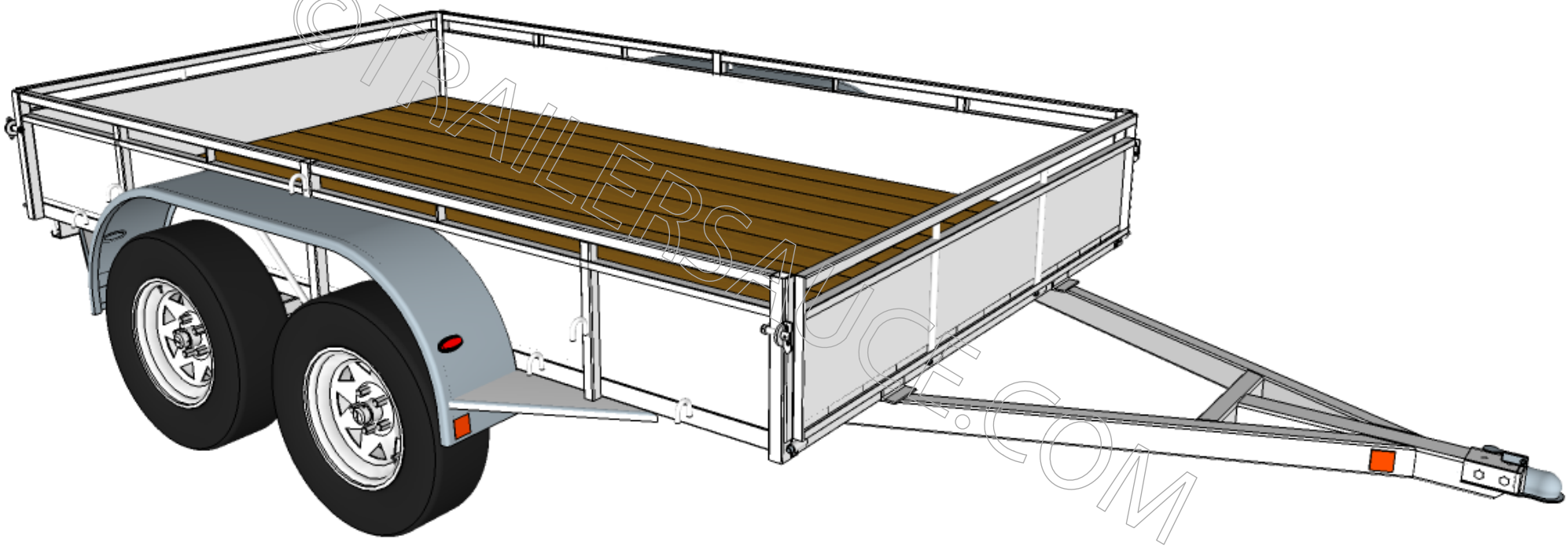

6' x 10' TANDEM AXLE TRAILER

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6' x 10' Dual/Tandem Cutting and Parts List

	Part	Material	Length/Description	Quantity
1	Chassis Rails	1" x 2" x 1/8" RHS	120"	2
2	Cross Members	1" x 2" x 1/8" RHS	70"	6
3	Cross Members - Mid section	2" x 2" x 1/8" SHS	70"	2
4	Tongue Main Sections	2" x 3" x 3/16" RHS	Approx 7' 4" before trimming	2
5	Tongue Insert	3" x 3" x 3/16" SHS	24"	1
6	Tongue Brace	2" x 3" x 1/8" RHS	Approx 16" before trimming	1
7	Light Channel	3/16" Mild Steel plate	70"L x 11 3/4"W	1
8	Light Channel Rods	1/2" Solid Rod	Approx 5" long- grind to fit light channel	4
9	Front/Rear/Center Side Uprights	1 1/2" x 1 1/2" x 1/8" SHS	17"	6
10	Central Side Uprights	1 1/4" x 1 1/4" x 1/8" SHS	15 3/4"	6
11	Tie Rails Sides - Front	1 1/4" x 1 1/4" x 1/8" SHS	4' 11 3/4"	2
12	Tie Rails Sides - Rear	1 1/4" x 1 1/4" x 1/8" SHS	4' 7 3/4"	2
13	Tie Rail Mid Support Plates	1" x 1/4" Flatbar	1 3/4"	4
14	Tie Rails Tailgates	1 1/4" x 1 1/4" x 1/8" SHS	70"	2
15	Tailgate Uprights	1 1/4" x 1 1/4" x 3/16" Angle	15"	4
16	Tailgate Centre Upright	1/2" Solid Rod	1' 1 11/16"	4
17	Hinge Pipes	1/2" NB Medium Pipe	2" or as per supplied with gudgeons	8
18	Hinge Gudgeons (Main & End)	1/2" Solid Rod	As per supplied	8
19	Droplock Tubes	9/16" ERW Tube (Thin wall)	1 1/2"	4
20	Sides - Front panel	14 gauge (0.080") Panel Steel	8' L x 14 11/16" W	2
21	Sides - Rear panel	14 gauge (0.080") Panel Steel	1'9"L x 14 11/16" W	2
22	Tailgates	14 gauge (0.080") Panel Steel	70" L x 16" W	2
23	Tongue Angle Gussets	1 1/2" x 3/16" Equal Angle Steel	Approx 4" long	2
24	Conduit Tubes	9/16" ERW Tube (Thin wall)	1 1/2" long	10
25	Spring Packers	1" x 2" x 1/8" RHS	Approx 5' required - cut to suit chassis	6 pcs
26	Tie Hooks	3/8" or 1/2" Solid Rod	4" long before bending- can use 1/2 chain links	10
27	Deck	As required		1
28	Tires	ST 215/75 R 14" Tires	1800 lb minimum load rated per tyre	4
29	Wheels	14" galvanised / painted		4
30	Hubs	1750 lb hubs (rated per each)	Can be upgraded to braking hubs/spindles	2 pr
31	Axle	2" x 2" x 3/16" SHS	Spindles to match hubs	2
32	Oscillating Rocker Assembly	To suit springs type and width		1 pr
33	Springs	4 or 5 leaf leaf/slipper springs, 2" wide	Upgrade to higher load if required	2 pr
34	Spring hardware	2" wide U Brackets and slippers		2 pr
35	Spring Plates	Plates to suit 2" axle & 9/16" U bolts		4
36	U bolts	2" Square U Bolts, 9/16" diameter		8
37	Fenders	10" or 10 3/4" wide Dual/Tandem axle fenders, un-galvanized or galvanized		2
38	Fender Brace	10 gauge (0.128") Panel Steel	11 1/4" x 20" unfolded	4
39	Fender Bracing Rod	3/4" Solid round bar	15" before trimming to fit	2
40	Coupler	3500 lb straight coupler to suit 3" box	Upgrade if braked	1
41	Chain/Cables	Rated at twice GTW		2
42	Shackles/Hooks	As per Chain/Cable rating		4
43	1/2" High tensile bolt/nut &Chain washer	Only required if bolting chain to tongue		2
44	Tailgate Drop Locks - Anti Luce	12mm x 54mm (minimum length) Long shank thread and locknut- available on ebay		4
45	Tailgate Latch plate	2" x 1/4" Flat Steel	Approx 3" long	4
46	Lights	4" square LED or bulb		2
47	Side Clearance lamps - Front	LED Sealed - Amber		2
48	Side Clearance lamps - Rear	LED Sealed - Red		2
49	Rear Marker lamps	LED Sealed - Red		3
50	4 Core Cable	Green, Yellow, Brown, White - 14 Gauge		approx 26 ft
51	2 Core Cable	Brown, White - 14 gauge		approx 22 ft
52	"P" Clips		Diameter to suit cable	12
53	Deck Fastenings	8G x 1 1/4" Self tapping c/sunk screws	Hot dipped galvanized	Approx 80
		SHS - Square Hollow Section / RHS - Rectangular Hollow Section		*Rev A*

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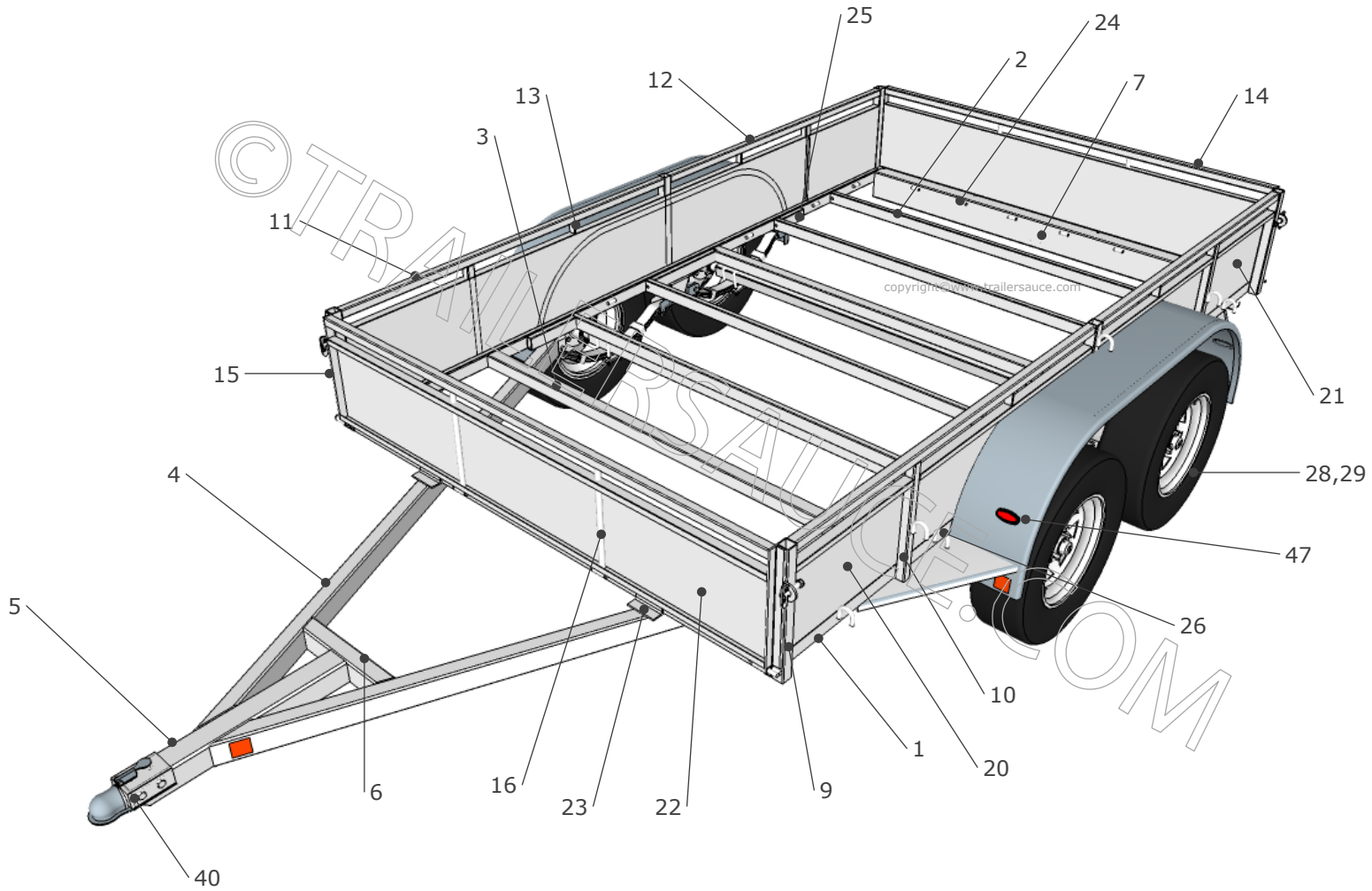

