

## Door Frame Corner Reinforcement Update

June 4, 2020

### **Introduction:**

This procedure addresses the reinforcement of the lower corners of the door frame. The update applies to XPO trailers built from April 2017 to July 2018.

### **Labor Requirements:**

Replacing lower rear corner reinforcements should take one mechanic two hours when using the proper tools and equipment, as outlined in this procedure. This procedure is written based on a proven shop practice for replacing lower rear corner reinforcement blocks. It identifies critical areas of concern. If read and followed, it will increase safety and efficiency and will prevent further damage to the trailer.

**⚠ CAUTION: This repair requires welding on galvanized steel components. Ensure area is properly ventilated before beginning the repair procedure. The use of a ventilated welding hood and/or respirator is also recommended. Individuals working on repairs are advised to always use proper safety equipment, including: safety glasses, hearing protection, cut-resistant gloves, steel-toed shoes, and face shields, etc.**

### **List of Materials:**

NOTE: Customers can order the correct replacement material to specification by trailer unit number from XPO Manufacturing.

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

- Angle grinder
- Cutoff Wheel
- Sanding Discs
- Safety equipment: safety glasses, hearing protection, cut-resistant gloves, steel-toed shoes, knee pads, and face shields, etc.

## Trailer Setup:

Park the trailer on a level shop floor and chock the wheels. Raise door and verify surrounding area is safe to continue with the repair. Remove taillights to protect from heat damage. Drill out the rivets for the taillights and remove. Pull taillight harness away from corners where repair will be made.

## Removing the Existing Corner Reinforcement:

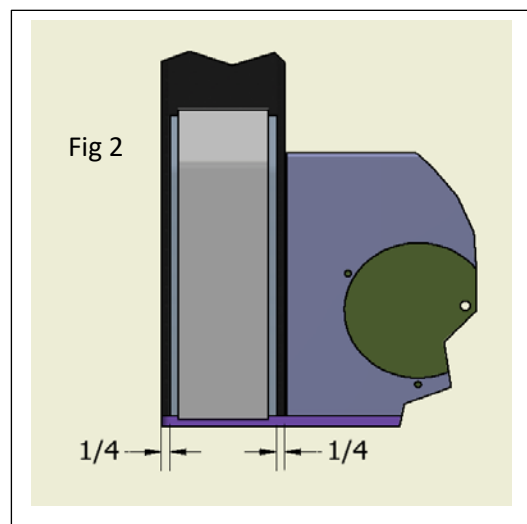
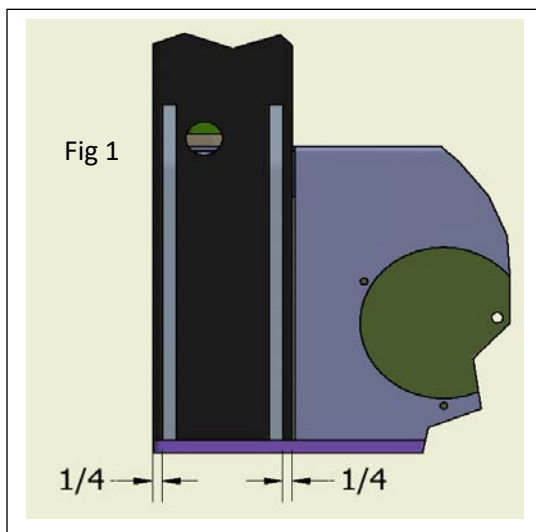
Locate the door frame corner guard, taillight guard, and taillight center guard. Removal will include the following steps:

1. Equipped with an angle grinder with cutoff with and safety equipment cut the welds holding taillight guards and corner guard. Roadside and Curbside will require the same procedure for removal. Once both are removed proceed to step 2. **Caution not to cut into the Door Frame or Door Seal during removal.**
2. Equipped with an angle grinder with sanding disc with and safety equipment grind the areas where the previous welds were located smooth.

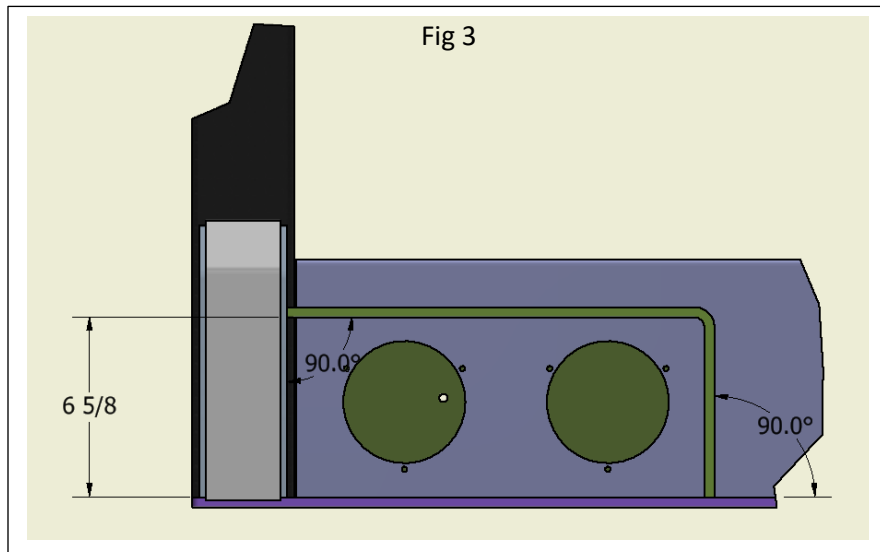
## Installing New Style Corner Reinforcement:

Using part 4300567 (4), 4300638 (2), 4300632 (2), and 4300362 (2) begin relocating these parts to the existing door frame.

