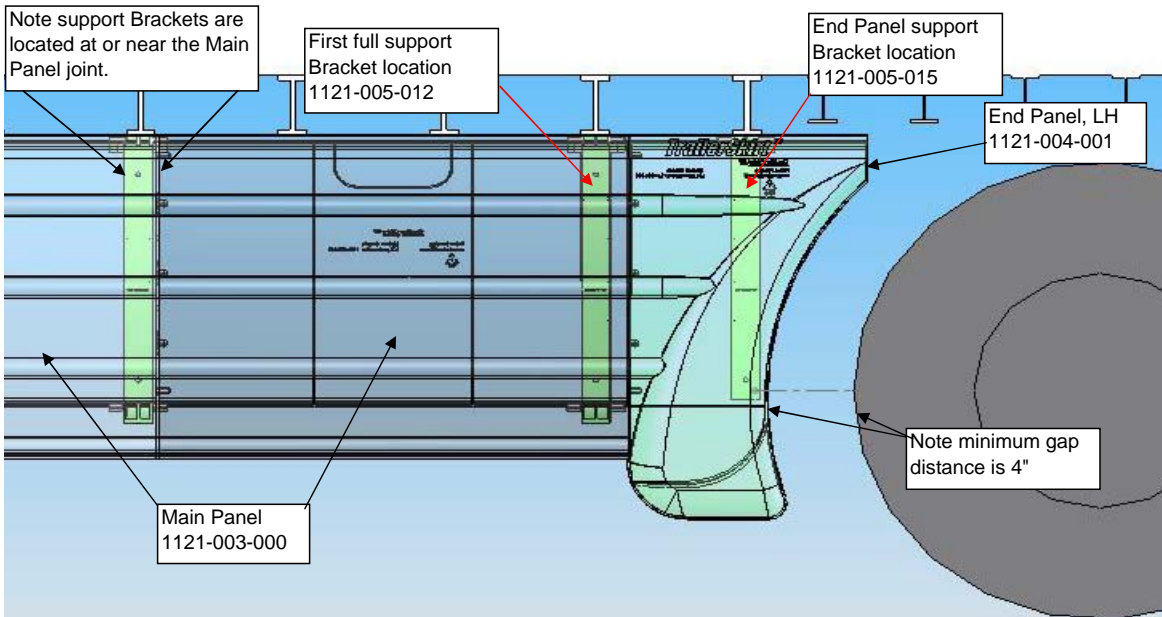
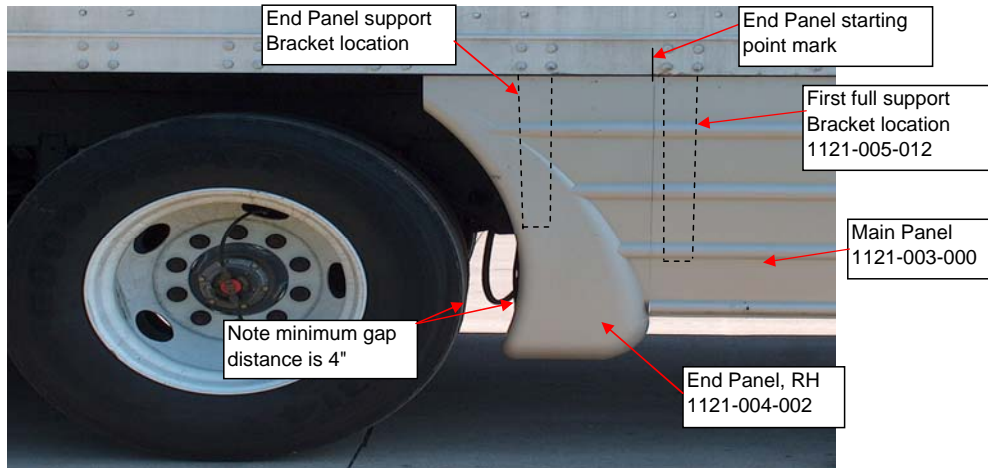


