

Meridian and Atlantic CNG Tailgate Lug Repair

Date: February 3, 2022
Bulletin Name: FEL-WI-018-A
Model: Meridian 78 and 79, Atlantic 29

Purpose:

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

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”)
- 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
- 271 Loctite®
- Silicone
- Marker for marking the cut-out

Parts Required (Order from McNeilus):

Item	Part Number	Description	Qty.
1	1620158	CS mount weldment	1
2	1620160	SS mount weldment	1
3	1136745	HHCS, 1/2-13 x 1.5, GR 8, YZ	20
4	1621307	Space washer	2

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. Close the CNG tank valves.
3. Inspect the lug outer weld for fatiguing and weld cracking (Figure 1 and Figure 2).

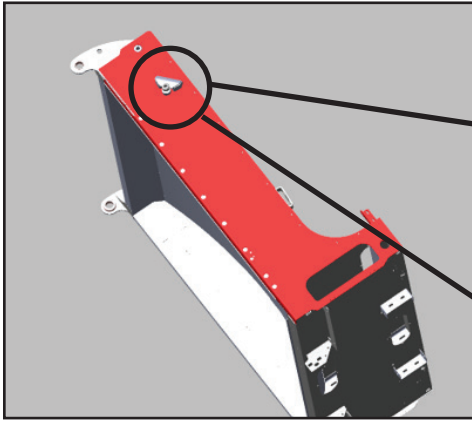


Figure 1

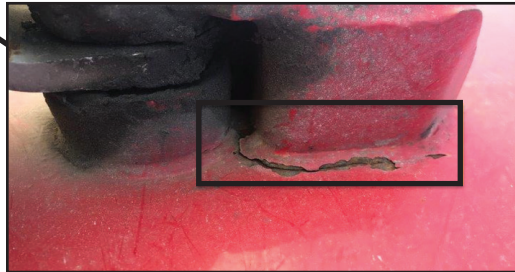


Figure 2

4. Remove the upper cylinder pin and move the cylinder away from the tailgate mounting lug.
5. Inspect the cylinder pins to ensure it is the correct pin. The correct pin will have two holes for greasing as shown in (Figure 3). If the pin is incorrect, replace with the correct part (PN 1619376). Purchase from StreetSmartParts.com or 888-686-7278.



Figure 3

This bulletin is limited to Internal McNeilus Use Only.

6. Locate the end of the fatigue or weld crack (Figure 4).
7. Drill 2/16" through the hole at that point (drill through 1/2" plate under lug) (Figure 4).