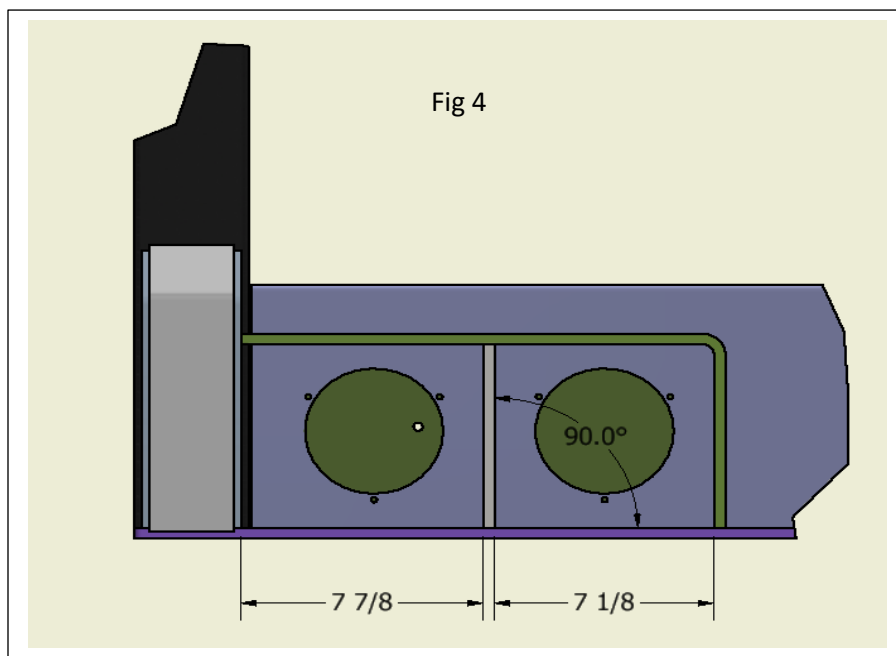
1. Start with Roadside, using parts 4300597 (2) locate flush with bottom door seal support plate with an spacing of  $\frac{1}{4}$ " from the sides of the RS door post as shown in Fig 1. and tack in place.
2. Using part 4300639 (1) locate flush with outer bottom door seal support plate and flush with parts 4300597 (2) as shown in Fig 2 and tack in place.



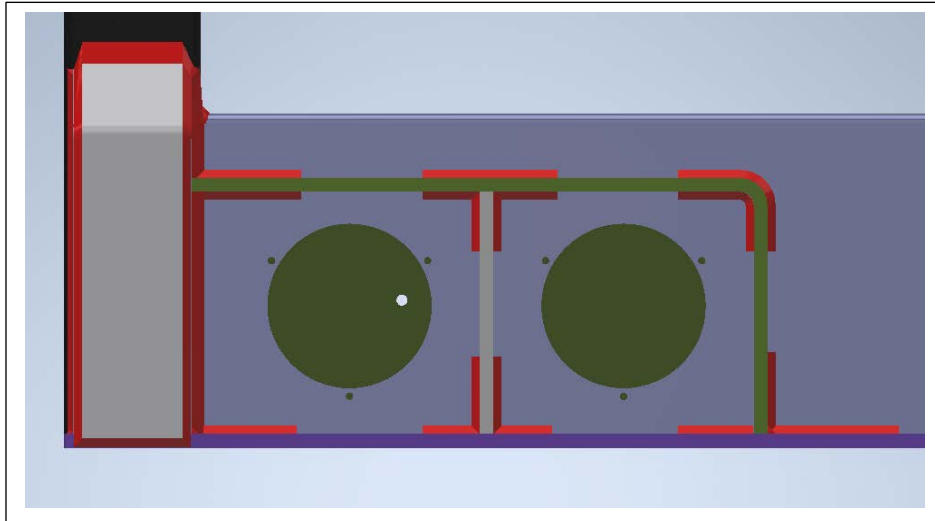
- Using part 4300638 (1) locate upper flush with right side of part 4300597 as shown in Fig 3. and tack in place. Caution level the horizontal with a level and part 4300632 (1).



- Using part 4300632 locate as shown in Fig 4. and tack in place.



- Using Fig 5. as a template complete welds using ¼" fillet welds.



- Now, repeat the process for Curb Side.
- After material has cooled down from the welds, prep the areas for painting.
- Clean any slag off and clean with alcohol.
- Either using silver spray paint or galvanized spray paint to paint the new reinforcement and surrounding area. Allow ample time for drying.
- Reinstall the taillights using rivets.

### **Complete the Repair:**

- Test all taillights for all functions.
- Sweep and clean the area where the repairs occurred.