



REPAIR DOCUMENT

Rear Frame Reinforcement: Roll-Up Door

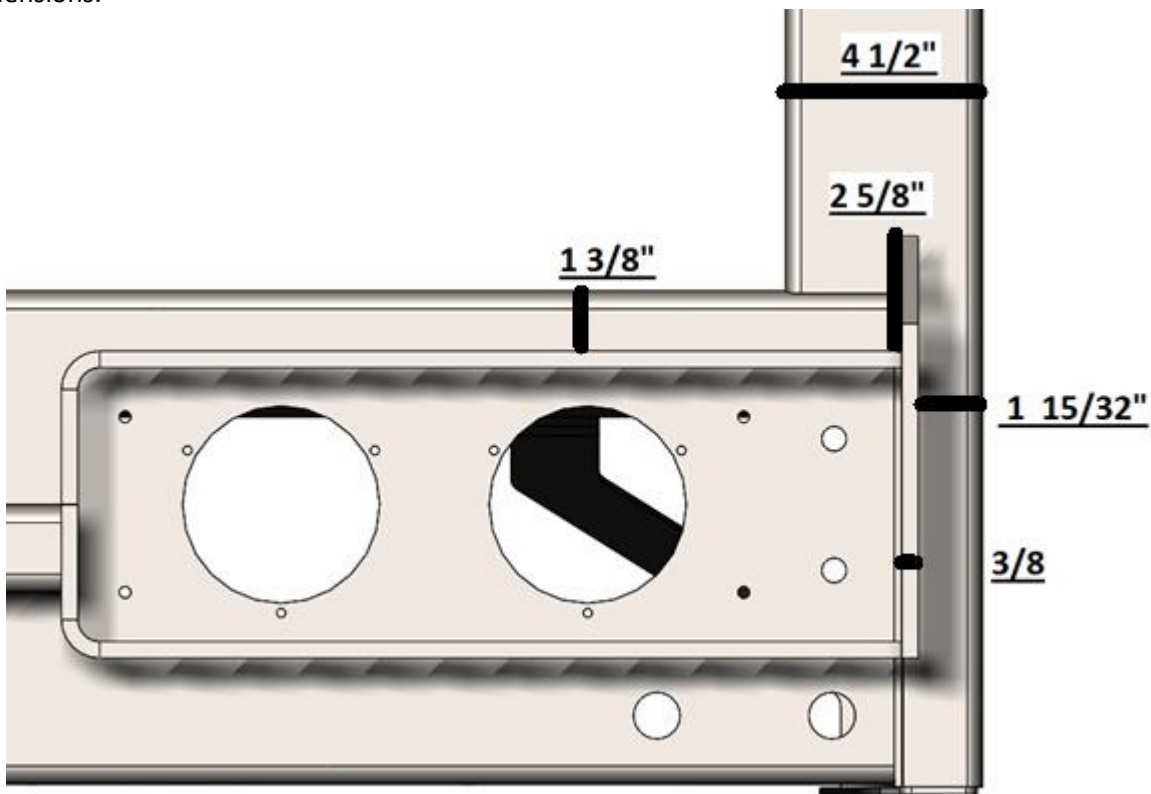
Repair Document #: RD-00105
Date: October 15th, 2020 -V4

Contact Information:

If you have any questions about this Repair Document, please contact the Stoughton Trailers Customer Service Department by toll free at (866)-725-0044 or by email (warranty@stoughtontrailers.com).

Subject:

Repair procedure for Rear Frame cracks on Roll-Up Door rear frames matching the below picture and dimensions.



Compare to Stoughton Rear Frame 24-06018 to ensure compatibility

Issue:

Cracks have been discovered in the lower and upper corners of the rear frame. See pictures below for examples. Inspect entire rear frame and under lower sill. All cracks must be repaired. If significantly more severe or upper corner of rear frame cracking and damage is found contact the Service Department at (866)-725-0044 or warranty@stoughtontrailers.com.



Example cracks in lower corners of rear frame



Example crack at upper corner of rear frame

Remedy:

Rear Frame welds must be inspected for cracks and proper weld size. Any cracks or undersized welds must be repaired according to the following procedures. If a crack is not repaired properly it will crack through the repair. Rear frame racking must be fixed and then held square prior to repair. Gussets will be added on all 4 corners of rear frame after cracks and welds are repaired per this document.

