

## ANCRA Track Replacement (Surface Mount)

See Video for Visual Instructions

May 21, 2019

### **Introduction:**

This procedure addresses the repair and replacement of an ANCRA safe stack track on a composite sidewall panel on trailers manufactured by XPO Manufacturing. Our objective is to show a safe and efficient method for repairing, removing, and reinstalling an ANCRA track.

### **Labor Requirements:**

Replacing an ANCRA track with composite side panel requires two qualified mechanics using the proper tools and equipment, as outlined in this procedure. The standard repair time per panel will vary depending on the style. Approximately times will be between 30 to 90 minutes. This procedure is written based on a proven shop practice for replacing a single ANCRA track on a composite side panel. It identifies critical areas of concern. If read and followed, it will increase safety and efficiency as well as prevent further damage to the trailer.

**⚠ CAUTION: Individuals who work with composite side panels are advised to always use proper safety equipment, including: safety glasses, hearing protection, cut-resistant gloves, steel-toed shoes, knee pads, and face shields, etc.**

### **Tools and Equipment Required:**

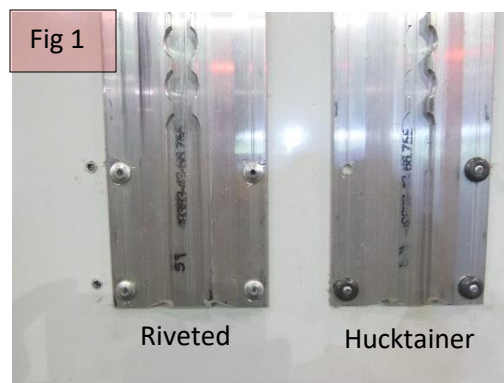
- Hand-held 3/8" air drills with 3/8" (.375) bits.
- Huck Gun 2025 P/N: 99-3464
- Pneumatic chisel w/ tapered 1/8" punch tip
- Punch tapered tip 3/16"
- Pneumatic chisel w/ chisel bit
- Hucktainer bolt's (HUCK HLPWCW-R12-8PL) (6000410)
- Hucktainer collar (HUCK HLPWCSC-R12) (6100410)
- 8 ft. ladder for inside and a 12 ft. ladder, manlift, or scaffold for outside
- Oscillating saw with a 5.5 cut-out knife blade
- Small screwdriver style pry bar
- Interior lighting for safe work inside the trailer, plus an electrical extension cord
- Scraper for removing adhesive
- Safety equipment: safety glasses, hearing protection, cut-resistant gloves, steel-toed shoes, knee pads, and face shields, etc.

## Trailer Setup:

Completely unload the trailer and park on a level shop floor. Chock the rear tires to prevent any moment of the trailer. Clean out any debris out of the trailer. Place an interior lighting inside and verify safe environment.

## Removing the Damaged ANCRA Track:

Composite side panels have one vertical column of rivets located on each side of the track to secure ANCRA safe stack tracks. First verify the mounting style of the tracks (Fig 1) and located the damaged track. After inspection of the track proceed to the mounting styles listed below.



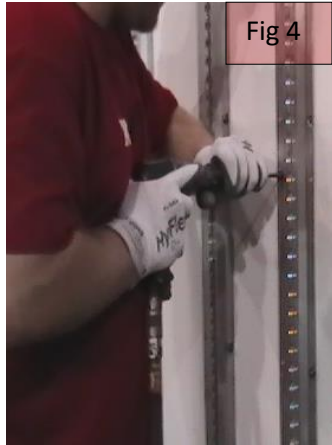
### Pop Riveted Mount

1. Equipped with an air hammer/chisel tip, mechanic will need to shear (cut off) the rivet button heads across the lower half of the track. Then proceed to shear (cut off) upper half of rivets that secure the track to the sidewall. Keep the chisel tip secured so as not to cut or gouge the composite sidewall panel (Fig 2).
2. Using an air hammer equipped with tapered punch 1/8" tip, punch out all rivet bodies from the vertical track seams that secure the tracks in place. This will force the rivet bodies from the panels, allowing the tracks to be easily removed (Fig 3). The track is now completely separated from the sidewall. If tracks are additionally glued proceed to Glue Mount Steps.



