



Repair Standards

01-013 – Crossmember Sections – Over Tandem

Disclaimer:

Only a certified and experienced person using suitable tools should complete the repairs described below. Repairs should meet or exceed manufacturer's minimum specifications and should be in agreement with all safety and ecological regulations.

Permissible upon return and does not require repair:

- Acceptable repairs.
- Crossmembers that are bent or bowed less than 3/8".

Requires repair upon return:

- Unacceptable repairs.
- Crossmembers with cuts or tears in them.
- Crossmembers that are bent or bowed more than 3/8".

Restrictions:

- There must never be more than six sectioned crossmembers on a single trailer.
- There must never be more than three sectioned crossmembers, in a row, on one given side of the trailer.
- There must never be a sectioned crossmember within the first two crossmembers at the front of the slider rails.
 - If there is damage to the front two crossmembers at the front of the slider rails, these crossmembers should be replaced with new ones.
 - These should be replaced through cutting and removed by sliding forward.

Note:

- Sections should be the length of the damaged area to the middle of the closest slider rail.
- A three-splice crossmember is permissible, as long as the sections are on both sides.
 - A three-splice crossmember is a crossmember with two separate sections causing two seams, or three "pieces"

Procedure:

1. Cut out the damaged area, beginning in the middle of the slider rail.
 - a. For best results, cut the damaged crossmember in a vertical direction.
2. Cut out the replacement crossmember and size it up to the original.
3. When the replacement and original are properly aligned, weld into place.



4. Cut out multiple braces to strengthen the section.
 - a. Braces should be: (1) 10" x 3 ½" x 1/8" and (1) 12" x 3 ½" x 1/8"
5. The braces should have six holes drilled in them, down the centerline and 3/8" in diameter.
6. Place the braces over the joint and center them before welding them vertically on each end to the crossmember web. Be sure to end the weld ½" from the edges of the brace.
7. Plug weld the braces (through the 3/8" holes drilled in step 5) to the crossmember web.
 - a. Welding the tops of the braces would create a solid weld, be sure NOT to do so.