FONTAINE FIFTH WHEEL®

ISO/TS16949 Registered

TECHNICAL BULLETIN

TB-030 • February 2003

BLOCKING KIT – KIT-BLK-SLD FOR HEAVY DUTY 5092 SERIES FIFTH WHEELS

Installation Procedure (Please read all of the instructions before beginning.)

1. IMPORTANT NOTES:

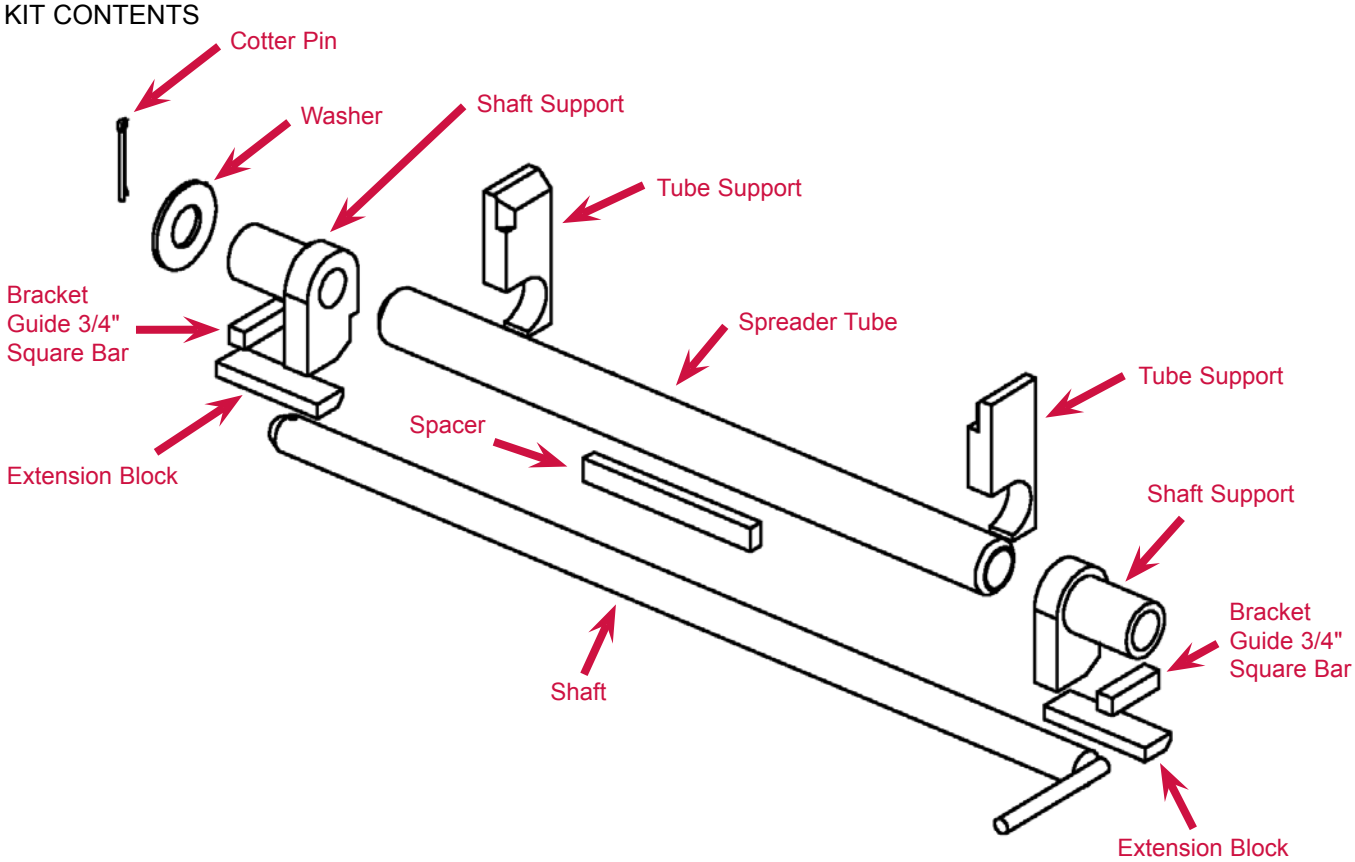
I. Blocking kits offered for Fontaine's sliding and plate mount fifth wheels **MUST** be installed by a certified welder.

