
A. PURPOSE.

The following repair method/procedure is provided to ensure the correct and quality repair are performed on assembled units with a crack condition in rear suspension I-Beam.

B. MATERIAL REQUIRED.

- | | | |
|----|---|--------------------|
| 1) | 20104993H 105-05199-2+Susp. Frame Stiffener Gusset, | Qty: 1ea/unit |
| 2) | 20105012H 105-05199-2+Susp. Frame Stiffener Gusset, | Qty: 1ea/unit |
| 3) | 20114782H 105-05230+H-Beam Frame Cover PLT, | Qty: 2ea/unit |
| 4) | 20104982H 105-05196+Susp. Frame Stiffener, | Qty: 2ea/unit |
| 5) | 20114814 Brace Channel 110-06031 4"X 1250mm | Qty: 1ea/unit |
| 6) | 10009229 Paint Scharpf SG-500G (Wax Soft) | Qty: 0.05 Gal/unit |
| 7) | 10001915 Primer Epicon Zinc CMP HB232 | Qty: 0.13 Gal/unit |

C. TOOL REQUIRED.

- 1) Angle grinder
- 2) Arc air torch equipment
- 3) Welding machine
- 4) Wire brush
- 5) Chisel & hammer
- 6) Spatula or scrapper
- 7) Combination Spanner
- 8) Pneumatic Reamer
- 9) Painting brush
- 10) Safety equipment (gloves, safety glasses, etc.)

D. HOW TO REPAIR.

1) Preparation.

Prior the modification, the procedure has to be reviewed and understood, then it's required that each trailer be located in a safe work place.

Place each trailer on a flat leveled surface & apply the parking brakes.

Instructions described below must be performed by trained personnel & must take all necessary safety precautions.

2) Disconnect sensors and ABS power cables, this is very important.



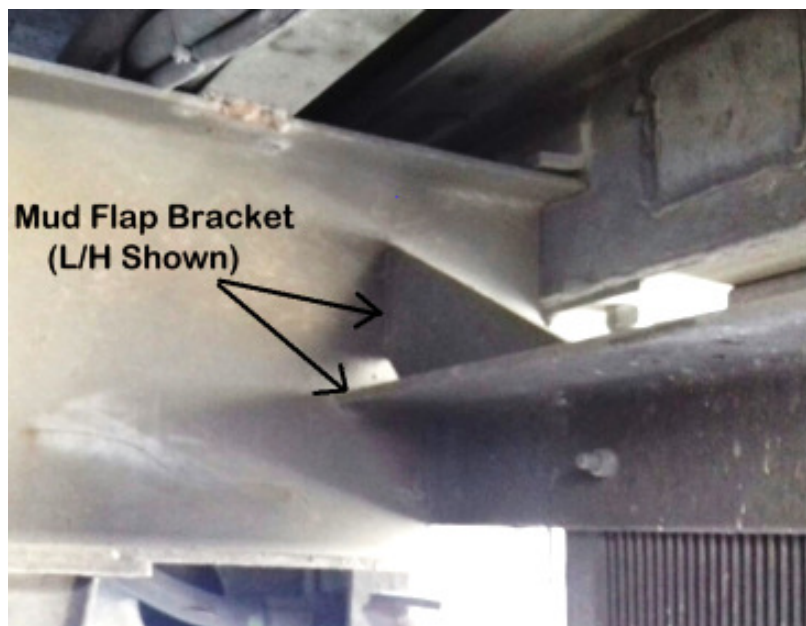
3) Clean and inspect the rear side of bogie rail, if there is a crack as shown below, keep going with whole modification procedure, otherwise go to steps 4, 5 and from 11 to 21.



4) To avoid any damage on tires & cables that are close to the area to be repaired, protect as much as possible.



5) Using arc air torch equipment, remove Mud Flap Bracket (**it's very important that main rail won't be damaged with this operation**), then clean and prepare the mud flap bracket to re-install latter.



6) Locate the end of the crack and drill a 5mm holes as below photo shows.



