



To: Repair Facilities
Subject: Front frame inspection and repair

Step #1: Identification and inspection

- Verify the trailer VIN number agrees with master list of effected units
- Visually inspect the identified area of concern. Clean thoroughly, check for any presence of cracking
- If trailer VIN is confirmed to be subject of this recall, proceed to appropriate repair and modification instructions. If trailer VIN number is not on the recall list, immediately contact Polar Customer Service for appropriate actions.

Step #2: Repair procedure, if no cracks are detected

- if no cracks are detected, repair will consist of the addition of a reinforcement kit
- installation instructions, part numbers, and installation drawing for the reinforcement kit are attached

Step #3: Repair procedure, if cracks are detected.

- If cracks are detected, repair may consist of replacement of the entire front frame.
- Detailed photos showing the location and extent of cracks must be immediately sent to Polar Customer Service, to obtain verification that front frame must be replaced.
- Installation instructions, part numbers, and installation drawing for the frame replacement are attached.

Caution / other questions or concerns:

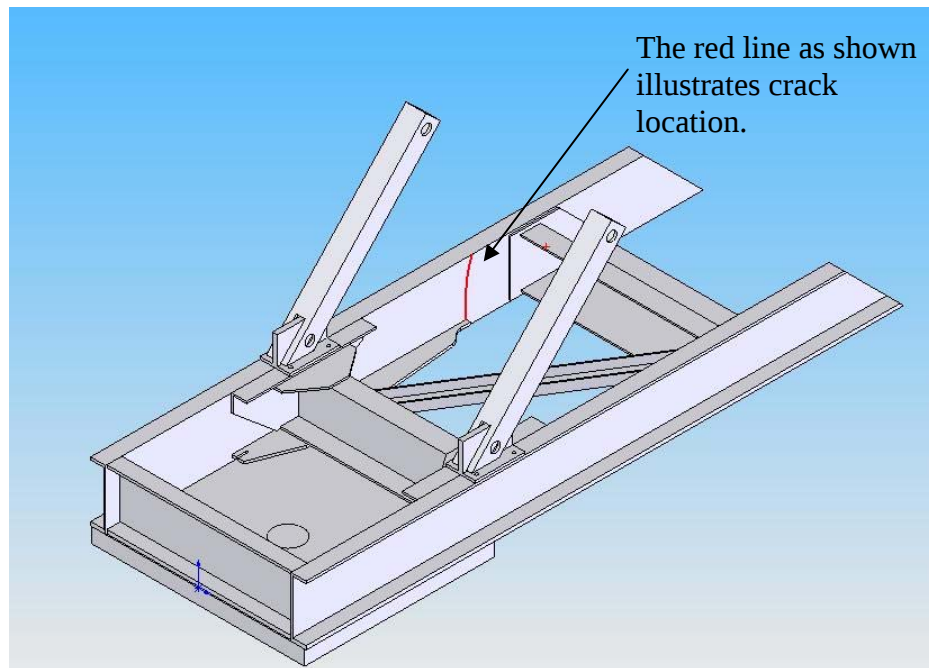
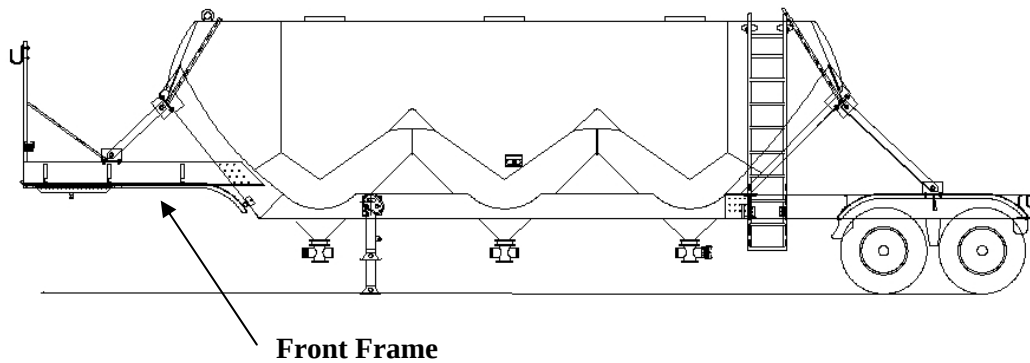
- Serial number must be verified before any repair is authorized. Only those serial numbers listed in the recall list are to be covered by this campaign.
- Polar Customer Service must be contacted to receive repair authorization documentation, before work begins on any trailer covered by this campaign.
- Scope of this campaign is strictly limited to the specific components and procedures that are detailed in the attached. No other work is to be performed under the scope of this repair authorization. Any unrelated concerns that may need to be addressed, must be discussed on a case-by-case- basis with Polar Customer Service. Separate authorization will be given, if necessary to address these unrelated concerns.

Problem Description:

A crack may develop in a weld termination in the right front frame rail of the front frame, and eventually propagate through the frame. If undetected, the crack will grow to the point of failure. See Figure B for a detail of the crack location.