II. **WARNING:** Failure to follow these instructions could cause a hazardous condition. Fontaine International is **NOT** responsible for improper installation or any welding to this product.

III. The top plate must be removed from the bracket before installing the blocking kit. All surfaces to be welded must be clean and free of paint and grease.

IV. This blocking kit can **ONLY** be used on heavy duty 5092 Series Fifth Wheel's with Mounting Heights of 8-3/4" to 10-3/4".

FIGURE 1
KIT CONTENTS



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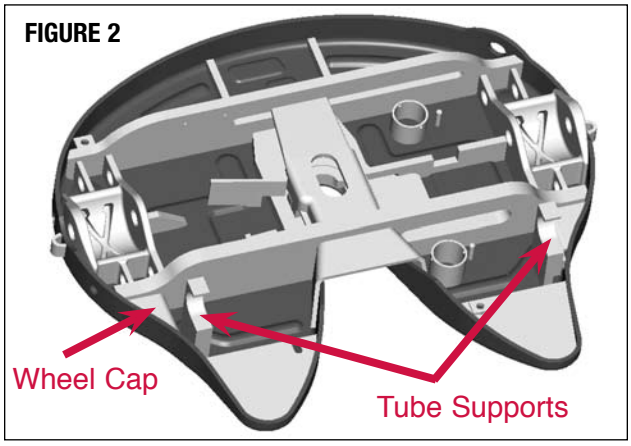
2. Place tube supports into top plate as shown in Figures 2 and 3.
3. Now place tube into tube supports as shown in Figures 4 and 5. Make sure tube is parallel to rear cross member. The tube supports should be flush with the wheel caps and the bottom chamfer should rest just over the grease groove as shown in Figures 2 and 3. Tube supports may need to be trimmed for proper fit. The tube should measure 2-5/8" from rear cross member to front side of tube on both sides as shown in Figure 5.