7) On the crack located on web (outside view), make a "v" groove with angle grinder as following picture shows.



8) Weld the crack over the “V” groove that was previously done.



9) Over the **inside** frame, remove the cracked weld and make the “V” groove as was made before to repair the crack.



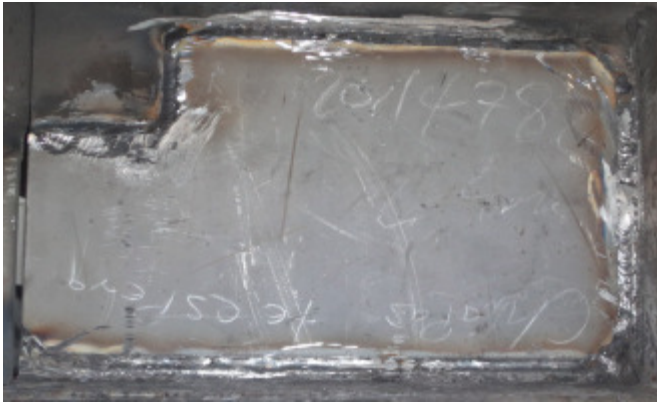
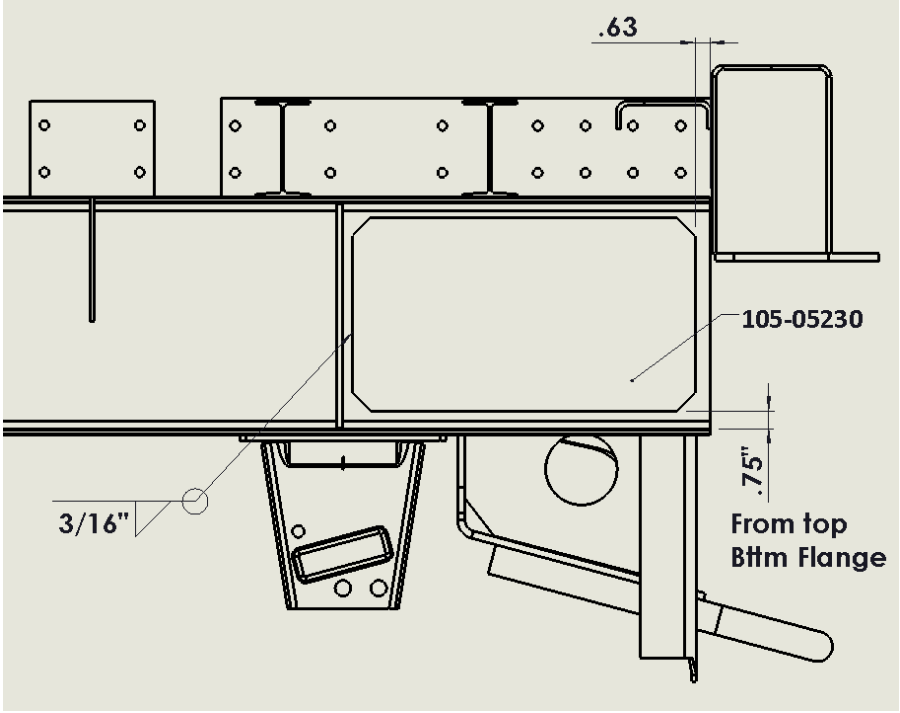
10) Repair the welding between web and X-member Pintle Hook.



