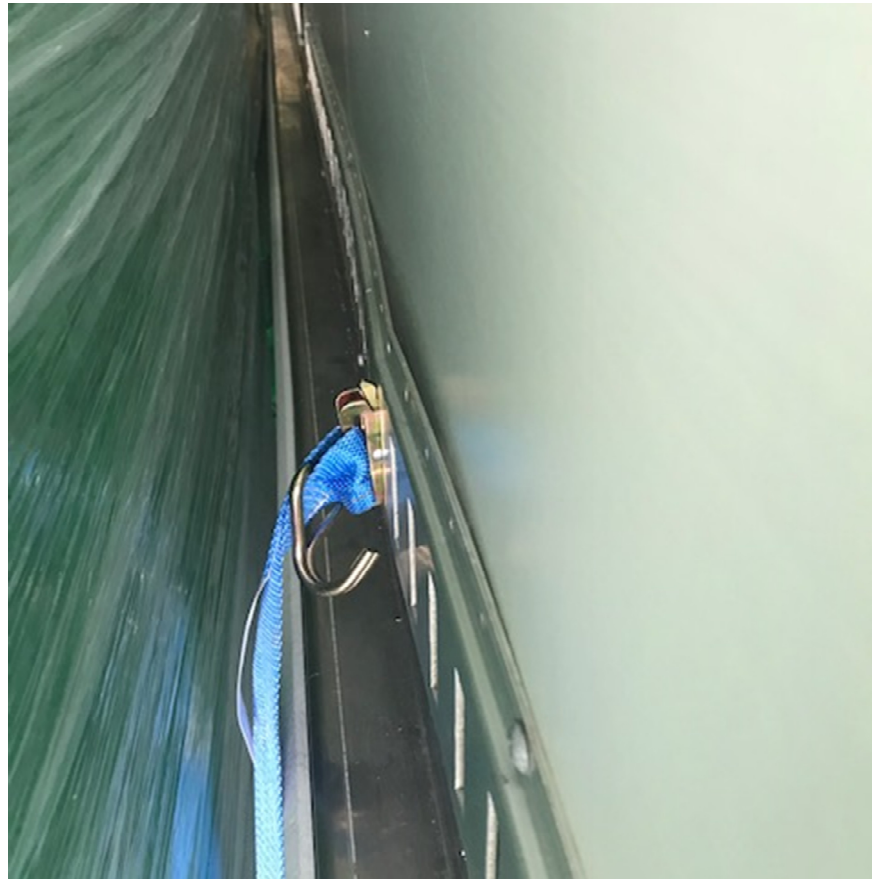




# AL track repair & reinforcement

1



Great Dane Engineering  
October 2018

*Great Dane*



## Parts List:

- (16) 41202546, BND, BACK-UP REINF TRK, 6.50"x144.00"
- (276) 42203548, RVT, AL UNIV HD .25DX.69
- (384) 42206342, CPSCW, HH NC ZN .31-12X2.00
- \*42600091, TRK, CRGO SER A AL 308" \* (QTY AS NEEDED)
- (7) 42301460, ADHSV, UNISEAL 5007.4S