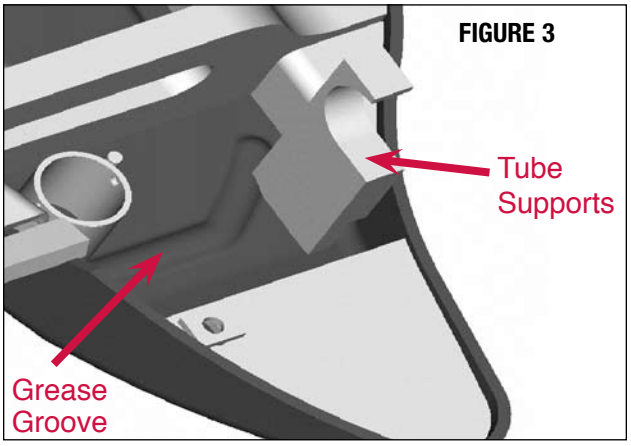
Tube Support Placement

FIGURE 2



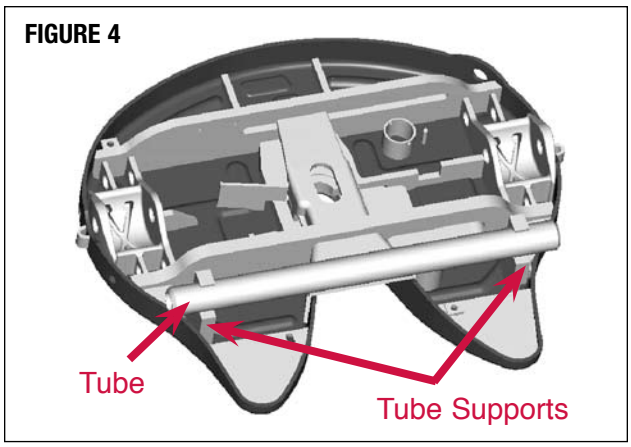
Tube Support Placement

FIGURE 3



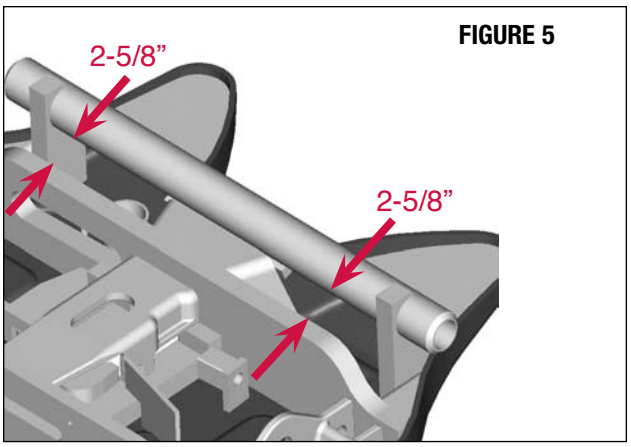
Tube and Tube Supports

FIGURE 4



Tube and Tube Supports

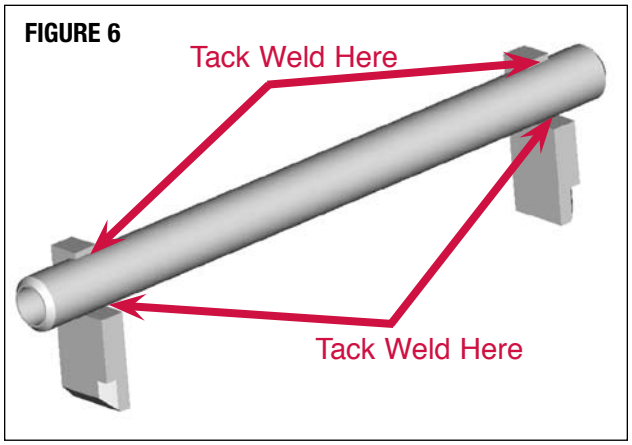
FIGURE 5



4. After tube supports and tube are in the correct position, tack weld tube supports to tube as shown in figure 6. This will help keep parts from drawing when final welds are made. Next, turn tube supports over and place a 3/16" minimum fillet weld as shown in Figures 7, 8 and 9.