TRAILERSKIRT™ Assembly Instructions

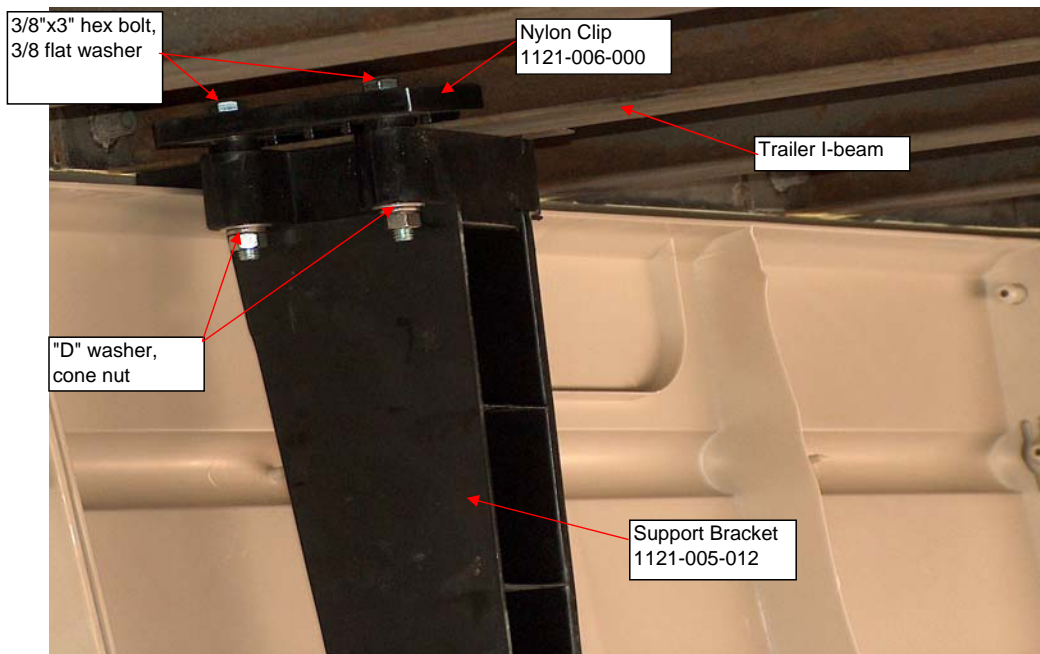
Bulk Shipped Components - Prep Centre Installation

NOTE 1: Instructions are for first trailer installation. Once Bracket location on I-beams has been established, multiple panel installation can take place.

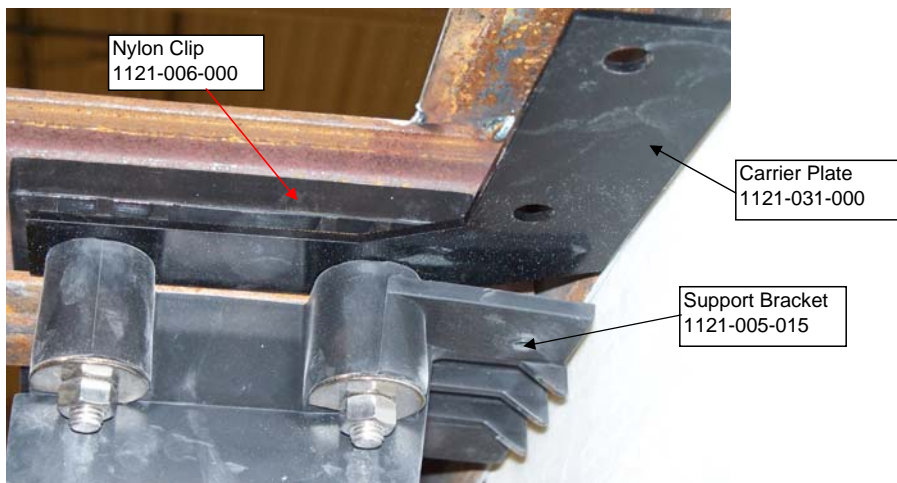
1.0 Position "bogie" wheel assembly to "California bridge position" for an 8 panel installation. If this is to be a 7 panel installation move the bogies to the most forward position. The fairing End Panel should be located 4" to 5" away from the bogie wheel assembly. Hold the End Panel in position (approximately 4" to 5" away from the "bogie" wheel) and mark the end of the panel on the trailer side rail. Locate the nearest I-beam after the mark, towards the trailer front. This is the starting point for support Bracket installation. Support Brackets are installed on every third I-beam, if they are evenly spaced 12" apart. The support Brackets should be located at or near the joint between two Main Panels. The support Brackets are installed 5/8" inboard (on the non-crank handle side) and are install inboard 5/8" at the bogies and 2-5/8" inboard at the crank handle. The four support Brackets which have the lower "claw" removed are for the End Panels. The panels may require shifting slightly to allow the support Bracket to hang within the End Panel.



