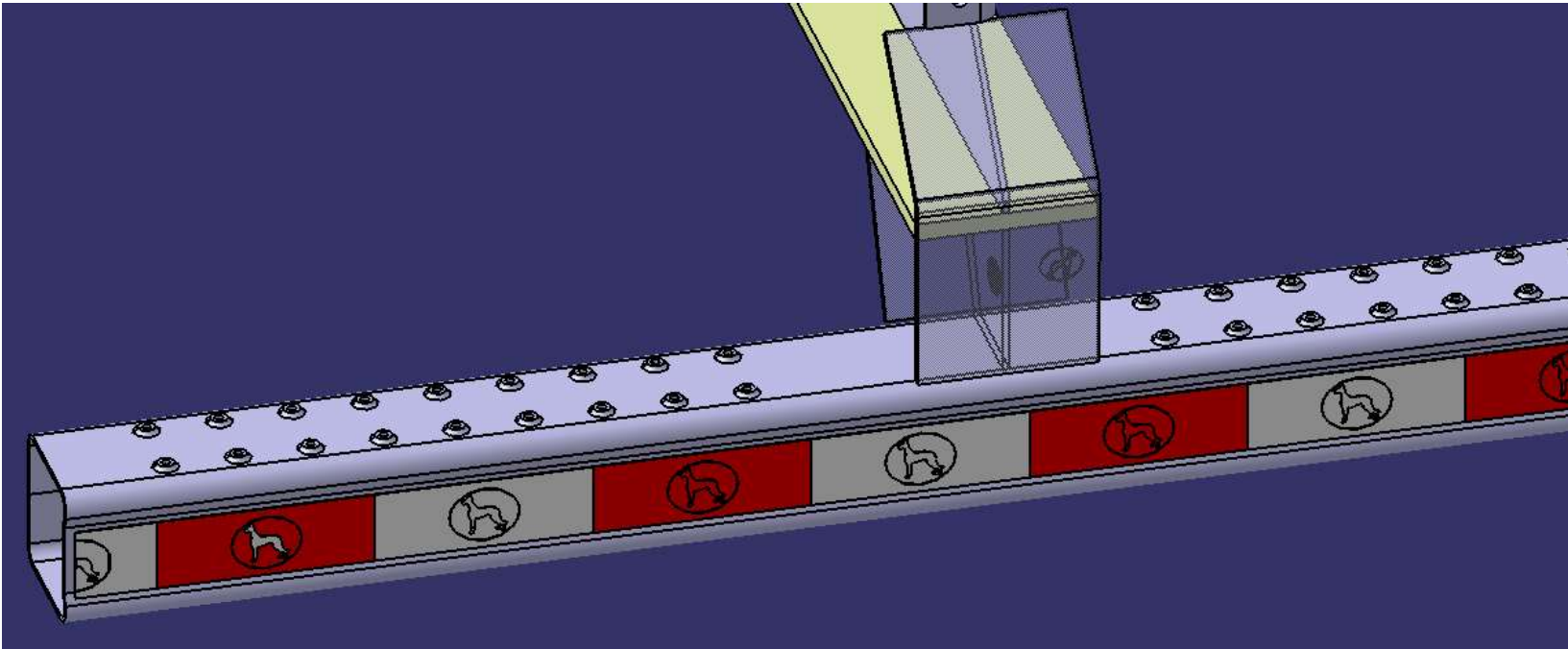




# RIG tube replacement

1



Great Dane Engineering  
November 2018

*Great Dane*



## Parts List:

- (1) 41700509, BM,IMPACT GRD 95.00 W/ S/G
- (1) 42102725, TAPE,CONSP RFLX 18521
- (1) 42100247, PLT,COMPLNC RIG 1.25X4.00
- (2) 42204205, RVT,AL AVDEL 01601-00619 BLIND
- (1) O'Reilly primer NASON 421-24
- (2) O'Reilly paint 667958ieb