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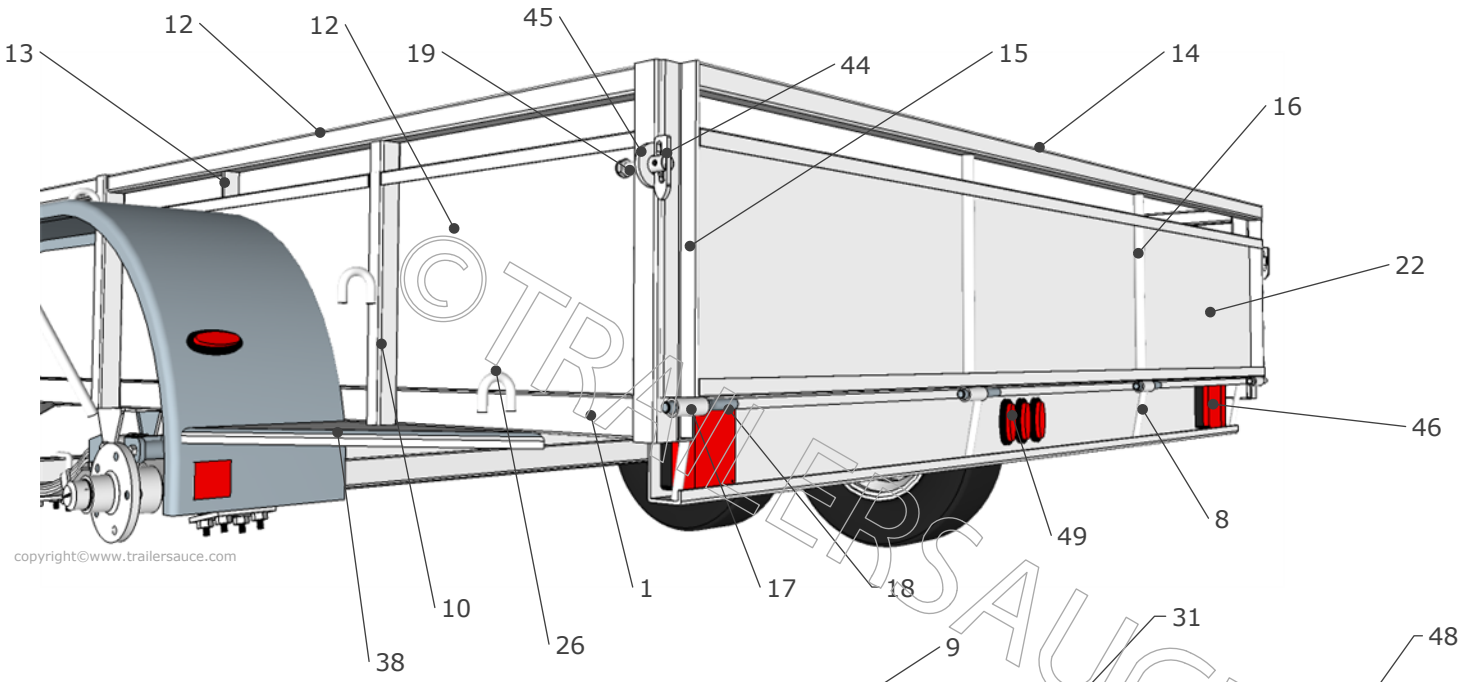
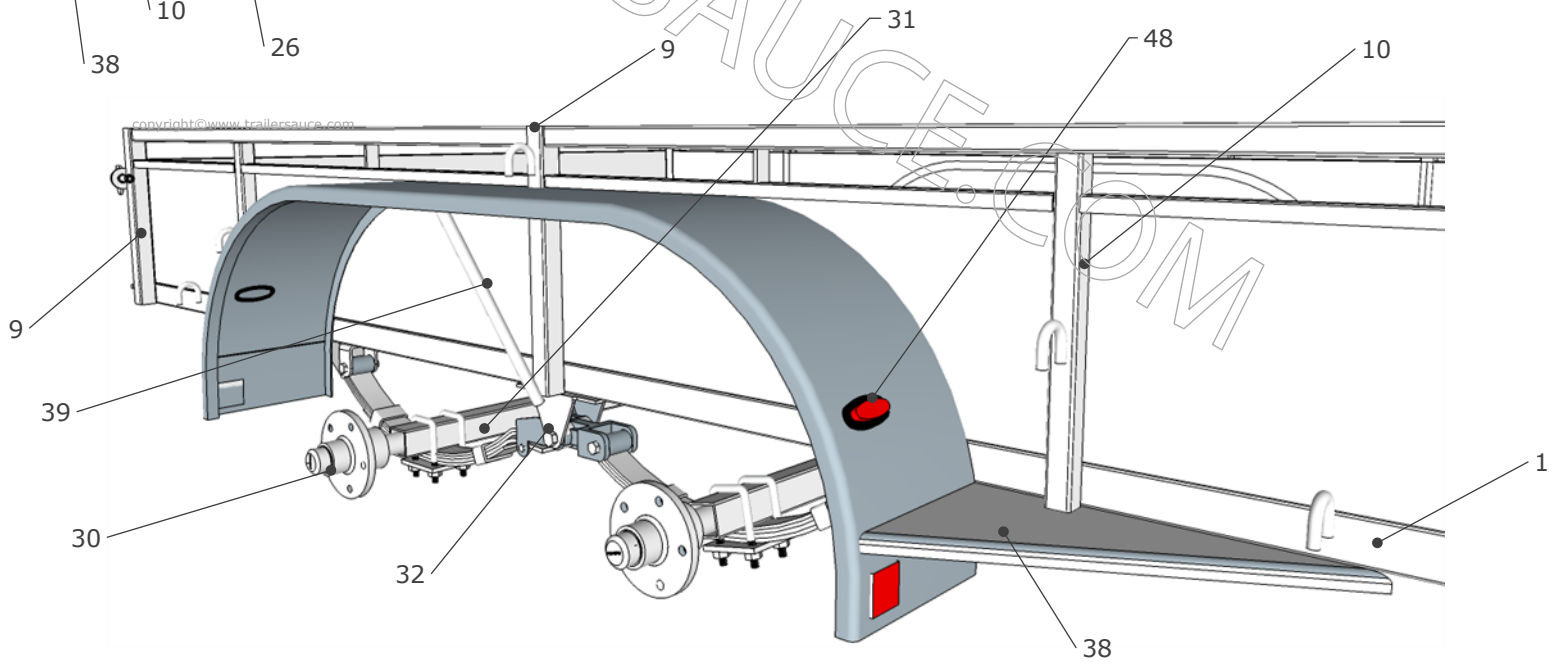
MAIN COMPONENTS

Matching with Bill of Materials





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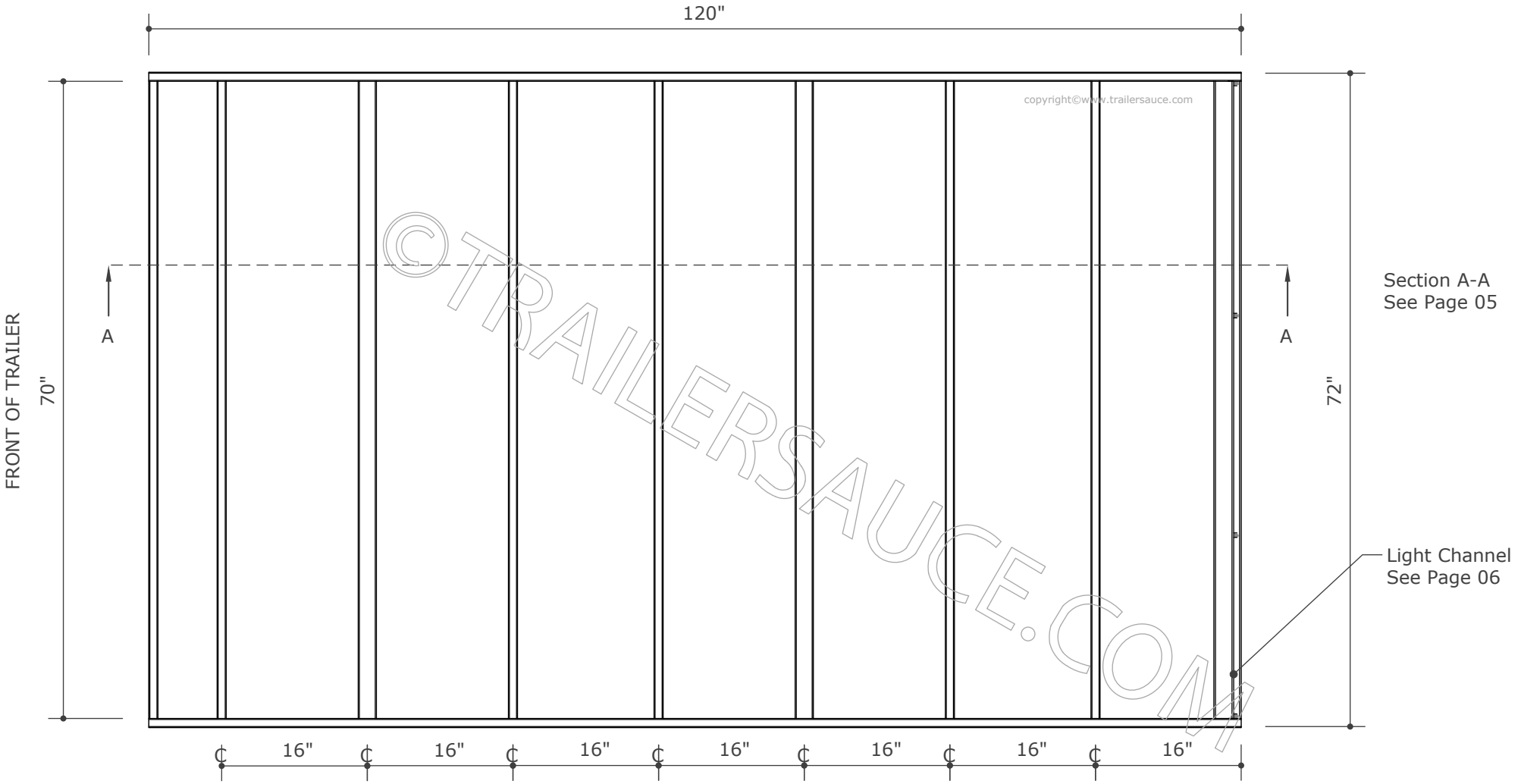

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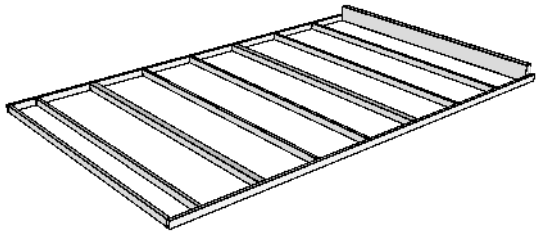
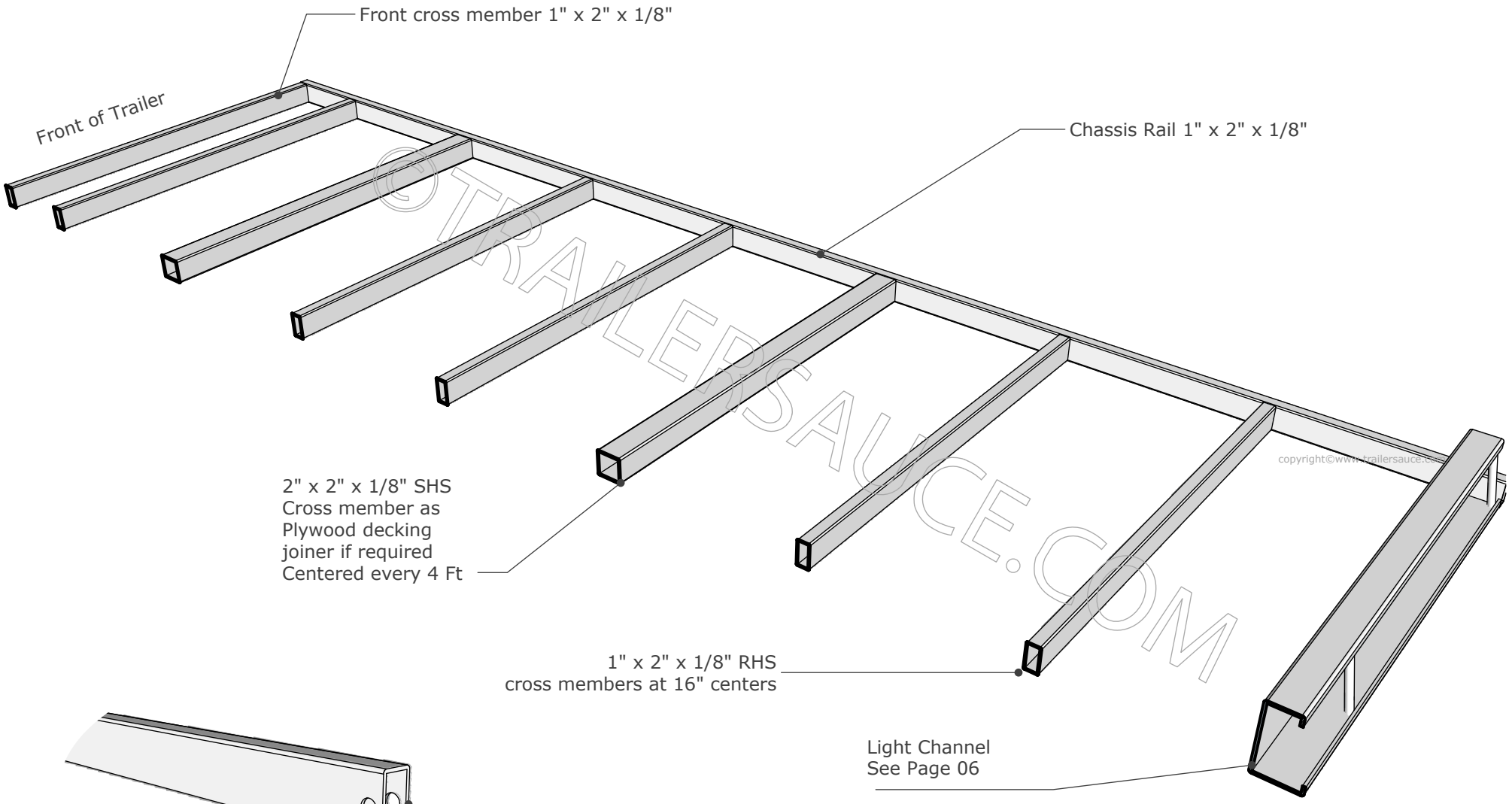


