

AXLE TUBE OR HITCH WELD BREAKAGE REPAIR

YOU MAY HAVE EXPERIENCED AXLE TUBE OR HITCH TUBE BREAKAGE:



REPAIR INSTRUCTIONS FOR AXLE WELD SEPARATION:

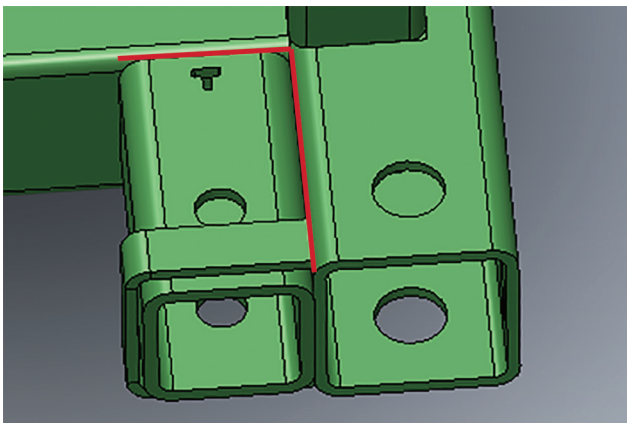


CRUSHING HAZARD

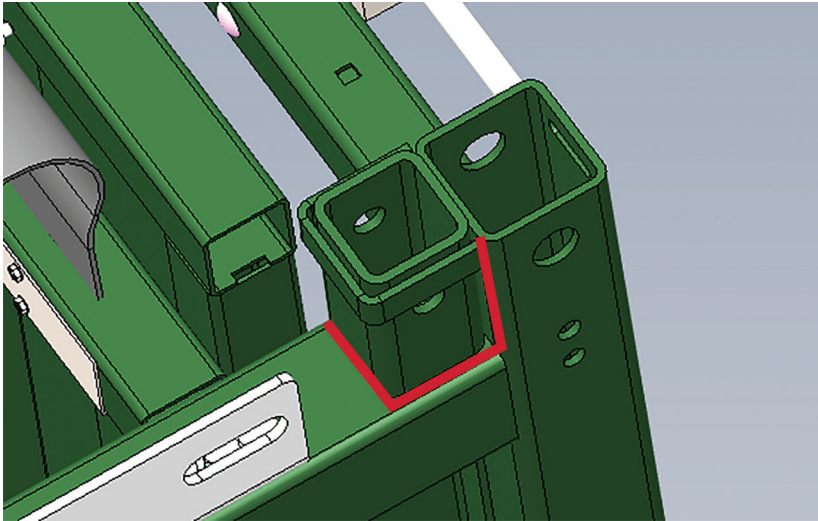
USE CAUTION WHEN WORKING UNDER A RAISED CHUTE – PROPERLY BLOCK THE CHUTE UP SO THAT IT WILL NOT FALL.

1. Straighten and realign the tubes.
2. Remove powder coat in the areas marked in RED in pictures below and prepare for welding (remove existing welds and grind to parent material).
3. This fix should be done to both sides even if only 1 side is broken.

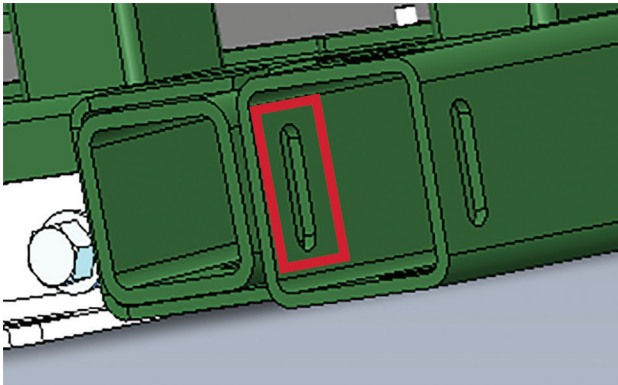
TOP VIEW



UNDERSIDE VIEW



SLOT VIEW



4. If there is no slot on the tube that the axle tube attaches to, cut one similar to the one in the above pictures (actual size is 3/8" wide by 1 1/4" long).
5. NOTE: The axle tube must have a 2° downward slope/kick when welded in place.
6. Weld the areas where the red marks are in the above pictures including a plug weld in the slot so that the axle tube and the outer tube are welded.
7. Ensure that the face weld does not interfere with the axle install.
8. Let cool and paint.
9. Make sure the axle fits.