## Tools needed:

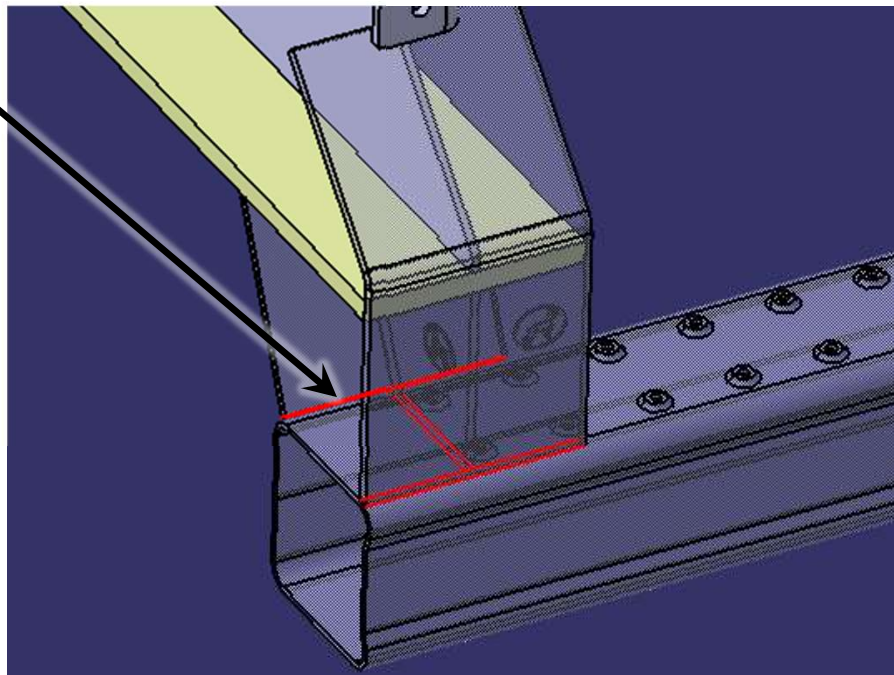
- Angle grinder, cut-off wheel, etc.
- Welding machine
- Rivet gun for 3/16" blind fasteners
- 7/32" drill bit



# Removing short RIG horizontal

- Cut away all welds attaching the upright to the current horizontal tube, RS and CS. (welds shown in red)