Repairs must be completed by a qualified welder. Additional weld criteria can be sourced from American Welding Society AWS D1.1/D1.1M 2020 for welding of structural steel.

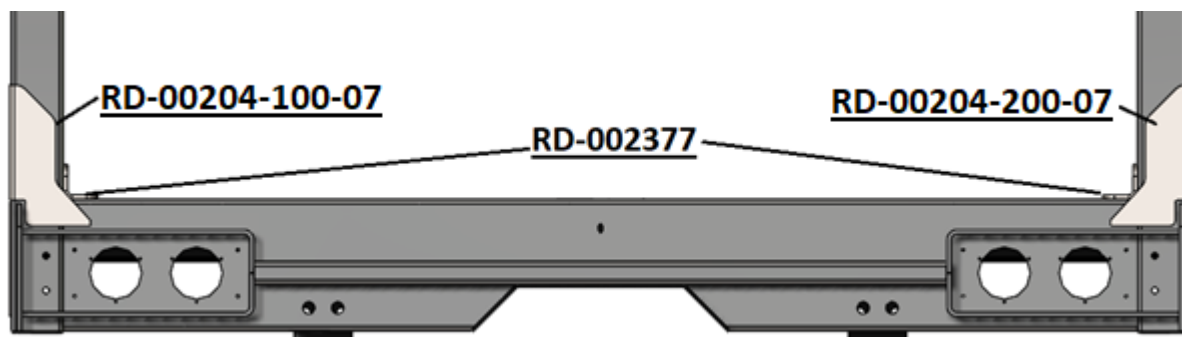
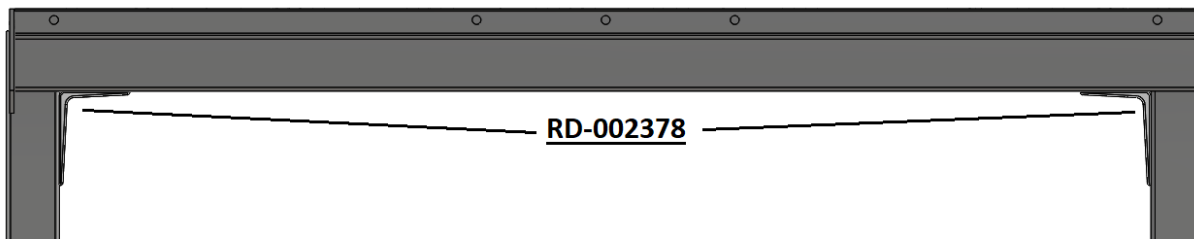
Warning:

During all steps of the repair procedure one must use appropriate safety precautions.

- Use proper personal safety equipment when working (i.e. safety glasses, hearing protection, safety shoes, etc.)
- Trailer must be properly supported at all times as is appropriate for the repairs being made
 - Check to ensure landing gear is in proper working order and providing proper support prior to repair
- The trailer must be empty and on level ground before any repairs are made
- Ensure proper welding precautions are in place
- Weld in a properly ventilated area
- Ensure proper safety precautions are being used for welding galvanized steel

Parts Required : Repair Kit RD-00104

Item	Qty	Description
RD-002378	2	ANGLE, CORNER-GALV
RD-002377	2	GUSSET-GALV
RD-00204-100-07	1	ANGLE, RR CNR REINF (Road Side) -GALV
RD-00204-200-07	1	ANGLE, RR CNR REINF (Curb Side) -GALV



Tools:

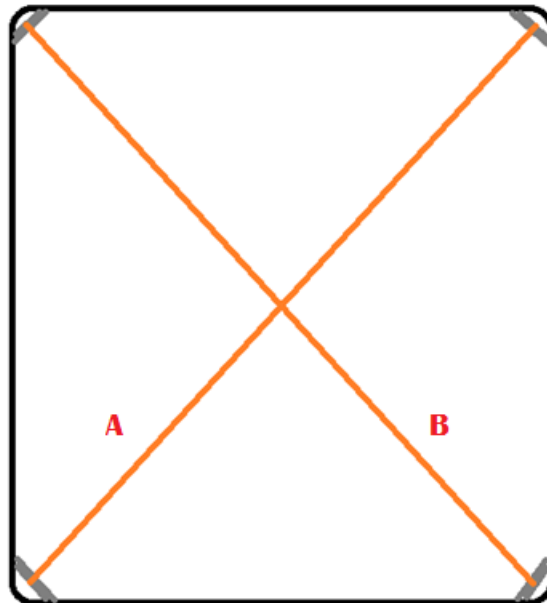
- E70S-6 weld wire or equivalent
- “Anti-Spatter” spray
- Wire brush and or wire wheel - Clean
- Grinder with cut off wheel, sanding flap wheel and HD metal grinding discs
- Hammer
- Cold chisel
- Weld blankets, wet towels and or Weld masking tape for protecting lights and wiring harnesses
- Tape measure and angled corner blocks for checking squareness of rear frame
- Come-alongs and chains to hold rear frame square
- Power Tools (air, corded or cordless) with wire wheel for weld prep and cleanup
- Cold Galvanize Paint (provide material and spec.)

INSPECTION:

1. Inspect for cracks and damage at all four corners of the rear frame opening and underside of the lower sill.

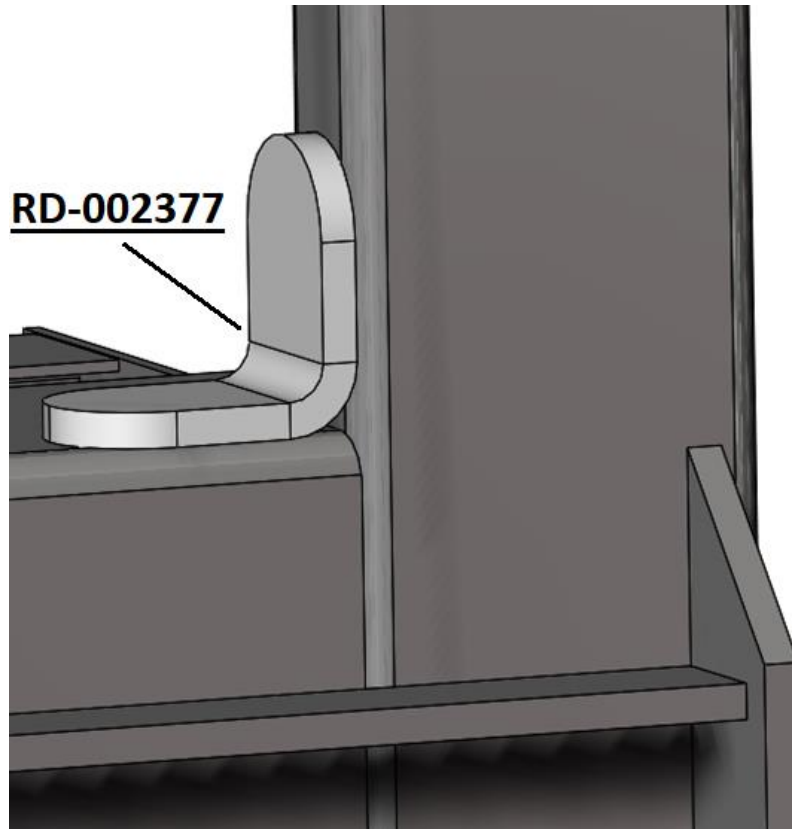
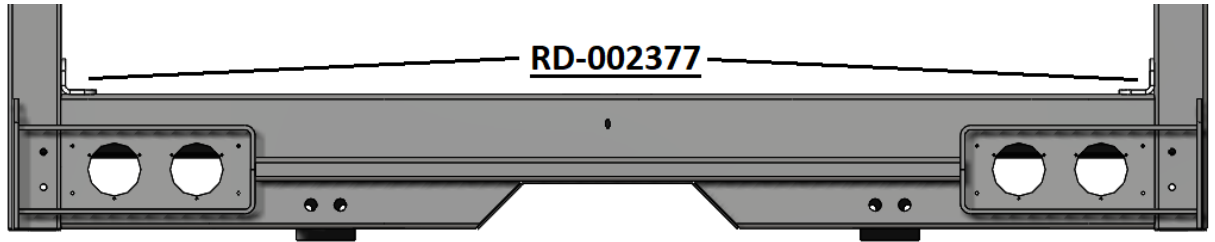
REPAIRING CRACKS, DAMAGE & WELDS:

1. Measure rear frame door opening for squareness. Measuring diagonally across the inside lower corner to opposite inside upper corner with corner blocks as shown below. The difference between A and B must be less than or equal to ½ inch ($|A - B| < 1/2\text{inch}$).
 - a. If the door frame diagonal measurements are more than ½ inch out of square it must be pulled into square before welding.