Secure the support Brackets (1121-005-012 and 1121-005-015) to the trailer I-beams using two black nylon Clips (1121-006-000), 3/8"x3" hex bolts, 3/8" cone nuts, 3/8" flat washers and 3/8" "D" washers. The "D" washers are located against the support Bracket. Torque bolts to 35ft-lbs. Hardware for this step is located in kit # 1A and # 1B (Support Bracket to I-beam, TSFAS116A/B).



Note: Some trailer models have no I-beams forward of the landing gear leg support structure. If this is the case install the Carrier Plate (1121-031-000) between the Clip and the support Bracket on the last support Bracket (1121-005-015). Otherwise discard the Carrier Plate if provided.

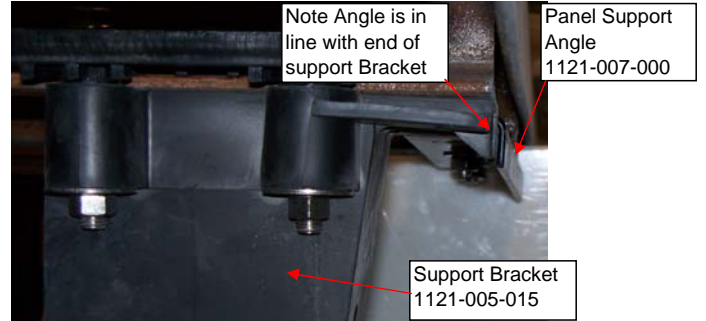
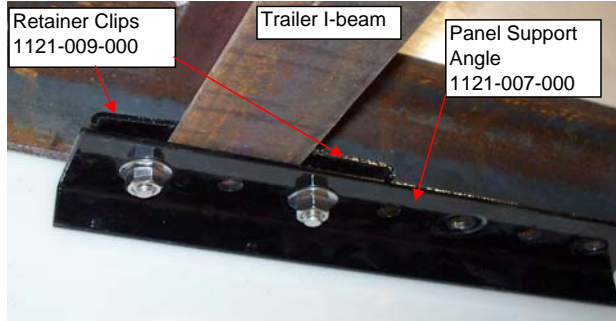


Support Bracket to I-beam Kit # 1A		TSFAS116A	QTY
Hex Bolt .375-16x 3.0 S.S.	SC217		88

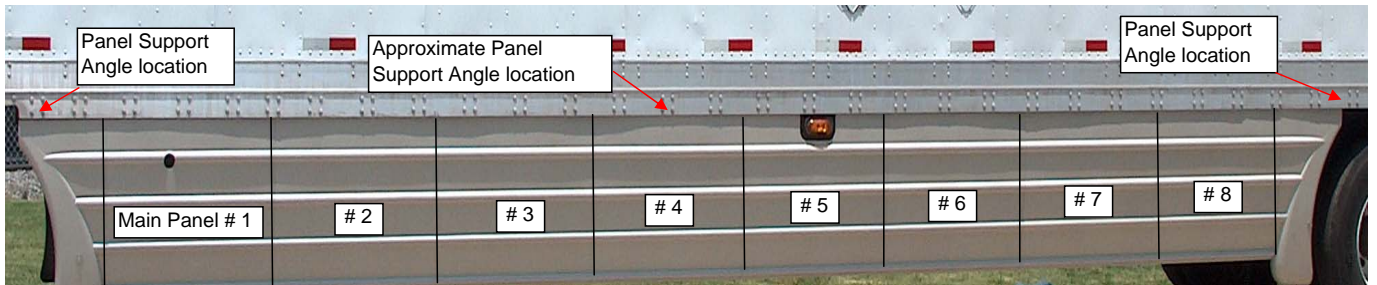
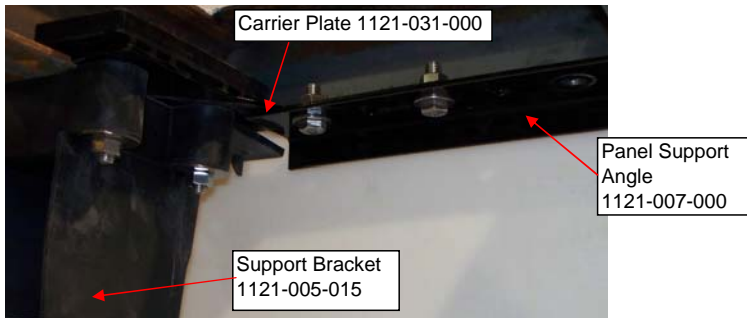
Support Bracket to I-beam Kit # 1B		TSFAS116B	QTY
Hex Cone Nut .375-16 D-N Zn	NU210		88
Flat Washer .375 S.S.	WA206		88
"D" Fender Washer .375 (1.125OD) S.S.	WA225		88