CHASSIS



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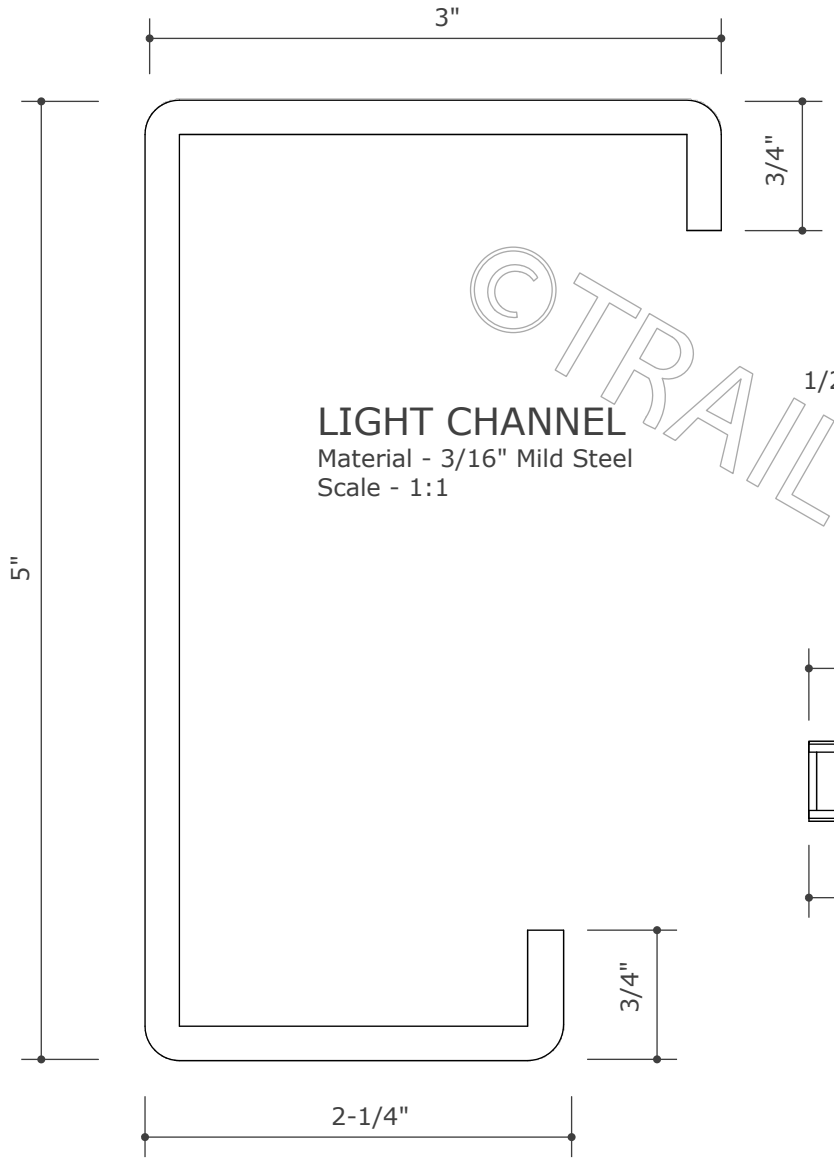
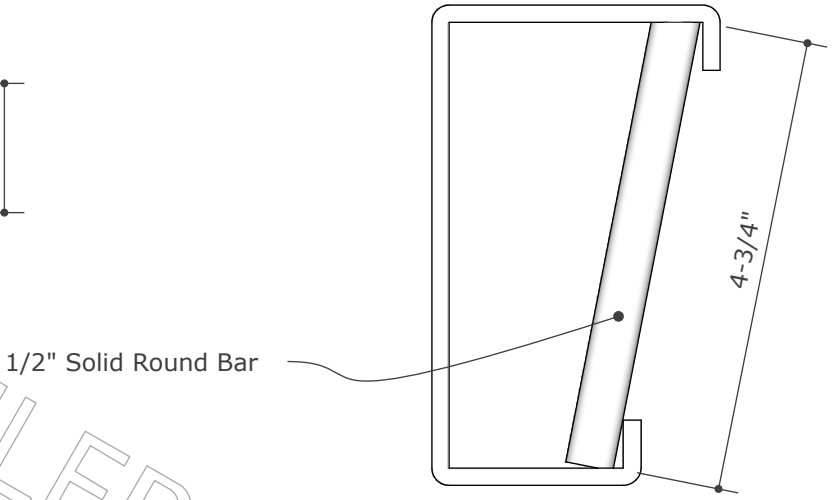
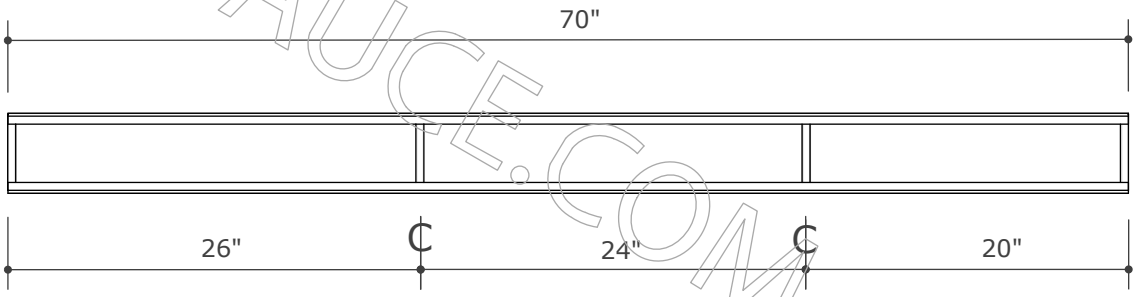
CHASSIS SECTION A - A



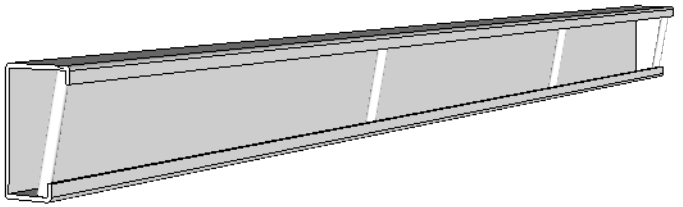
LIGHT CHANNEL

Material - 3/16" Mild Steel
Scale - 1:1





Round bar spacings



LIGHT CHANNEL

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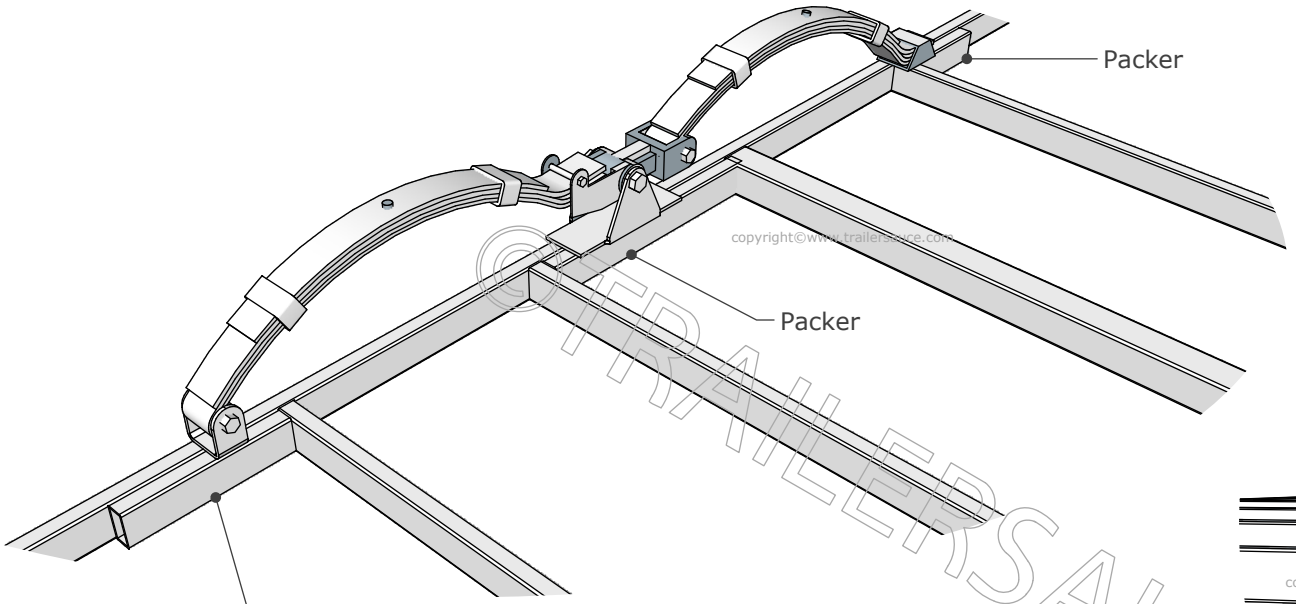

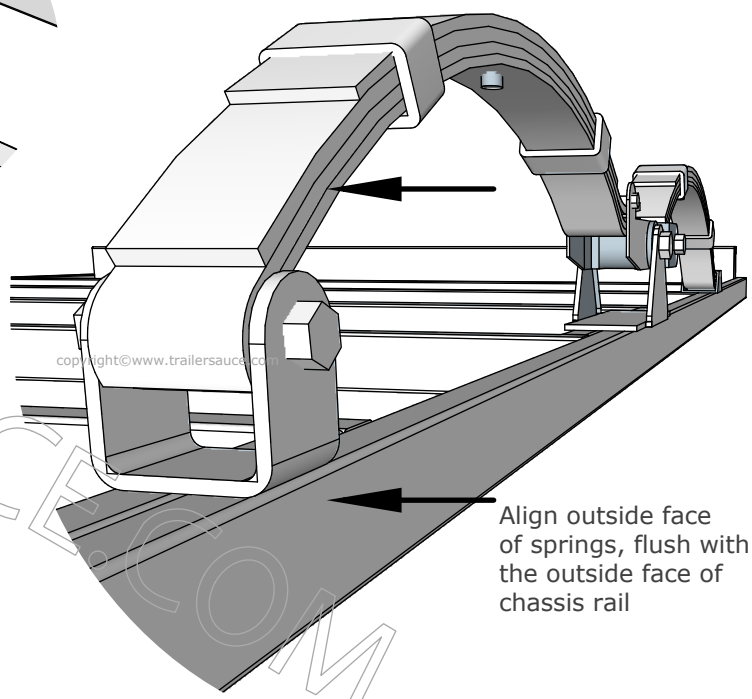

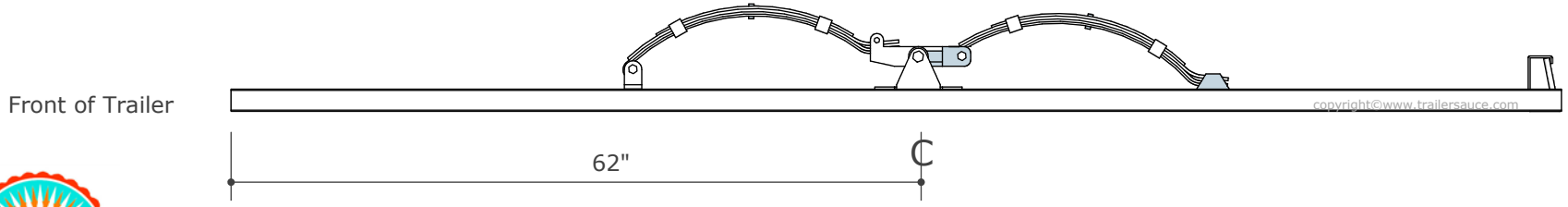

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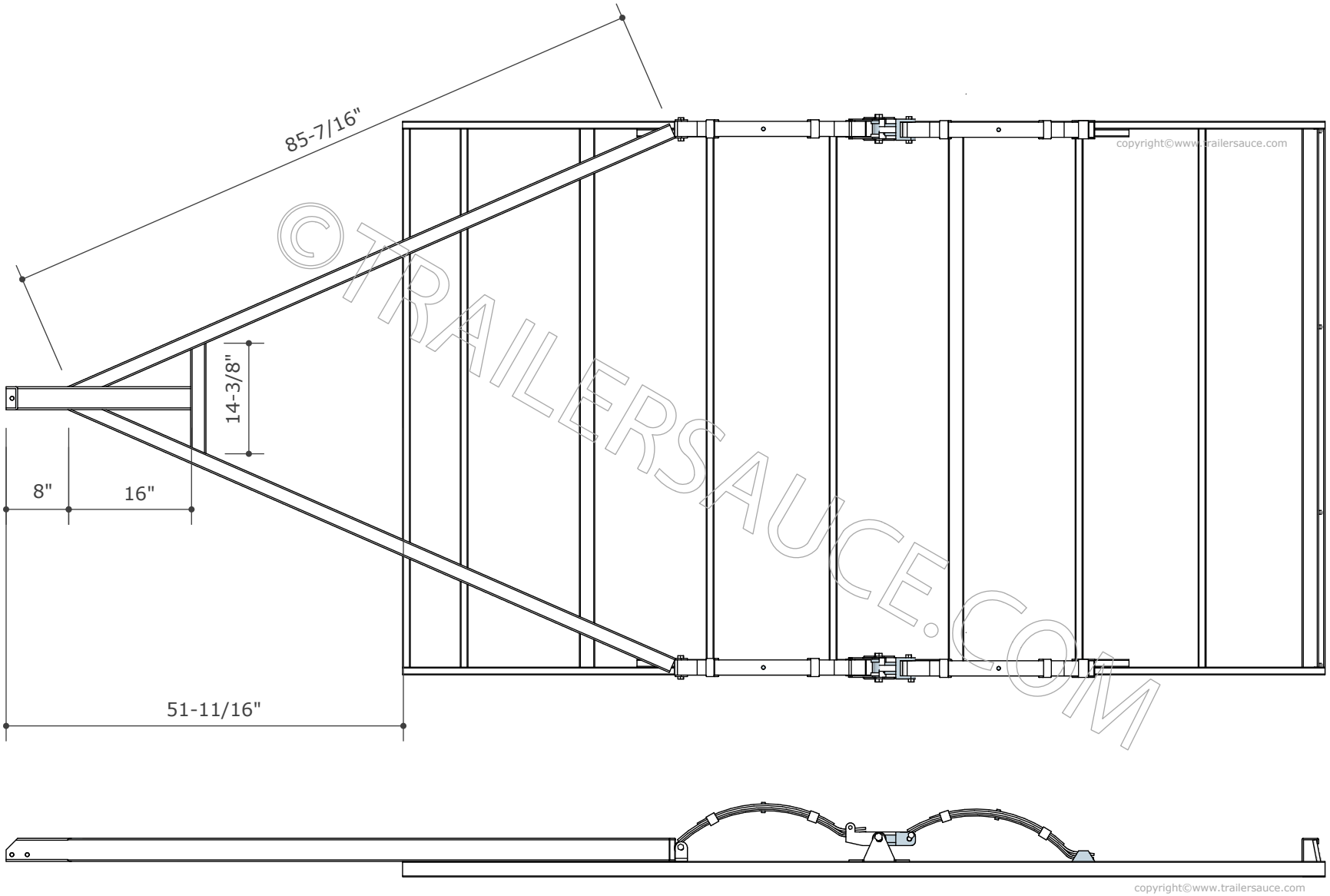
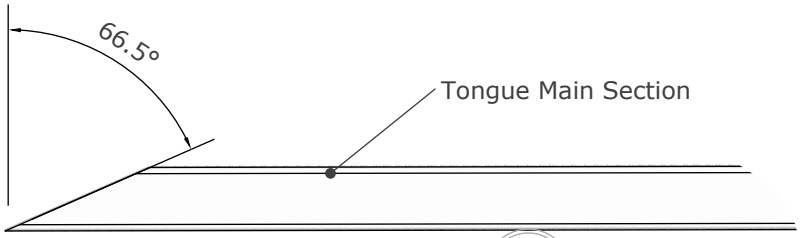
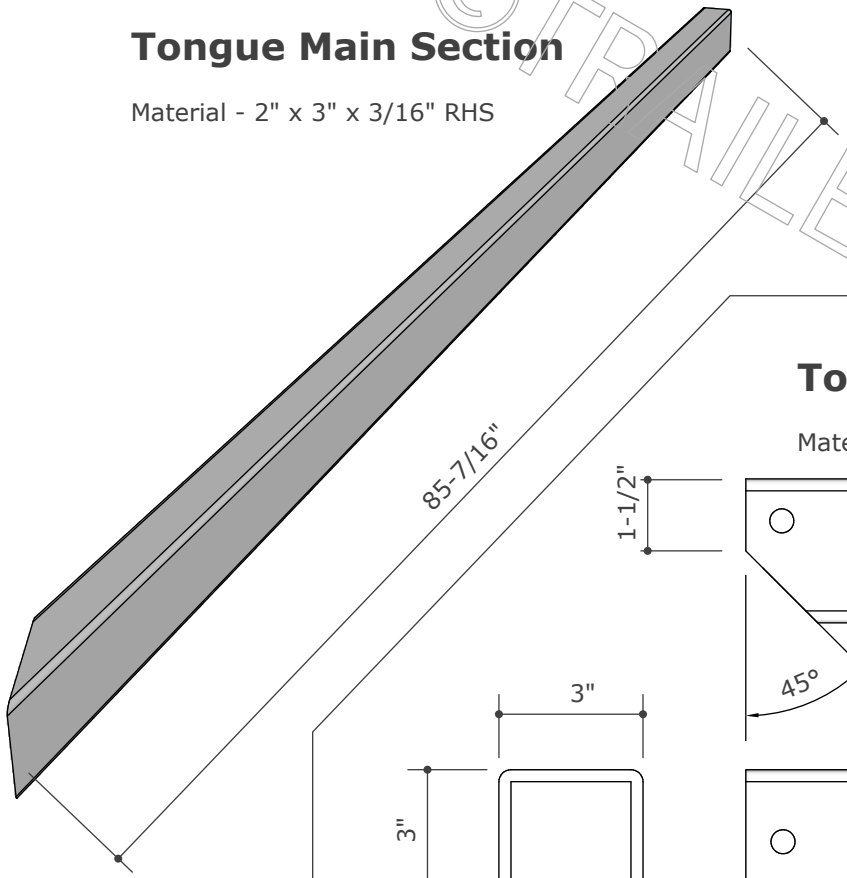


