

Floor Cracks Repair

Front Panel
VN, VHD, VAH, VT**FSB 811-005, Floor Cracks Repair (Front Panel)**

(October 2012)

For VN, VHD, VAH and VT vehicles requiring front floor panel repair due to early stage cracking, utilize the following procedure to complete the repair.

Required Parts

- 1 - 85121636 Floor Panel
- 2 - 84020594 Floor Panel Re-inforcement

Note: Information is subject to change without notice.
Illustrations are used for reference only and can differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

Procedure

You must read and understand the precautions and guidelines in Service Information, group 8, "General Safety Practices, Cab" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.



WARNING

When disassembling cab components, sudden movements, caused by stresses in the structure, can occur. Surrounding components can shift or fall down when components are removed.

Note: For information about welding and safety, read Function Group 810, Information Type Repair Body Panel, Replacement.

Note: The same illustrations are reused for different variants. Some details may differ from the variant you are working on. However, the essential information in the illustrations is always correct.

Note: This procedure begins with the interior removed. For information on how to remove the interior, refer to Function Group 85.

Note: This procedure is only to be used when floor damage is inboard of the floor longitudinal crossmembers.

- 1 Secure the vehicle for service by parking it on a flat level surface, applying the parking brake, chocking the rear wheel, and placing the transmission in neutral.
- 2 Disconnect all cables from the negative (ground) and positive battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
- 3 Remove the engine cover.
- 4 If applicable, remove the transmission shifter.

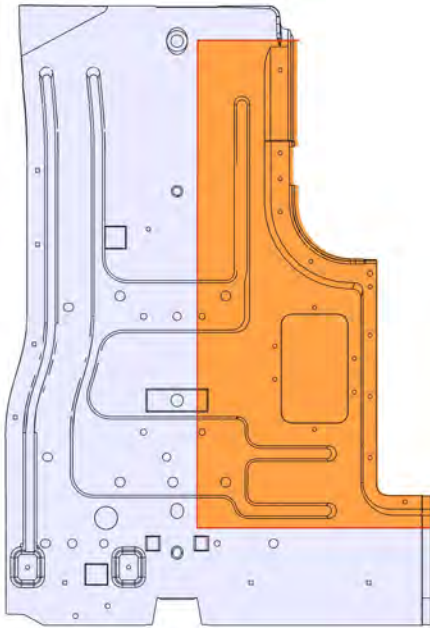
5 Inspect the repair area.



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6 Remove the shifter floor panel and accessory access panel.

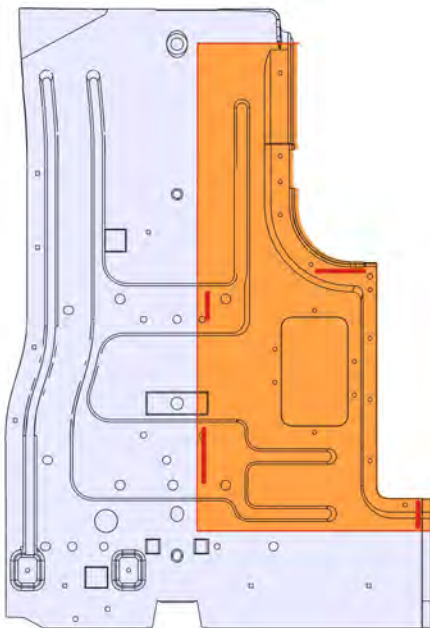
7 Layout the repair area.



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8 Drill out the spot welds in the repair area.

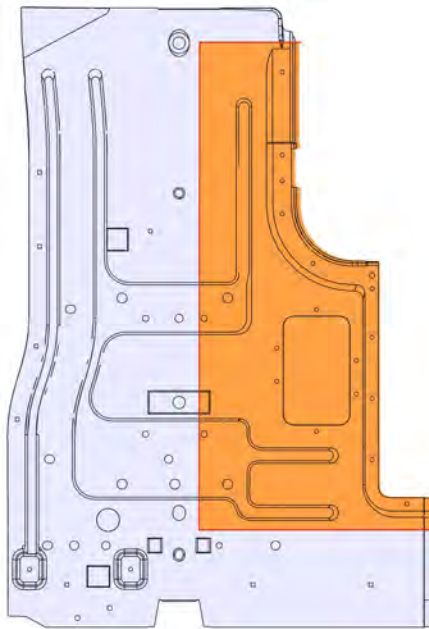
Note: The amount spot welds can be different for each repair.



