



Service Bulletin

TRLR45H/TRLR70USH Gusset Installation

Product Group: Trailers	Date Issued: 03/23/18	Expiration Date: 03/23/19	Service Bulletin No. TL20180306
Bulletin Type <input checked="" type="checkbox"/> Mandatory <input type="checkbox"/> Information Only <input type="checkbox"/> Recommended Change		Models/Series Affected: TRLR45H VIN L021853, L021854, L021855, L021856, L021857, L021858, and L021873 TRLR70USH VIN L021931, L021932, L021933, L021934, L021936, and L021937	

Details Problem: Improve existing trailer design. Solution: Install trailer reinforcement gussets.

Parts Information <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th colspan="5">Table 1. Gusset Installation Kit</th> </tr> <tr> <th>Item No.</th> <th>Part No.</th> <th>Description</th> <th>Qty.</th> <th>Remarks</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>49941-02</td> <td>Gusset, Jack Crossmember, TRLR45</td> <td>2</td> <td>TRLR45 only</td> </tr> <tr> <td>1</td> <td>49927-02</td> <td>Gusset, Jack Crossmember, TRLR70</td> <td>2</td> <td>TRLR70 only</td> </tr> </tbody> </table> <div style="text-align: center; margin-top: 20px;"> <p>Figure 1. Gussets</p> </div>	Table 1. Gusset Installation Kit					Item No.	Part No.	Description	Qty.	Remarks	1	49941-02	Gusset, Jack Crossmember, TRLR45	2	TRLR45 only	1	49927-02	Gusset, Jack Crossmember, TRLR70	2	TRLR70 only
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Item No.	Part No.	Description	Qty.	Remarks																
1	49941-02	Gusset, Jack Crossmember, TRLR45	2	TRLR45 only																
1	49927-02	Gusset, Jack Crossmember, TRLR70	2	TRLR70 only																

WORK SAFELY!

Only a *certified welder* with proper training should perform this installation. Follow all shop safety rules while performing this installation.

NOTICE

If gussets are already installed on the jack crossmember of your trailer frame, please disregard this bulletin.

NOTICE

Failure to repair may compromise structural integrity of the trailer frame when unintentionally overloaded.

SAFETY

- Perform all work in a well-ventilated area to prevent inhalation of dust and toxic fumes.
- **DO NOT** use chlorinated solvents in areas where welding will take place.
- **ALWAYS** properly dispose of paint and solvents.

REQUIRED TOOLS

- Welder
- Locking C-clamp
- Approved respirator
- Welding face shield
- Safety glasses
- Gloves
- Hard hat
- Grinder
- Flat black spray paint

PREPARATION

1. Make sure the gussets are accounted for before beginning this installation procedure. Refer to Table 1 and Figure 1.
2. Place the trailer in an area free of dirt and debris. Make sure it is on secure, level ground with chock blocks underneath each wheel to prevent the trailer from rolling.

DECAL REMOVAL

NOTICE

Due to **excessive heat** during the welding process, the possibility exists that the **Vehicle Identification Number (VIN)** and **tire pressure** decals may become damaged.

NOTICE

Record the **entire** Vehicle Identification Number (VIN) displayed on the decal before removing the decal.

Replacement VIN and tire pressure decals will be provided only after a claim has been filed with the MQ Warranty Department.

1. Record the **entire** Vehicle Identification Number displayed on the VIN decal. Also record the **last five digits** of the VIN number which are stamped into the trailer frame (Figure 2).