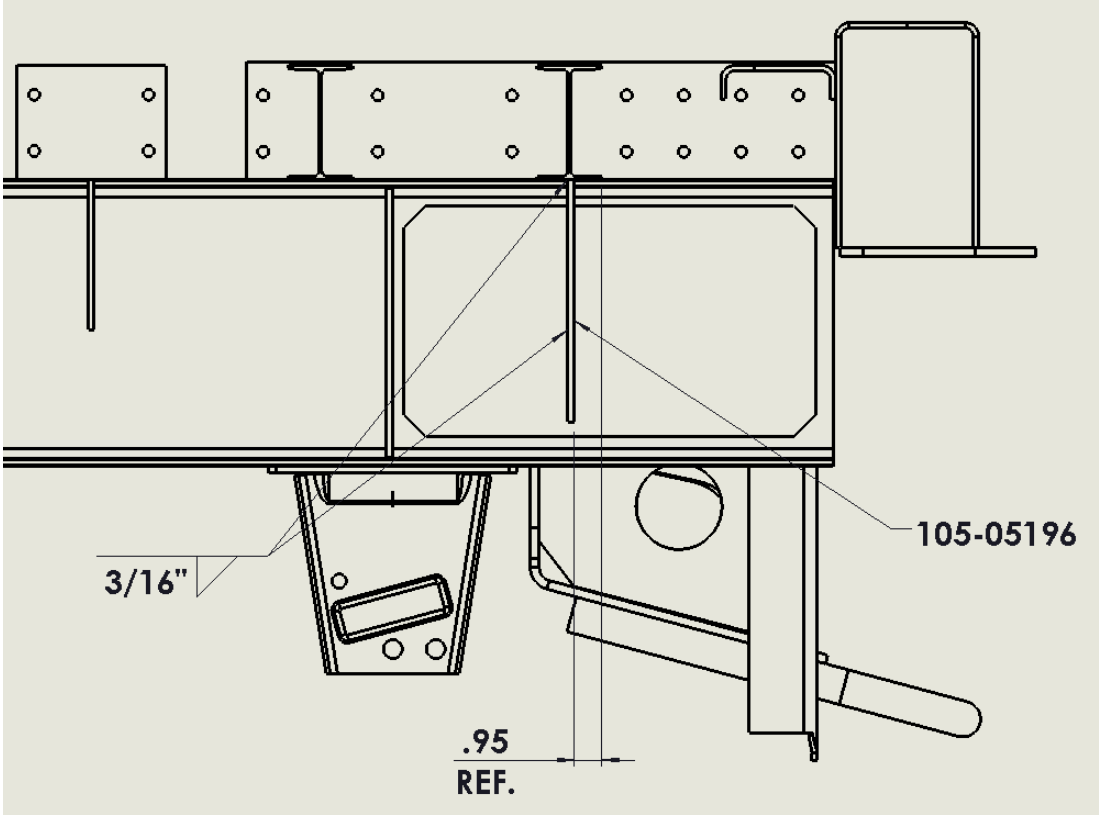
11) Grind off, clean and check that no spatters are over the area and it's smooth to place the reinforcement plate 105-05230.