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- 9 Using a cut off tool, cut out the damaged floor section.

Note: The illustration shown is meant as a representation only. The exact size and shape of the damaged floor section to remove depends on the extent of the damage.

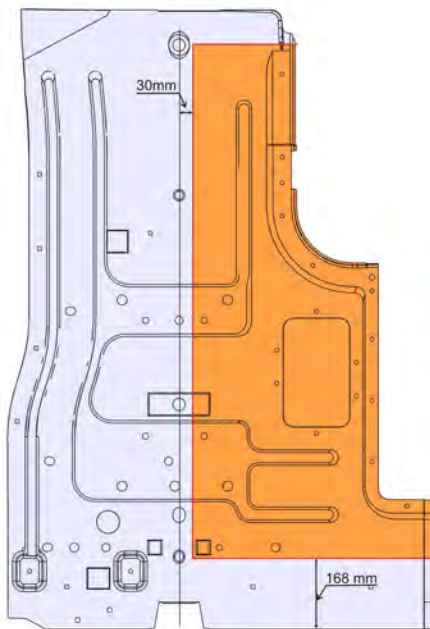


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- 10 Grind off the spot welds.

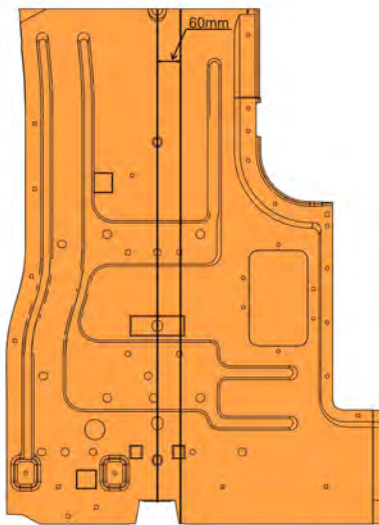
11 Layout the patch panel.

Note: The patch panel must have a minimum of 25 mm (1 in.) overlay on all side of the area being patched.



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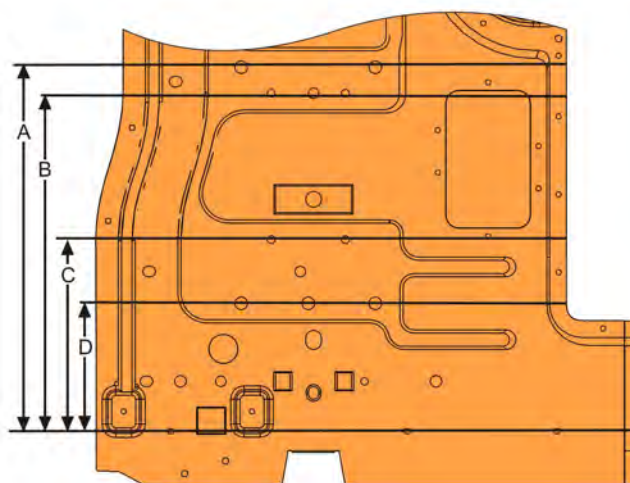
12 Layout the hole location on the floor according to the image.



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13 Layout the hole location on the floor according to the image and table.

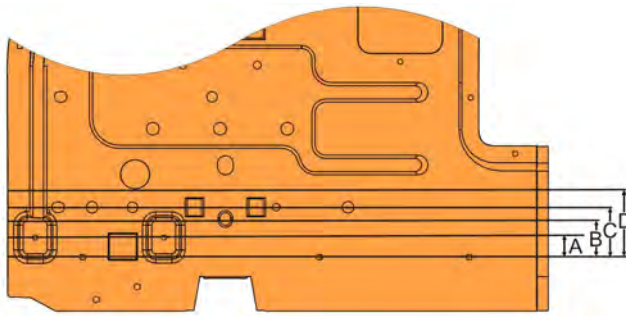
	Dimension
A	697 mm (27.5 in.)
B	637 mm (25.0 in.)
C	361 mm (14.0 in.)
D	241 mm (9.5 in.)



