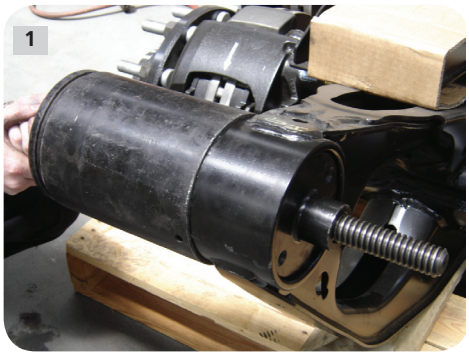
SAF-HOLLAND Group

Procedure for reinforcing the side wall of trailing arm for lift axle kit

Procedure for reinforcing the side wall of trailing arm for lift axle kit

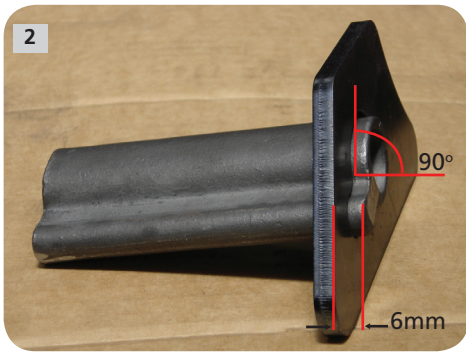
1. Remove the 3D bush with appropriate tool.



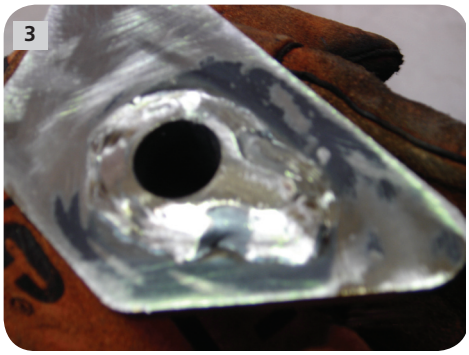
2. Prepare sleeve to be welded to the reinforcement plate.

   Correct offset = 6mm

   90˚ angle between plate and sleeve.



3. Weld sleeve to the plate, fillet all around.

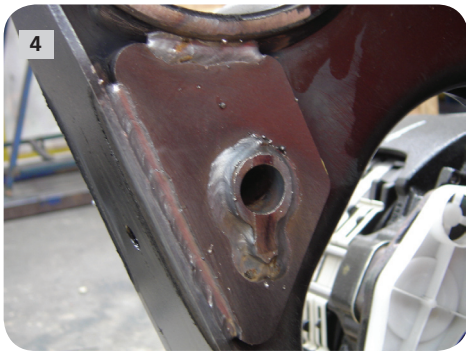


4. Prepare the welding areas.

   Weld the plate to the existing welds of the 3D bush housing and bottom plate. Do not weld on side walls of the trailing arm.

   Front and bottom edge of the reinforcement plate only. Take care to the size and length of the welds (do not weld the full length of the edges).

   Weld size min 5mm.



5. Weld second plate on the other side of the trailing arm. Keep 90˚ between sleeve and plate.

   Weld the sleeve to the plate (same procedure as before).

6. Allow the assembly to cool down.

   Seal the top and back edges on both sides with Sikaflex, as well as all non welded radii.

7. Re-paint the reinforcement plate and the working area.

8. Re-install the 3D bush (be careful of the correct position "TOP" mark must be in top position).

   Welding recommendation:

   Welding wire size: 0.9mm; Type: SG3

   Welding gas: 92/ 8 (MIG)

   Welding: 180-200 A / 27-30 V

   Wire speed: 14 m/min