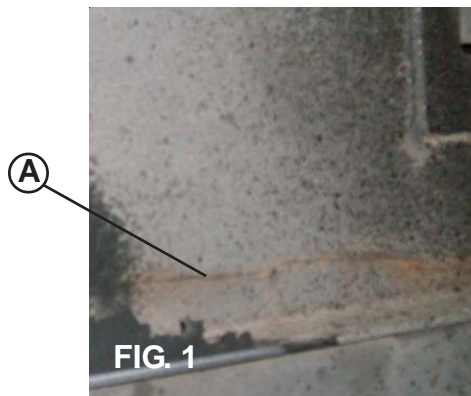




REPAIRING FRAME CRACKS IN AXLE LOCATION



P/N - 106124

1. REMOVE WHEEL IN FRONT OF CRACKED FRAME AREA.
2. PULL UNDER BELLY TO INSPECT BACKSIDE OF FRAME RAIL AND FRAME CRACK AREA. BE SURE AREA IS CLEAR OF INSULATION, OBSTRUCTIONS OR FIRE HAZARDS.
3. INSPECT CRACK, FIG. 1 (A) AND CHECK FOR LENGTH OF CRACK.
4. GRIND CRACK TO CLEAN AREA FOR BETTER WELD PENETRATION.
5. REPAIR CRACK BY ADDING A WELD TO BOTH SIDES OF THE FRAME RAIL.
6. WELD NEW REINFORCEMENT PLATE ON, SEE FIG. 2. WELD COMPLETELY AROUND THE ENTIRE PERIMETER OF THE PLATE.
7. PAINT NEW PLATE AND WELD AREA.
8. RE-INSTALL WHEEL.
9. PERFORM AXLE RETRO (AS NEEDED). SEE PAGE 2.



AXLE RETRO PROCEDURE

AN AXLE RETRO IS PERFORMED TO UNITS THAT HAVE OR COULD HAVE SPRING HANGER ISSUES. IT IS USED TO MINIMIZE OR EVEN PREVENT SWAY IN THE UNIT AND STRENGTHEN THE AXLE AREA.

1. STRAIGHTEN OR REPLACE SPRING HANGERS.
2. RECORD MEASUREMENTS OF THE DISTANCE BETWEEN EACH OF THE SETS OF THE SPRING HANGERS, **FIG. 1A**, ACROSS THE UNIT FROM CURB SIDE TO ROAD SIDE.

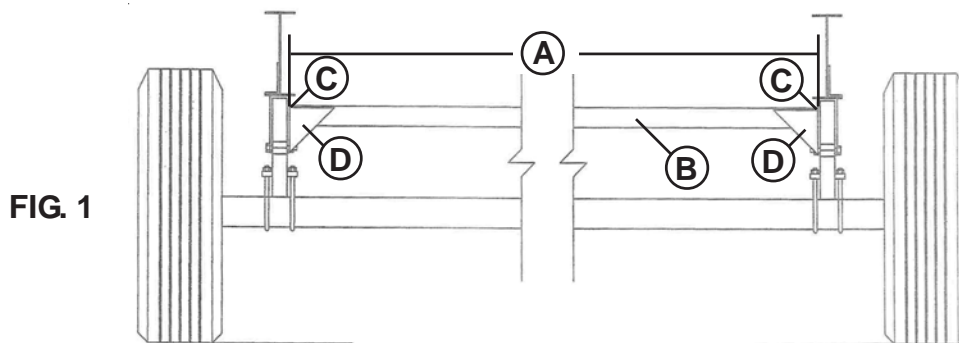


FIG. 1

3. CUT 3 PIECES OF 2 X 2 - 11GA. TUBE STEEL, SEE **FIG. 1B**, AT THE 3 RECORDED MEASUREMENTS.
4. PLACE AND WELD THE 3 TUBES BETWEEN EACH OF THE 3 SETS OF SPRING HANGERS AS SEEN IN **FIG. 1C**.
5. USING 3 X 5 TRIANGULAR GUSSETS, REINFORCE THE TUBES BY WELDING 2-4 GUSSETS ONTO TUBE, I-BEAM AND SPRING HANGER, SEE **FIG. 1D**.