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14 Layout the hole location on the floor according to the image and table.

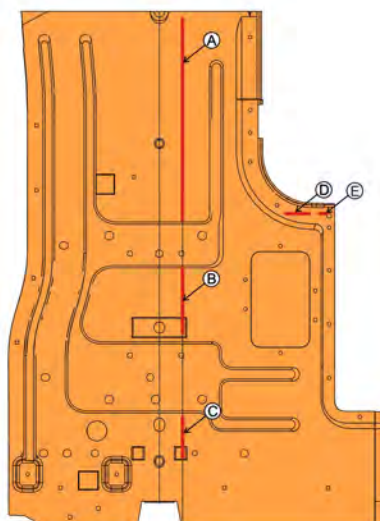
	Dimension
A	45 mm (1.75 in.)
B	67 mm (2.6 in)
C	94 mm (3.7 in.)
D	123 mm (4.8 in.)



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15 Drill 6 mm (1/4 in.) holes in the floor panel according to the image and table.

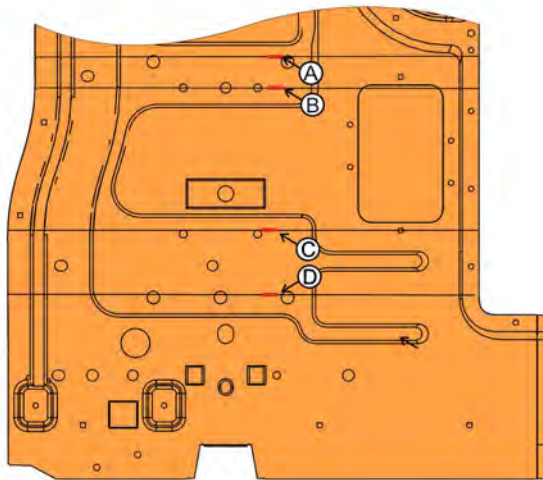
	Number of Holes	Distance Apart
A	15	40 mm (1.5 in.)
B	4	45 mm (1.75 in.)
C	3	45 mm (1.75 in.)
D	2	30 mm (1.2 in.)
E	1	N/A



W8034401

16 Drill 6 mm (1/4 in.) holes in the floor panel according to the image and table.

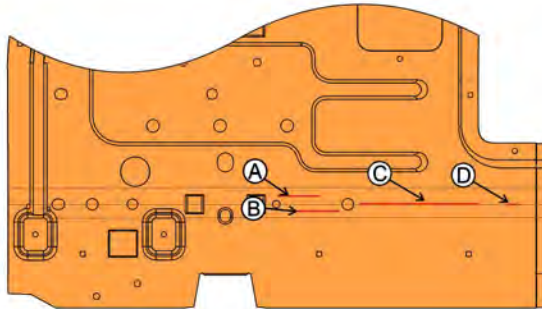
	Number of Holes	Distance Apart
A	1	N/A
B	1	N/A
C	1	N/A
D	1	N/A
E	1	N/A



W8034402

17 Drill 6 mm (1/4 in.) holes in the floor panel according to the image and table.

	Number of Holes	Distance Apart
A	2	40 mm (1.5 in.)
B	2	40 mm (1.5 in.)
C	6	30 mm (1.2 in.)
D	1	N/A



