



CorroGuard Repair Procedure on a Support Gear Leg

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Great Dane L.P.

9-03-10232017



General Notes

- Ensure that the trailer is properly supported. Use wheel chocks to prevent movement of the trailer. If support gear must be removed, support front of trailer with an approved device.
- Post a sign on the trailer indicating not to move trailer, repairs are in process (Man in Trailer).
- Wear proper PPE at all times.



Required Material

3M Underseal Undercoating

- Great Dane Part Number: MMM 08882
- 3M number: 08882
- Container Size: 20 oz.
- Paintable: Yes
- Rubberized Type: Yes
- Application Method: Aerosol Can
- Color: Black
- Volatile Organic Compound (VOC): 38% weight
- 1-2 cans needed per trailer.





Required Tools

- Box cutter (utility knife)—with extra new blades.
- Putty Knife
- Wire brush power wheel.
- Sanding Disks.
- Masking tape (not shown)
- PPE as required (safety glasses, gloves, work boots, etc.)





General Procedure

BEFORE STARTING THE REPAIR:

- *Inspect support gear legs for function. Correct any functional problems first before continuing with this repair. Leg replacement maybe required. Also check underside of sand shoe and replace if worn or badly bent.*



Corroguard Repair Procedure:

- Trim bulging, loose Corroguard with a sharp knife. Remove until the Corroguard remaining is firmly attached.
- Remove loose, flaking rust with a wire brush power wheel. Clean all loose debris, dirt, and dust from the repair area.
- Thoroughly apply a first coat of 3M Underseal 08882. Allow to cure for 20 minutes.
- Apply a 2nd coat of 3M Underseal 08882. Allow to cure before placing back into service.

See Details on the following slides.



Identifying Loose CorroGuard

If CorroGuard is loose and can be lifted, repairs should be made. The photos below were taken from ground level looking up at the bottom of the upper telescoping leg.





Identifying Bulging CorroGuard

If CorroGuard is bulged, it has broken loose from the parent metal and there is rust behind the Corroguard. The Corroguard must be cut away and repairs made. See the “Repair Procedure” slide that follows.





Repair Procedure

1. As Found.

(Complete leg removal from trailer is not necessary, but K-brace may require removal. If so first support trailer properly.)



2. Remove loose CorroGuard.



3. Grind away rust dirt and debris w/ Wire Power Wheel.



4. Apply two Coats of 3M UnderSeal, spaced 20 minutes apart at room temperature.





Re-attaching K-Brace, Completion.

- Check K-Brace for rust. Using the same procedure described before, remove loose Corroguard, wire brush away rust and debris, and apply 2 coats of 3M Underseal
- Re-attach K-Brace, torqueing the $\frac{3}{4}$ " Grade 8 bolts to 350 ft-lbs.
- Check for any other areas of loose or bulging Corroguard and apply the same repair.
- Perform a final functional check on the Support Gear before returning to service.