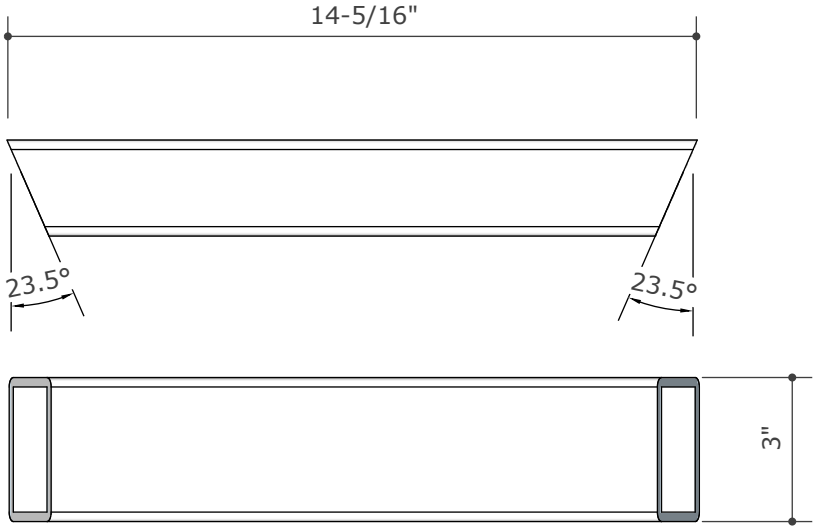
TONGUE SETUP



Tongue Main Section

Material - 2" x 3" x 3/16" RHS



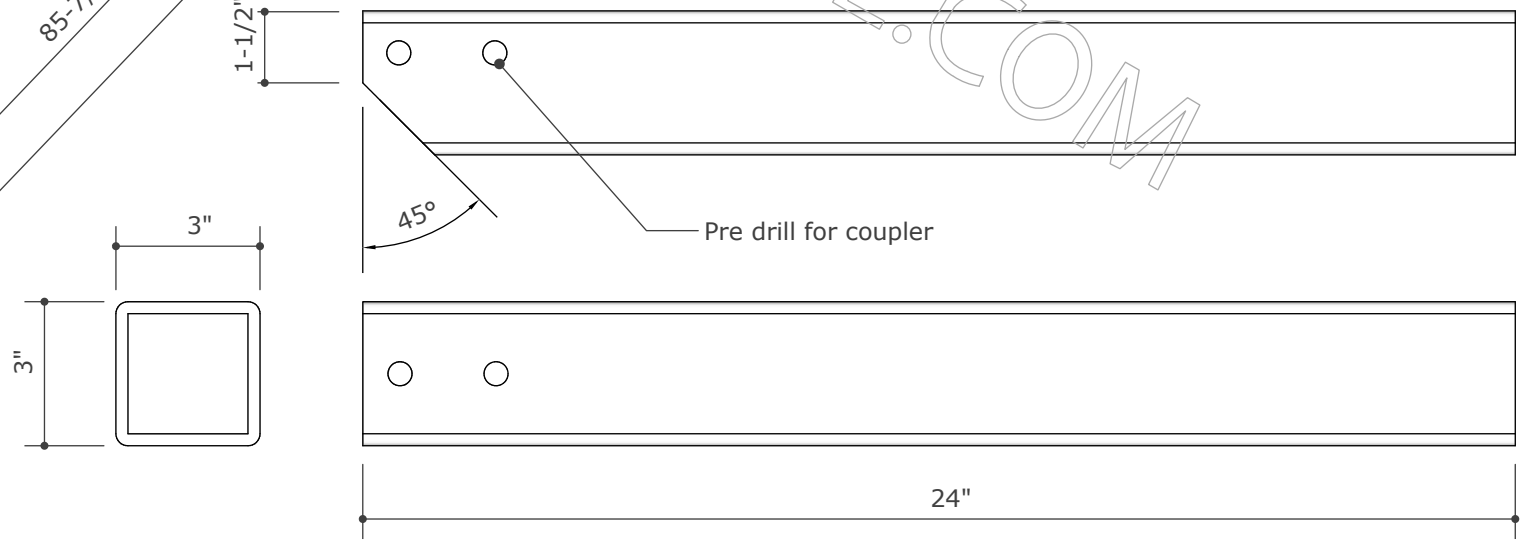


Tongue Brace

Material - 2" x 3" x 1/8" RHS

Tongue Insert

Material - 3" x 3" x 3/16" SHS



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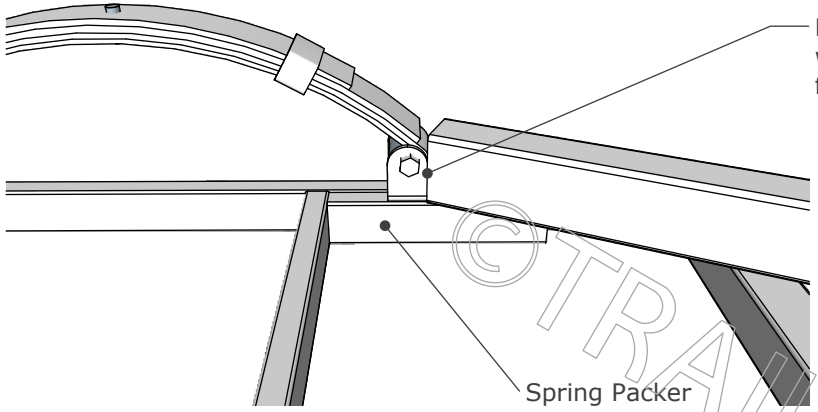

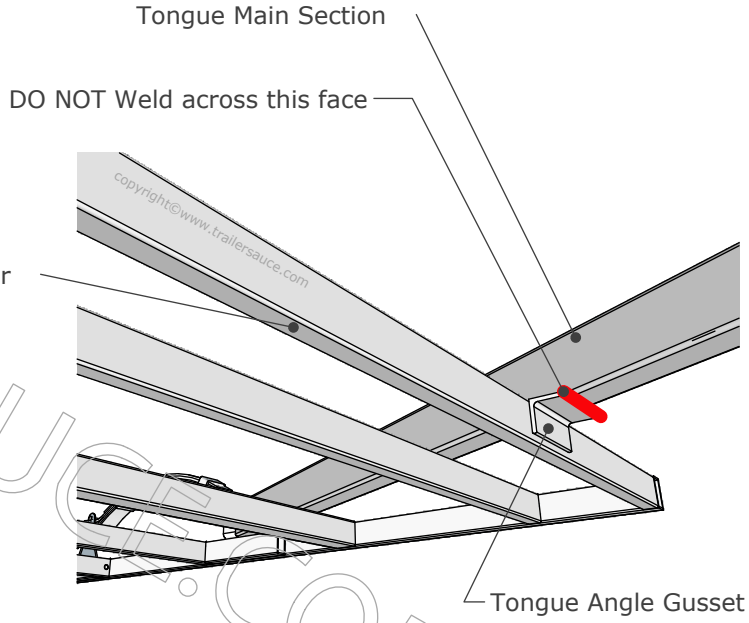

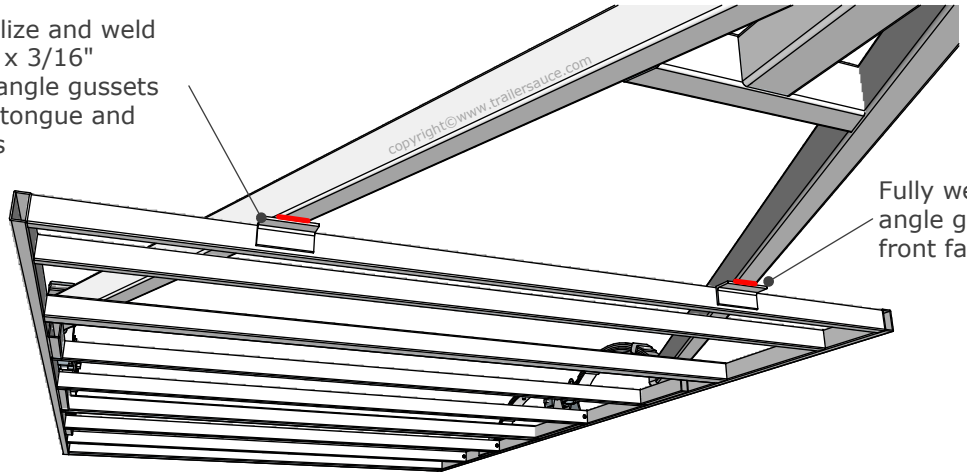

The point where the drawbar and front chassis cross member meet is where most of the stress and flexing of the tongue occur under normal use (vertical motion).

Welding across the top face of the tongue at this point can introduce additional crystalline stresses within the steel around the welds heat affected zone (HAZ), which over time may cause cracking of the base steel and failure of the tongue.

TONGUE & ANGLE GUSSET DETAIL

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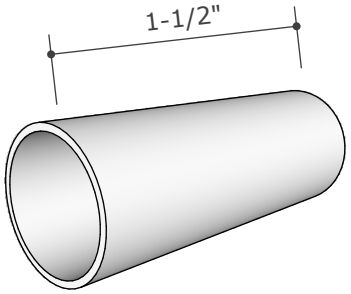
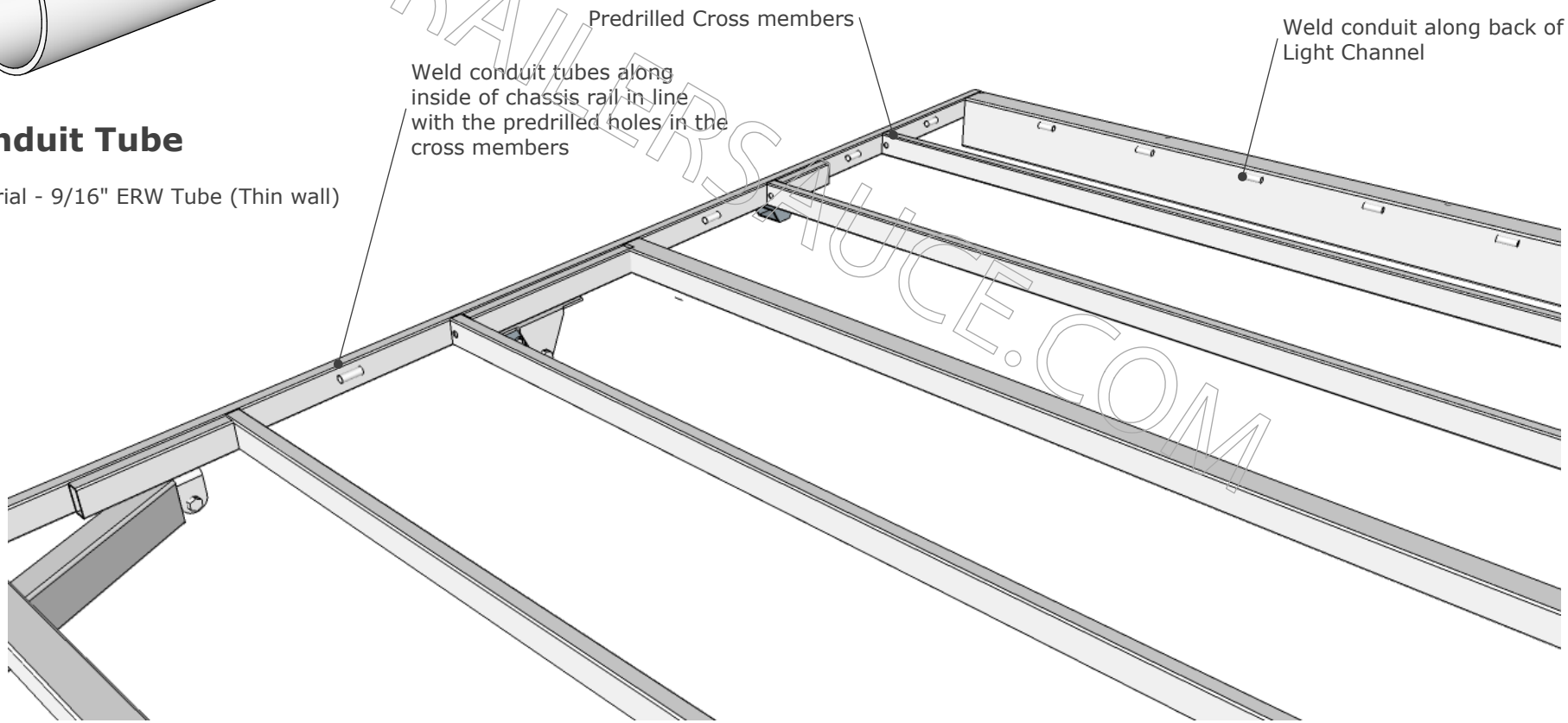
Conduit tubes are only required along the chassis rail from the end of the tongue. The lighting cable will run down the inside of the tongue and come out at the spring hanger, then through the spring packers and conduit tubes



Conduit Tube

Material - 9/16" ERW Tube (Thin wall)



