



Process Title:	Cracked Rear Corner Post Repair (Non-Foam Filled)	Effective Date:	8/19/2013		
Originator:	Missy Criswell	SG #:	035	Revision Level:	B
Department Affected:	Service Repair Centers	SG Approval:	Corp. Director of Quality - Greg Kunze		
Required PPE:	Safety glasses, weld helmet / glasses, weld gloves, face shield, steel toe shoes, ear plugs				
Required Tools:	Drill, 17/64 & #11 drill bits, welder, 4" grinder, wire cutters, clamps,				

### Job Steps with Visual Reference

#### STEP 1

Remove all tail lights, grommets, and wires. Protect the tail lights wires while the repair is being done.



#### STEP 2

Use grinder to grind down the affected welds, top and bottom, until smooth.



#### STEP 3

Drill a hole at the end of the cracked weld.



#### STEP 4

Fill the drilled hole and the ground down weld with a new weld to repair the crack.



#### STEP 5

Secure the affected parts with a clamp as shown.



#### STEP 6

Make sure that all parts are square before continuing to step 7.



**STEP 7**

Grind down all the welds where gussets will be installed in later steps.



**STEP 8**

Install the boomerang gusset, part # 019039. This shall be placed in the upper corner where the header and the corner post meet, each top corner. Stitch weld on all sides.



**STEP 9**

Install the 8" x 8" triangle gusset, part # 019003. Align and clamp the gusset in place. Tack weld and check for proper placement before completing the welds.



**STEP 10**

Stitch weld triangle gussets on all available sides.

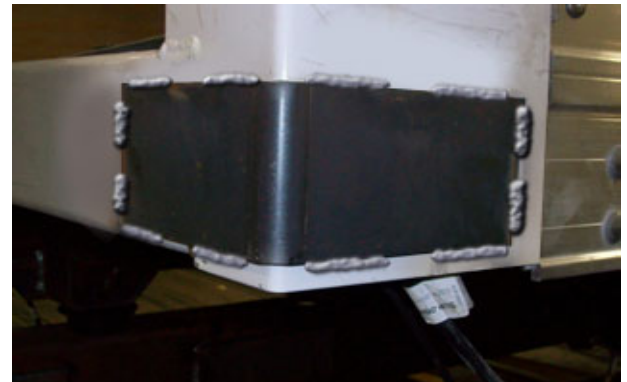
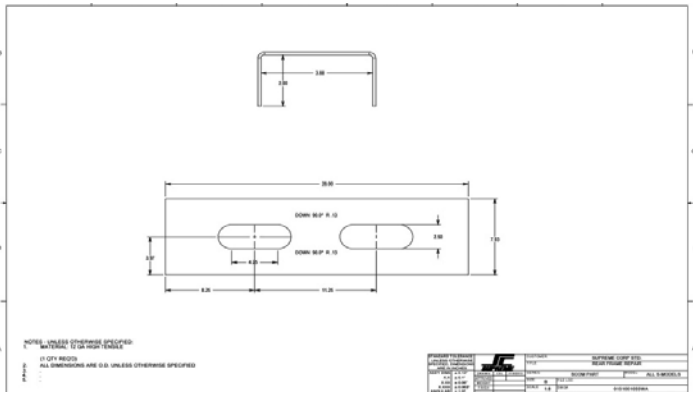


**STEP 11**

Install the 60 series corner post repair bracket, if applicable, part # 0151001055WA. Place this part over the rear corner post light holes, flush with the threshold. Weld on all sides.

**STEP 12**

Install the wrap around gusset, part # 015572683. Install on bottom of each rear corner post. Stitch weld on all sides.



**STEP 13**

Prep/clean the affected areas for paint. Once paint is applied the repair is complete.



**STEP 14**

Re-install grommets, lights, and light wiring and verify light function.