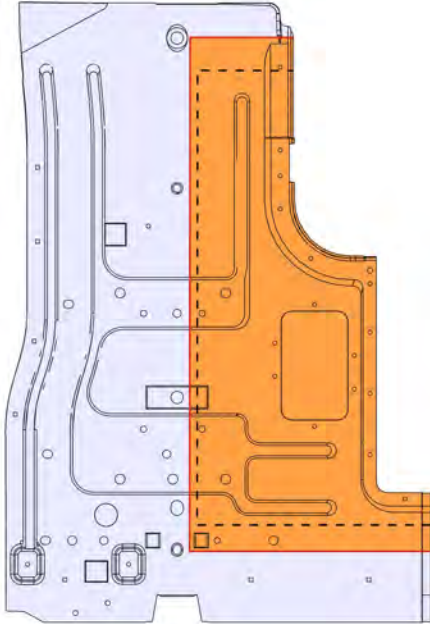
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18 Cut out the patch panel.

19 Install weld studs.

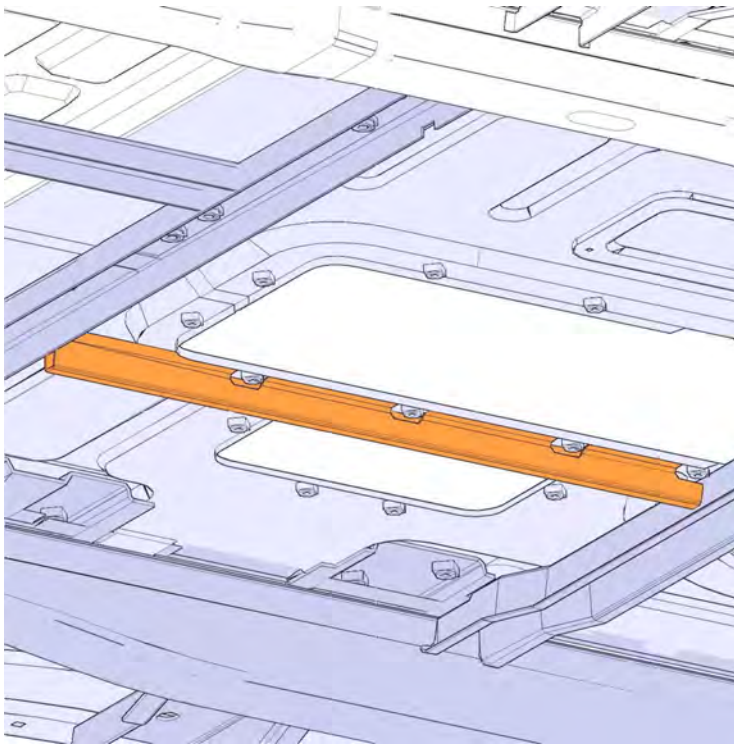
20 Grind off the edges of the replacement panel to be prepared for welding.

21 Lay the replacement section of floor panel on top of the panel for a test fit. Position the floor support brace underneath the floor patch. Once the proper fit has been obtained, secure the panel and floor support brace with clamps



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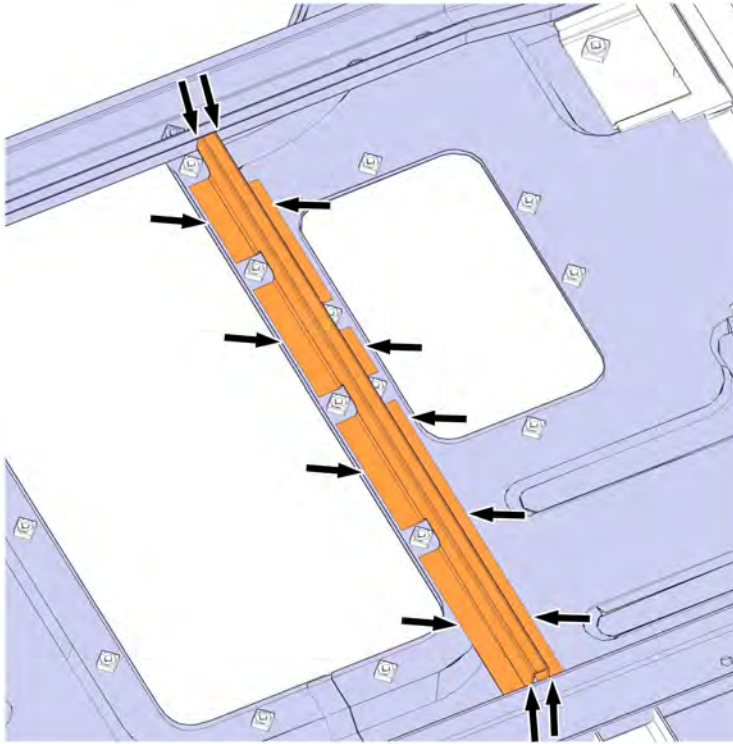
22



