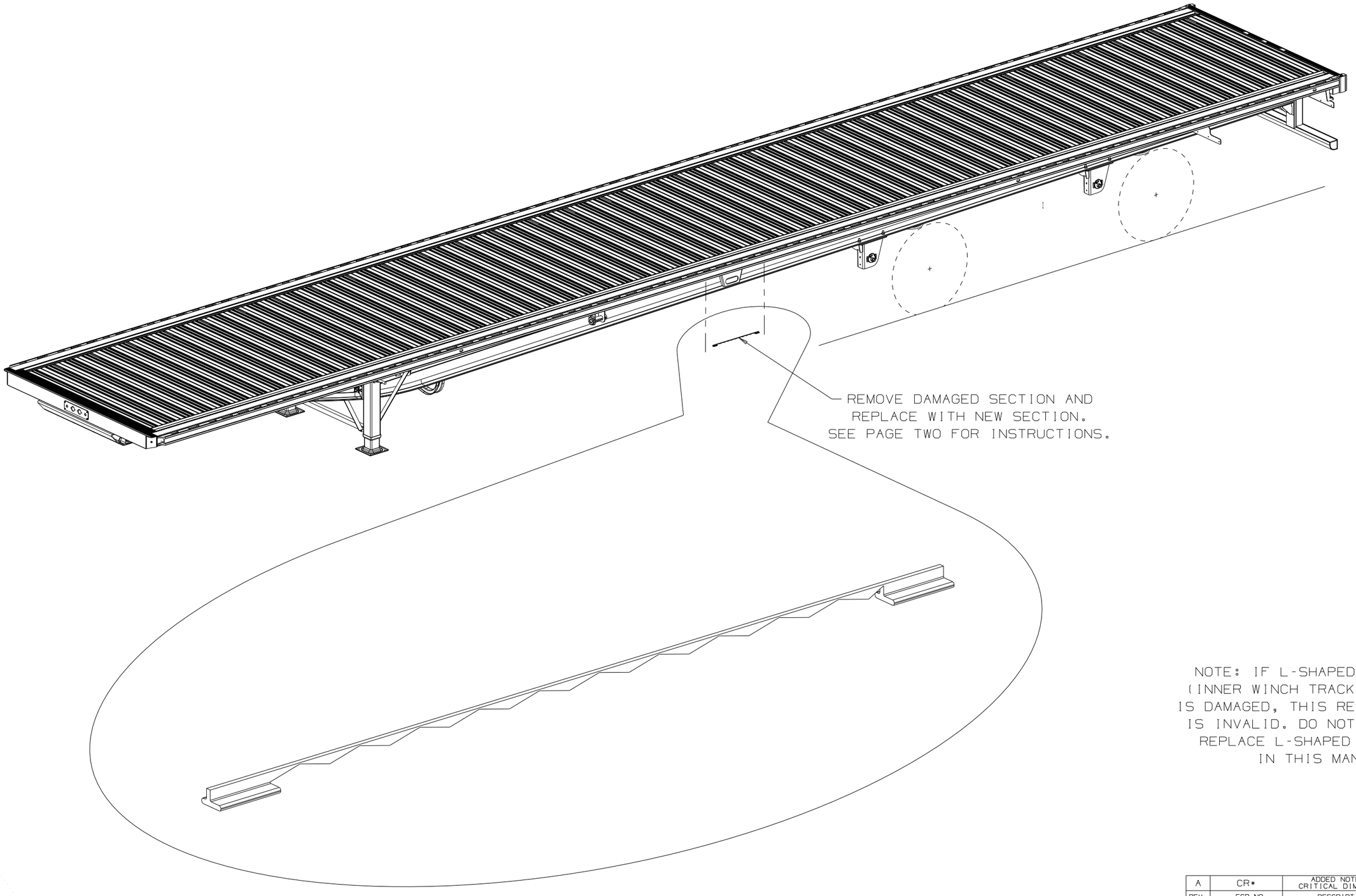


NOTE: IF L-SHAPED EXTRUSION (INNER WINCH TRACK EXTRUSION) IS DAMAGED, THIS REPAIR DRAWING IS INVALID. DO NOT ATTEMPT TO REPLACE L-SHAPED EXTRUSION IN THIS MANNER

REV.	ECR NO.	DESCRIPTION	BY	DATE
A	CR*	ADDED NOTE ON CRITICAL DIMENSION	AA	08/16/16

DO NOT SCALE DRAWING	TOLERANCES UNLESS OTHERWISE SPECIFIED	DRAWN BY: AA	DATE: 03/16/16
DIMENSIONS ADHERE TO: ASME Y14.5M-1994	FRACTIONS: ± 1/16	CHECKED BY	DATE
THIRD ANGLE PROJECTION	DECIMALS:. ± .06		
	HOLES:.. ± .010	APPORVED BY	DATE
	ANGLES:... ± 2°		
	UNITS OF DIMENSION ARE: INCHES		

FONTAINE TRAILER CO.
HALEYVILLE, AL

TITLE: OUTER WINCH TRACK EXTRUSION REPAIR (REVOLUTION)