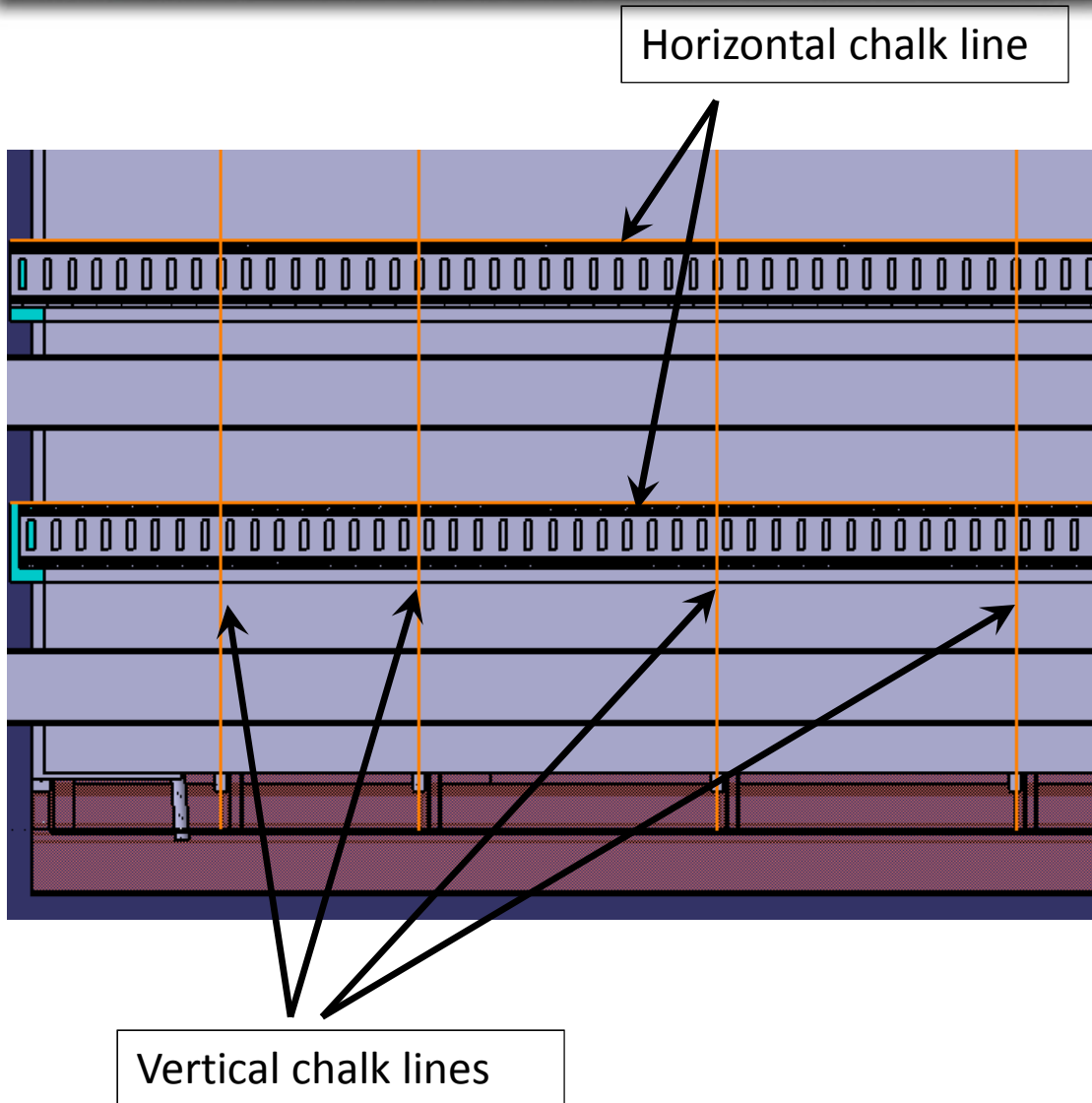
## Tools needed:

- Pneumatic riveter
- Pneumatic or electric driver
- Isopropyl Alcohol
- Chalk reel
- 0.265" drill bit
- T27 torx bit
- 1/2" socket



