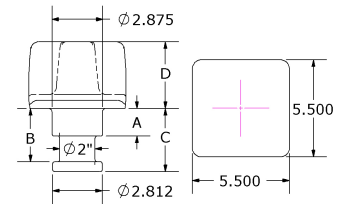
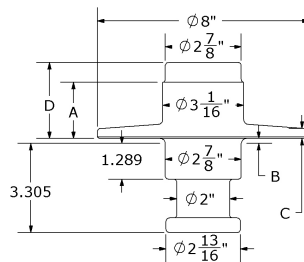
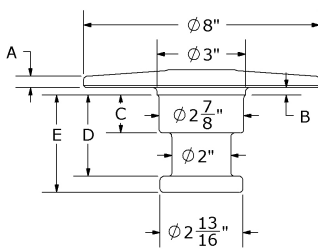
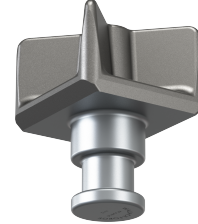
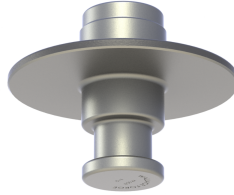


KINGPINS

Wallace Forge Co.
3700 Georgetown Rd.
Canton, Ohio

Phone: 330-488-1203
Fax: 330-488-1217
www.WallaceForge.com



INSTALLATION AND MAINTENANCE

WARNINGS

1. Standard SAE dimensional tolerances apply to all of the dimensions.
2. Wallace Forge 2" diameter kingpins are not for off the road equipment. A 3-1/2" diameter.
3. Kingpins are forged out of 8630 alloy steel and heat treated to 302-363 Brinell, Unless otherwise noted.
4. Wallace Forge kingpins will hold approximately 150,000 PSI ultimate and yield strength.
5. All kingpin and 100% Brinell hardness checked, magnetic particle inspected, and weldable.
6. Rockwell reading may be different as there may be some surface carbonization.
7. The use of a lube plate alters the kingpin dimensions from SAE standards and may prevent proper coupling.
8. If the kingpin is not securely mounted rapid wear will occur.

WELDING RECOMMENDATIONS

1. Welding procedures should be in accordance with those published by the American Weld Society or other technical groups. All welding personnel should be properly trained and certified.
2. Proper bracing should be ensured, and in accordance with SAE J133.
3. The area being welded must be clean to the bare metal. The area must be free of paint, scale, dirt, or other foreign substances.
4. Preheat approximately one inch of the eight inch diameter at the base of the kingpin and mounting surface to 400° – 500°F. This is your welding area.
5. Low hydrogen welding rod (5/32") or low carbon wire (.045") should be used.
6. A welding procedure which alternates from side to side and minimizes wear buildup is recommended to avoid distortions.
7. Surrounding area, and welded area should be normalized to 600°F and allowed to slowly cool.
8. Inspect weld to ensure that it is free of cracks and slag inclusions.

INSPECTION AND MAINTENANCE

All instructions are based on SAE J2228 recommendations.

1. Inspect the kingpin for damage before every use. If any nicks, cracks, deformations, or gouges are noticed the trailer should not be operated, and the king pin should be replaced immediately.
2. If kingpin is worn more than a 1/8" (.125") on 2" or 2.88" kingpin should be replaced.
3. Check straightness of kingpin and upper coupler plate. An uneven kingpin or coupling plate can cause kingpin to not lock properly, or cause excessive wear.
4. Do not modify or add to any product.