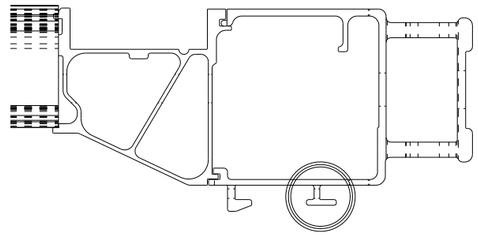
PRINTED OR COPIED DOCUMENT IS UNCONTROLLED DOCUMENT UNLESS STAMPED ORIGINAL

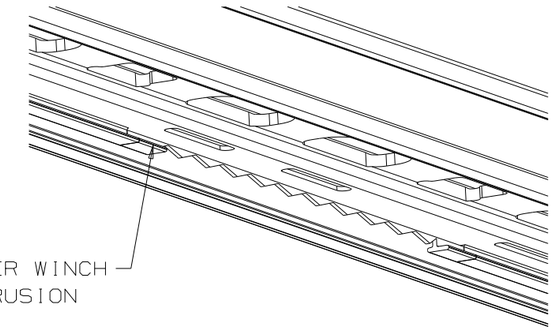
SIZE:	SCALE:	SHEET:
B	*:*	1 OF 2

DRAWING NUMBER	REV.
W0000313	0

INSTRUCTIONS:

1) Determine required outer winch track leg replacement length.
   a. Establish location of required end cuts using the following parameters.
      i. Cut location to be approximately 2" beyond any visible damage.
      ii. Mark the location of the end cuts for future reference.
   b. Order replacement outer winch track extrusion (Fontaine PN 50822327) from Fontaine PartSource at 866-382-7278. If repair area is longer than 7 feet, ask Fontaine PartSource about options.





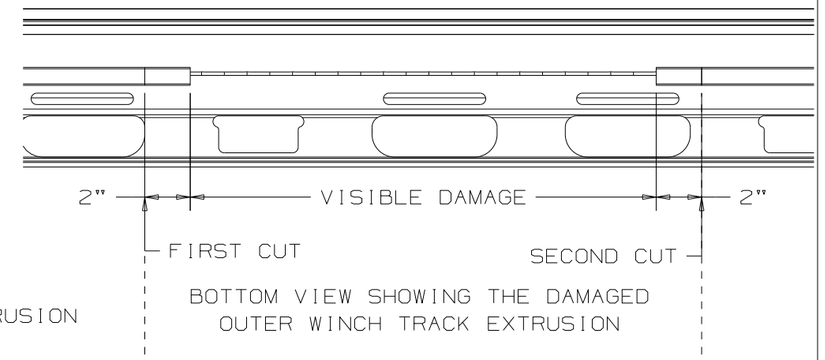
Start of the Repair

2) Mark the location for the required cuts to remove the damaged section .

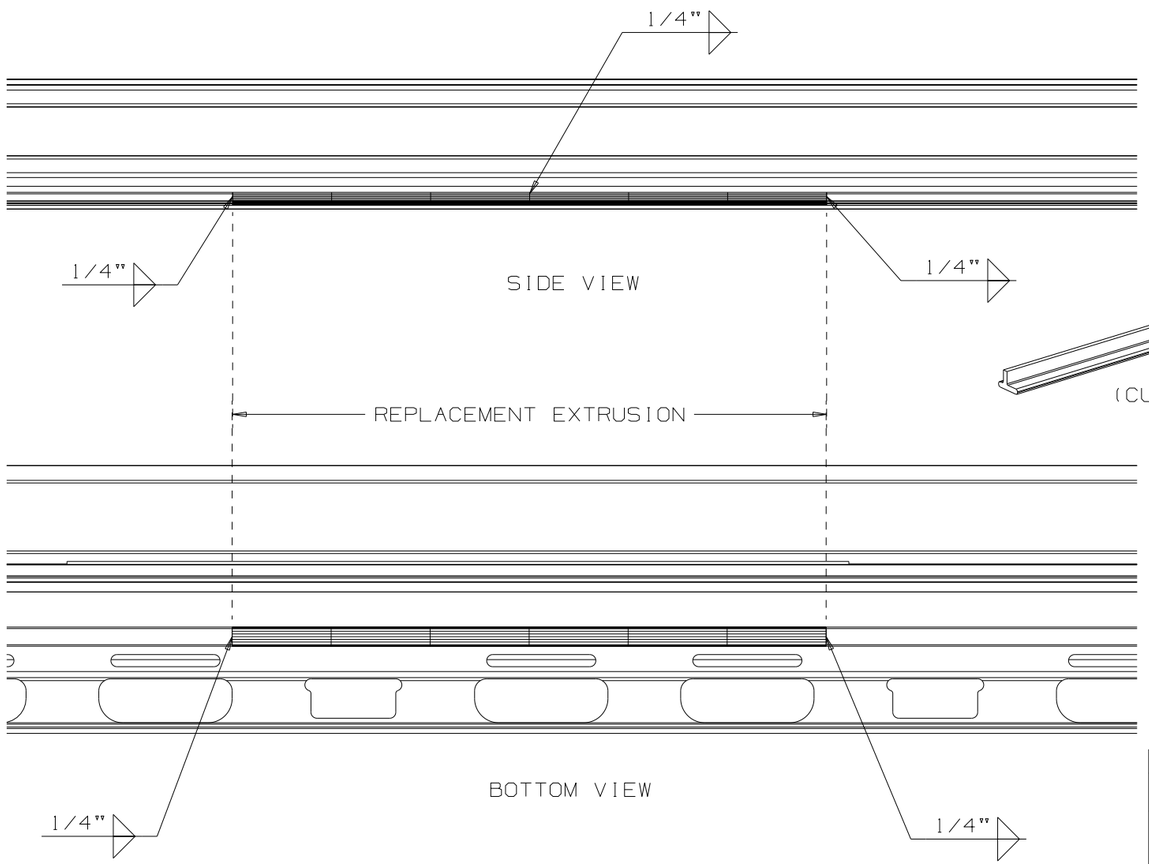
3) Remove the damaged winch track extrusion.
   a. Use a circle saw or reciprocating saw to make two cuts into the bottom of the damaged T-extrusion at marked locations. Make cut as close as possible to bottom of side rail.
   b. Knock damaged extrusion loose with a hammer and wedge.
   c. Clean up repair area by using sander equipped with disc designed for aluminum.