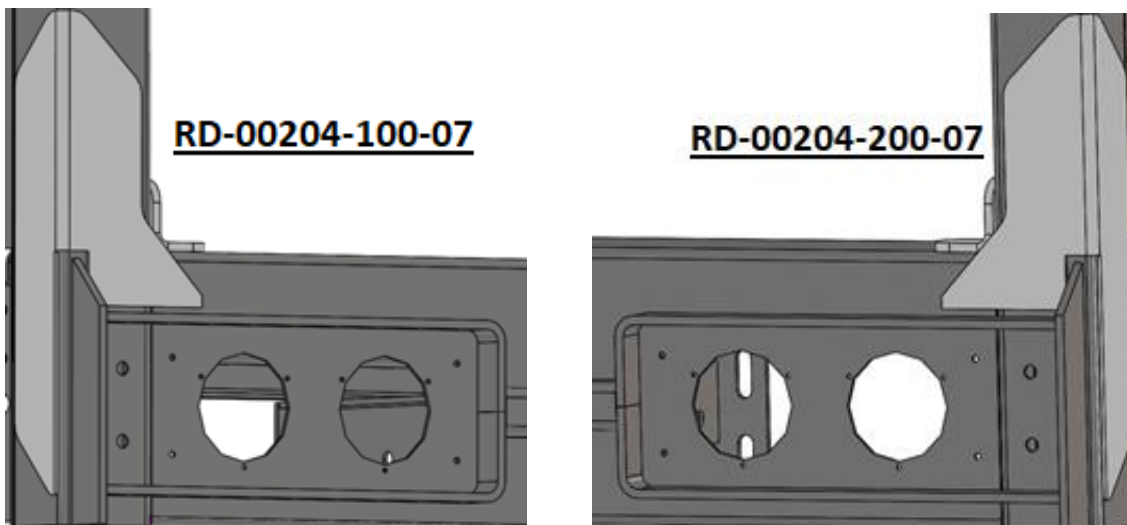
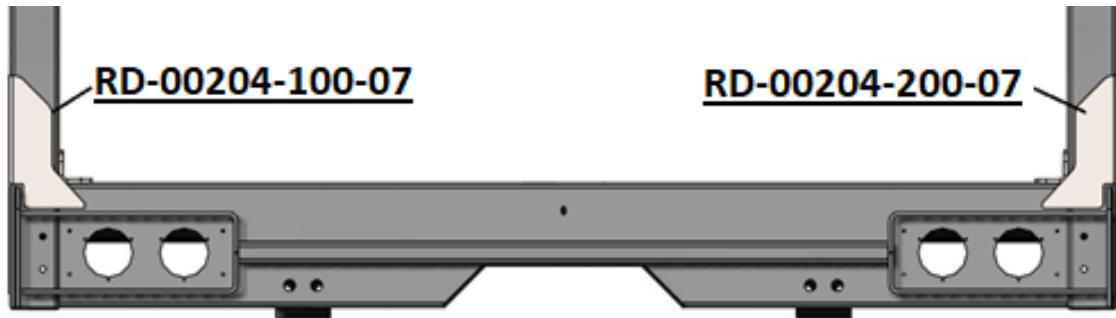


2. Apply weld blankets or wet towels around wiring harness or lights if repairing near them
3. Any area to be welded must have the galvanizing removed.