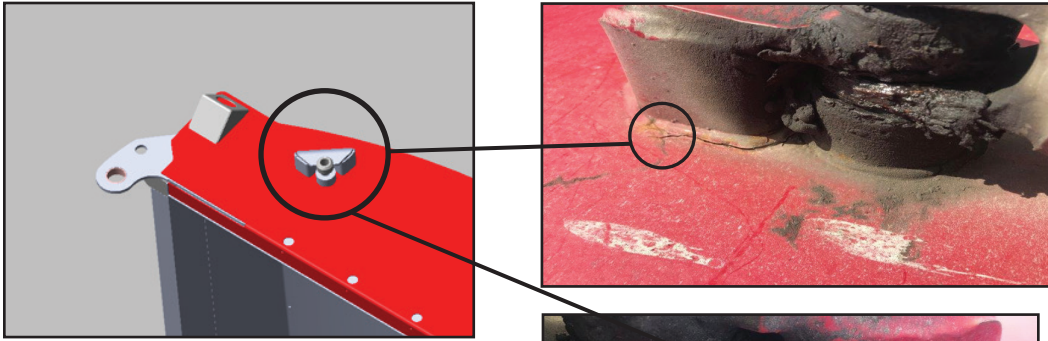


Figure 4

8. Fill hole and weld cracks or fatigue with silicone to prevent water intrusion (Figure 5).

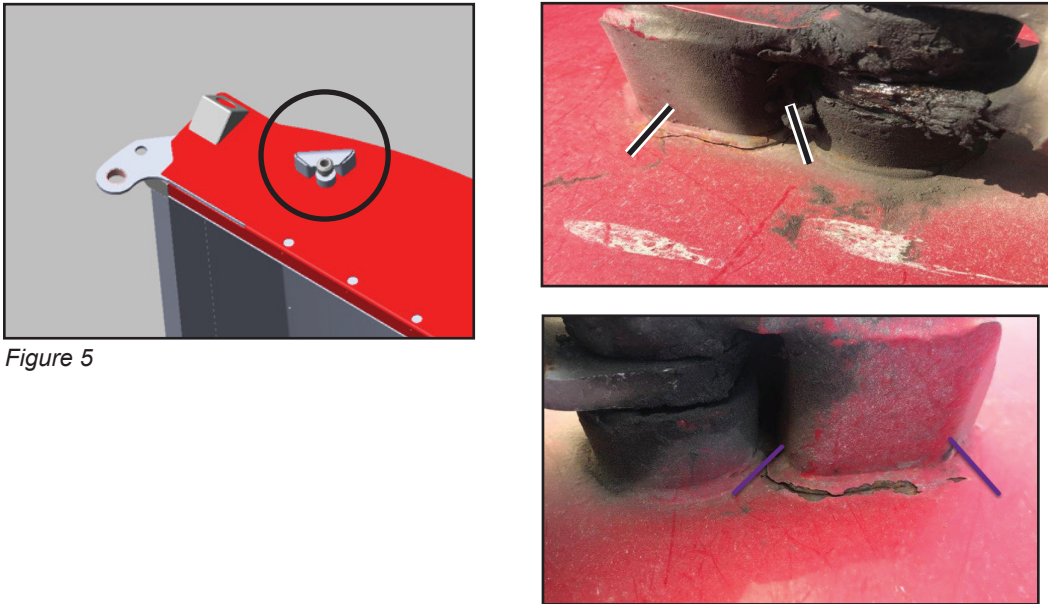


Figure 5

9. Repeat steps 3 through 8 to the other side of the tailgate.

This bulletin is limited to Internal McNeilus Use Only.

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 6). If the pin is incorrect, replace with the correct part (PN 1619376). Purchase from StreetSmartParts.com or 888-686-7278.



Figure 6

2. Slide the street side drill template or the curb side drill template over the inside mount bushing and mark the six (6) bolt centers or drill 3/16" pilot holes (if template has the 3/16" drill bushings) (Figure 7).

NOTE: It is important to use the correct template for each side of the truck. The templates are stamped "SS" or "CS" to identify which one to use.

3. Remove the template and drill the marked or pilot drilled holes to 27/64" diameter (0.422 Ø) for tapping with 1/2-13 threads.
4. Tap the six holes with a 1/2-13 tap.