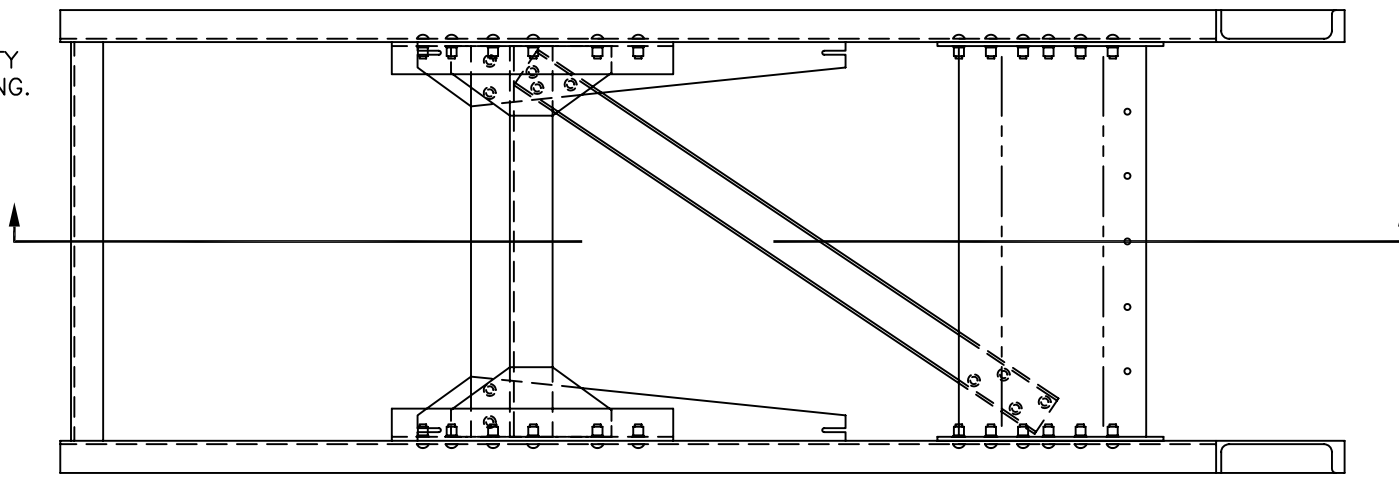
Remedy Description:

A reinforcement upgrade has been developed that will prevent the crack from occurring. In cases where cracking has occurred complete replacement of the front frame may be warranted. Polar will be covering the cost of the required upgrades.

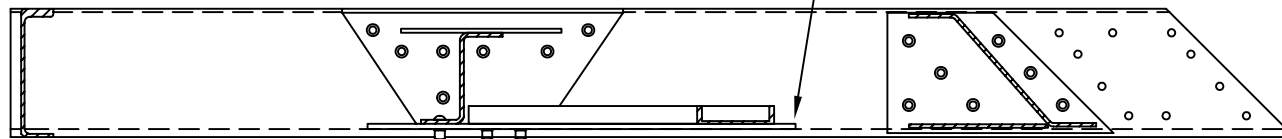


Potential Crack Location

- 1.) INSPECT THE CURBSIDE MAIN FRAME RAIL FOR ANY SIGN OF CRACKING. IF ANY CRACKING IS PRESENT, CALL THE WARRANTY DEPARTMENT AT POLAR BEFORE PROCEEDING. 800-826-6589



CHECK THIS AREA



REV	DESCRIPTION	DATE	BY	REV	DESCRIPTION	DATE	BY

① *DO NOT SCALE PRINT*
TOLERANCES AS FOLLOWS
UNLESS OTHERWISE NOTED:
A. MACHINING $\pm 1/32"$
B. SHEET METAL SHEARING
THRU 10 GA. $\pm 1/32"$
C. STRUCTURAL LENGTH $\pm 1/8"$
D. BREAK PARTS $\pm 2"$
E. PUNCHING LOCATION $\pm 1/64"$
WELD SYM. PER A.W.S. STDS.

DRAWN BY
JASON

CHECKED BY

SEPIA OF
SK-4013

POLAR
Tank Trailer, Inc.

12810 County Road 17
Holdingford, MN 56340

Phone: 1-320-746-2255
Fax: 1-320-746-2937

TITLE FRONT FRAME MODIFICATION
CROSSBRACE & ANGLES
PAGE 1 of 4

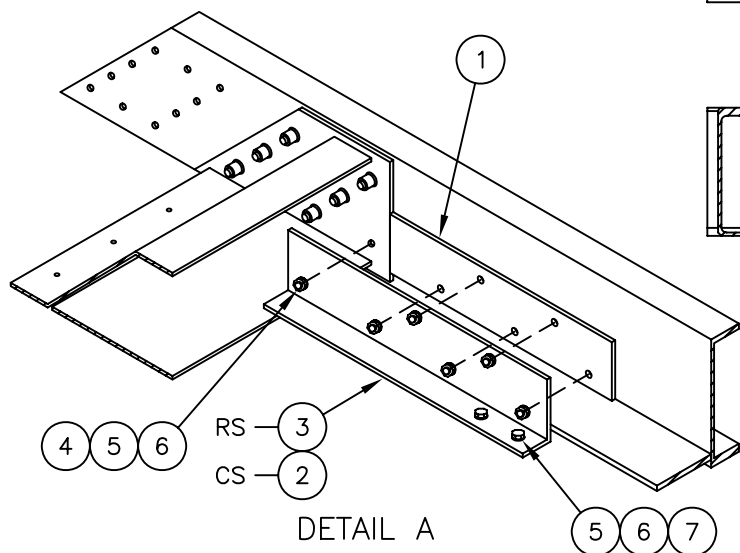
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DWG. NO. B SK-4143 /