# Procedure

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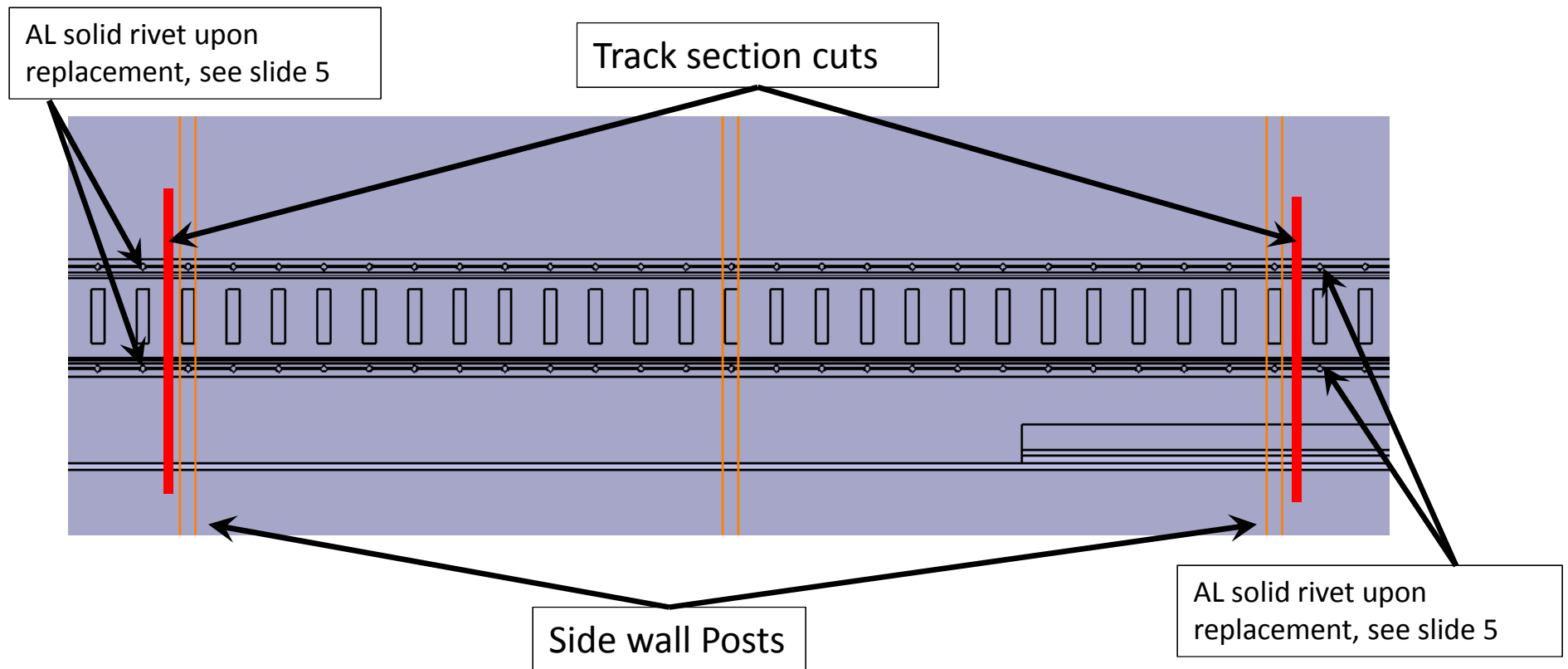


- Before the cargo track is removed from the trailer, make a chalk line mark located 0.665" inches above and parallel to the top edge of the track. This will be used to locate the reinforcement backer.
- It may be helpful to mark the track to locate where the post screws will go. The track may now be removed. Make vertical chalk lines indicating the location of the existing screw holes in the liner.



# Replacing damaged track sections

- For sections of damaged track, cut away the track at a location centered between fastener holes and close to the upright locations. Locations to cut should be marked prior to track removal from the sidewall.
- When replacing sections of track, use a minimum section length of 4 feet. Replace no more than 2 sections, spaced a minimum of 6 feet between sections. If these guidelines cannot be met, replace the entire track length.