REPAIR INSTRUCTIONS FOR HITCH WELD SEPARATION:

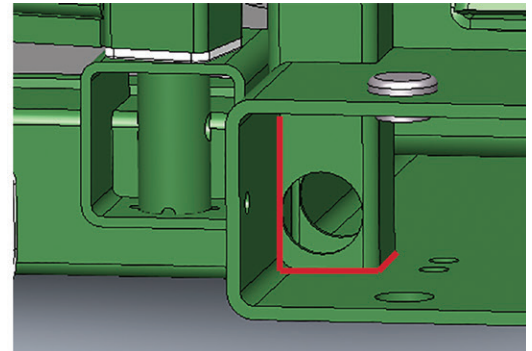
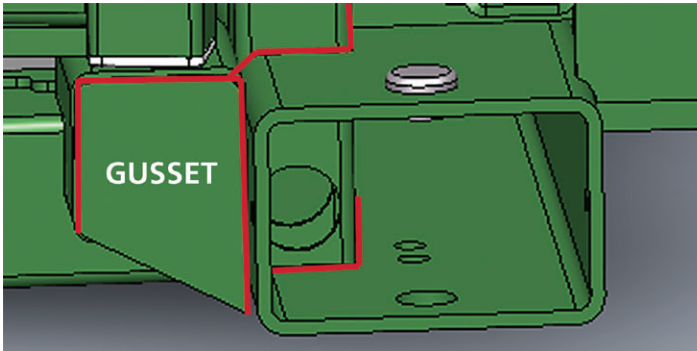


CRUSHING HAZARD

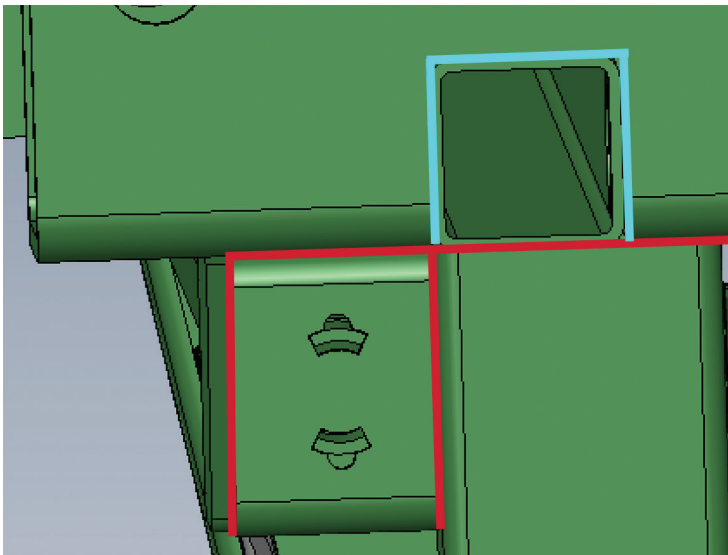
USE CAUTION WHEN WORKING UNDER A RAISED CHUTE – PROPERLY BLOCK THE CHUTE UP SO THAT IT WILL NOT FALL.



1. Straighten and realign the tubes.
2. Remove powder coat in the areas marked in RED in pictures below and prepare for welding (remove existing welds and grind to parent material).
3. This fix should be done to both sides even if only 1 side is broken.
4. Manufacture 2 gussets (P/N 2009497) (or we can send them to you) to fit on the end of the tube.



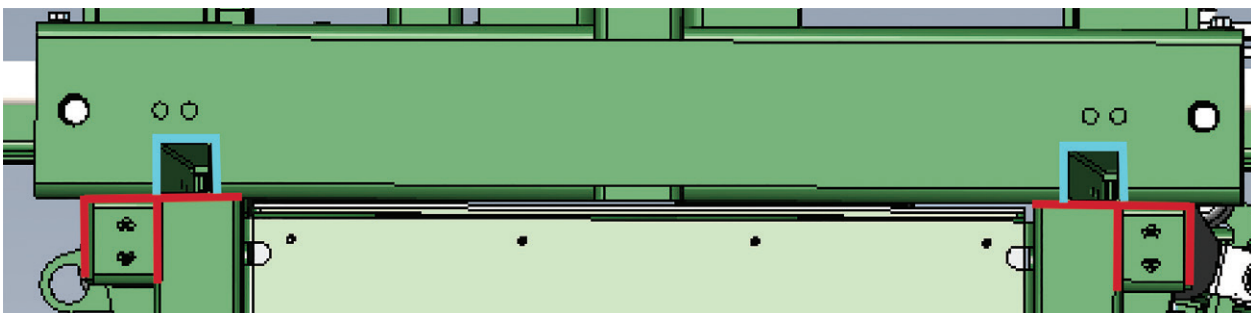
UNDERSIDE VIEW DETAILED



WELDING NOTES:

Blue lines are optional.
Red lines are mandatory.

UNDERSIDE VIEW



5. Weld the areas where the red marks are in the above pictures, when welding the top side of the gussets, be sure to keep the plastic bushing above the tube cool.
6. Repeat welding for both sides.
7. Let cool and paint.

FURTHER ASSISTANCE

For further information or technical help call Arrowquip client care at 1-877-275-6075 or email cs@arrowquip.com.

1-866-383-7827 | CS@ARROWQUIP.COM



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