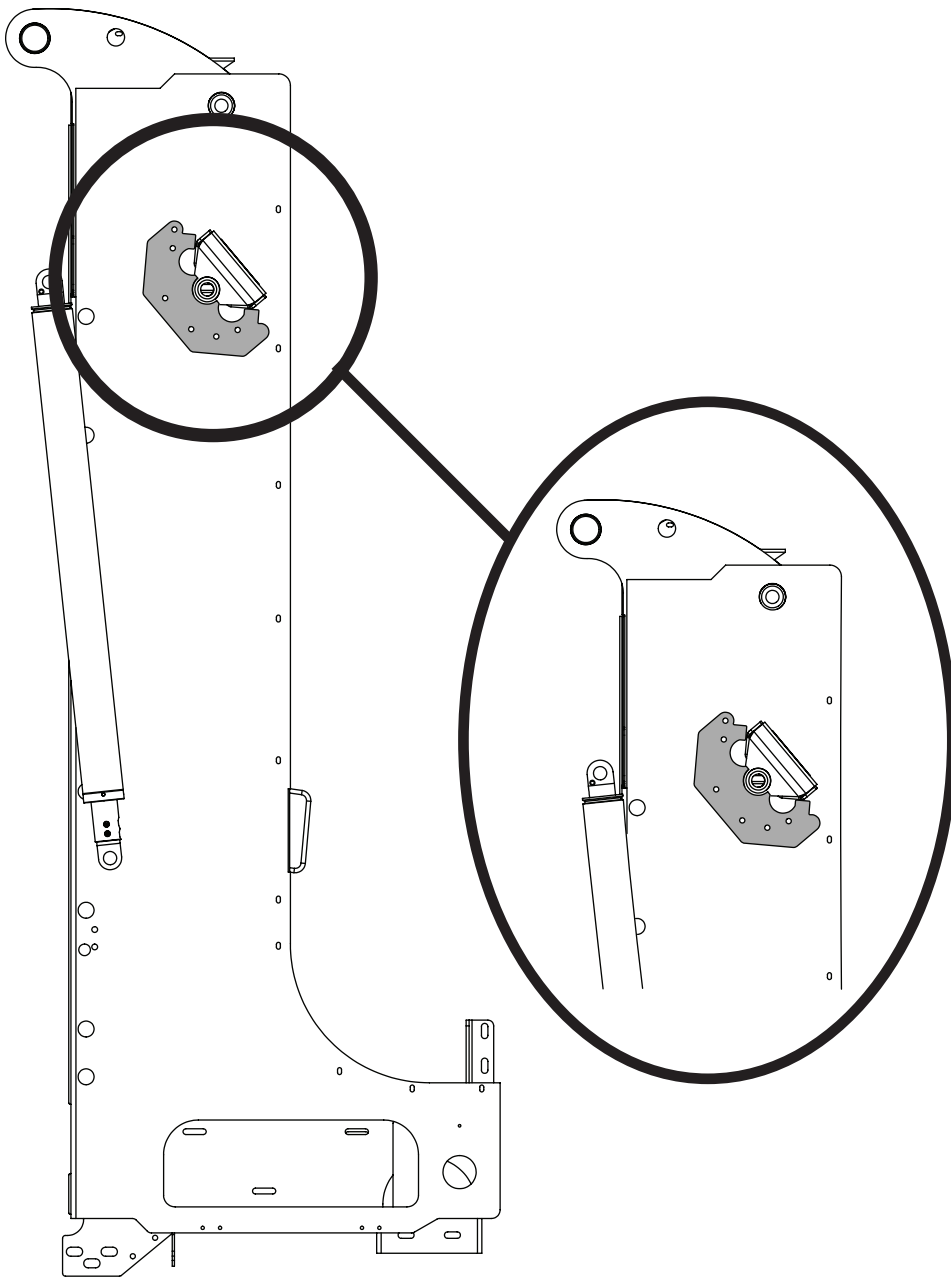


Figure 7

This bulletin is limited to Internal McNeilus Use Only.

5. Place the current side reinforcement bracket on the truck and install two 1/2-13 X 1.5" bolts (Figure 8).

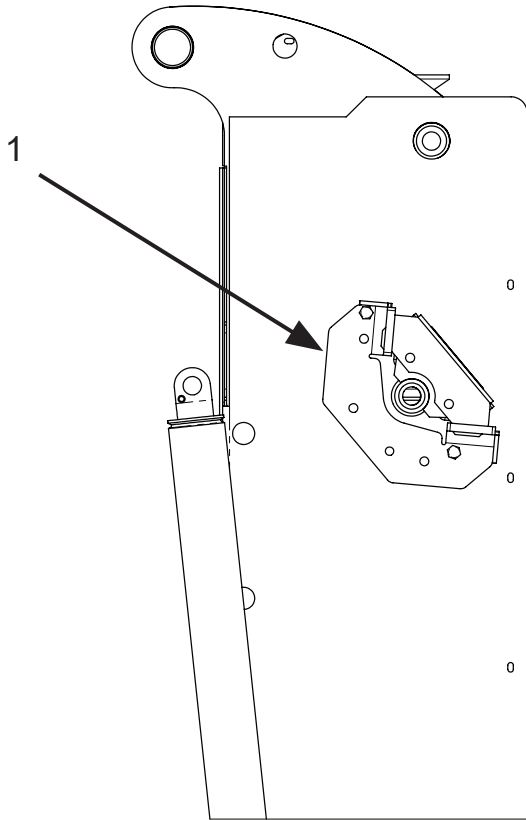


Figure 8

6. Using the bracket, locate and drill the two 27/64" (0.422") diameter tap drill holes on the top of the mounting lug and tap these also to 1/2-13 threads (Figure 9).