REV

THIS DRAWING IS THE PROPERTY OF POLAR TANK TRAILER, INC. & IS SUBJECT TO RETURN UPON REQUEST. IT IS NOT TO BE USED IN ANY WAY DETRIMENTAL TO THE INTERESTS OF POLAR TANK TRAILER, INC.

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- This technical drawing illustrates a mechanical assembly, possibly a door hinge or latch mechanism, shown in a side view. The assembly is mounted on a vertical surface, indicated by a dashed line on the left. The main components include a horizontal plate at the top, a vertical plate on the right, and a diagonal plate at the bottom. The assembly is secured with multiple screws and bolts. A coordinate system is shown in the bottom right corner, with the origin at the bottom right and the axes pointing towards the top left and bottom left. The drawing includes various dimension lines and labels, such as '100', '150', '200', '250', '300', '350', '400', '450', '500', '550', '600', '650', '700', '750', '800', '850', '900', '950', '1000', '1050', '1100', '1150', '1200', '1250', '1300', '1350', '1400', '1450', '1500', '1550', '1600', '1650', '1700', '1750', '1800', '1850', '1900', '1950', '2000', '2050', '2100', '2150', '2200', '2250', '2300', '2350', '2400', '2450', '2500', '2550', '2600', '2650', '2700', '2750', '2800', '2850', '2900', '2950', '3000', '3050', '3100', '3150', '3200', '3250', '3300', '3350', '3400', '3450', '3500', '3550', '3600', '3650', '3700', '3750', '3800', '3850', '3900', '3950', '4000', '4050', '4100', '4150', '4200', '4250', '4300', '4350', '4400', '4450', '4500', '4550', '4600', '4650', '4700', '4750', '4800', '4850', '4900', '4950', '5000', '5050', '5100', '5150', '5200', '5250', '5300', '5350', '5400', '5450', '5500', '5550', '5600', '5650', '5700', '5750', '5800', '5850', '5900', '5950', '6000', 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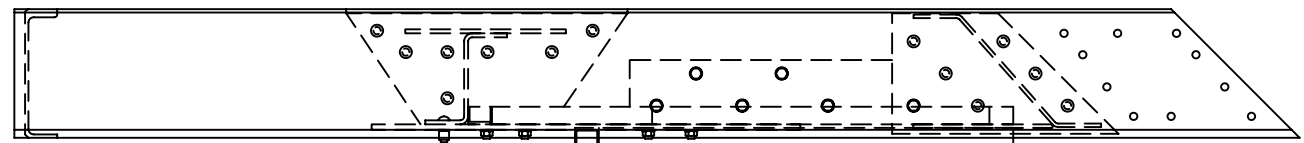


ITEM #	QUA.	PART #	DESCRIPTION
7	4	SP188046	CAPSCR ZP 5/8-11X2 GRADE 8
6	32	022409	WASHER FLAT ZP 5/8
5	16	021707	LOCKNUT ZP 5/8-11UNC
4	12	024042	CAPSCR ZP 5/8-11X1 3/4 GR8
3	1	KM6021	ANGLE AL REINF FRT FRM APX RS
2	1	KM6020	ANGLE AL REINF FRT FRM APX CS
1	2	KM6022	PLATE AL SPACER W/HOLES

[illegible]

3.) INSTALL CROSS BRACE

- DRILL HOLES IN ENDS OF CHANNELS 1 & 2 WITH HOLE PATTERN FROM SPACER PLATE 3.
- BOLT CHANNELS 1, 2, AND SPACER 3 TOGETHER.
- BOLT END OF CHANNEL 1 DIRECTLY TO TOP OF WELDED GUSSET PLATE.
- BOLT END OF CHANNEL 2 TO BOTTOM SIDE OF REAR CROSSMEMBER PLATE.
- DRILL 11/16" DIA. HOLES AS NEEDED.
- TORQUE ALL BOLTS TO 159 Ft.-Lbs.



ITEM #	QUA.	PART #	DESCRIPTION
6	22	022409	WASHER FLAT ZP 5/8
5	11	021707	LOCKNUT ZP 5/8-11UNC
4	11	024042	CAPSCR ZP 5/8-11X1 3/4 GR8
3	1	SM9127908	PLATE SPACER AL .3125 CRS-CHL
2	1	SM9127907	CHL ALUM .247X1.65X4X47LG
1	1	SM9127906	CHL ALUM .247X1.65X4X18LG

[illegible]

Front Frame Modification, Page 4 of 4



PHOTOGRAPH OF COMPLETED MODIFICATION