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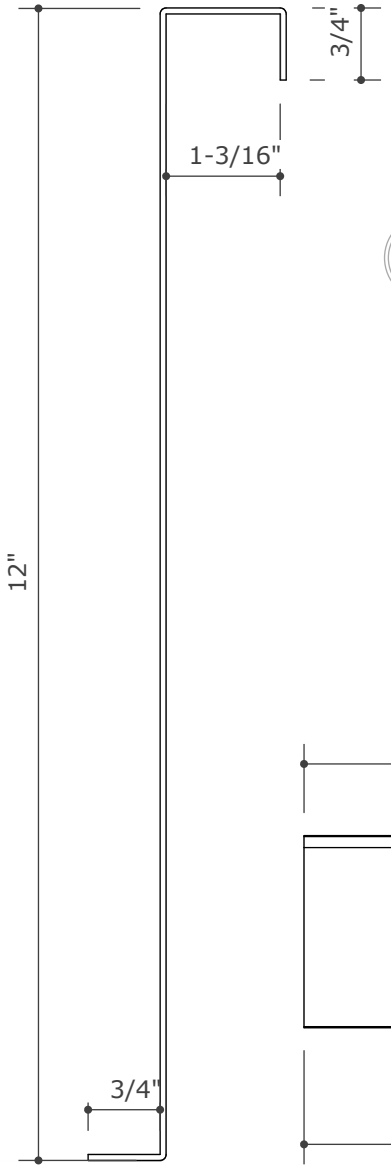
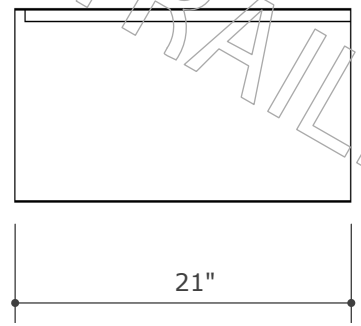
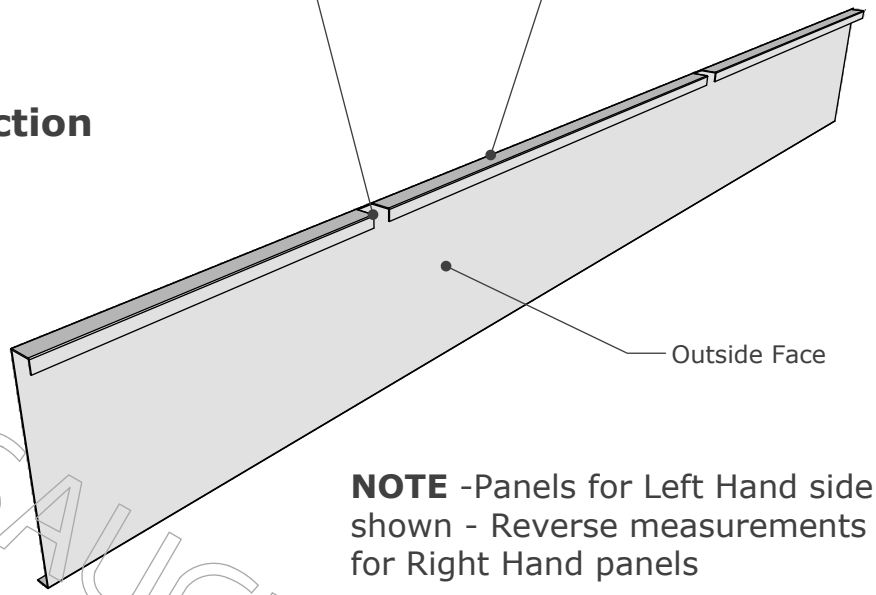
CONDUIT TUBE



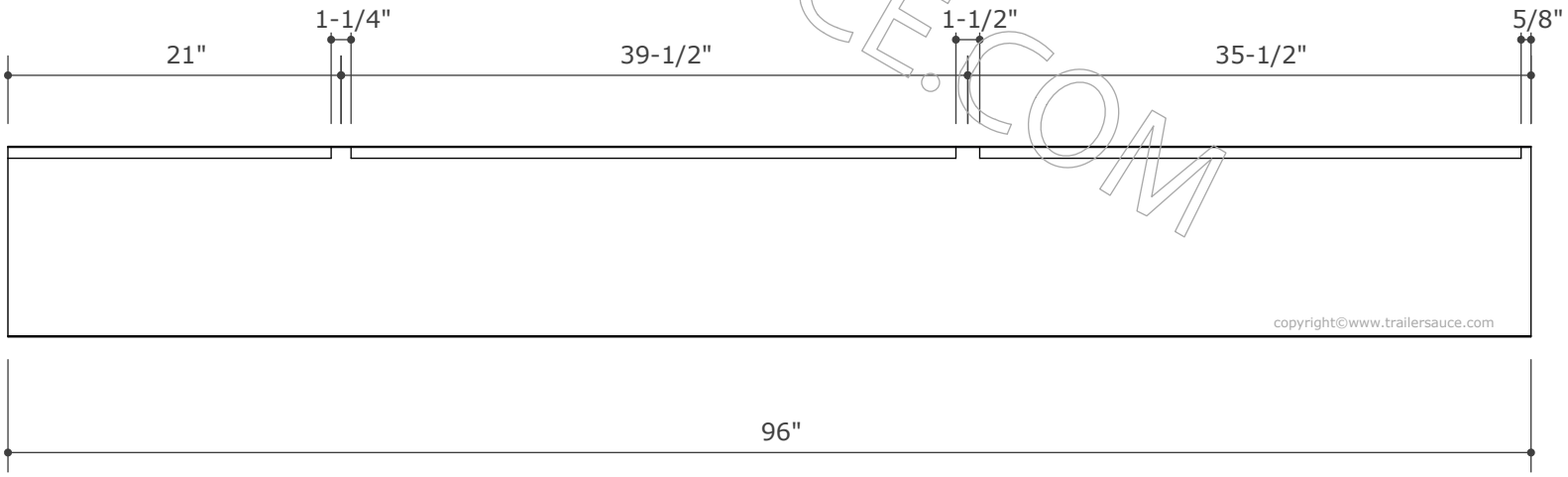
Side Panel - Rear Section

Material - 14 Gauge (0.080")





NOTE -Panels for Left Hand side shown - Reverse measurements for Right Hand panels



Side Panel - Front Section

Material - 14 Gauge (0.080")

SIDE PANELS

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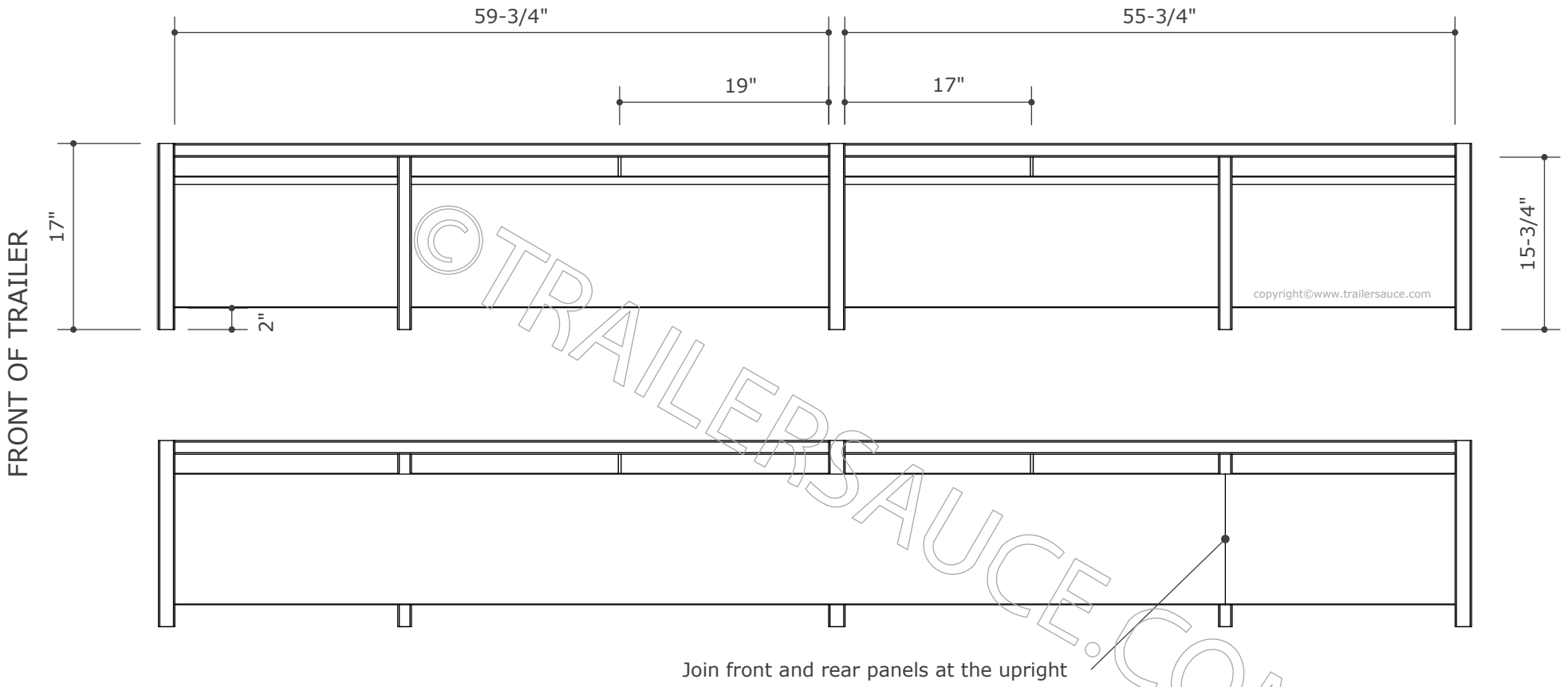

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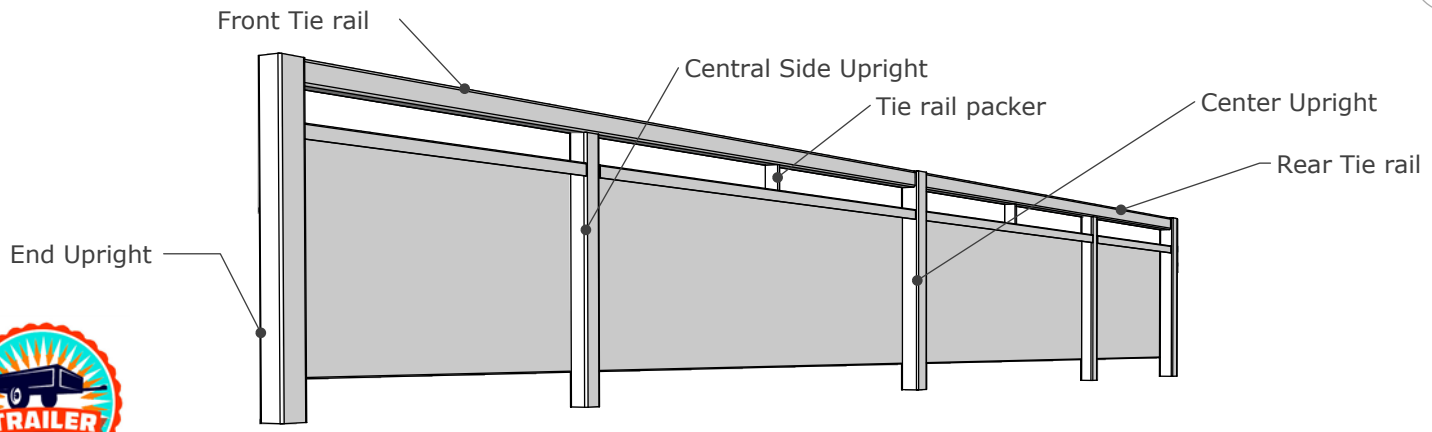
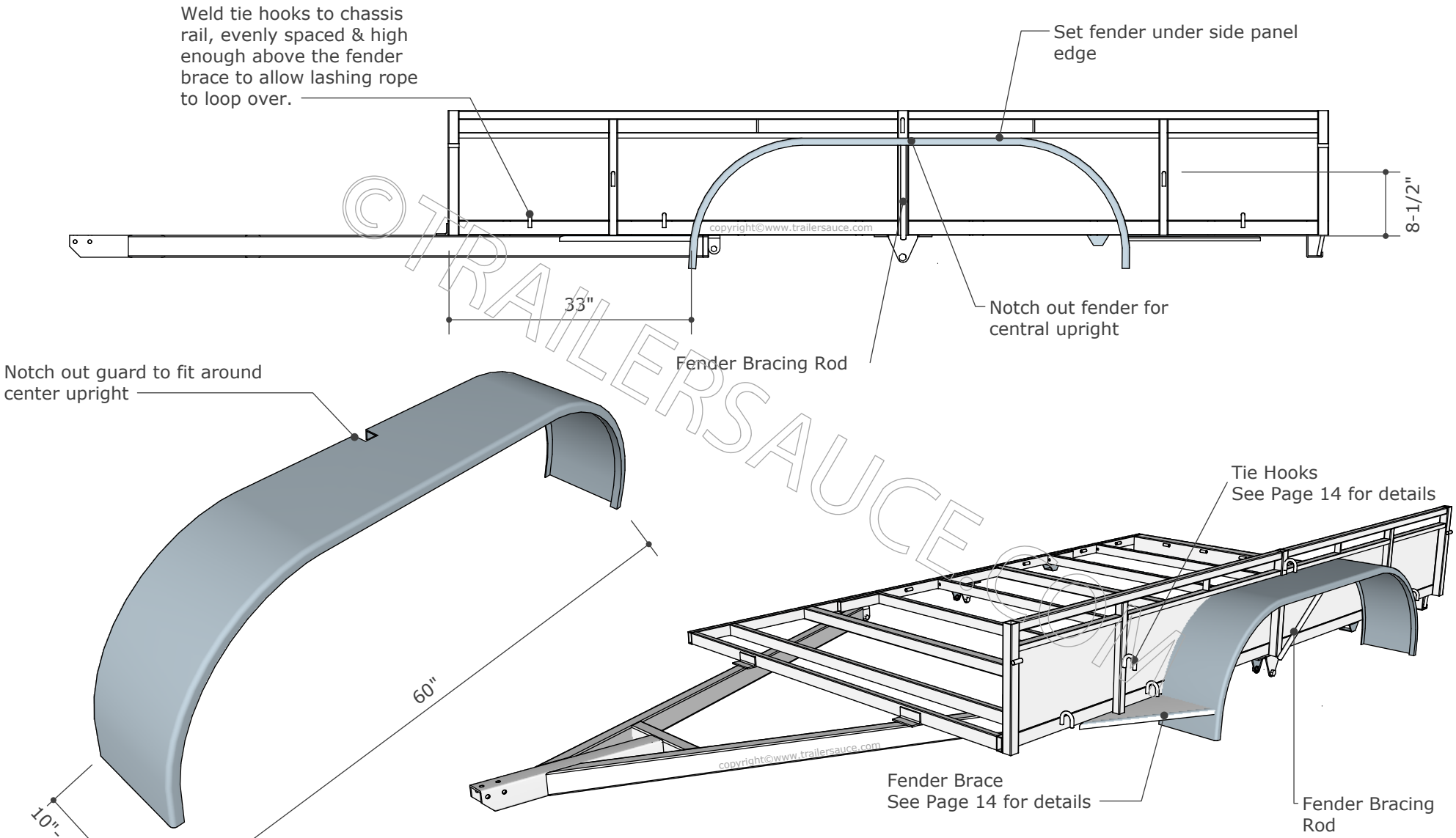