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- Weld four (4) tack welds on the vertical wall of the floor support brace to the cab crossmembers. Remove the floor patch panel and finish welding the floor support brace.
- 23 Install the replacement patch panel and weld into position.

24 Where the floor patch panel attaches to the support brace, plug weld in the nine (9) locations.

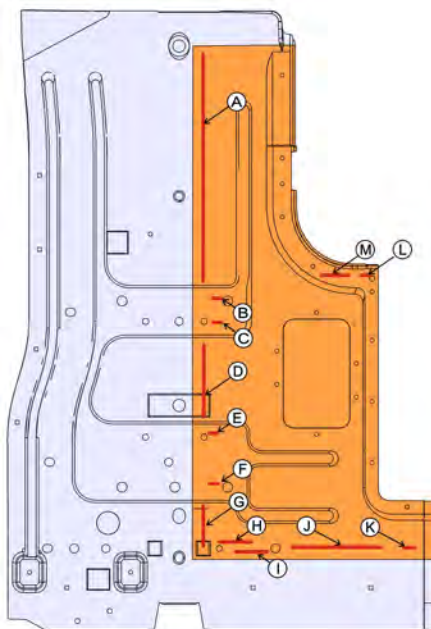


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25 Where the floor patch panel attaches to the support brace, clean and grind all the welds and seams.

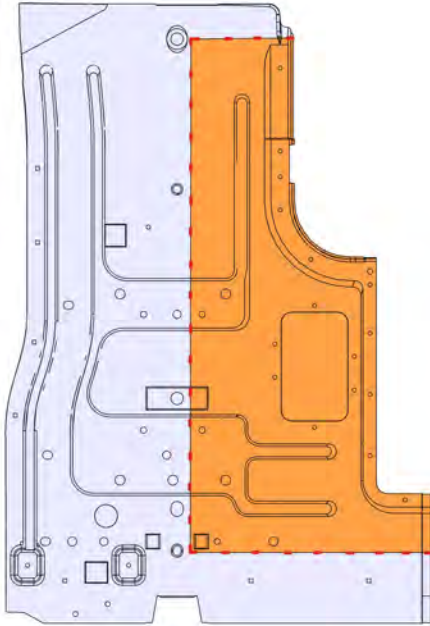
26 Plug weld according to the image and table.

	Number of Welds
A	15
B	1
C	1
D	4
E	1
F	1
G	3
H	2
I	2
J	6
K	1
L	1
M	2



W8034590

27 Seam weld the perimeter of the patch panel using 13 mm (0.5 in.) welds every 38 mm (1.5 in.).



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28 After the welding has been completed grind off all of the spot welds and apply Seam sealer to all joints and welds.

29 Apply primer coat to both sides of the repaired area.

30 Apply paint to both sides of the repaired area once the primer has cured.

31 If required, Install the shifter floor panel and accessory access panel into position. Torque the fasteners to 24 ± 4 Nm (18 ± 3 ft-lb).

32 Install the engine cover. Torque the fastener to 24 ± 4 Nm (18 ± 3 ft-lb).

33 Install interior. For information on how to install the interior, refer Function Group 85.

Note: Cover unused holes with sealant backed aluminium tape.

34 If applicable, Install the transmission shifter.

35 Reconnect all previously removed cables to the negative (ground) battery terminals.

Reimbursement

This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	W
Labor Code	
Primary Labor Code	81102-2-00 15.7 hrs.
Causal Part	85121636

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