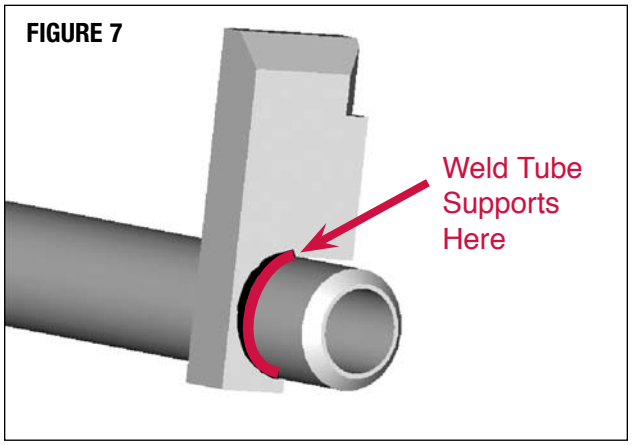
Tack Weld Locations

FIGURE 6



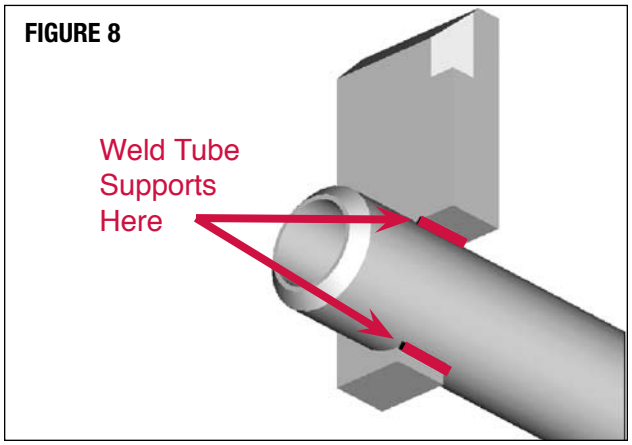
Weld Locations For Tube Supports

FIGURE 7



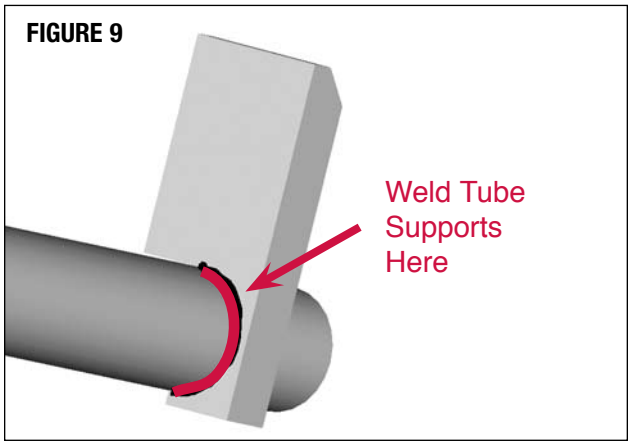
Weld Locations For Tube Supports

FIGURE 8



Weld Locations For Tube Supports

FIGURE 9



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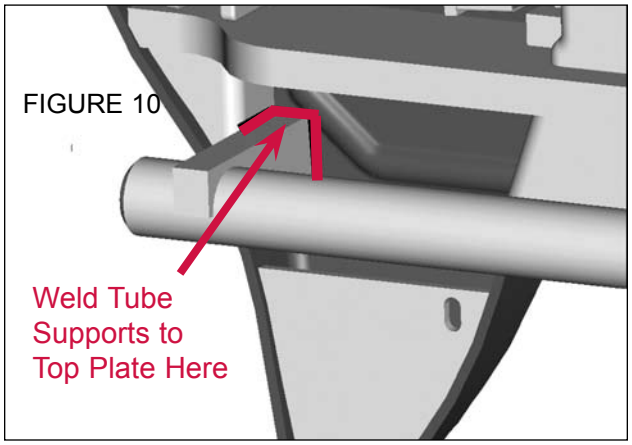
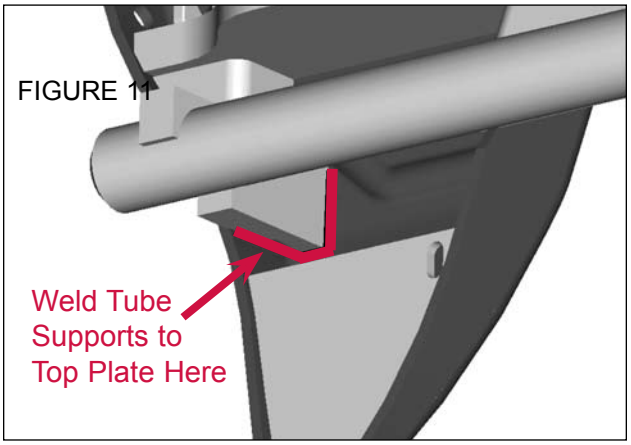
5. Place tube supports and tube back into the top plate. Next, weld tube supports into top plate as shown in Figures 10, 11 and 12 while maintaining the 2-5/8" measurement from Figure 5 on page 2.

NOTE: The tube supports require a Three-Pass, 3/16" minimum fillet weld on each pass.

