

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR843	Securing Rear Wall To Floor	1 OF 1		SER-E	C.WARD	7/14/2017

Read process before beginning. If you do not understand any part please contact: Chris Ward, VP of Parts and Warranty at 1-866-953-5555 or by E-mail @ cward@ARBOCSV.com.

Good Mechanics safety practice must be followed on any repairs.

Safety practices should include but not be limited to properly supporting the chassis, axles, blocking tires, and a work area free of clutter.

Complaint: Rear Wall gapping at wood floor connection

Cause: Securement Fasteners missing

Correction: Add 993561 (Self-Tapping Screws) to secure center of wall to structural steel floor at bumper connections

Vehicles Affected: Vehicles with gaps between wood floor and rear wall

Labor Operation Code: 027801

Labor Time Allowance: .5 hours per unit

Parts Returned: No

Tools Required

Parts Required

1406406 Sealant, Sika Fast Cure MP75AM 400ML Black
993561 Screw, 1/4-20 X 1 1/2 PHIL FLAT TY F ZN (QTY 2)

Repair Instructions:

Step 1: Remove bumper and bumper bezel

Step 2: Apply Black Sika to the rear wall where the wood floor meets

Step 3: Approximately 1-3/4" above the frame rail, drill a 1/2" hole through the exterior skin and tube on rear wall (1 above each bumper mount)

NOTE: Approximate location of the hole is either side of the bumper to the bezel dimples



Step 4: Inside the 1/2" hole, drill a 7/32" through the rear wall and floor framing (1 above each bumper mount)

Step 5: Install self-tapping screws to close the gaps (1 above each bumper mount)



Step 6: Re-caulk interior floor (where needed)

Step 7: Re-install bumper bezel and bumper