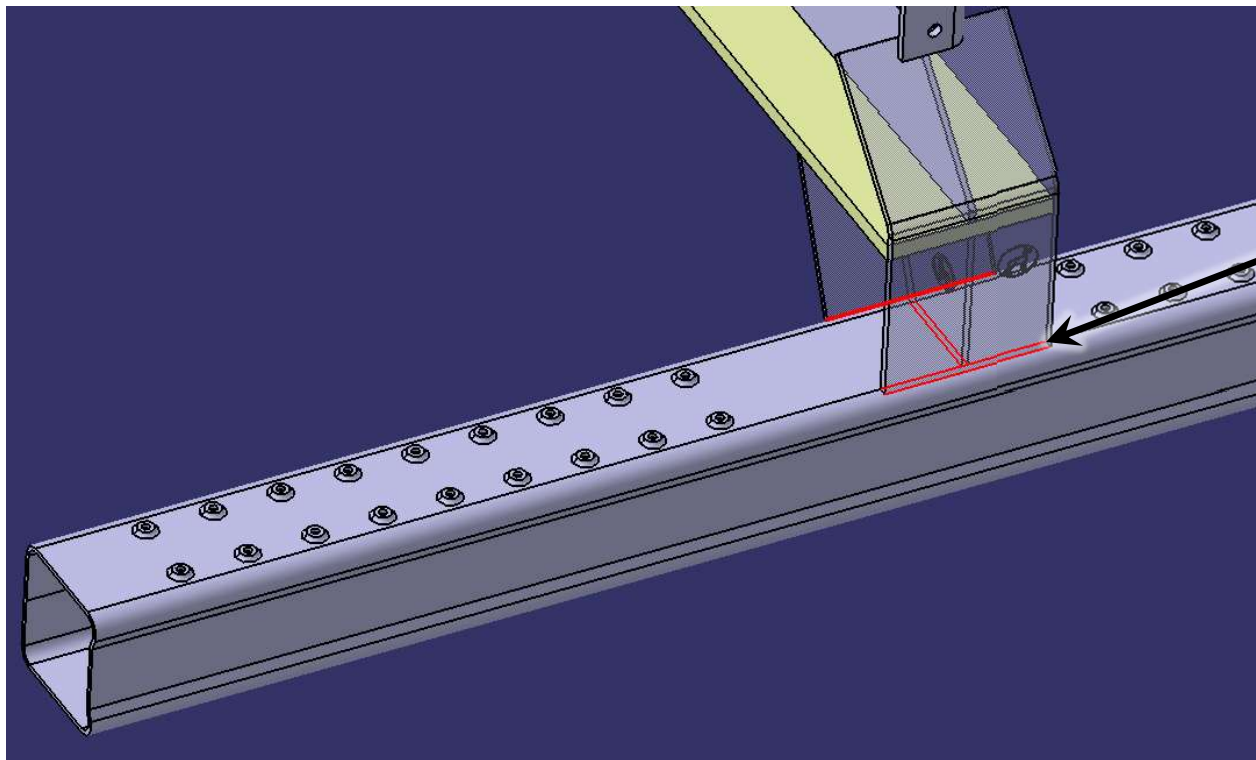
Cut away welds and remove tube





# Installing full length RIG tube

- With short tube now removed, position and center new 95" long tube in fore-aft and lateral directions.
- Weld RS and CS uprights all around with a 0.25" weld bead.



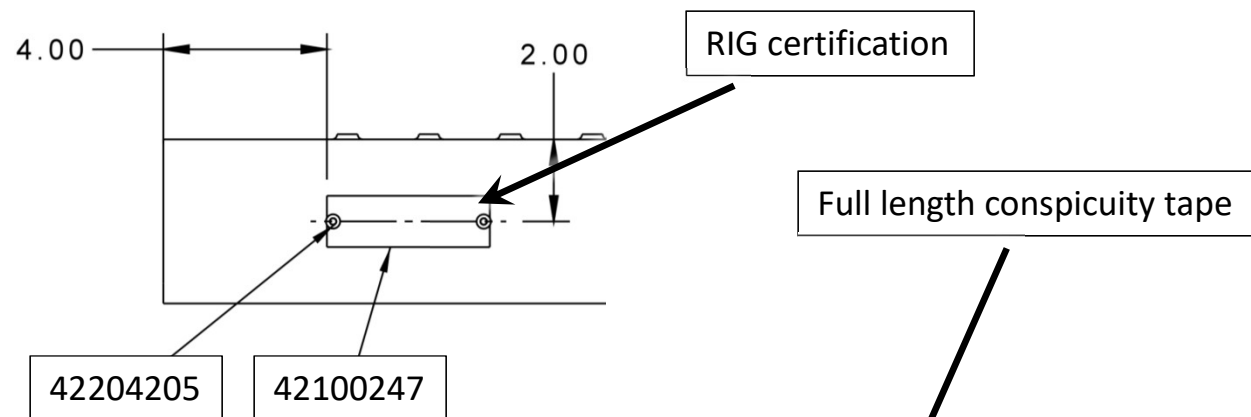
Weld all around with  
0.25" weld bead



# Paint tube and install ancillary components

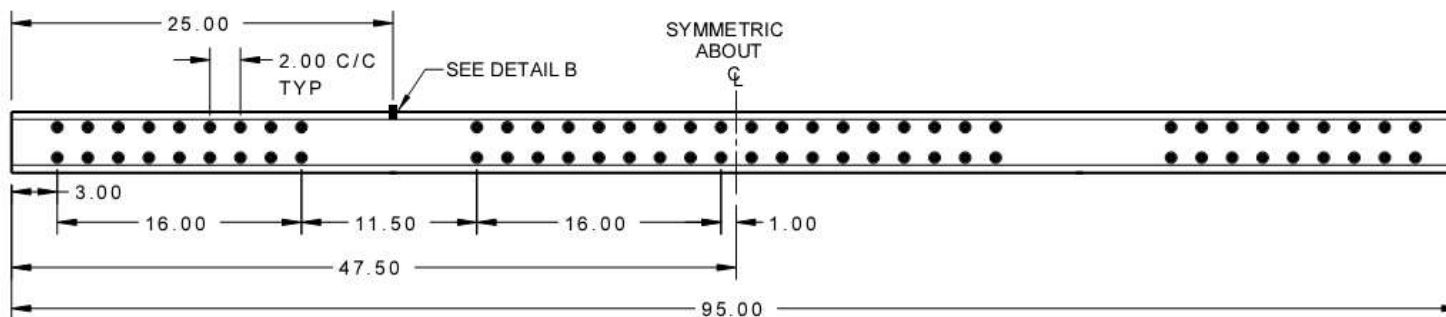
5

- After tube is welded in place clean away all dirt, debris, weld spatter and oil residue before priming with NASON 421-24 and painting with 667958ieb.
- After paint is cured, install RIG certification plate as shown on the CS.
- Install conspicuity tape 42102725 full width of new RIG tube.

