDED.
2. PLACE PARTS AT THE GIVEN LOCATIONS.
3. FOLLOW WELD CALLOUTS.
4. VERIFY THAT THERE IS A 2" WELD ON ALL SIDES AT LOCATION A AND THE GAP IS FILLED AT LOCATION A.

BILL OF MATERIALS

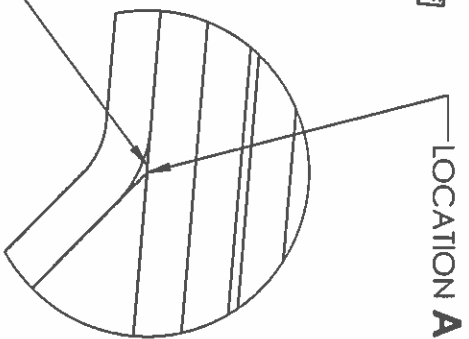
PN	DESC	QTY
2970005	FB 1-1/2" X 3/16" X 16	8
3060006(20AC-51)	FB 4 X .25 X 16	2

NOTE: PART 3060006(20AC-51) MUST BE FORMED (BENT) WITH A 3/8" RADIUS BEND.

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UNLESS OTHERWISE SPECIFIED:		DRAWN		NAME	DATE	TITLE:
DIMENSIONS ARE IN INCHES		CHECKED		JD	2/23/16	
TOLERANCES:		ENG APPR				BIG TEX TRAILERS 20AC-51 JOINT REINFORCEMENT
ANGULAR MATCHES: BEND ±2°		MFG APPR				
TWO PLACE DECIMAL ±		G.A.				SIZE DWG. NO. A 20AC-51 JOINT REINFORCEMENT REV A
THREE PLACE DECIMAL ±		COMMENTS				
PROJECT GEOMETRIC	MATERIAL					1:80
VARIES	FRS					
NOT LIST	USED ON					SHEET 2 OF 3
APPLICATION	DO NOT SCALE DRAWING					

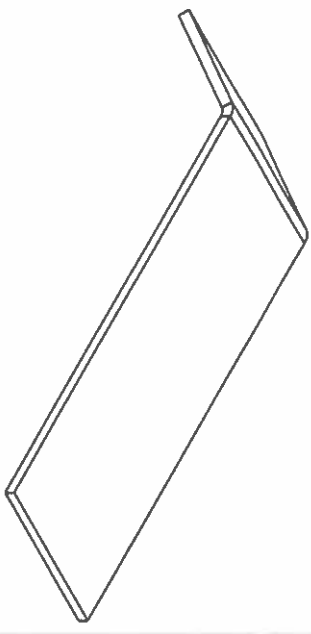
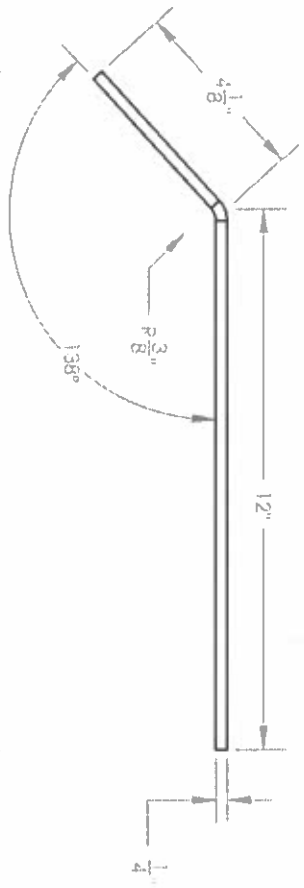
010-3



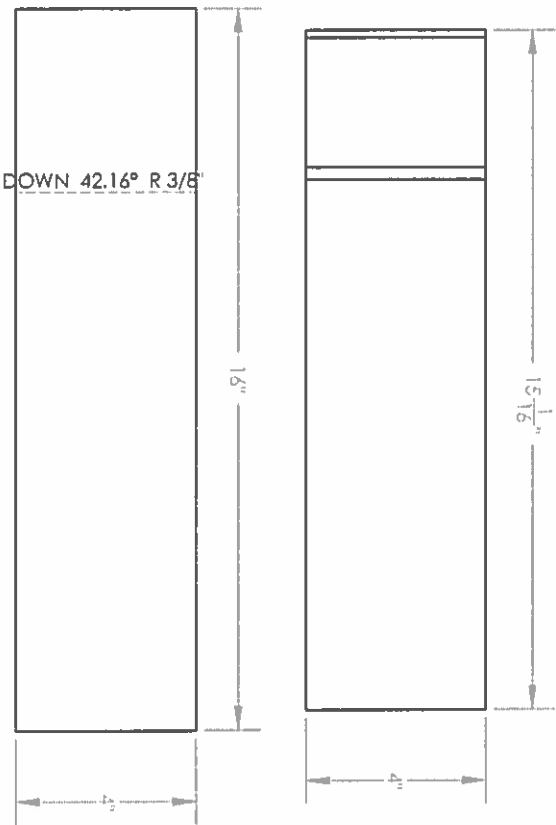
SIZE	DWG. NO.	REV
A	20AC-51 JOINT REINFORCEMENT	A
1:80		

SHEET 3 OF 3

010-4



PICTORIAL VIEW



FLAT PATTERN

NOTE: ALL FINISHED PARTS MUST MEET FORMED DIMENSIONS.
FLAT PATTERN WILL YIELD DIFFERENT RESULTS BASED ON
BEND PARAMETERS.
DECIMAL VALUES MAY BE PROVIDED FOR GREATER THAN 1/16"
PRECISION FOR BENDING.

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UNLESS OTHERWISE SPECIFIED:		DIMENSIONS ARE IN INCHES		TOLERANCES		DRAWN		NAME		DATE		BIG TEX TRAILERS	
BEND ANGLES: 1/16"		TOLERANCES: 1/16"		CHECKED		JD		02/24/2016					
ANGULAR MATCH: BEND ±2		TOLERANCES: 1/16"		ENG APPR									
THREE PLACE DECIMAL ±		TOLERANCES: 1/16"		MFG APPR									
BRIEF GEOMETRIC		TOLERANCES: 1/16"		COMMENTS									
TOLERANCES: 1/16"		TOLERANCES: 1/16"											
MATERIAL		TOLERANCES: 1/16"											
ASTM A36 Steel		TOLERANCES: 1/16"											
FMSH		TOLERANCES: 1/16"											
APPLICATION		TOLERANCES: 1/16"											
METAL		TOLERANCES: 1/16"											
USED ON		TOLERANCES: 1/16"											
DO NOT SCALE DRAWING		TOLERANCES: 1/16"											

FB 4 X .25 X 16

TITLE:

SIZE DWG. NO.

A 3060006(20AC-51)

1/4

WEIGHT: 4.529 SHEET 1 OF 1

REV A