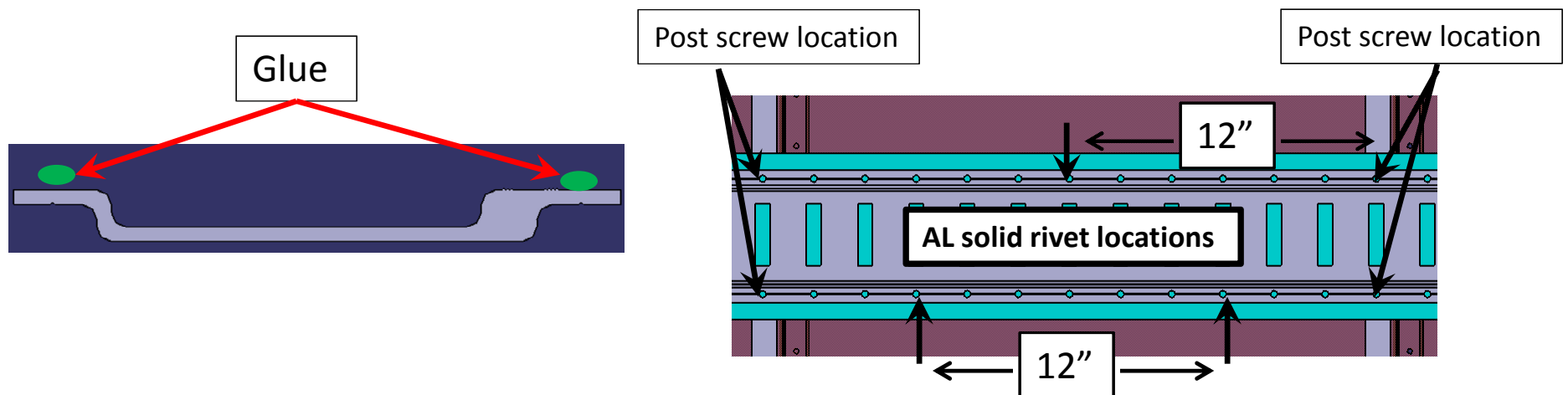




# Procedure

5

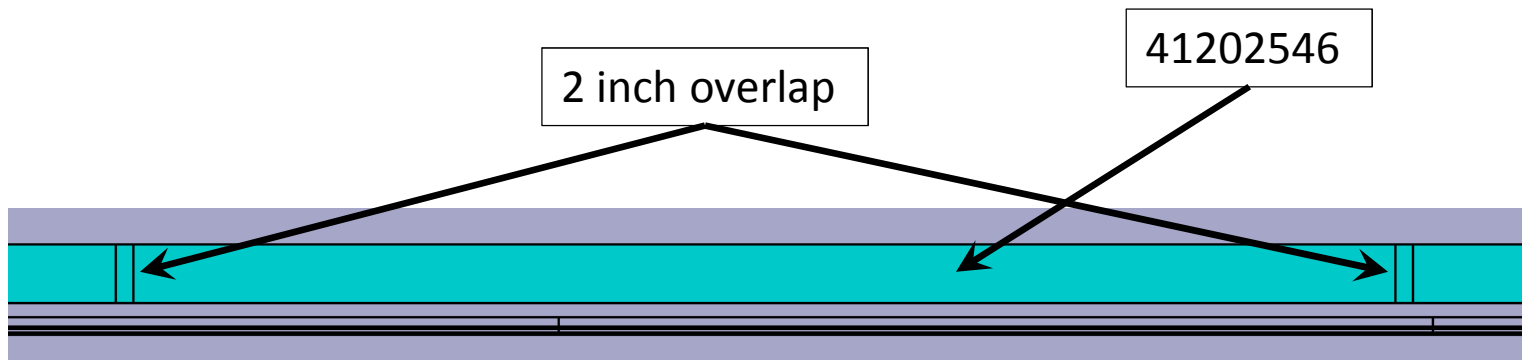
- With the track removed from the wall, thoroughly clean the surfaces of the track and the reinforcement backer 41202546 that will be bonded. Isopropyl alcohol should be used.
- Place ~ 3/16"- 1/4" glue bead of 42301460 along the length of the track section, on top and bottom mating faces. Center the track onto the backer leaving 0.665" to the free edge. Use a clamp to hold the track and backer together. It may make sense to focus on one 144" section of track at a time. Glue 'Time-To-Handling Strength' is 40 minutes.
- Once clamped together, match drill from a pre-punched track hole and place a rivet 42203548 to hold the components together. Be sure to place all rivet heads on the **LINER** side. A typical 24" post section is shown for reference.  
Where sections of damaged track are cut away, it will be necessary to place additional fasteners at the ends of the cut section. Refer back to slide 2 if necessary.





# Procedure

- Glue and fasten all remaining backer reinforcements.
- Overlap sections of backer 41202546 by 2". The final overlap may be increased to avoid excess protruding forward of the original track location. The front to rear dimension of the installed backers should match the original total length of installed track.



