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| Process Title: | Cracked Rear Corner Post Repair (Non-Foam Filled) | Effective Date: | 8/6/2013 | | |
| Originator: | Missy Criswell | SG #: | 035 | Revision Level: | A |
| Department Affected: | Service Repair Centers | SG Approval: | Warranty Manager - Henry Yoder | | |
| 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. 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.



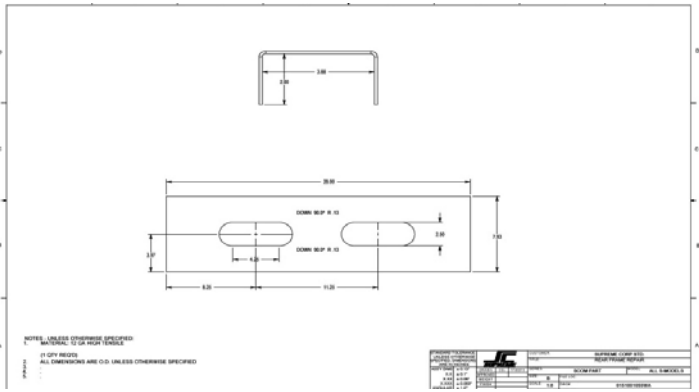
STEP 10

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. 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.