NOTE -Left Hand side shown
Reverse measurements
for Right Hand Side

SIDE DETAIL



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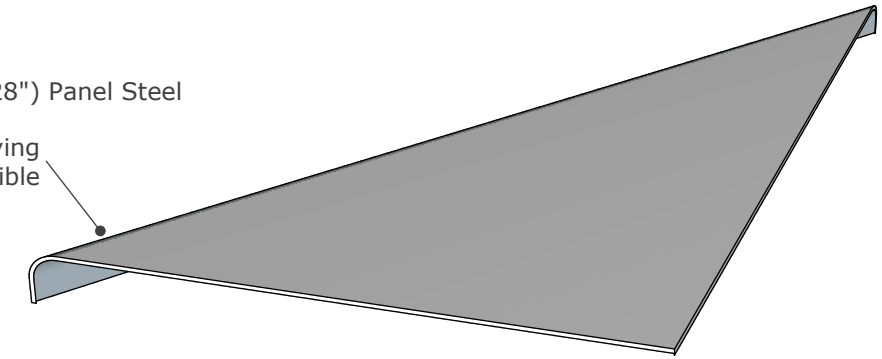
FENDER FITTING

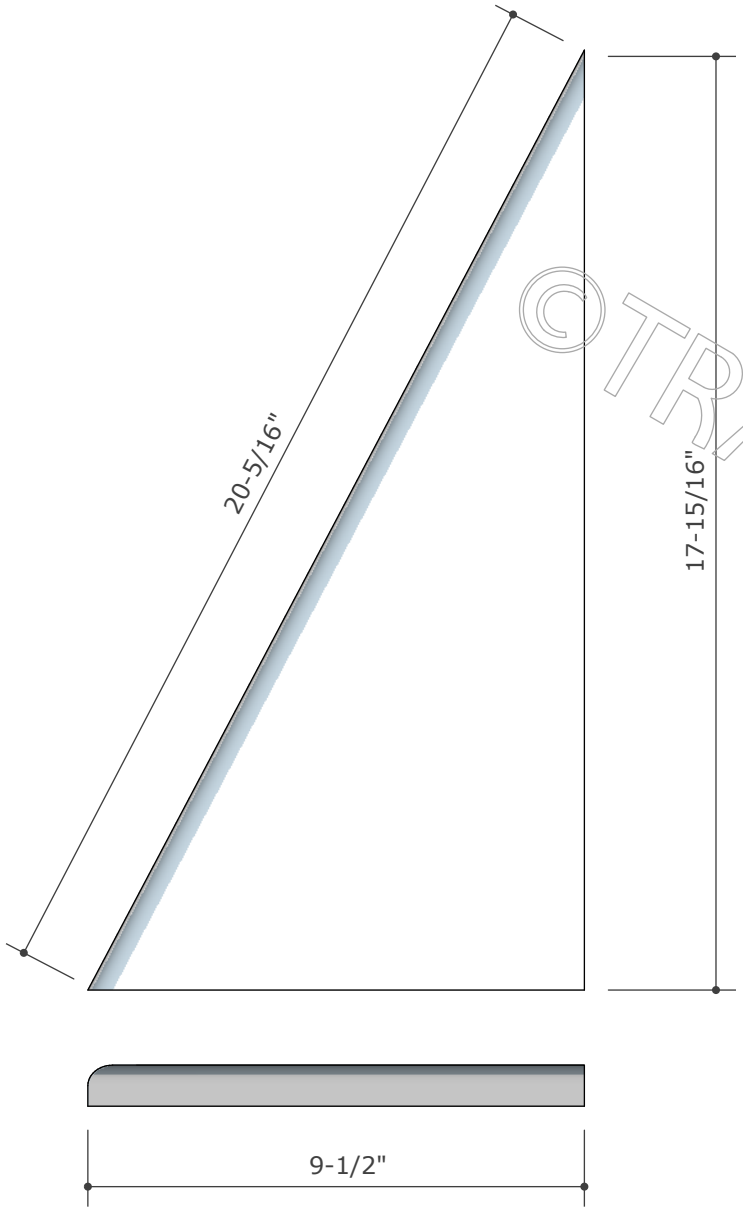
Fender Brace

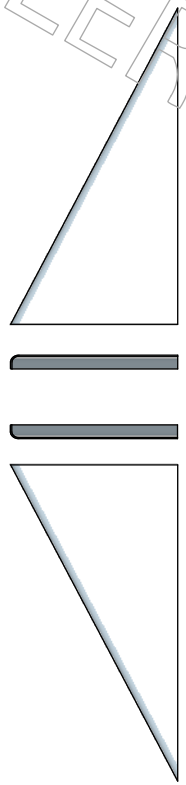
Material - 10 Gauge (0.128") Panel Steel

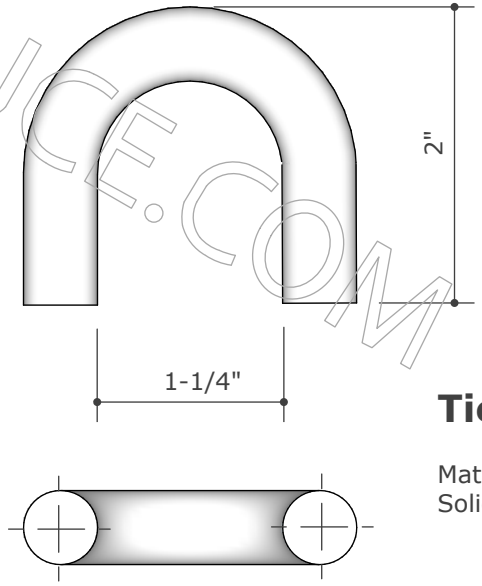
Match edge of brace to the stying of the fender edge if possible



NOTE - Fabricate 2x braces as per the main drawing and 2x braces as mirror image (reverse) as per below







Tie Hook

Material- 3/8" or 1/2"
Solid Round Bar

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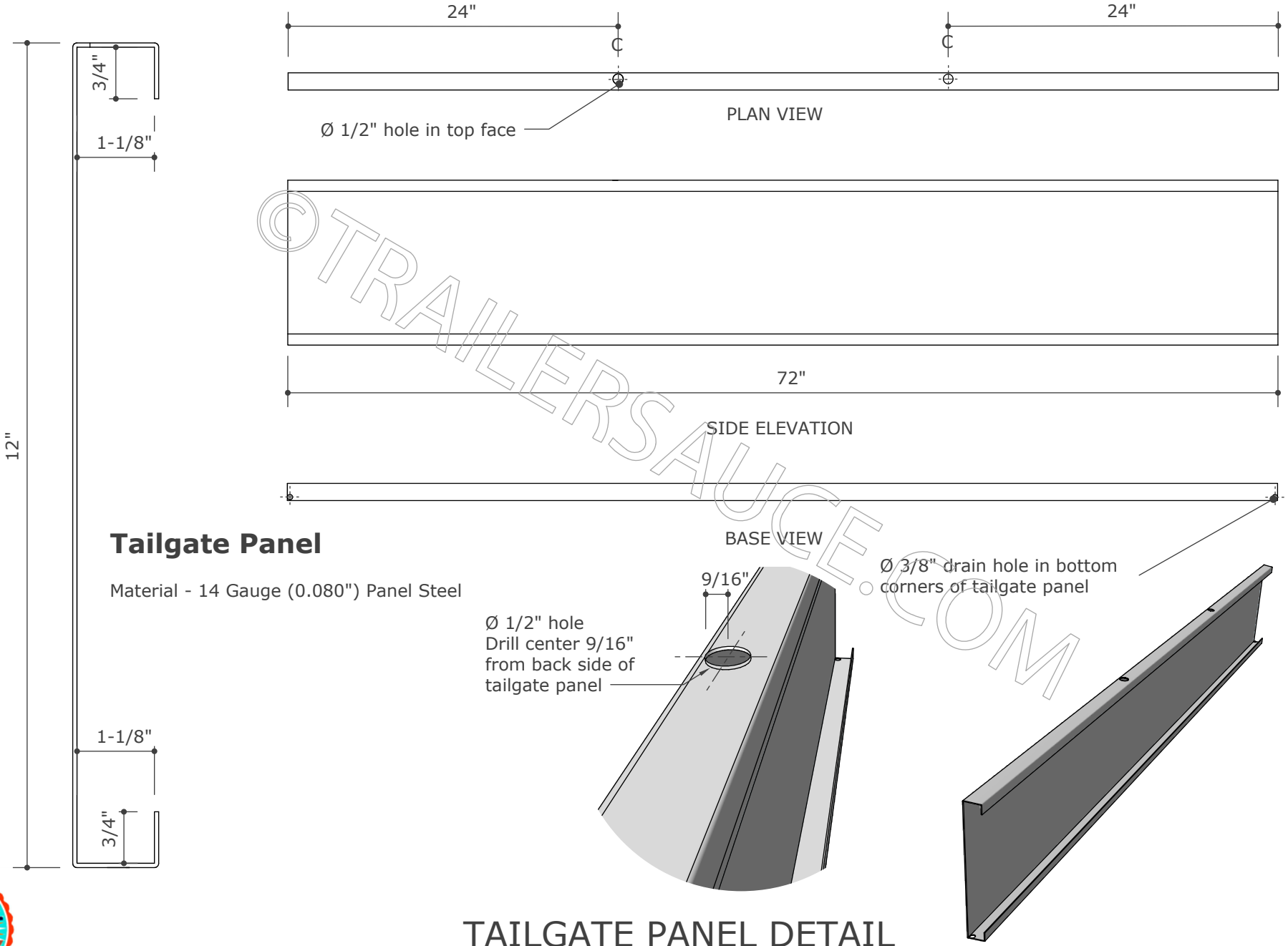

Tailgate Panel

Material - 14 Gauge (0.080") Panel Steel

TAILGATE PANEL DETAIL

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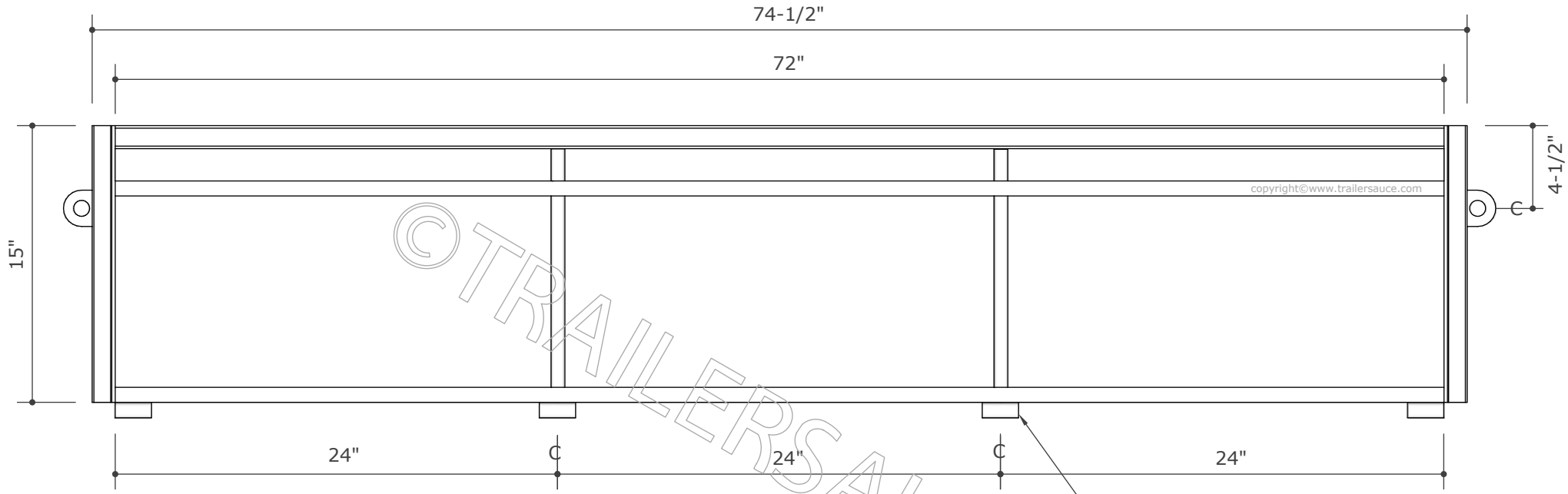

