Step One

- Place cut away from the collar.
- Strain sheet shall be used to replace the skin.
- Complete the welds.
- A certified welder shall perform all welding.
- Structural welding code for steel - AWS D1-90.

Step Two

- 3/16" steel sheet with a 55,000 psi minimum yield.
- A certified welder shall perform all welding.
- Structure welding code for steel - AWS D1-90.

Step Three

- Identify strut cart that needs to be repaired.
- Carefully cut out the roller housing and plate.
- Make sure that the roller pin does not get damaged.

Step Four

- Remove the roller assembly from the housing.
- Put new pivoting roller assembly on roller pin note.
- Welding required on the pivoting roller assembly.

Step Five

- Weld replacement housing plate to the outside of the housing unit.
- This assembly is to move freely inside the housing.
- No welding required on pivoting roller assembly.
- Plate to pin
- Plate 10 Pin
- 3/16