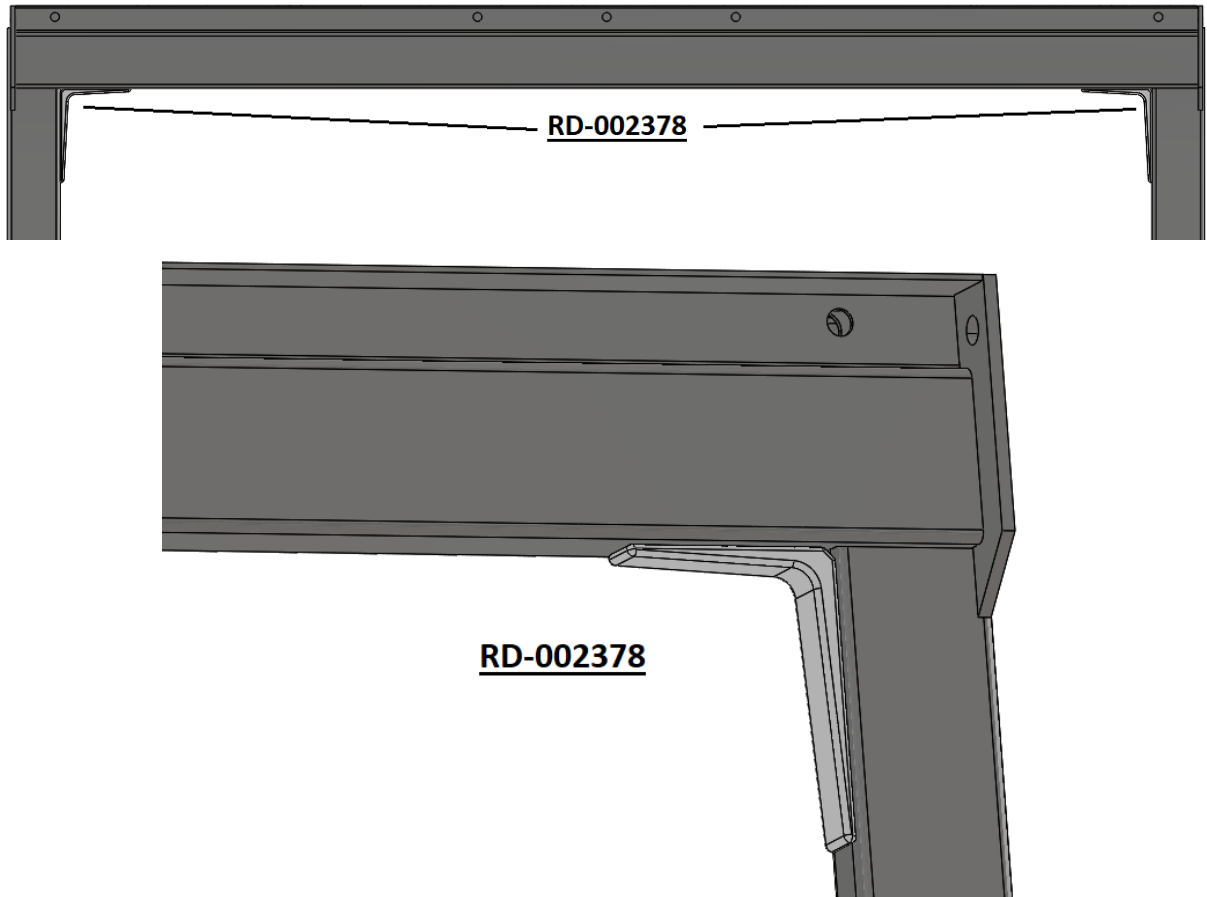
4. Repair cracks.
 - a. Grind out cracks to produce a groove $\frac{1}{2}$ the material thickness and extend past both ends of crack
 - b. Weld along groves to fill, insure proper penetration
 - c. Grind surface flat
5. Clean weld areas on lower corners of rear frame.
6. If necessary, remove door seal.
7. Install gussets RD-002377 flush with the back of the rear frame (outer face) on both sides as shown below. Weld around entire perimeter of the gusset with $\frac{3}{16}$ " weld.



8. Clean weld areas on lower corners of rear frame again around larger install area of RD-00204-100-07 and RD-00204-200-07 located as shown below. Then weld entire perimeter of both RD-00204-100-07 and RD-00204-200-07 with 3/16" weld.



9. Clean weld areas on upper corners of rear frame and weld gussets RD-002378 flush with the back of the rear frame (outer face) on both sides as shown below. As necessary remove and or protect door seal in this area. Weld entire perimeter of both RD-002378 gussets with 3/16" weld. Reinstall door seal.



10. After all welding, paint weld repaired areas with cold galvanize spray paint.
11. Reinstall door seal.
12. Ensure everything removed is re-installed correctly and check function of the door.