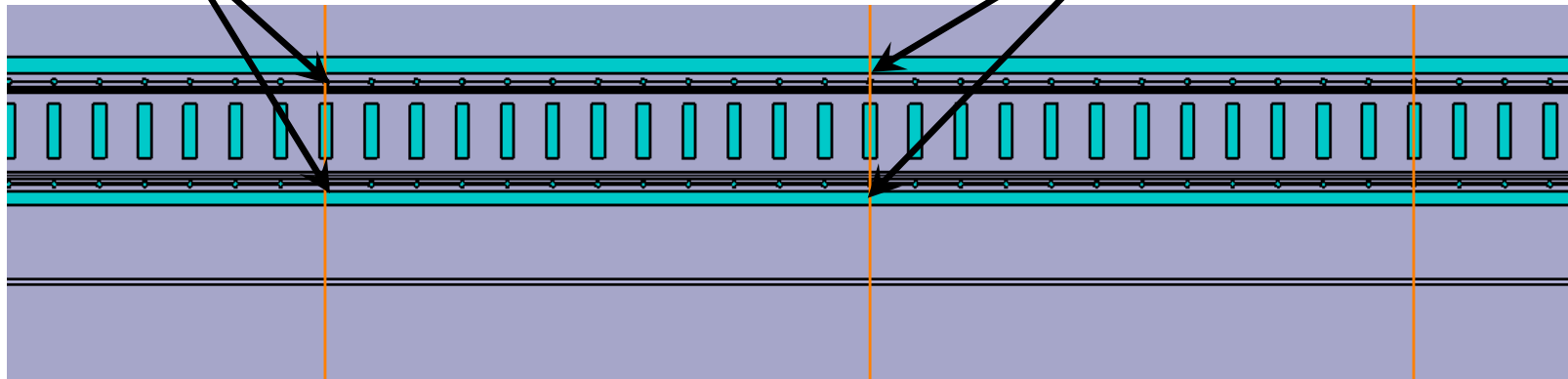


# Procedure

- With reinforced track section now assembled, align the top edge of reinforcement backer plate with the horizontal chalk line previously made. One screw may be placed at the front and rear into a Side Wall post marked with vertical chalk lines to hold the section in place. Position screws down 0.33" from the top edge.
- Fasten the track to the posts using 0.313" screws, top and bottom. Fastening the backer to the posts can now be finalized, using (2) 0.313" screws at each post location. There should be a total of 4 screws at each post location. Slide 8 displays a reference detail for fastener placement.
- Repeat slide 2-7 for all remaining track locations.

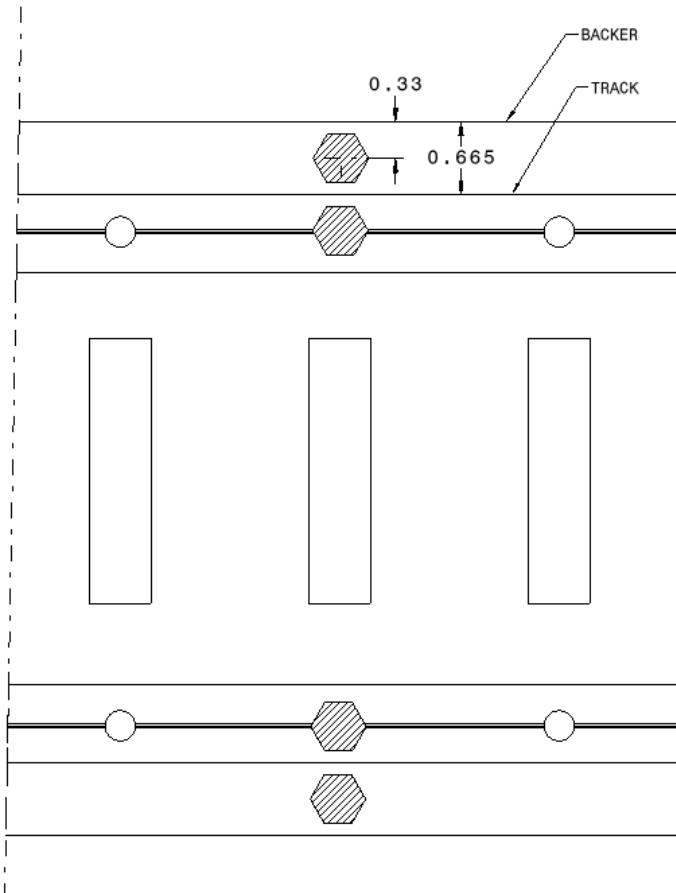
0.313" screws top & bottom of track; typical each sidewall post

