

**Meridian Diesel Tailgate Lug Repair**

**Date:** February 03, 2022  
**Bulletin Name:** FEL-WI-017-A  
**Model:** Meridian 78 and 79

**Purpose:**

McNeilus Truck and Manufacturing offers these instructions for repairing the lugs on the Front Loader Meridian tailgate.

**Notice:**

- This work instruction should be read and understood in its entirety before performing this procedure.
- All procedures outlined in the work instruction must be performed by skilled service personnel. Refer to the product service manual for descriptions of maintenance procedures.
- This work instruction is confidential and limited to exclusive distribution within McNeilus sales and service branches.

**SAFETY NOTICE**

**Perform your company’s Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.**

**SAFETY NOTICE**

**Use appropriate Personal Protective Equipment (PPE) as required by your company.**

**Tools and Equipment Required:**

Customer to supply:

- Drill, 3/16” drill bit (for pilot hole) (0.188”), 27/64” drill bit (tap drill for 1/2-13 thread) (0.422”), 17/32” drill for bolt holes (0.531”)
- Small hand grinder with cutoff wheels and grinding discs
- Tap driving tool with 1/2-13 tap
- Torque wrench with 3/4” socket for 75 to 85 ft-lbs
- 3/4” wrench
- Marker for marking the cut-out
- 271 Loctite®
- Matching truck body color spray can of paint or primer
- Welder

**Parts Required (Order from McNeilus):**

Item	Part Number	Description	Qty.
1	1620306	BRACKET, STANDARD TAILGATE CYLINDER LUG, STREET SIDE WELDMENT	1
2	1620307	BRACKET, STANDARD TAILGATE CYLINDER LUG, CURB SIDE WELDMENT	1
3	1621305	PLATE, COVER, DIESEL	2
4	1136746	SCR, CAP, HEX .50-13 X 1.75 G8 ZY	25
5	120201	NUT, HEX, LKDT .50-13 G9 ZY	23

**PROCEDURE 1: Inspect for and repair cracking**

1. Perform your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate. Place the vehicle in park with the parking brake engaged, chock vehicle wheels, disconnect vehicle battery (see service manual for instructions if needed).
2. Inspect the lug outer weld for fatiguing and weld cracking (Figure 1 and Figure 2).

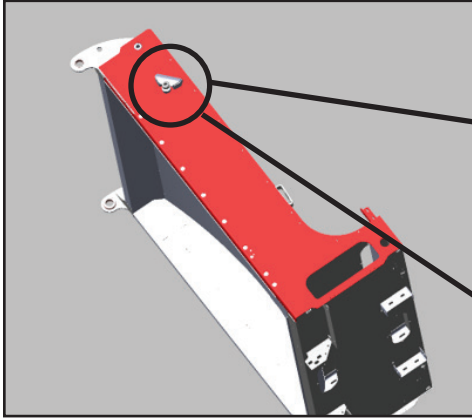


Figure 1

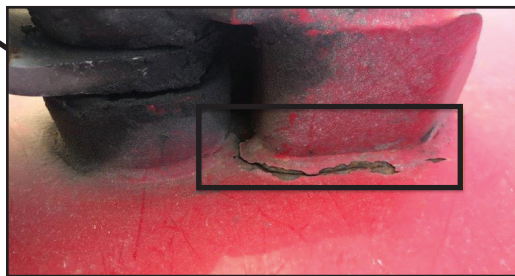


Figure 2

3. With the tailgate closed, starting on one side of the tailgate, disconnect the top end of the cylinder and move it away from the lug.
4. Grind weld where weld has fatigued and/or cracked (Figure 3).

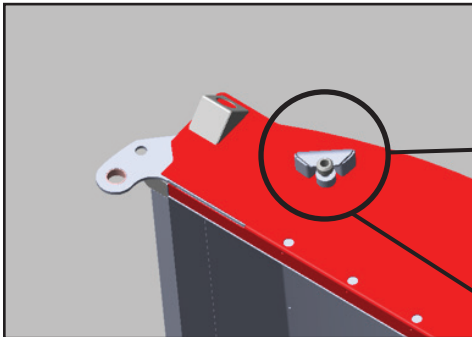
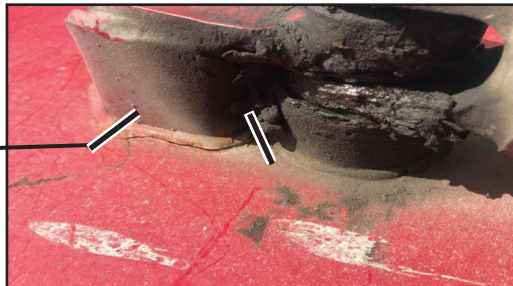


Figure 3



5. Reweld tailgate lug with 1/8" fillet weld.
6. Repeat steps 2 through 5 to the other side of the tailgate.

**Procedure 2: Install reinforcement**

1. If not already inspected, inspect the cylinder pins to ensure it is the correct pin. The correct pin will have two holes for greasing as shown in (Figure 5). If the pin is incorrect, replace with the correct part (PN 1619376). Purchase from StreetSmartParts.com or 888-686-7278.