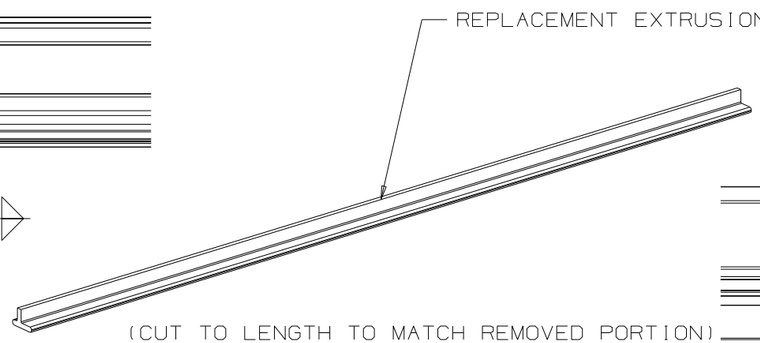
4) Cut replacement extrusion to required length and weld into place. Use $\frac{1}{4}$" weld on all seams.
   a. Prep for installation by cleaning all weld areas with a stainless steel wire brush
   b. Tack extrusion into place and then make first two welds on bottom seams of winch extrusion.
   c. Weld all remaining seams

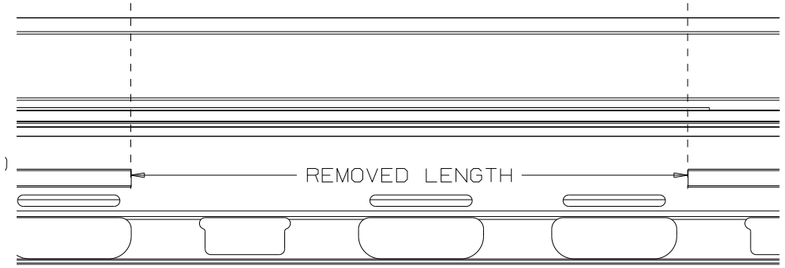
5) Clean up welds with sander or in-line grinder. Leave as much material as possible on innermost edge to maintain strength. Make sure winch travels over repair area. Clean weld smoke from side rail.



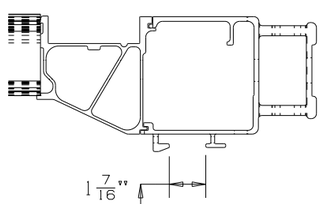
BOTTOM VIEW SHOWING THE DAMAGED OUTER WINCH TRACK EXTRUSION







DAMAGED OUTER WINCH TRACK EXTRUSION REMOVED



SPECIAL TOLERANCE
+ 0"
- 1/16"

REV.	ECR NO.	DESCRIPTION	BY	DATE
A	CR*	ADDED NOTE ON CRITICAL DIMENSION	AA	08/16/16

DO NOT SCALE DRAWING	TOLERANCES UNLESS OTHERWISE SPECIFIED	DRAWN BY	DATE	FONTAINE TRAILER CO. HALEYVILLE, AL
DIMENSIONS ADHERE TO: ASME Y14.5M-1994	FRACTIONS: ± 1/16	AA	03/16/16	PRINTED OR COPIED DOCUMENT IS UNCONTROLLED DOCUMENT UNLESS STAMPED ORIGINAL
THIRD ANGLE PROJECTION	DECIMALS: . ± .06	CHECKED BY	DATE	SIZE: B / SCALE: * : * / SHEET: 2 OF 2
	HOLES: .. ± .010	APPROVED BY	DATE	TITLE: OUTER WINCH TRACK EXTRUSION REPAIR (REVOLUTION)
	ANGLES: ... ± 2°			DRAWING NUMBER W0000313 / REV. 0
	UNITS OF DIMENSION ARE: INCHES			