## Hucktainer Mount

1. Using an air hammer equipped with tapered punch 3/16" tip, punch out all Hucktainer from inside towards outside panel (Fig 4).
2. If Hucktainer fails to punch, revert to cutting collar off with grinder w/ cutoff wheel (Fig 5), and punch inside toward outside of panel. If tracks are additionally glued proceed to Glue Mount Steps.



## Glued Mount

1. Once rivets or hucktainer are removed, use the 2" masking tape outline both sides of the track to prevent scratches to the interior sidewall panels.
2. Using small screwdriver style pry bar, pry track up so that the oscillating multitool with 5.5" Cut-out Knife Blade (Fig 6) can be inserted between the sidewall and track (Fig 7). Carefully turn unit on and break the glue bond on bottom of the track.
3. Equipped with small screwdriver style pry bar, pry lower portion of track up from wall. Grab track and remove screwdriver. Now pull track away from the wall slowly (Fig 8). The track is now completely separated from the sidewall.

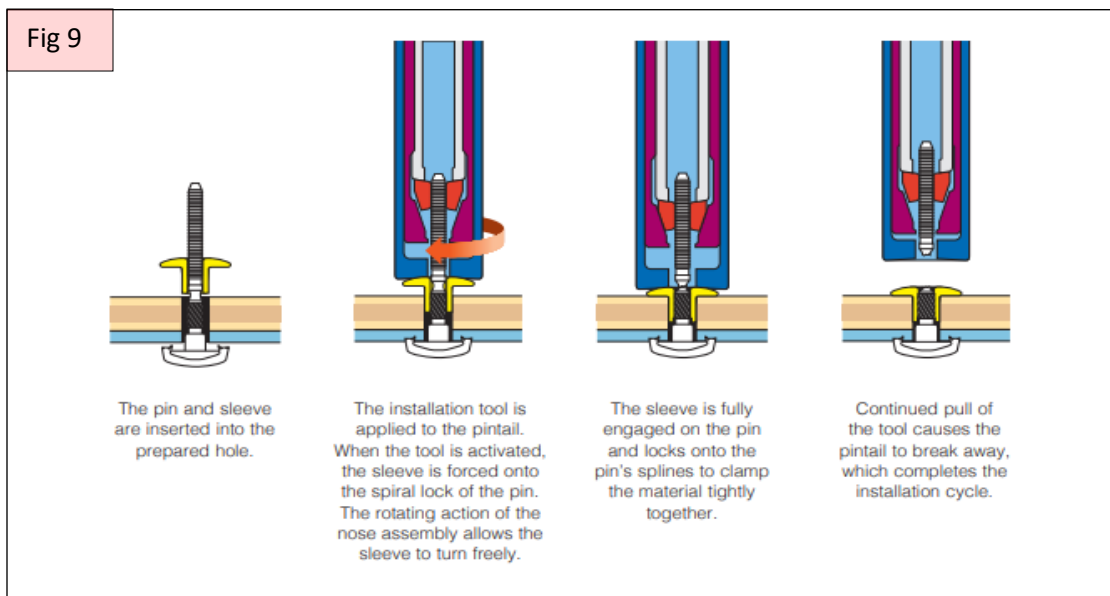


## Preparing Sidewall for New Track

1. If tracks were equipped with Hucktainer's proceed to step 3.
2. If tracks were equipped with Rivets, Drill out existing  $\frac{1}{4}$ " rivet holes to  $\frac{3}{8}$ " (.375) for preparation for the Hucktainer bolts in both sidewall and track.
3. Clean off all adhesive residue off the panel using a scraper where previous track was glued. If track was not previous glued proceed to wipe down all surfaces that will encounter the new track using alcohol. Sticky residue will attract and hold drill shavings, plus prevent maneuvering the new track into place.

## Installing New Track

1. Replace all previous rivets with Hucktainer fasteners. Insert Hucktainer from the outside into the sidewall through the track. Place Hucktainer collar onto the shaft, then use the Huck gun to properly seat the Hucktainer's (Fig 9).



## Complete the Repair:

1. Sweep out the interior and clean up all debris.
2. Install new decals if needed.