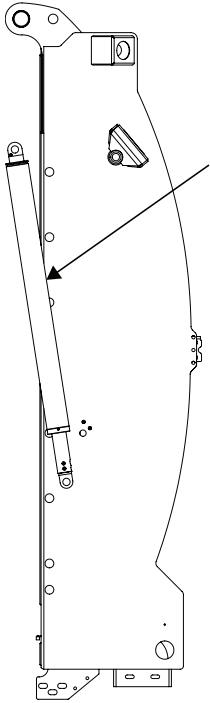


Figure 4



Figure 5

2. Use the cylinder mount pin to position the lug bolt template (Figure 6, Item 1) and rotate the template so the stop bolt (Figure 6, Item 2) touches the side of the lug. (Also for reference, cylinder pin is Item 3 in Figure 6).

**Important:** Make sure to use the correct parts for the side of the tailgate that you are working on.

**NOTE:** While it is possible to place the stop bolt in either outside hole location, it is recommended to put the stop bolt in the top hole so the weight of the fixture will keep it in place while the hole locations are marked.

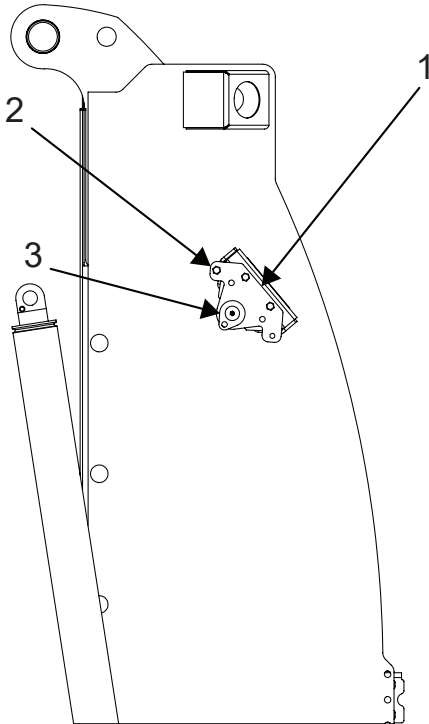


Figure 6

**This bulletin is limited to Internal McNeilus Use Only.**

3. Mark these hole locations and drill to 27/64" diameter (0.422Ø) (Figure 7).
4. Tap both 27/64" holes in the top of the lug with 1/2-13 threads.

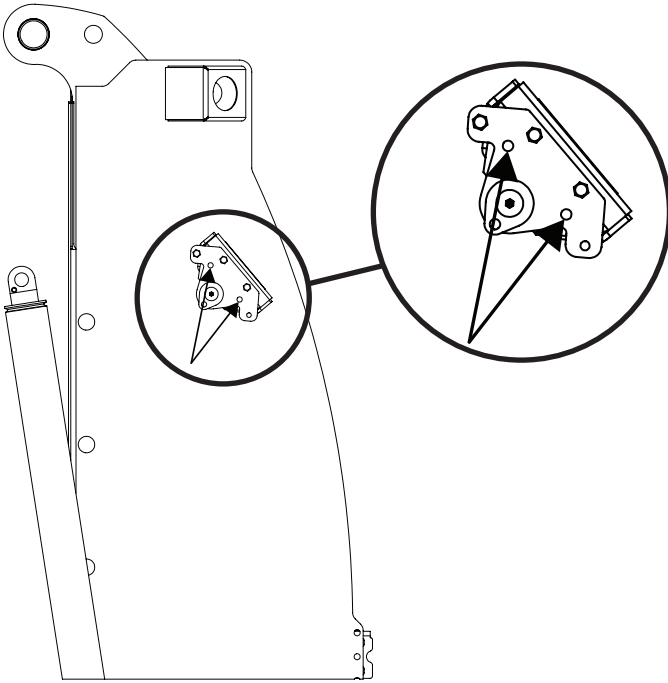


Figure 7

5. Mount the lug reinforcement bracket (Figure 8, Item 1) using the two 1/2-13 bolts in the top of the lug (Figure 8, Item 2). Tighten these bolts sufficiently that they hold the bracket in place and position the bracket parallel with the tailgate as described.