0.313" screws top & bottom of backer; typical each sidewall post

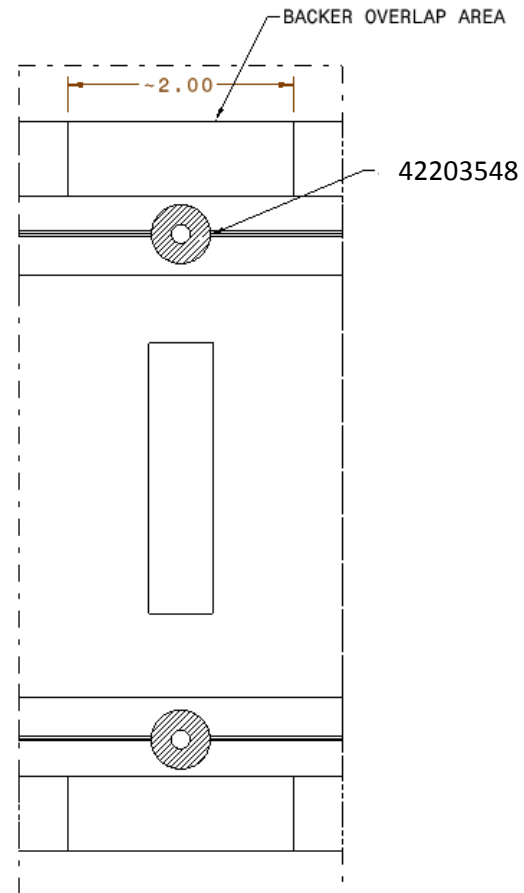




### Typical screw detail at post location

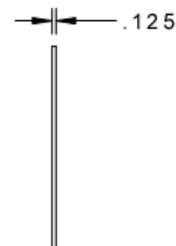
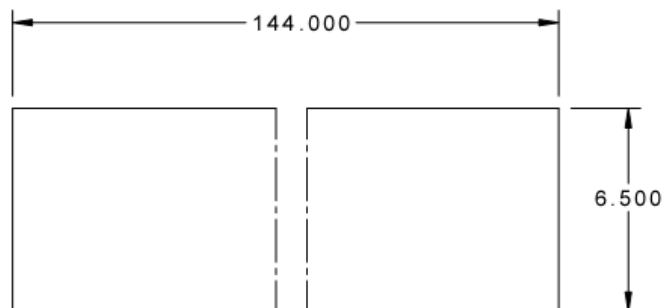
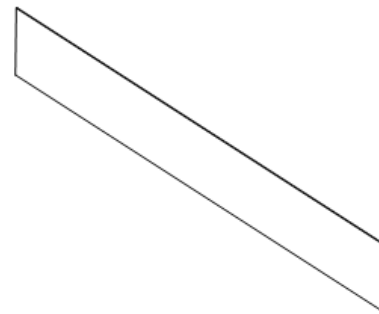


### Solid rivets at all backer overlaps





<b>REV</b>	<b>DWG NO:</b> 41202546	<b>DATE</b>	<b>BY</b>
-	NEW	10/09/2018	BWS
		CN 182152543	



MATERIAL: 6061-T6AL 0.125X6.500X144.00



**Great Dane Trailers**  
A Division of Great Dane Limited Partnership

ALL DIMENSIONS ARE IN INCHES.

DWN BY: B.Stephens  
10/09/2018

CN  
182152543  
WEIGHT  
11.4661b

**DWG TITLE:**  
BND, BACK-UP REINF TRK  
.125X6.50X144.00

TOLERANCES TO BE ±0.050  
UNLESS OTHERWISE NOTED.

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**SHEET:** 1 OF 1

**DWG NO:** 41202546

**REV:** .