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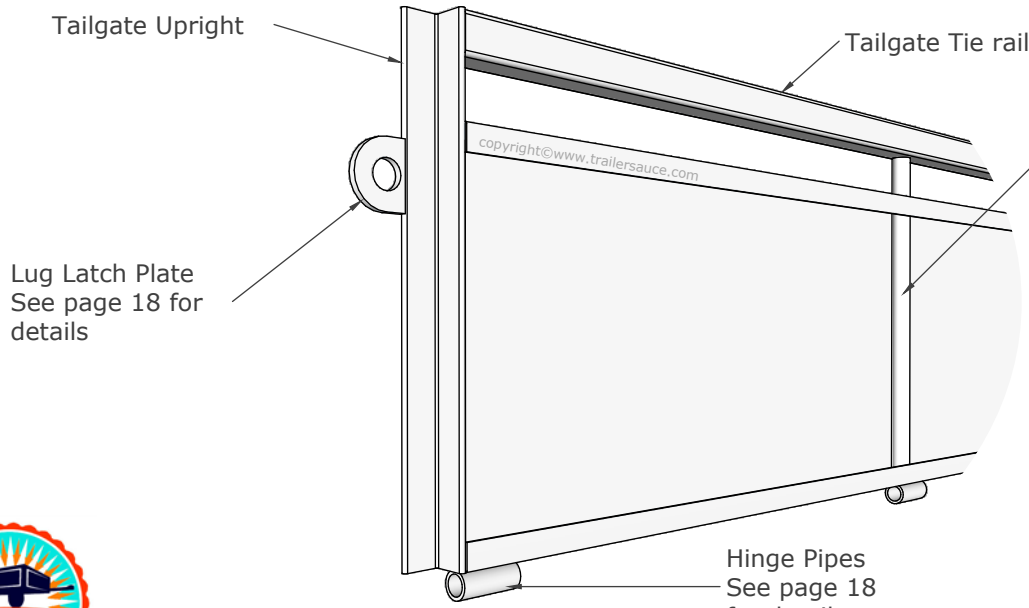
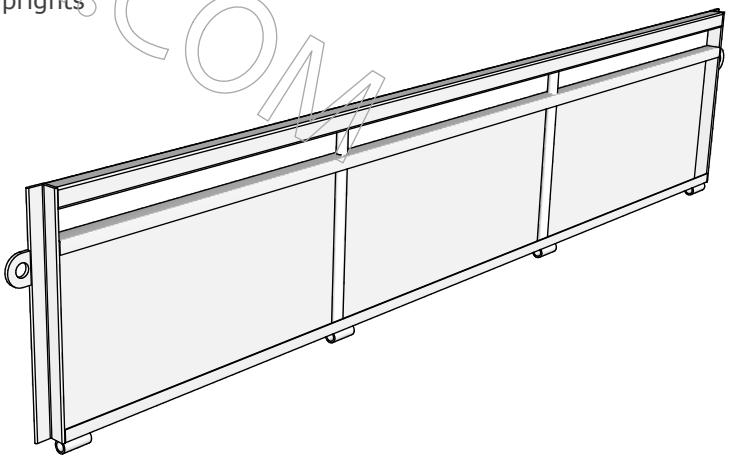
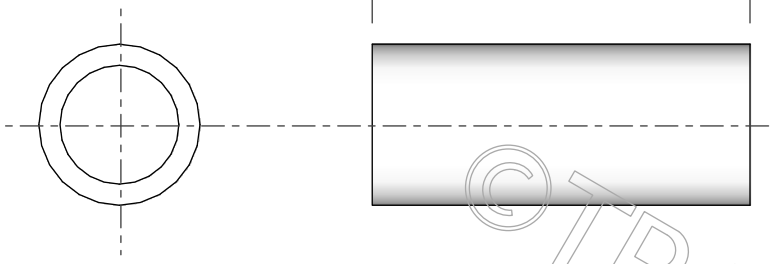
See page 19 for hinge pipe fitting details

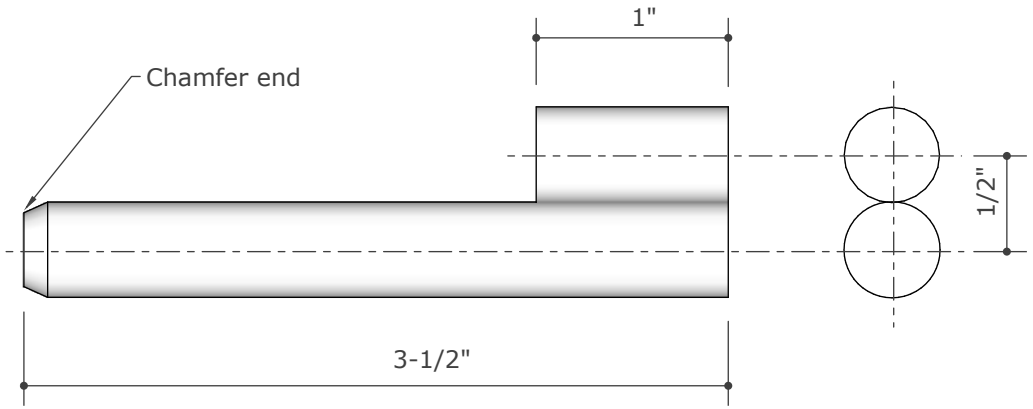






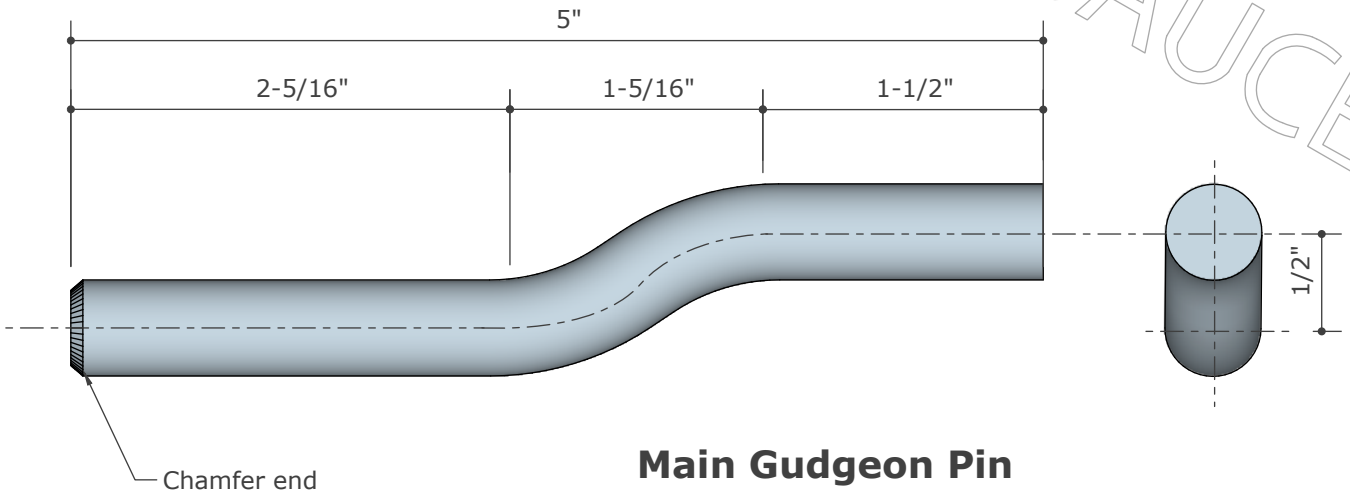
Hinge Pipe

Material - 1/2" Med Nominal Bore Pipe



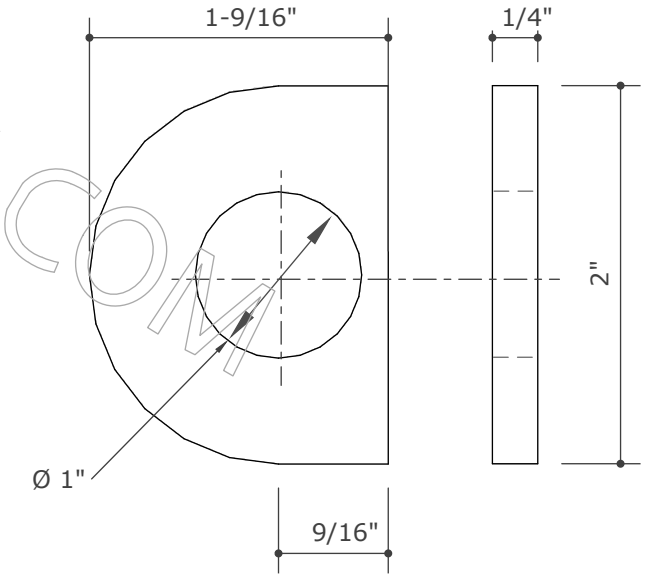
End Gudgeon Pin

Material - 1/2" Bright Round Bar



Main Gudgeon Pin

Material - 1/2" Bright Round Bar



Latch Plate

Material - 2" x 1/4" Flatbar

TAILGATE HARDWARE

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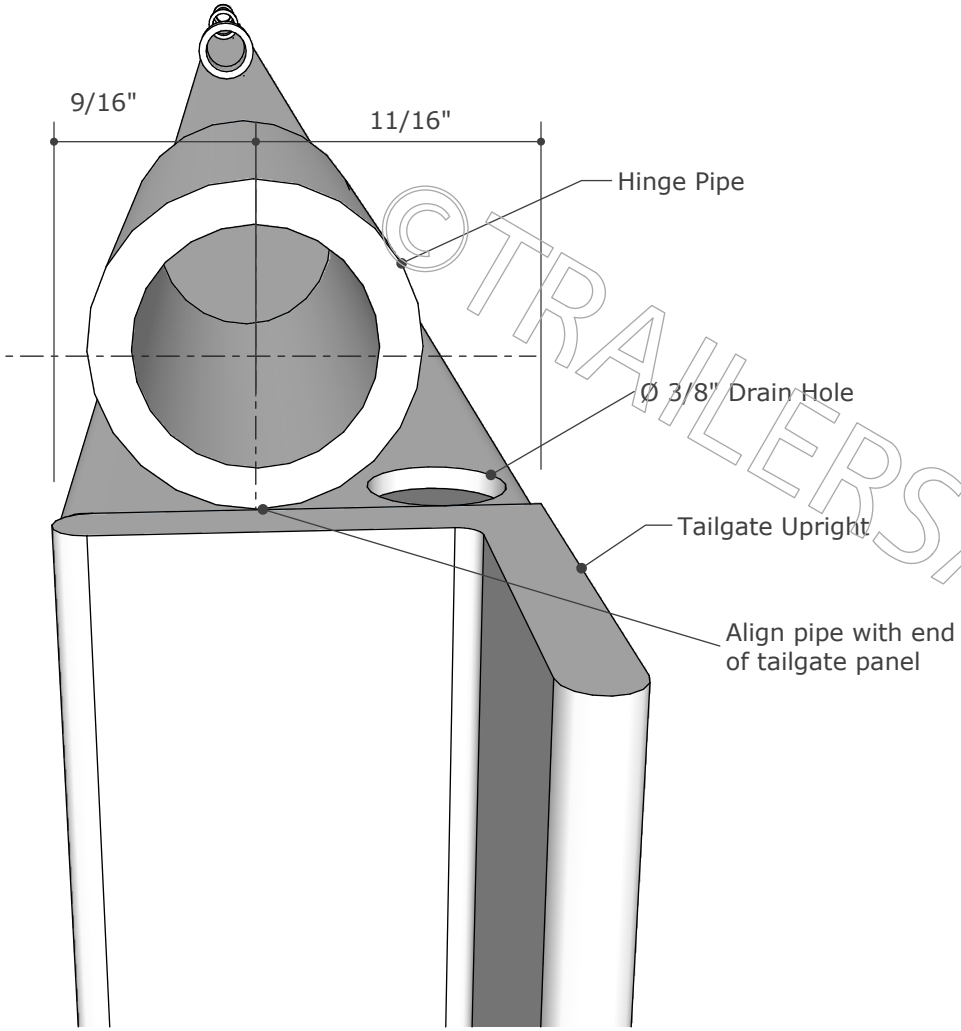