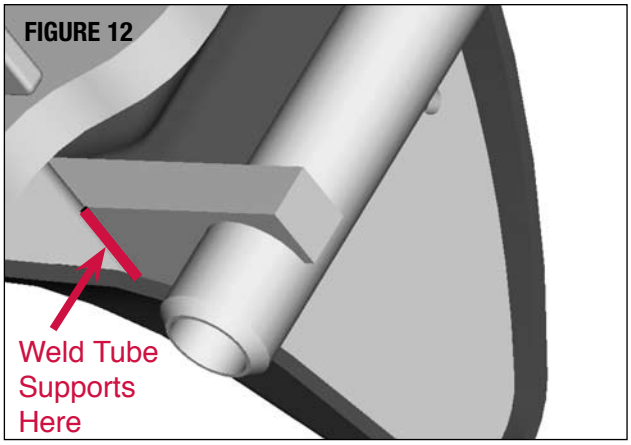
Weld Locations For Tube Supports



Weld Locations For Tube Supports

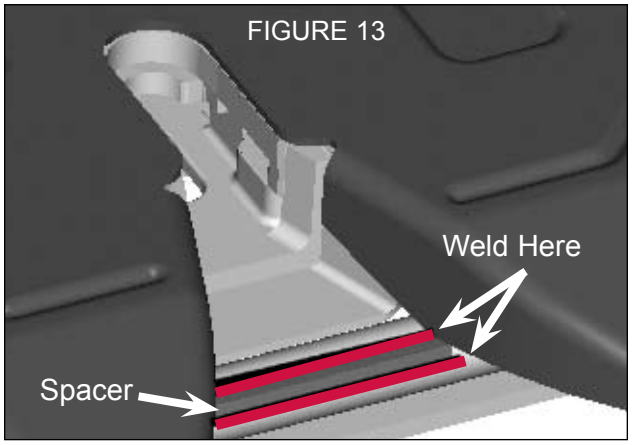


Weld Locations For Tube Supports

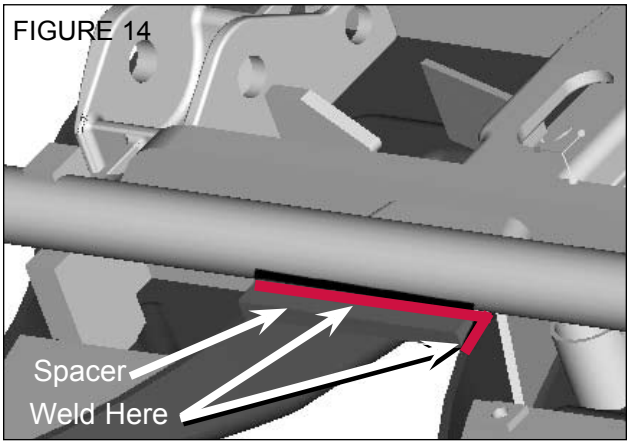


6. Insert the 5/8" x 1" x 8.25" flat spacer bar behind tube. Next, tack the bar into position. Finally, weld a 3/16" minimum fillet weld to throat plate, spacer and tube as shown in Figures 13 and 14.
7. Remove the Rocker Limit Blocks and Guide Bars (see Figure 15) from the lower assembly. Grind or burn blocks off and grind all excess material until surface is flat.
8. Place top plate back on the bracket and set a level on top of top plate (figure 16).
9. Slide one shaft support onto shaft making sure the notched end of the shaft support is towards the front of top plate and the tube of the shaft support is facing away from fifth wheel.
10. Slide shaft into tube and into the other shaft support making sure the notched end of shaft support is towards the front of the wheel and the tube of the shaft support is facing away from fifth wheel as shown in Figure 16.
11. Trim ends of shaft supports, if necessary, so that top plate is sitting level.

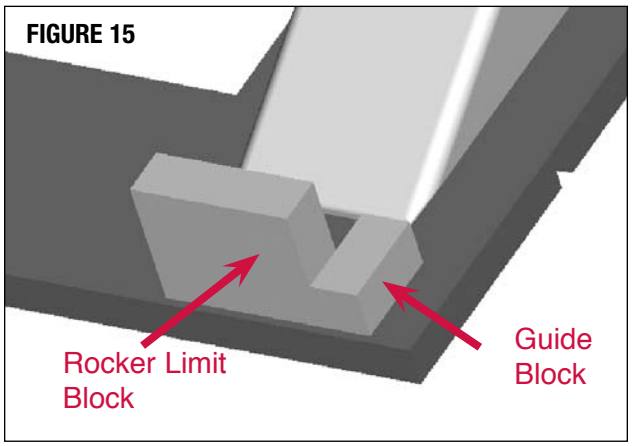
Throat Plate Installation



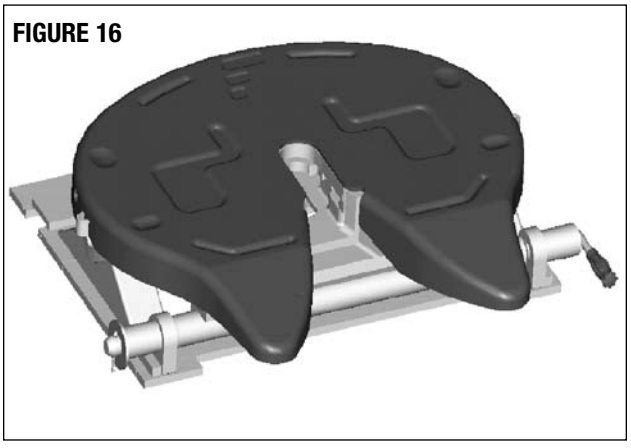
Throat Plate Installation



Rocker Limit Block and Guide Bar



Correct Position of Tube Supports



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NOTE: If blocking kit is being installed on sliding mount you must install extensions and bracket guides on rear of bracket as shown in Figures 17 through 20.

NOTE: Weld Extension Block As Shown in Figure 17. Grind Extension block weld flush with bottom side of bracket.