Also Required			QTY
Support Bracket	1121-005-012		18
Support Bracket - "claw" removed	1121-005-015		4
Nylon Clip	1121-006-000		44
Carrier Plate (for some models)	1121-031-000		2

2.0 Assemble Panel Support Angles (1121-007-000) to the trailer I-beams (six locations), using hardware kit # 2 (Panel Support to I-beam, TSFAS117). The Panel Support Angle is a roughly 12" long steel "L" with several holes in one side. The shorter leg is assembled in line with the end of the Support Bracket, or 5/8" inboard from the trailer side rail. The Panel Supports are located at each End Panel and at the approximate middle of the Panel assembly. Use 3/8"x 1.25"hex bolts, 3/8" Cone nuts and 3/8" washers. Torque bolts to 35 ft-lbs.



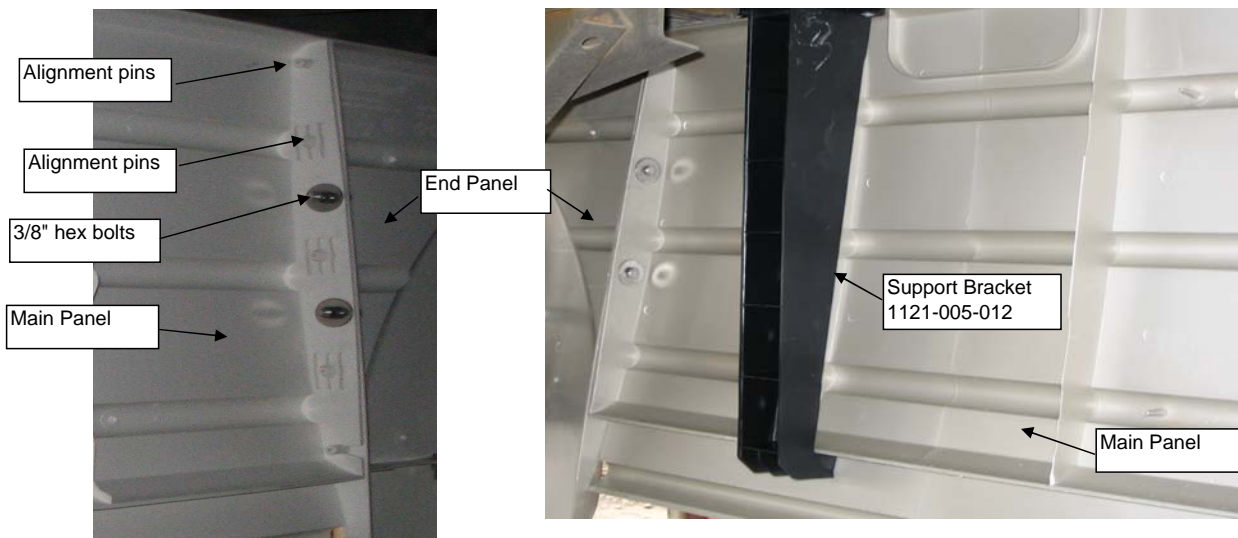
Note: If Carrier Plate is used, bolt Panel support Angle to Carrier Plate as shown below.