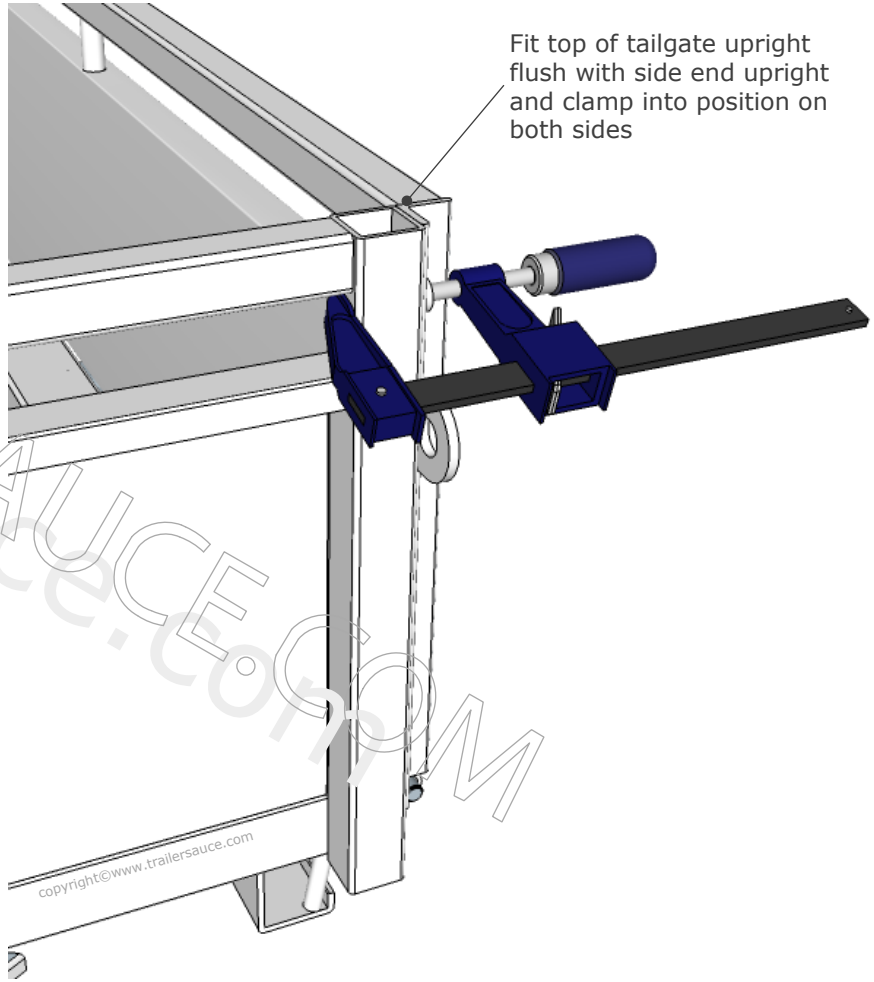

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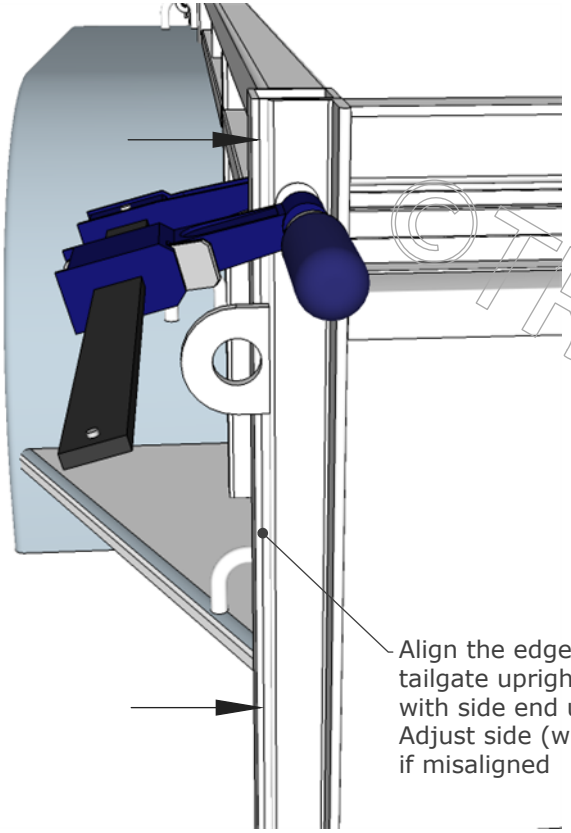
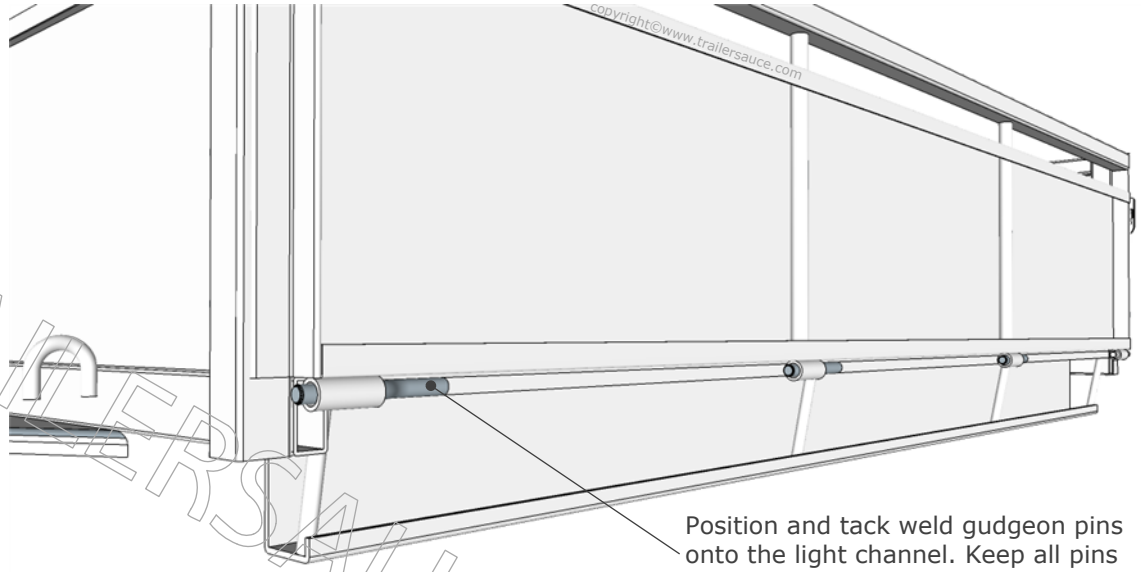
Align end hinge pipes with the end of the tailgate panel and 9/16" from outside face of tailgate to center of hinge pipe.
Tack weld securely.

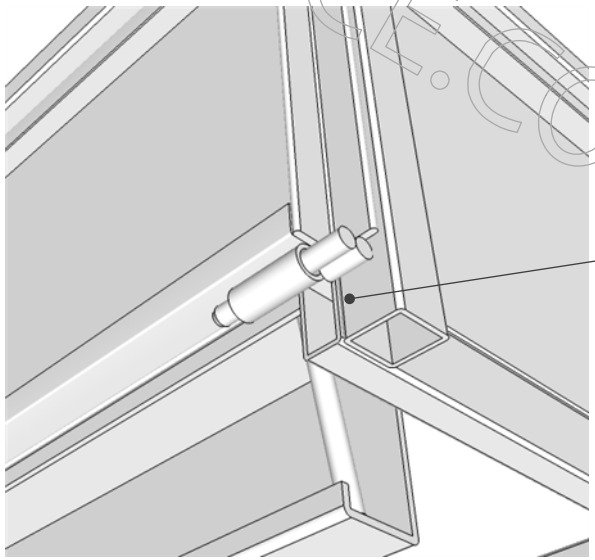
TAILGATE FITTING



Align the edge of the tailgate upright parallel with side end upright. Adjust side (with force) if misaligned



Position and tack weld gudgeon pins onto the light channel. Keep all pins in the same vertical plane.



Position and tack weld end gudgeon onto side upright

Once the gudgeon pins have been tack welded into position, unclamp tailgate & open/close tailgate checking for smooth operation. If binding or stiffness is encountered, cut tack welds on offending gudgeon pin(s) and adjust.
Repeat tailgate fitting procedure for front tailgate.

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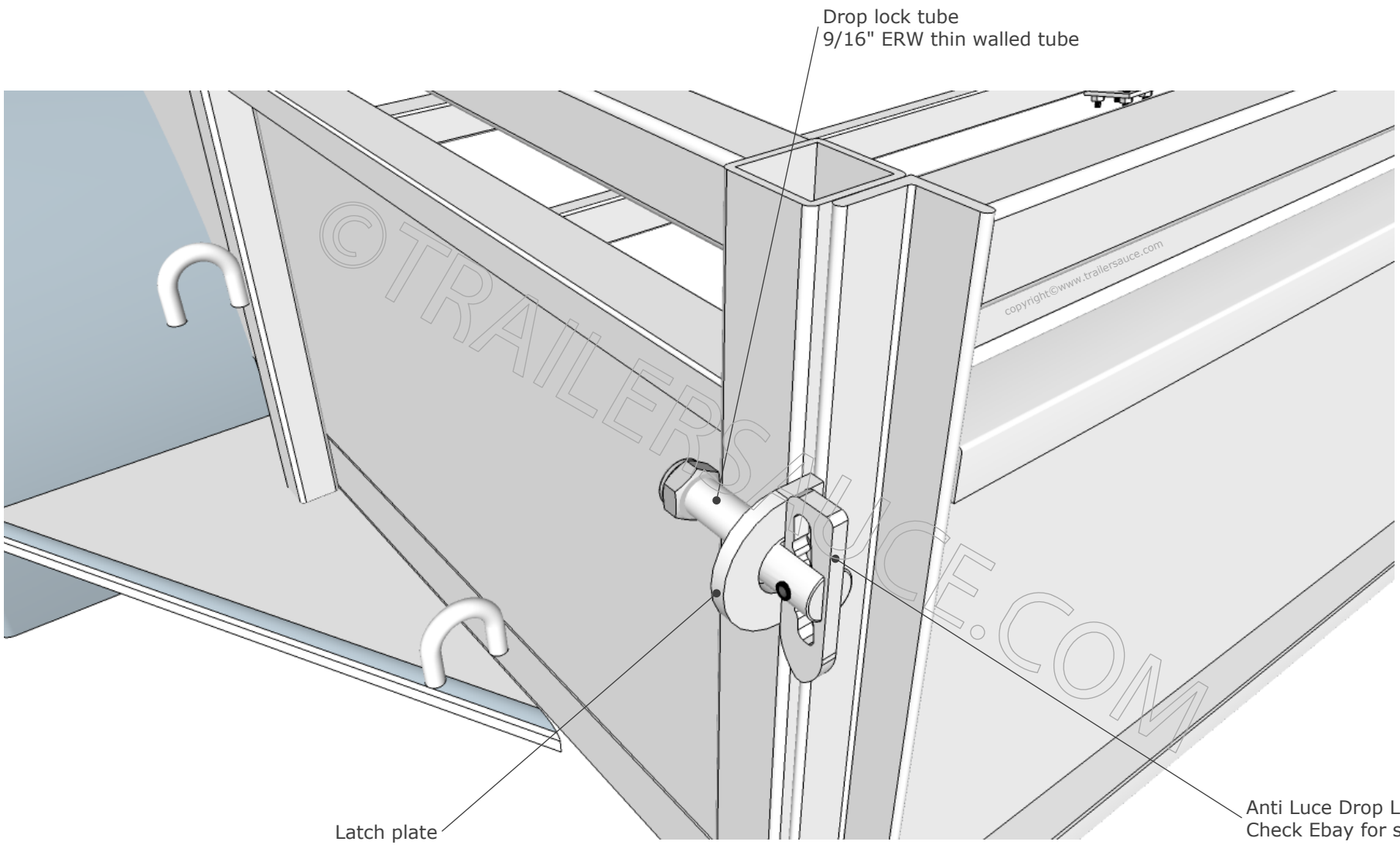
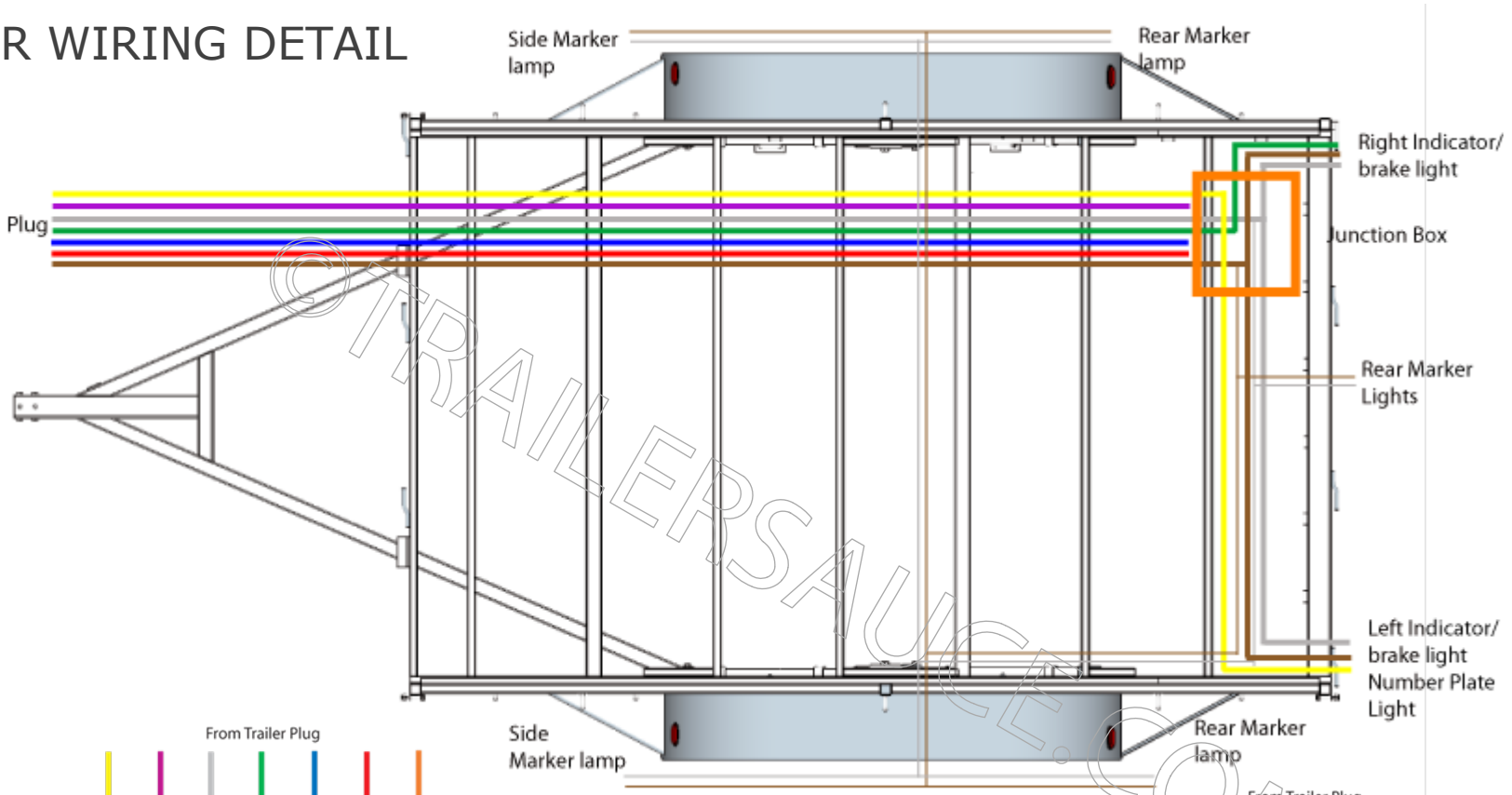


Fit the Anti Luce drop lock onto the drop lock tube and centralize within the latch plate hole. Level and tack weld drop lock tube to the side upright. Check operation of the tailgate before fully welding.

TRAILER WIRING DETAIL



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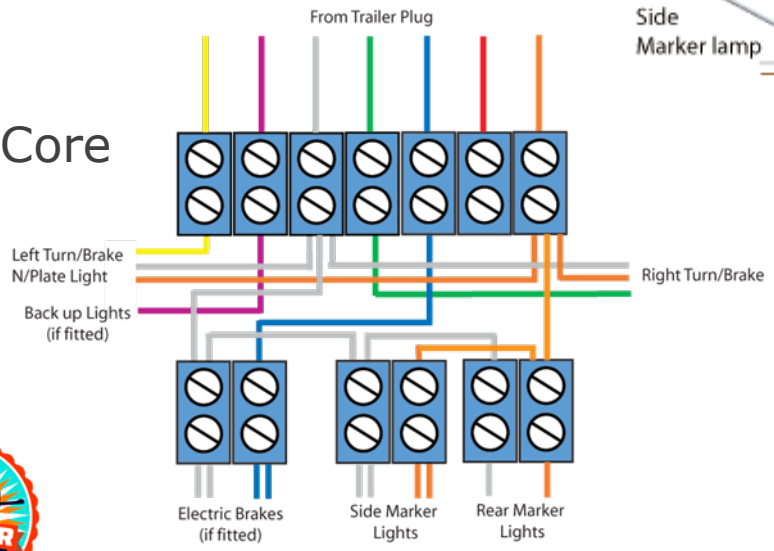
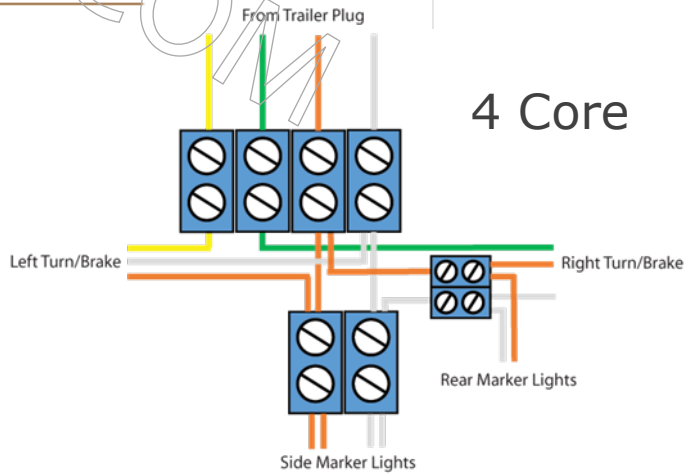
7 Core



4 Core



Junction Box Detail