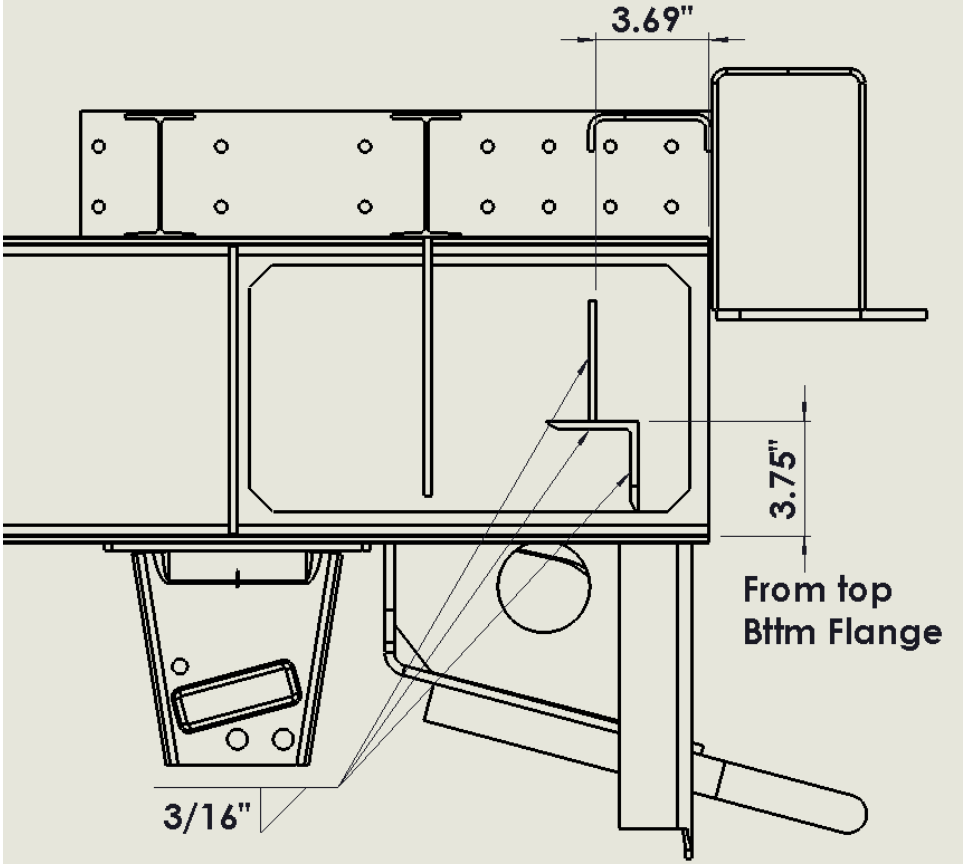
12) Install and weld the 20114782H 105-05230+H-Beam Frame CVR PLT as below sketch shows.



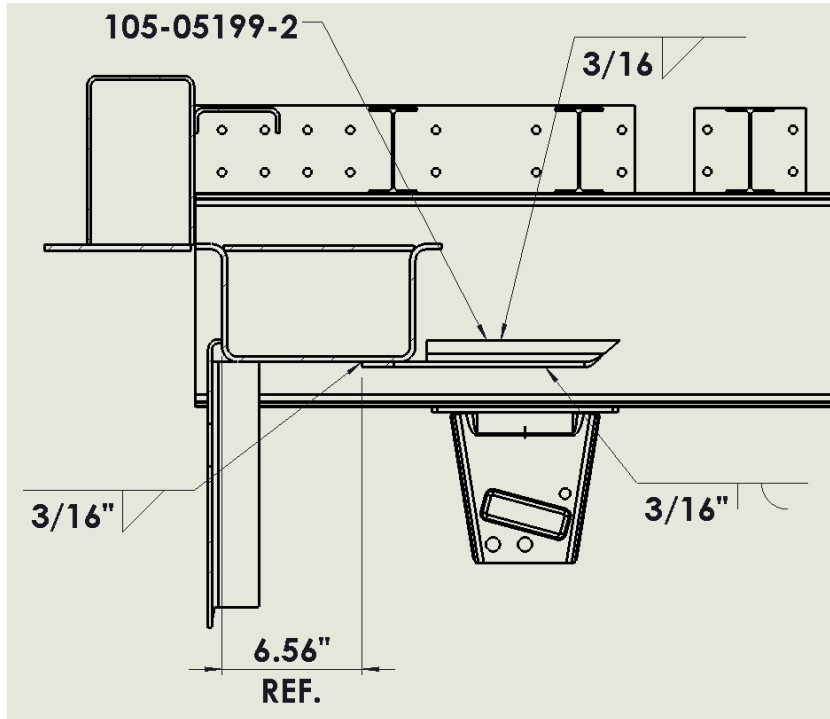
13) Install 115-15130-8 and 20104982H 105-05196+Susp. Frame Stiffener and weld as required below.



14) Re-install Mud Flap bracket previously removed and weld as required below



15) Install 105-05199-2 L/H & R/H + Susp. Frame Stiffener Gusset, as required by side and as below sketch (L/H Shown).