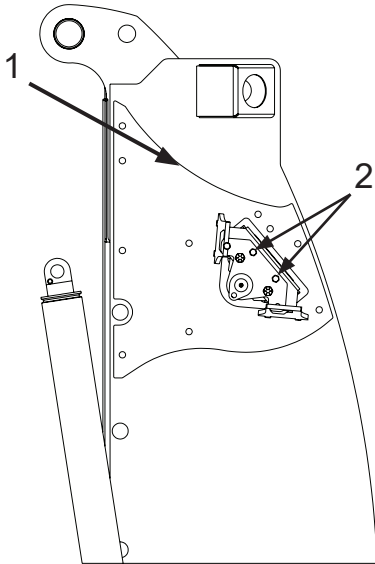


Figure 8

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6. Mark these ten (10) bolt locations and then drill all ten to 17/32" diameter (1.531Ø) (Figure 9).
7. Insert all ten 1/2-13 x 1.75" bolts. Locknut will be installed during a later step (along with proper torque values).

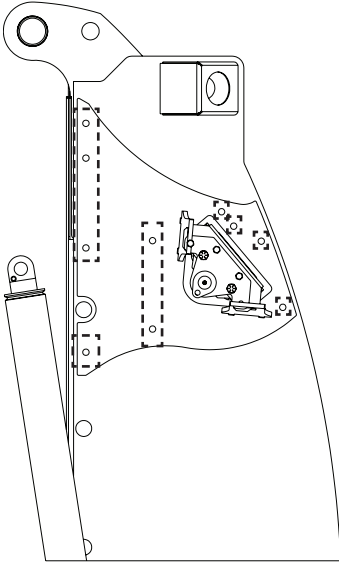


Figure 9

8. Pull each of these two top lug bolts, apply 271 Loctite, and reinstall.
9. Torque the two (2) top lug bolts to 75 ft-lbs.
10. Repeat steps 1 through 9 of this procedure on the other side of the tailgate. **Important:** Make sure to use the correct parts for the side of the tailgate that you are now on.
11. Remove your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.
12. Open the tailgate and engage tailgate safety props.
13. Perform your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.

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14. Align the cut template as shown and mark the inside shape (Figure 10, Item 1).

Notes on Figure 10: Item 2 – Foot end of cut template touches this face.

Item 3 – Align this edge with the face of the tailgate and the “foot” with the face shown.

Item 4 – Leave the inside panel material around this weld slot.

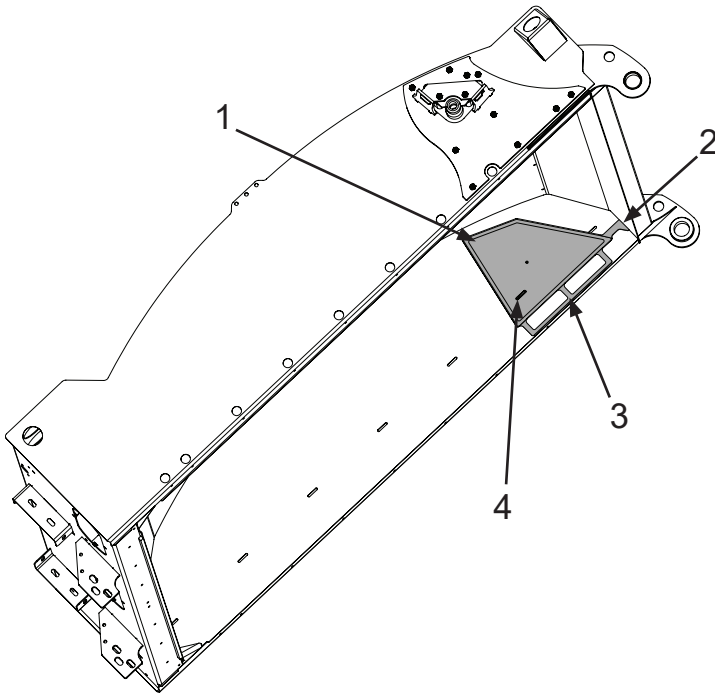


Figure 10

15. Cut out the marked section of the inside panel.

**NOTE:** Cut around the weld slot (Figure 10, Item 4) leaving the small part of the panel attached.

16. Assemble locknuts to each bolt from the inside of the tailgate through the access cut into the tailgate wall and torque to 90 ft-lbs.

17. Position the weld cover over the cut out in the inside side wall and weld all around the perimeter. The slot is positioned over the existing weld on the internal rib. Weld this slot closed tying it to the rib.

18. Repeat steps 14 through 17 to the other side of the tailgate.

19. Cycle the tailgate up and down. End the cycle with the tailgate lowered.

20. Procedures are complete. Truck may be returned to service.

21. Remove your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate. Disengage the parking brake, remove the chocks from the vehicle wheels, reconnect vehicle battery (see service manual for instructions if needed).



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