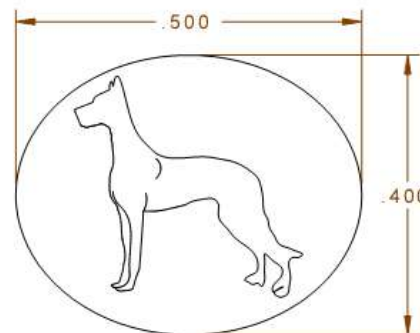
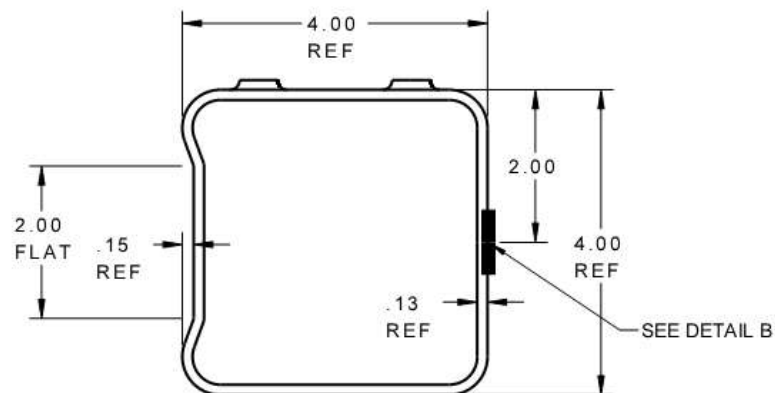




REV	DWG NO: 41700509	DATE	BY
F	REVISED THE DESCRIPTION, WAS "BM,IMPACT GRD BNKLY TBD W/ S/G 95.00". ADDED VENDOR ID # TO JDE 2.	08/17/11	JW
		CN 08/17/11	




**\*\*NOT TO BE MODIFIED UNLESS ENGINEERING APPROVED\*\***



DETAIL B  
SHOWN LARGER THAN ACTUAL SIZE  
LOGO TO BE APPROXIMATELY STAMPED  
AT THE LOCATIONS SHOWN

VENDOR: HOLLAND  
VENDOR ID: TB-0273-07W6N006

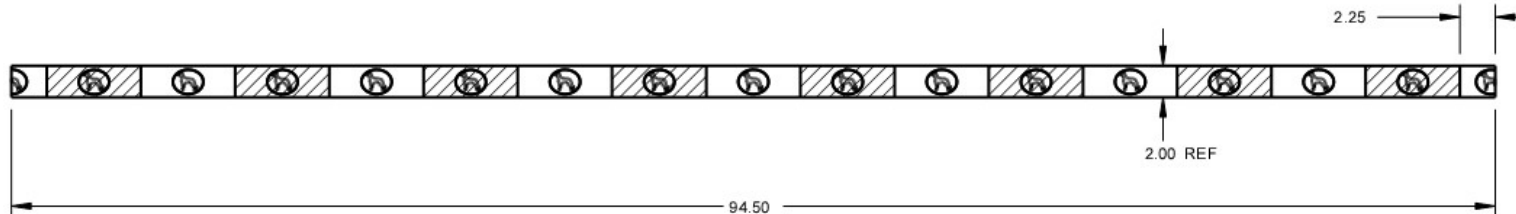
MATERIAL: .134 MIN CERT 80,000 YLD TBNG STL X 4 X 4 X 95.00

 <b>Great Dane Trailers</b> A Division of Great Dane Limited Partnership	ALL DIMENSIONS ARE IN INCHES.		CN 17-516 WEIGHT 55.8421b	<b>DWG TITLE:</b> BM, IMPACT GRD 95.00 W/ S/G HLND #TB-0273-07W6N006
	DWN: B.Straub 03/29/2006	CHK:		
TOLERANCES TO BE ±0.050 UNLESS OTHERWISE NOTED.	<b>NOTICE:</b> THIS DOCUMENT CONTAINS PROPRIETARY TECHNICAL DATA WHICH IS THE CONFIDENTIAL PROPERTY OF GREAT DANE. ABSENT THE EXPRESS WRITTEN PERMISSION OF GREAT DANE USE OR DISCLOSURE OF THIS DOCUMENT IS FORBIDDEN.			<b>REV: F</b>