Panel Support to I-beam Kit # 2		TSFAS117	QTY
Hex Bolt .375-16x1.25 S.S.		SC212	12
Hex Cone Nut .375-16 D-N Zn		NU210	12
Flat Washer .375 S.S.		WA206	24

Also Required			QTY
Panel Support Angle (steel)	1121-007-000		6
End Panel Retainer Clip (steel)	1121-009-000		12

3.0 Assemble the Main and End Panels to support Brackets. Off the trailer (on a clean work bench is fine) align the male pins in the main panel with the holes in the end panel. Squeeze the panels together to engage the pins. Install two 3/8-16 x 1.25" hex bolts, with large fender washers, into the pre-drilled holes in the connection flange between the two panels. Tighten bolts, washers, hex nuts to 35ft-lbs.



Lift the assembly into position and slide the Main Panel to engage the upper and lower support Bracket "claws" with the upper and lower flanges of the Main Panel. The End Panel will be engaged with the upper "claw" and Panel Support Angle only. Continue engaging panels onto the support Brackets and bolting them to the previous Panel.

Once you reach the Side Marker light, stop. Remove the light from its holder and remove the holder from the trailer. Using the holder as a template mark the light outline on the Main Panel. This is often in the upper right or left corner of the panel. Cut out the light hole in the Main Panel using a jigsaw. Some models have rivet flanges, while others have a rubber grommet. Install the Side Marker light to the panel and continue engaging the Main Panels to the support Brackets.

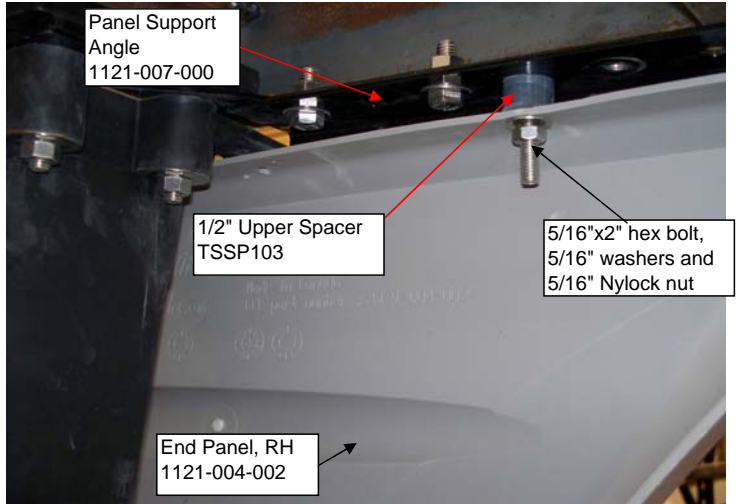
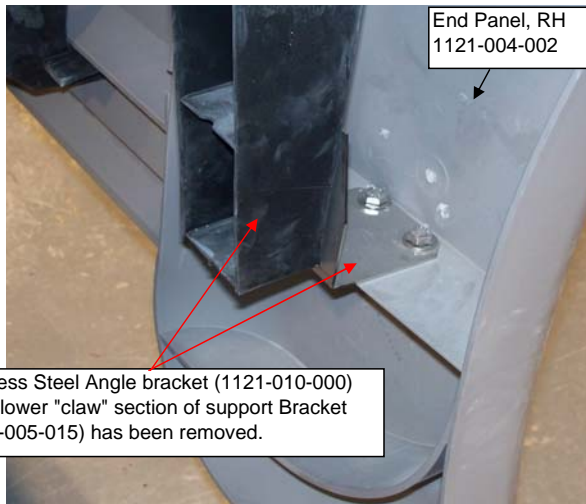
Note: As the Main Panels are installed, before covering the landing gear crank shaft, record the location of the crank shaft and remove the handle.