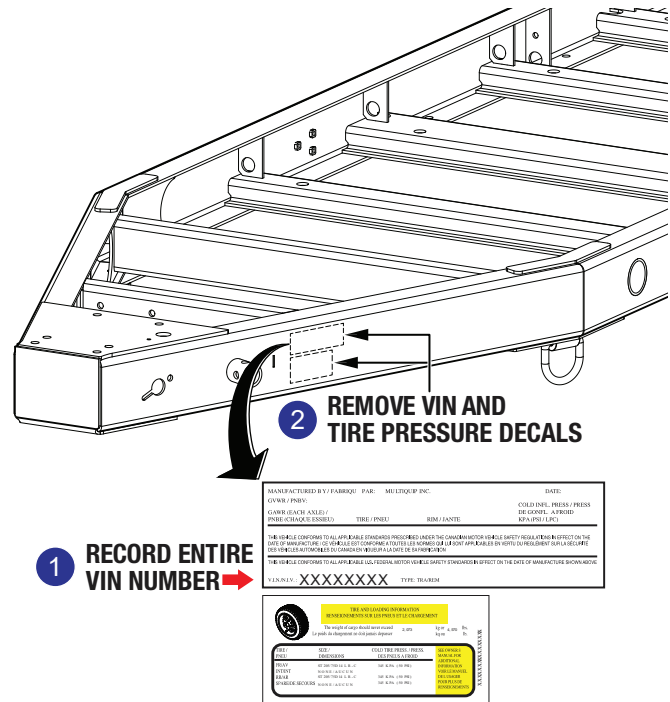


Figure 2. VIN/Tire Pressure Decal Removal

2. Remove the VIN and tire pressure decals (Figure 2).

PAINT REMOVAL

1. Using a grinder, remove the paint from the areas to be heated during welding (Figure 3).

NOTICE

Failure to properly remove the powder coat prior to welding may cause **excessive porosity** in the welds.

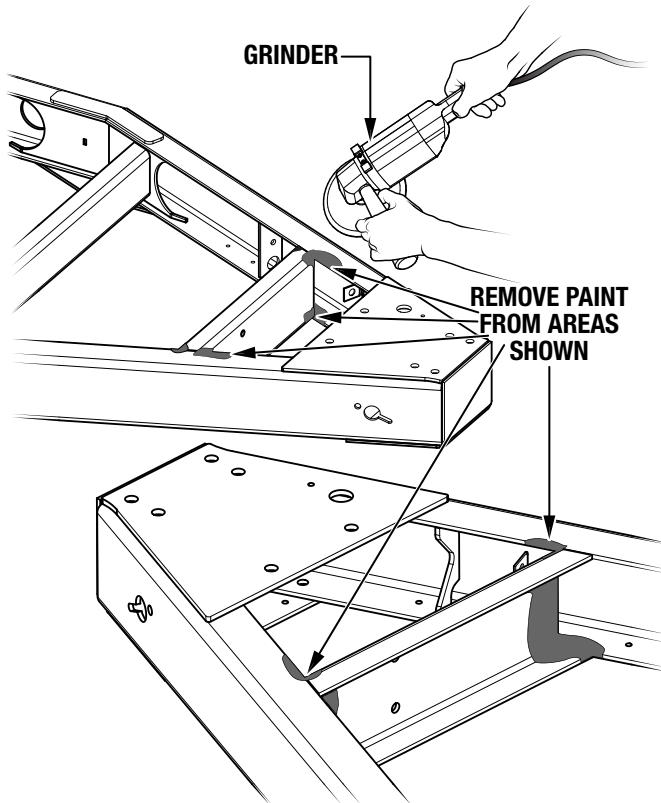


Figure 3. Paint Removal

CAUTION

If the paint cannot be removed, wear an approved respirator before heating or welding to prevent inhalation of hazardous material.