REV	DWG NO: 42102725	DATE	BY
A.	REVISED THE VENDOR ID, 18521 WAS L02-56GD-044EA.	04/13/2011	JW
		CN	20-1477




NOTES:

1. SHEETING TO MEET THE SPECIFICATION OF FFMVSS 108.
2. SHEETING MUST BE MARKED DOT-C2.
3. SHEETING IS TO BE 2.00 X 6.00 AND 6.00 PATTERN.
4. SHEETING TO BE APPLIED TO A SMOOTH, CLEAN, DRY SURFACE AT TEMPERATURES RANGING FROM 50-100°F.
5. LOGO TO APPEAR IN BOTH RED AND WHITE SECTIONS.
6. HATCHED AREA REPRESENTS RED COLOR.

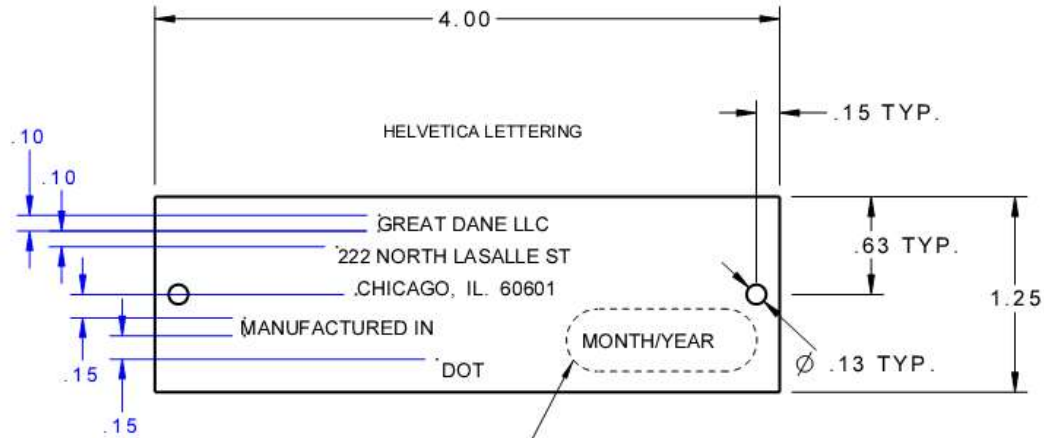
VENDOR:	REFLEXITE
VENDOR ID:	18521
CONSPICUITY MATERIAL:	Reflexite V82 DOT
COLOR:	WHITE/RED WITH LOGO

MATERIAL: PLASTIC

 <b>Great Dane Trailers</b> A Division of Great Dane Limited Partnership	ALL DIMENSIONS ARE IN INCHES.		CN 20-723 WEIGHT 0.2581b	<b>DWG TITLE:</b> TAPE, CONSP RFLX 18521 2.00X94.50 WHT/RED W/LOGO V-82
	DWN:	CHK:		
TOLERANCES TO BE ±0.050 UNLESS OTHERWISE NOTED.	<b>NOTICE:</b> THIS DOCUMENT CONTAINS PROPRIETARY TECHNICAL DATA WHICH IS THE CONFIDENTIAL PROPERTY OF GREAT DANE. ABSENT THE EXPRESS WRITTEN PERMISSION OF GREAT DANE USE OR DISCLOSURE OF THIS DOCUMENT IS FORBIDDEN.			<b>REV:</b> A.



REV	DWG NO: 42100247	DATE	BY
-	NEW	CN	8/24/17



NOTE:

- 1. MATERIAL TO BE .025 STAINLESS STEEL WITH .015 EMBOSSED LETTERS.

MATERIAL: SS



Great Dane

DWN BY:

ALL DIMENSIONS ARE IN INCHES.

CN  
8/24/17  
WEIGHT  
0.0361b

DWG TITLE:  
PLT, COMPLNC RIG 1.25X4.00

TOLERANCES TO BE ±0.050  
UNLESS OTHERWISE NOTED.

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SHEET: 1 OF 1 SCALE: 1

DWG NO: 42100247

REV: .