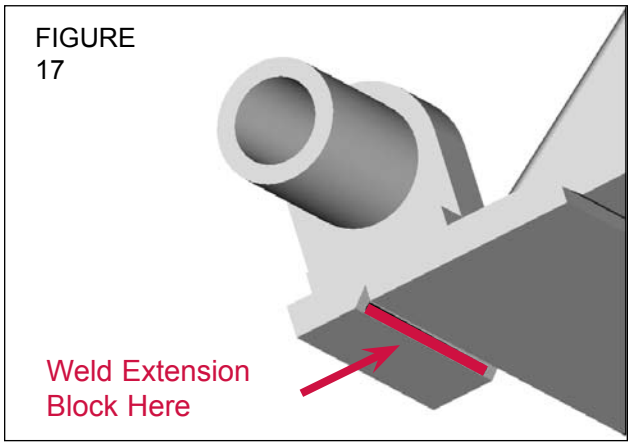
12. Install Bracket Guides as shown in Figure 18. Make sure bracket guide is 5/8" away from outside edge of slide bracket as shown in Figure 19.

NOTE: Do not weld on outside edge of guide. A weld in this location will cause interference with slide rail.

13. Tack shaft supports onto lower mount on all four sides making sure shaft will slide after each tack. Tap shaft supports with a hammer until shaft will slide easily. Weld shaft supports to plate mount using a 3/16" minimum fillet weld on all four sides as shown in Figures 19 and 20.
14. Assemble the provided washer and cotter pin onto shaft as pictured in Figure 16 (previous page).
15. Lubricate the entire length of the shaft with Never Seize before first use.

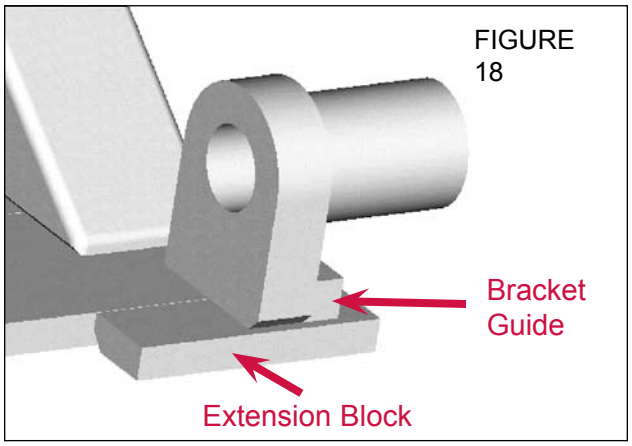
Slide Bracket Extension

FIGURE 17



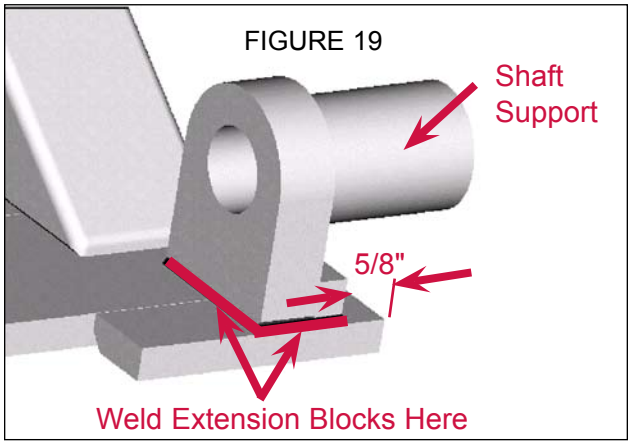
Slide Bracket Extension

FIGURE 18



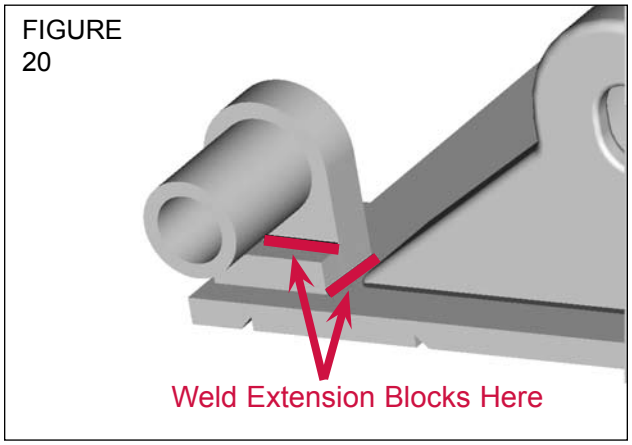
Weld Pattern For Shaft Supports

FIGURE 19



Weld Pattern For Shaft Supports

FIGURE 20



END OF PROCEDURE