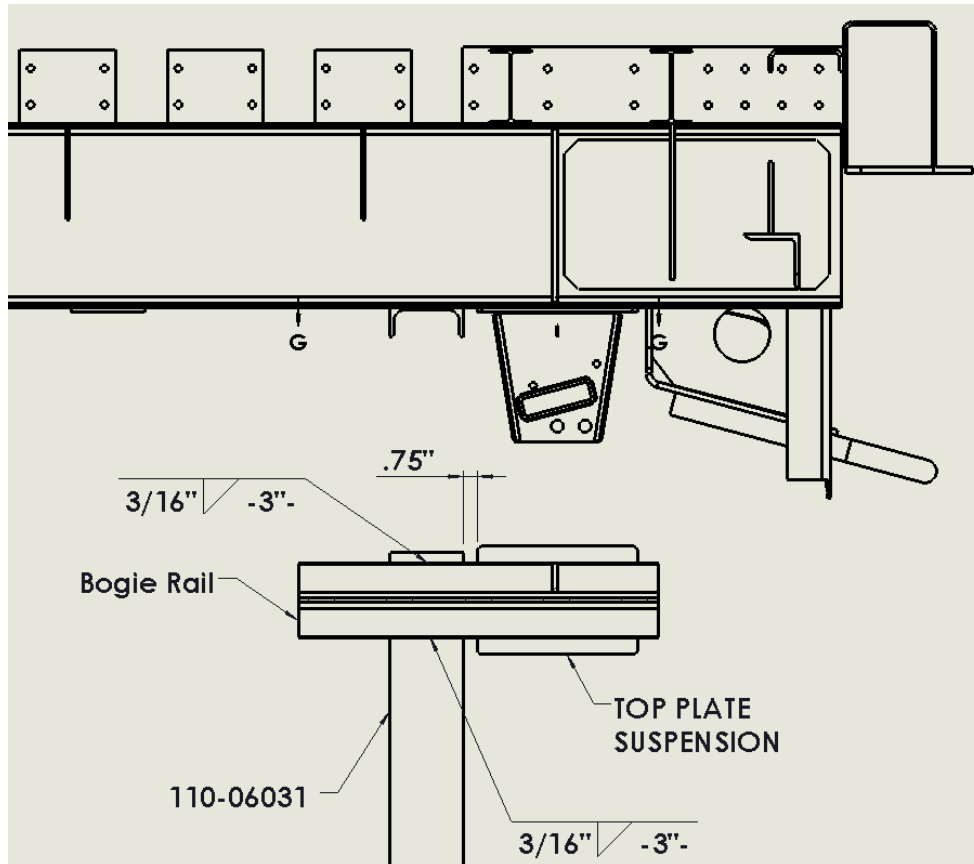


16) Verify position and location of gussets as below, then apply weld as required on sketch showed above.



17) Repeat steps from 3 thru 16 to repair the opposite side if it's need.

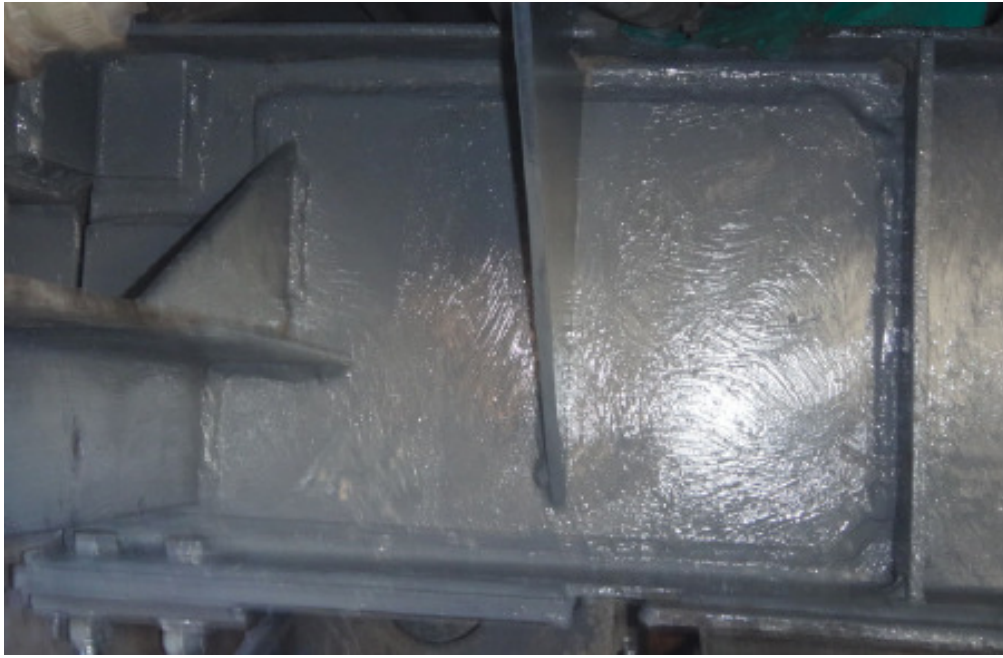
18) Brace channel 110-06031 must be installed in front of rear hanger and weld as shown below.



