

Date: 12/8/2025	Rev.: FR	No.: B25020
Re.: Aluminum Drop Deck RIG Reinforcement		Type: Safety
Priority: As soon as practical.		
Units Affected: See Vin Listing		

Background: Wabash has determined that the rear impact guard on certain Aluminum Drop Deck Trailers built between July 1st 2024 & April 4th 2025, fail to comply with the requirements as outlined in Federal Motor Vehicle Safety Standard numbers 223 “Rear Impact Guards” and 224 “Rear Impact Protection”. This bulletin will list the parts and outline the steps to reinforce and update the unit as needed for the rear impact guard to comply with all FMVSS standards.

Materials:

<u>Item</u>	<u>Part Number</u>	<u>Qty</u>
Short Riser Gusset (low deck units)	9100-0243	2
Long Riser Gusset (standard drops)	4060-0158	2
Bolt-on Mounting plate	4270-0244	2
Bolt (5/8-18 X 2 1/2, GR8)	P7010-0002	4
Nut (5/8 Stover)	P7310-0014	4
Washer (5/8 Flat)	P7580-0009	8
DOT Bumper Decal	25002396	1

Tools:

- Drill
- Welder
- Impact
- Wrench
- Torque Wrench

 **CAUTION!**

- Wear appropriate personal protective equipment (PPE) when carrying out the following procedure. Examples include gloves, safety glasses, hearing protection and hard hat.
- Should welding or cutting be needed, do so in a well-ventilated area. Wear appropriate welding head/face/eye protection, gloves and clothing.
- Refer to adhesive and chemical manufacturer’s Safety Data Sheet (SDS) for safe use and handling instructions if applicable.
- Follow your company’s safety procedures in addition to these recommendations.
- Follow industry standards for installation and tightening of all fasteners where torque values are not called out.

Procedure:

- 1) Clamp the bolt-on mounting plate part # 4270-0244 onto the bottom of the beam flange on both C/S and R/S. Ensure plate is centered on the beam flange and tight against the vertical bumper riser tube as shown below.



- 2) Transfer drill 11/16" holes into the bottom of the main beam flange on both C/S & R/S using part # 4270-0244 as the template. ***(Do not install fasteners at this time)***

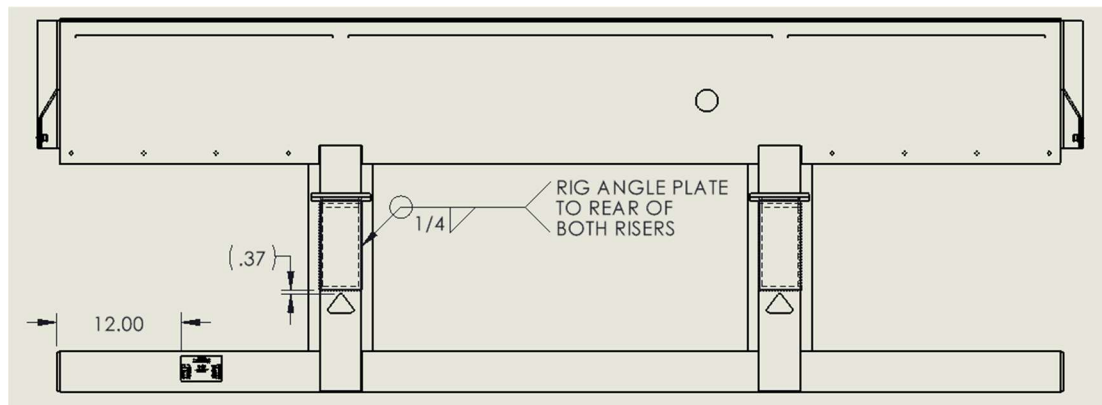


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- 3) Determine which bumper riser gusset will be used for the unit being repaired. If help is needed to determine which riser gusset is needed, contact Wabash Warranty for assistance.
 - a. Install the bumper riser gusset tight against the bumper riser centered on the tube and against the mounting plate; then tack weld in place.



- 4) Weld the bumper riser gusset to the bumper riser tube and the flat mounting plate using a 1/4" weld around the entire perimeter. Do this on both C/S and R/S.
 - a. The symbol for welding is shown below and the illustrated examples are shown at the top of page 4.



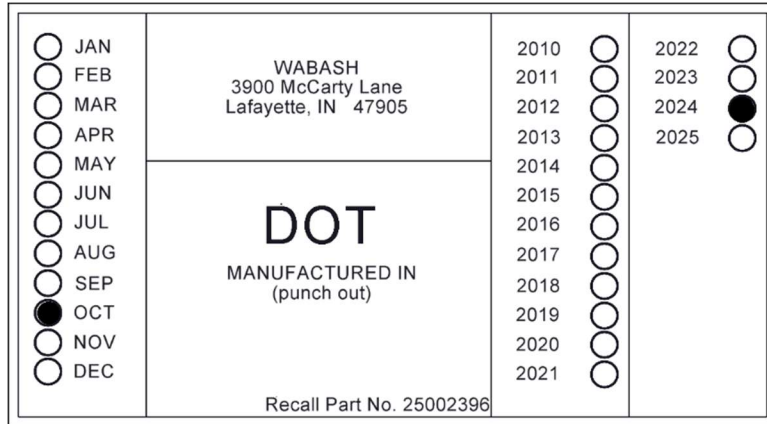


- 5) Install 5/8" bolts and washers with the bolt heads located on top of main beam. Install stover lock nuts and washers on bottom side of the mounting plate.
 - a. Torque all of these fasteners to 150ft.lbs

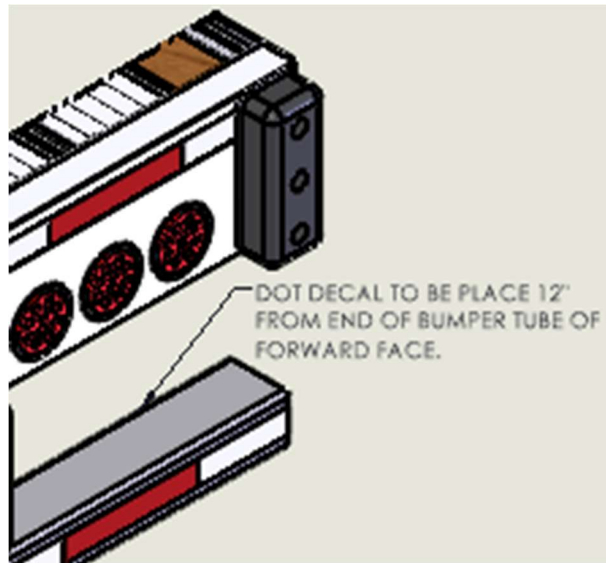


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- 6) Punch out the Month and Year the trailer was produced on the supplied DOT bumper label
(This must match the month and year punched out on the trailer's VIN tag, see example below)



- 7) The label must be placed on the forward-facing surface of the bumper tube. Locate the label (12 inches) inboard from the edge of the bumper tube on the curbside.



Weld Specifications - recommended

- i. Aluminum wire per AWS A5.10 ER 4043
- ii. 100% Argon Shielding Gas

SRT = 2 HRS