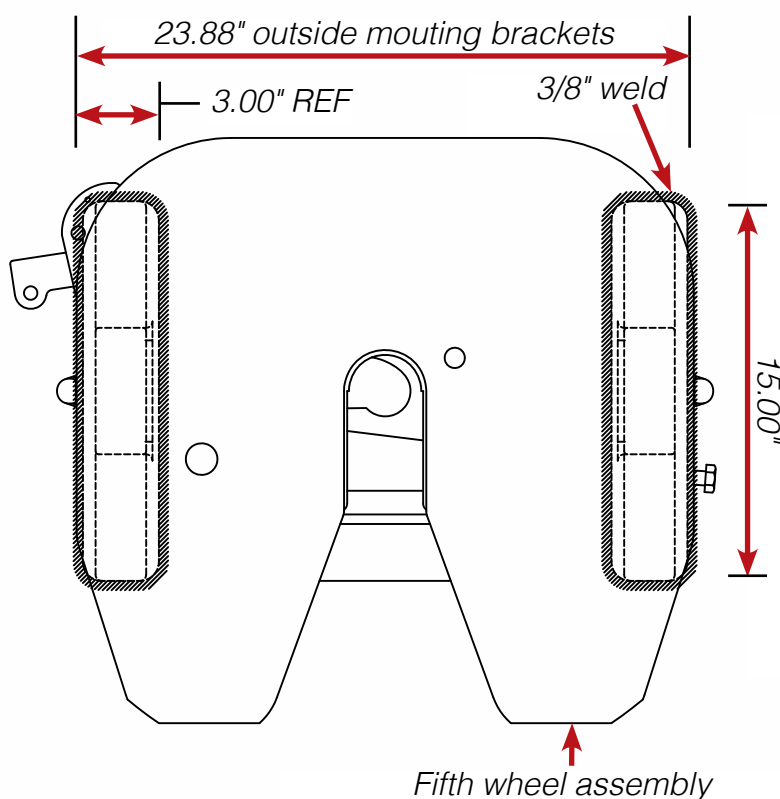


Weld-on bracket procedure

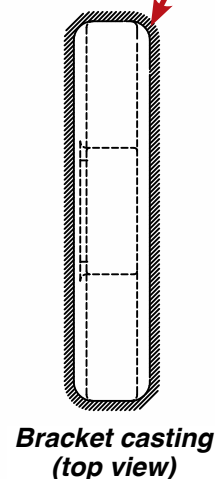


Warning!

Fontaine Fifth Wheel requires that the following procedure be followed when installing the weld-on bracket. **Failure to follow said procedure may result in catastrophic failure.**



Do not stop or start welds on the corners of the bracket castings



Fillet welds must be made using the gas metal arc welding (GMAW) process and qualified to ANSI/AWS D1.1 Section 4. These welds should be 3/8" or greater welds and encircle the entire base of each bracket, at its point of contact with the surface of mounting angle or base plate (see pictures above). After welding, a method of non-destructive testing (ex. Magnetic particle testing, dye penetrant testing, etc.) must be performed on the bracket welds prior to painting to verify that cracks do not exist in the welds. These welds must pass the inspection criteria set forth by ANSI/AWS D1.1 Section 6.

For additional assistance, please call Customer Support at 1-800-874-9780.