Panel Connection Kit # 3		TSFAS118	QTY
Hex Bolt .375-16x1.25 S.S.		SC212	36
Hex Cone Nut .375-16 D-N Zn		NU210	36
Fender Washer .375 (1.125OD) S.S.		WA216	72

Also Required			QTY
Main Panels	1121-003-000		16
End Panel - LH	1121-004-001		2
End Panel - RH	1121-004-002		2

4.0 From the backside of the End Panels connect the End Panel to the support Bracket using Hardware Kit # 4 (TSFAS119, End Panel to Panel Support). Place the Stainless Steel angle 1121-010-000 against the front face of the support Bracket, 1121-005-015 and the rear face of the End Panel -RH, 1121-004-002. The S.S. angle has two 5/16" holes on one side. This side should be sitting on top of the lower flange of the End Panel. Connect the S.S. Angle to the support Bracket with a 3/8"x1.25" hex bolt, 3/8" washers and 3/8" cone nut. Mark the two 5/16" holes on the End Panel flange using the S.S. Angle as a template. Push the panel out of the way and drill the two 11/32" holes. Connect the S.S. Angle to the End Panel with two 5/16"x1" hex bolts, 5/16" washers and 5/16" Nylock nuts.

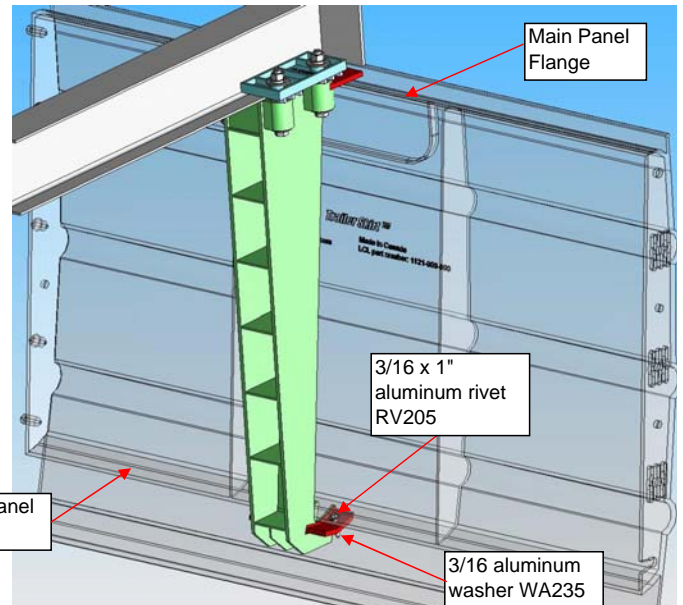
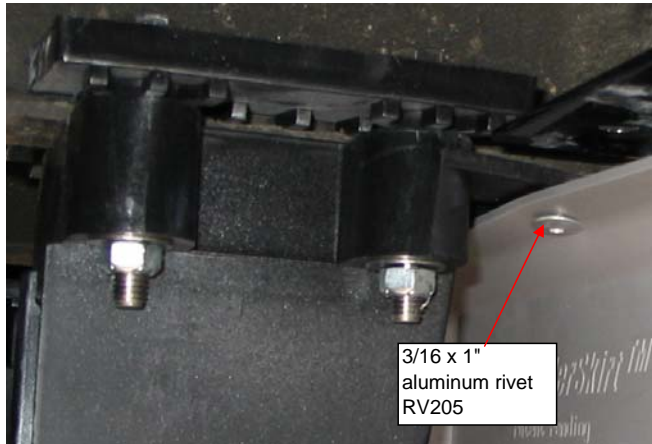


Now locate an open hole in the Panel Support Angle (1121-007-000) and drill an 11/32" hole in the upper flange of the End Panel to align with the hole in the Panel Support Angle. Install a 5/16"x2" hex bolt and washer from the Panel Support Angle, 1/2" (grey ABS) Upper Spacer, TSSP103, and the End Panel flange. Complete the connection with a 5/16" washer and Nylock nut. Tighten to 35ft-lbs.

Note: The two middle Panel Support Angles are connected to the Main Panel in the same manner as above., at roughly the center of the trailer.