19) Apply primer 10001915 PRIMER EPICON ZINC CMP HB232 over each area welded.



20) Apply protective coating 10009229 PAINT SCHARPF SG-500G all over the parts installed.



21) Re-connect ABS power & sensor cables.

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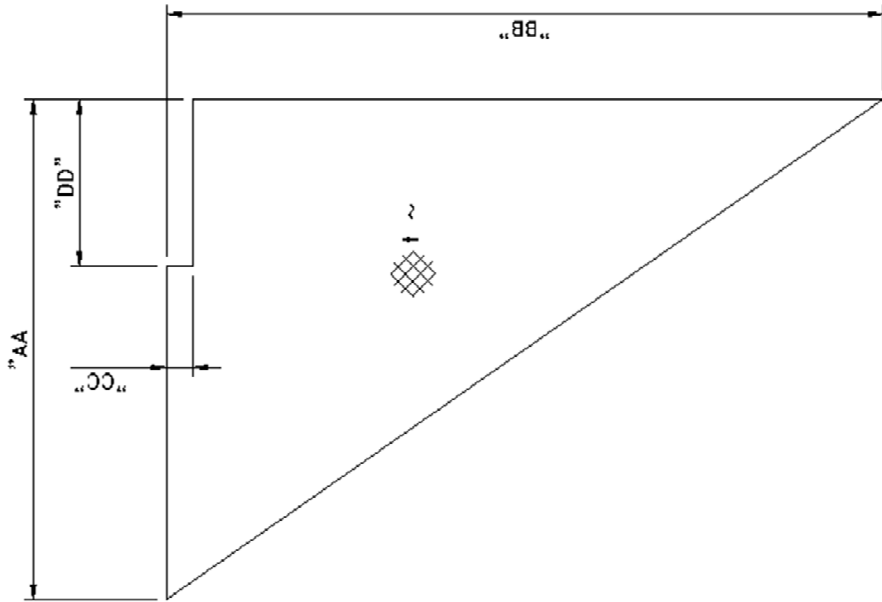
4-C19x45*

FINISH	MATERIAL
2000XXX	EXISTING SAP #
2000XXXN	NO SHOT
2000XXXH	SHOT
2000XXXG	HOT DIP GALV
2000XXXS	SUS 201
2000XXXP	PAINTED
2000XXXS3	SUS 304

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MARK	DATE	DETAIL OF REVISION	CHECKED	APPROVED
APPROVED	J.R.U.G.	TITLE		DATE
CHECKED	--	H-BEAM FRAME COVER PLATE		AUG.05.16
DRAWN	J.A.P.			SCALE
				N/A
UNLESS OTHERWISE SPECIFIED DIMENSIONS IN MM TOLERANCES ARE: 3" (100MM) ±0.0025 3" (100MM) ±0.0050 3" (100MM) ±0.0100 3" (100MM) ±0.0150 3" (100MM) ±0.0200 3" (100MM) ±0.0300 3" (100MM) ±0.0400 3" (100MM) ±0.0500 3" (100MM) ±0.0600 3" (100MM) ±0.0700 3" (100MM) ±0.0800 3" (100MM) ±0.0900 3" (100MM) ±0.1000		HYUNDAI TRANSLEAD		
ASSEMBLY		SAP NUMBER	DRAWING NUMBER	REVISION
BOGIE		20114782	105-05230	A