WELDING

1. Place the gusset (P/N 49941-02 or P/N 49927-02) between the jack crossmember and drawbar rail as shown in Figure 4.

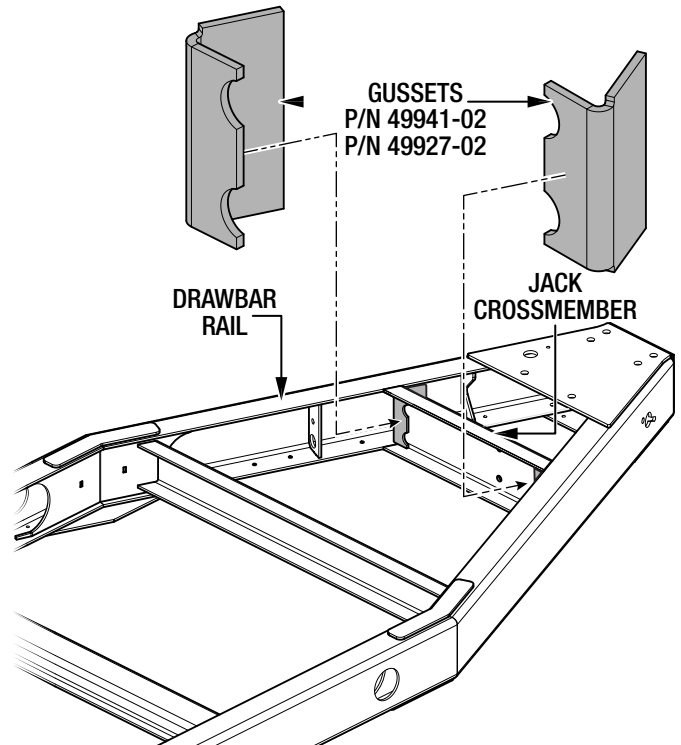


Figure 4. Gusset Placement

2. Once the gusset is correctly positioned, secure it in place with a locking C-clamp as shown in Figure 5.

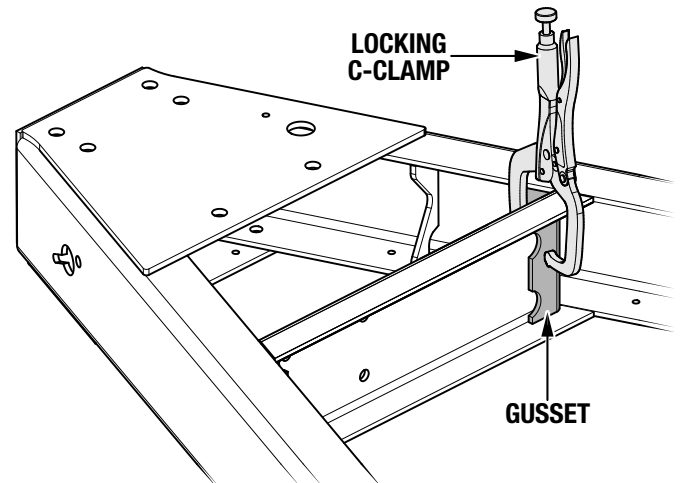


Figure 5. Secure Gusset with Clamp

3. Weld the gusset to the trailer frame (Figure 6).

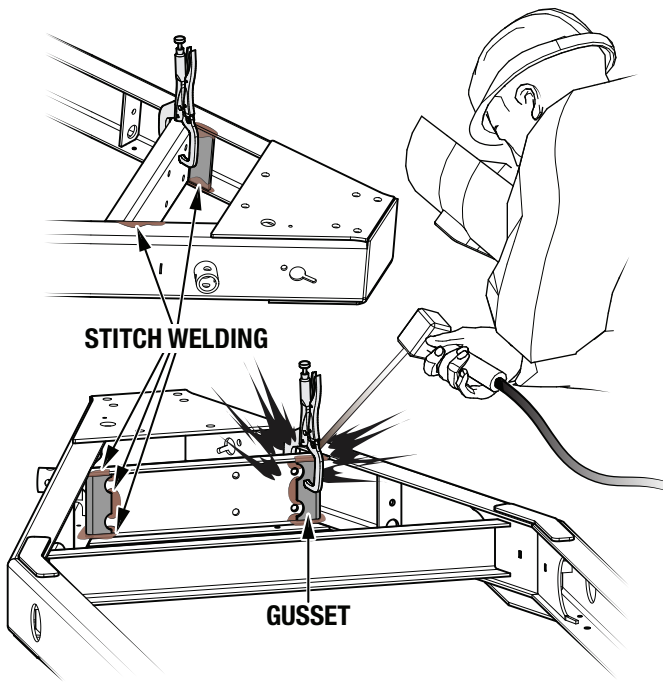


Figure 6. Gusset Welding

4. Repeat steps 1–3 with the second gusset on the opposite side of the trailer frame.
5. At the completion of the welding process, remove any flux, burrs, or rough edges from the welding area.

PAINTING

NOTICE

Allow the welded area to cool before painting.

1. Clean all welded areas on the trailer frame with a wire brush, then paint the welding areas with **flat black spray paint** (Figure 7).