End Panel to Panel Support Kit # 4	TSFAS119	QTY
Hex Bolt .375-16x1.25 S.S.	SC212	4
Hex Cone Nut .375-16 D-N Zn	NU210	4
Flat Washer .375 S.S.	WA206	8
Hex Bolt .313-18x1.0 S.S.	SC224	8
Hex Bolt .313-18x2.0 S.S.(Full thread)	SC220	6
Hex Nylock Nut .313-18 D-N S.S.	NU208	14
Lock Washer .313 S.S.	WA214	14
Flat Washer .313 S.S.	WA213	28
1/2" ABS Pipe upper spacer	TSSP103	6
Also Required		
S.S. Angle Bracket	1121-010-000	4

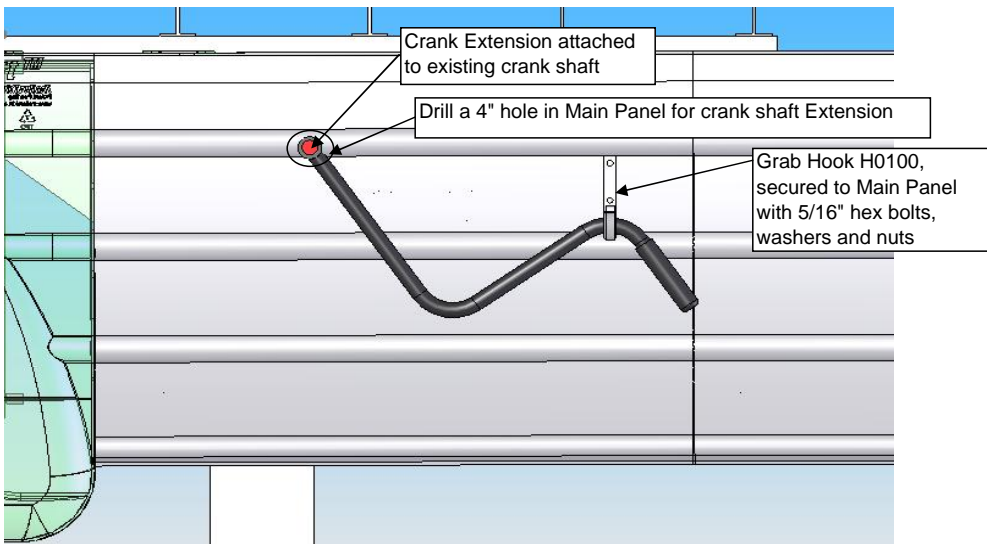
5.0 From the backside of the End Panels and Main Panels secure support Brackets, 1121-005-012 to Main Panels 1121-003-000 using Hardware Kit # 5 (Panel to Support Bracket, TSFAS120). Drill 7/32" holes into the upper flange of the Main Panel and through the side flange of the support Bracket. Insert a 3/16" rivet. Place a 3/16" washer on the other end of the rivet and crimp the two surfaces together. Repeat for the other side flange and the two lower flanges of the support Bracket. Note the End Panel support Brackets do not have lower flanges.



Panel to Support Bracket Kit # 5	TSFAS120	QTY
Aluminum Large Head rivet 3/16"x1"	RV205	80
Aluminum Washer - backup 3/16 rivet	WA235	80

6.0 Install Crank Handle Extension using Hardware Kit # 6 (Crank Handle, TSFAS121). Locate the center of the landing gear crank shaft. Drill a 4" diameter hole through the Main panel, 1121-003-000. Insert the Crank Shaft Extension, 1121-025-001, through the hole and engage the existing crank shaft. Choose a hole in the Crank Shaft Extension which would allow the shaft to protrude beyond the Main Panel so that the Crank Handle will be free to rotate. Secure the Extension in place with a 3/8"x2" hex bolt, 3/8" washers and 3/8" cone Nut. Reinstall the crank handle to the Crank Extension.

Install the Grab Hook to the Main panel, such that the hook will secure the crank handle in place. Use two 5/16"x2" hex bolts, 5/16" washers and 5/16" Nylock nuts.