SAP NUMBER	TYPE	"A"	"B"	"C"	"D"	"E"	WEIGHT	DATE	CHECKED
20104892	1	200	215	14	50	6.4	- kg	--	--
--	-	--	--	--	--	--	-- kg	--	--

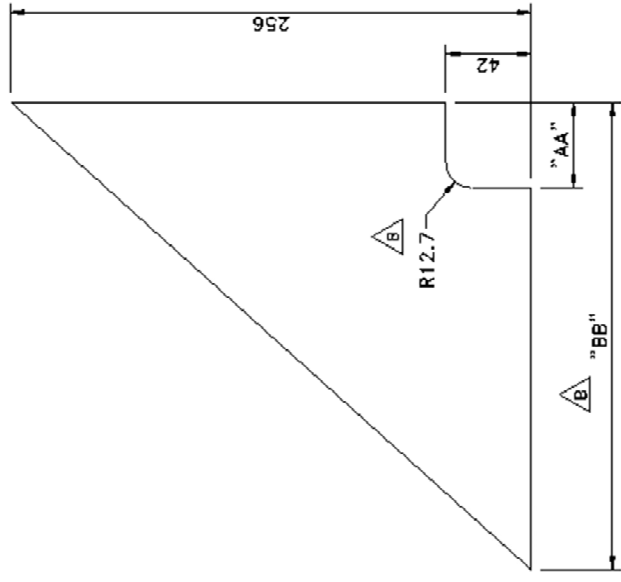
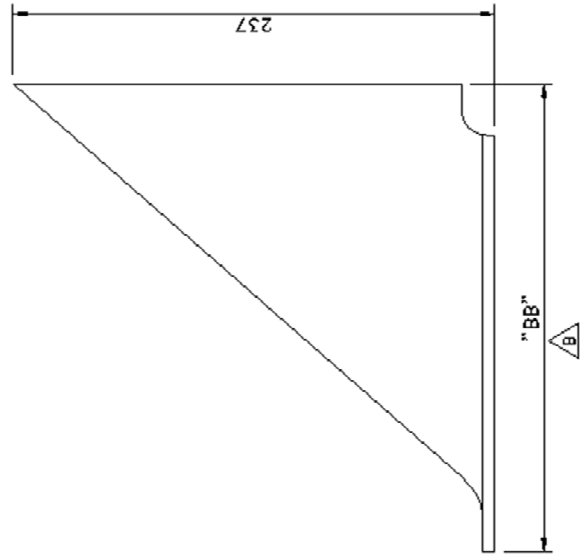
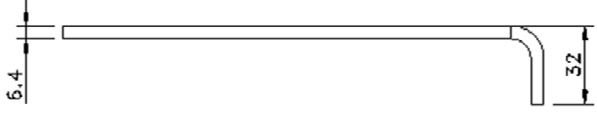


FINISH	MATERIAL
2000XXX	EXISTING SAP #
2000XXXN	NO SHOT
2000XXXH	SHOT
2000XXXG	HOT DIP GALV
2000XXXS	SUS 201
2000XXXP	PAINTED
2000XXXS3	SUS 304

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MARK	DATE	DETAIL OF REVISION	CHECKED	APPROVED
APPROVED	SLM	TITLE SUSPENSION FRAME STIFFENER		DATE
CHECKED	--			JUN.06.15
DRAWN	SYN			SCALE
SURFACE COEFFICIENT SPECIFIED DIMENSIONS IN MM TOLERANCES ARE: #1 (0.0008) #2 (0.0016)		HYUNDAI TRANSLEAD		N/A
ASSEMBLY		SAP NUMBER	DRAWING NUMBER	REVISION
BOGIE		SEE TABLE	105-05196	A

