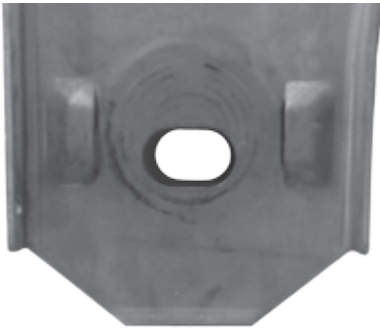


# TECHNICAL PROCEDURE VANTRAAX® ULTRAA-K®

**SUBJECT:** Frame Bracket  
Pierced Alignment Guide Repair

**LIT NO:** T82004

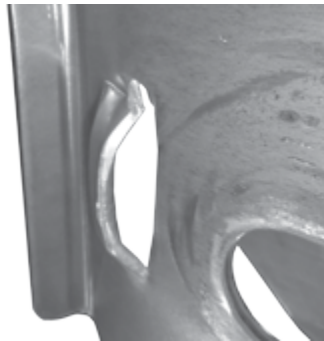
**DATE:** October 2015



**NOTE:** This procedure should only be performed once. Rewelding damaged metal can crystallize and weaken parent material.



Normal



Damaged



Repaired

For VANTRAAX® ULTRAA-K® sliders, the QUIK-ALIGN® alignment guides are fabricated by piercing the metal, as shown above. In the event of an impact (e.g. tires hitting an immovable object), the forces may be strong enough to move the alignment collars. Should this happen, the pierced alignment guide may be damaged.

**IMPORTANT:** Refer to Hendrickson literature number [L64 Welding Procedures](#) for weld parameters.

This type of damage is repairable by:

1. Pound the piercing back into shape and place.
2. Thoroughly clean weld area in preparation for welding.
3. Ensure weld area is dry.
4. Weld torn metal using 0.045 wire.
5. Grind weld smooth. Ensure area under pivot collar is flat and free of weld spatter.
6. Apply surface coat per Hendrickson literature number [T1 2004 ULTRAA-K Surface Coat Maintenance Procedure](#).

Call Hendrickson at **866.RIDEAIR (743.3247)** for additional information.



[www.hendrickson-intl.com](http://www.hendrickson-intl.com)

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