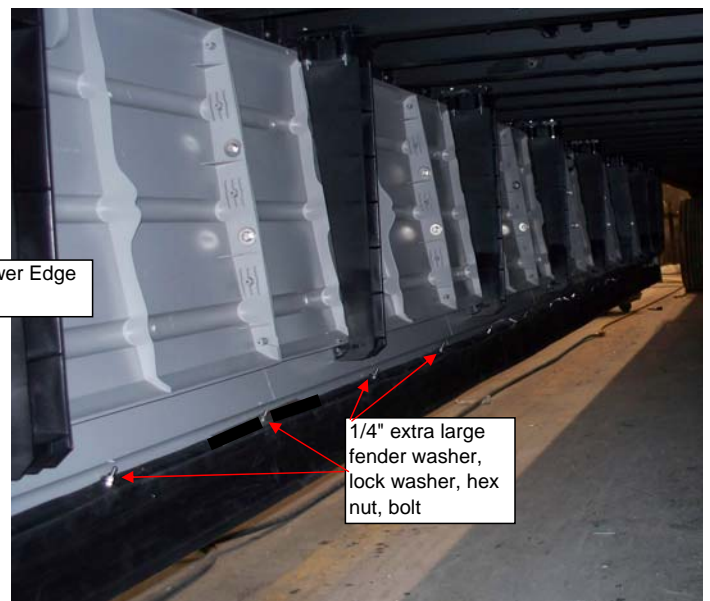
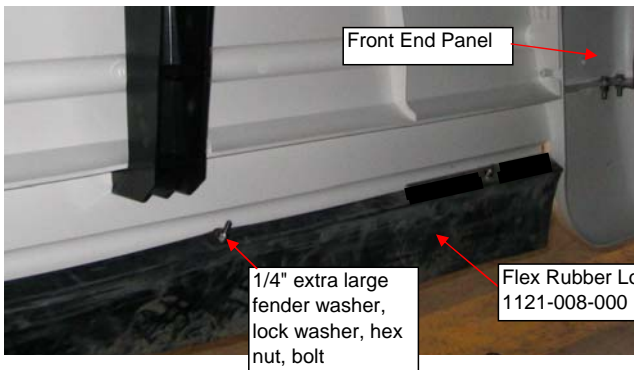


Crank Handle Kit # 6	TSFAS121	QTY
Hex Bolt .375-16x 2.0 S.S.	SC223	1
Hex Cone Nut .375-16 D-N Zn	NU210	1
Flat Washer .375 S.S.	WA206	2
Hex Bolt .313-18x2.0 S.S.(Full thread)	SC220	2
Hex Nylock Nut .313-18 D-N S.S.	NU208	2
Flat Washer .313 S.S.	WA213	4
Grab Hook	H0100	1

7.0 Install the Flexible rubber lower edge using Flex Edge Kit # 7B (TSFAS115B), Flex rubber (1121-008-000). Beginning at the Main panel closest to the front End Panel, hold the short end of the Flex rubber against the lowest inside flange of the Main Panel. Note that the Main Panel flange is not flat. Using the hole in the end of the rubber (approximately 6" from the end) as a guide, drill a 1/4" hole as close to vertical as possible in the Main Panel lower flange. Insert from the front side of the Main Panel a 1/4" button head bolt with a 1/4" fender washer. The bolt should pass through the Main Panel and flex rubber. Install 1/4" large fender flat washer, lock washer and hex nut. Pull rubber tight and tighten hex nut. Holding the end of the rubber against the skirt flange drill an additional 1/4" hole through the rubber and Main Panel. Install 1/4" button head bolt as above and tighten.

Move to the next hole in the flex rubber. While pulling the rubber tight, drill a 1/4" hole in the lower flange. From the front install a 1/4" button head bolt and fender washer through the Main Panel and hole in the rubber. Install the extra large fender washer, lock washer and hex nut. Pull rubber tight and tighten hex nut. Continue as above until the end of the rubber is reached.

Note: if less than 8 Main Panels have been installed on the trailer then the flex rubber must be cut down to size. Also a new hole will have to be drilled in the end of the rubber.



Flex Skirt Bag	TSFAS115B	QTY
Button Socket Cap SS 1/4-20x1-1/4	SC221	40
Hex Nut 1/4"-20 D-N S.S.	NU203	40
Flat washer 1/4" (5/8"OD) S.S.	WA208	40
Lock Washer .250 S.S.	WA209	40
Fender Washer .34"ID (1"OD) S.S.	WA201	40

Also Required		QTY
Flex Skirt - 300"	1121-008-000	2