SAP NUMBER	TYPE	AA	BB	WEIGHT	DATE	CHECKED
20104883	LH	1	230	1.43 kg	--	--
20104893	RH	2	206	1.64 kg	--	--



UNFOLD

NOTE:
*RH AS SHOWN
L/H OPPOSITE

FINISH	MATERIAL
2000XXX	EXISTING SAP #
2000XXXN	NO SHOT
2000XXXH	SHOT
2000XXXG	HOT DIP GALV
2000XXXS	SUS_201
2000XXXP	PAINTED
2000XXXS3	SUS_304

MARK	DATE	TYPE	BY	DATE	SYN	APPROVED
△	JUN.11.15	TYPE 2	DAIM 306	MMS 230	ADDED 12.7 RADIUS	SLM

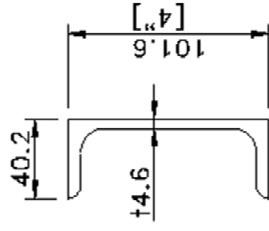
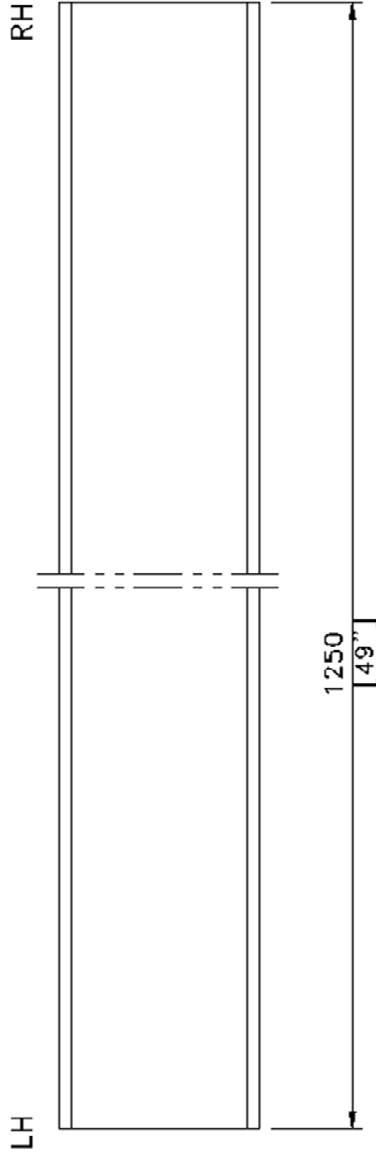
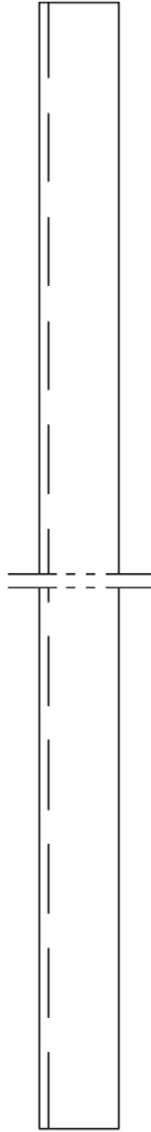
APPROVED	DATE	CHECKED	DATE
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DETAIL OF REVISION	TITLE
	SUSPENSION FRAME STIFFENER GUSSET

SCALE	DATE
N/A	

HYUNDAI TRANSLEAD	
ASSEMBLY	DRAWING NUMBER
BOGIE	105-05199
REVISION	B

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MARK	DATE	DETAIL OF REVISION	CHECKED	APPROVED
APPROVED	J.R.U.G.	TITLE		DATE
CHECKED		BRACE CHANNEL		AUG.05.16
DRAWN	J.A.P.			SCALE
				N/A
		ASSEMBLY	SAP NUMBER	DRAWING NUMBER
		BUMPER	20114814	110-06031
				REVISION
				A