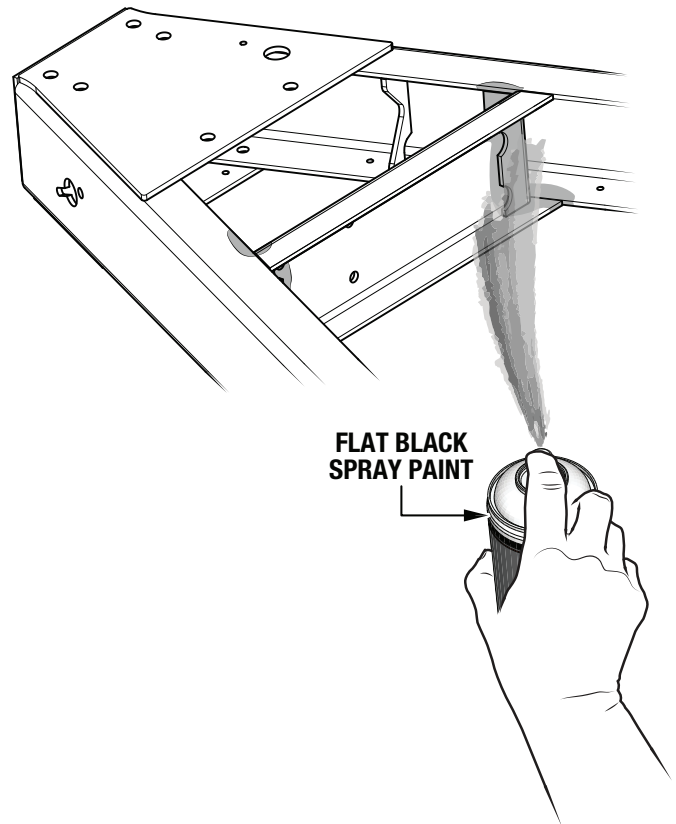


Figure 7. Paint Welding Areas

VIN AND TIRE PRESSURE DECAL REPLACEMENT

NOTICE

The steps below cannot be completed until your warranty claim has been processed. Once your claim has been processed and your VIN number has been verified, replacement VIN and tire pressure decals will be sent to you.

1. Compare your new replacement VIN decal identification number with the number that was recorded earlier. If the numbers match, proceed to step 2. **If the numbers DO NOT match, contact the MQ Warranty Department.**
2. Clean the decal location on the trailer surface with isopropyl alcohol.
3. Place the replacement VIN and tire pressure decals onto the trailer as shown in Figure 8.

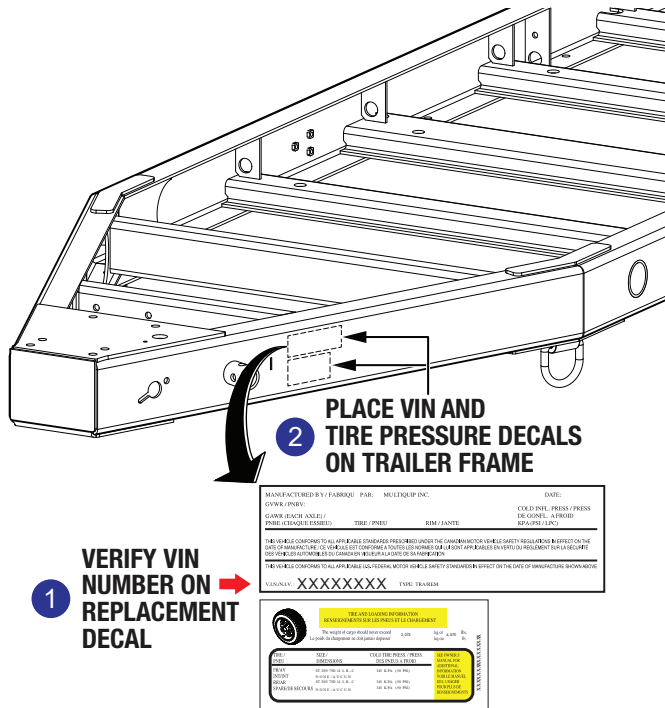


Figure 8. Decal Replacement



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HERE'S HOW TO GET HELP

PLEASE HAVE THE MODEL AND SERIAL
NUMBER ON-HAND WHEN CALLING

UNITED STATES

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18910 Wilmington Ave. Tel. (800) 421-1244
Carson, CA 90746 Fax (310) 537-3927
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MQ Parts Department

800-427-1244 Fax: 800-672-7877
310-537-3700

Warranty Department

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