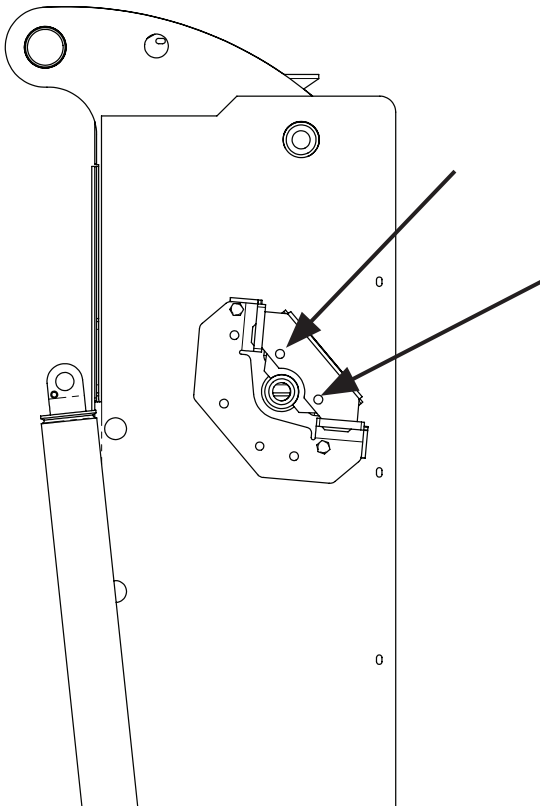


Figure 9

This bulletin is limited to Internal McNeilus Use Only.

7. Install all eight (8) 1/2-13 X 4.5" GR8 bolts using 271 Loctite (red) and using a torque wrench, torque all eight bolts to 80 ft.-lbs.
8. Reinstall the cylinder and place washer, part number 1621307, between the mount bushing and the cylinder clevis as shown in Figure 10.

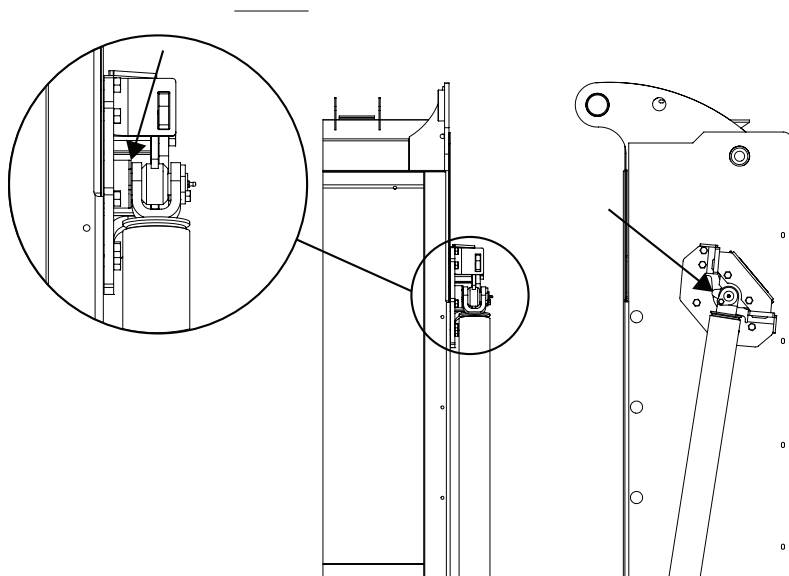


Figure 10

9. Repeat the reinforcement installation for the cylinder lug on the other side of the tailgate by following steps 1 through 8 of this procedure. Be sure to use the correct side versions of the reinforcement bracket and hole template.
10. Tailgate should be cycled up and down. End the cycle with the tailgate lowered.
11. Procedures are complete. Truck may be returned to service.
12. 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).



(888) 686-7278

www.streetsmartparts.com