

Preview Solution CBR-2500-4

Versa Table Repair - VN (4), PR (4)

Published 17 September 2025

Valid For

Volvo Chassis - VN (4)

Mack Chassis - PR (4)

Model Year - 2025 to current

This procedure describes the standardized method for repairing failed inserts pulled out of a table surface. It applies only when the receiving hole is not significantly damaged. Acceptable conditions include surface fraying or peeling at the painted layer only, with no full-depth cracking.

Tools & Materials

- JB Weld Clear Weld, 5-min, 2-part epoxy (3200 PSI strength)

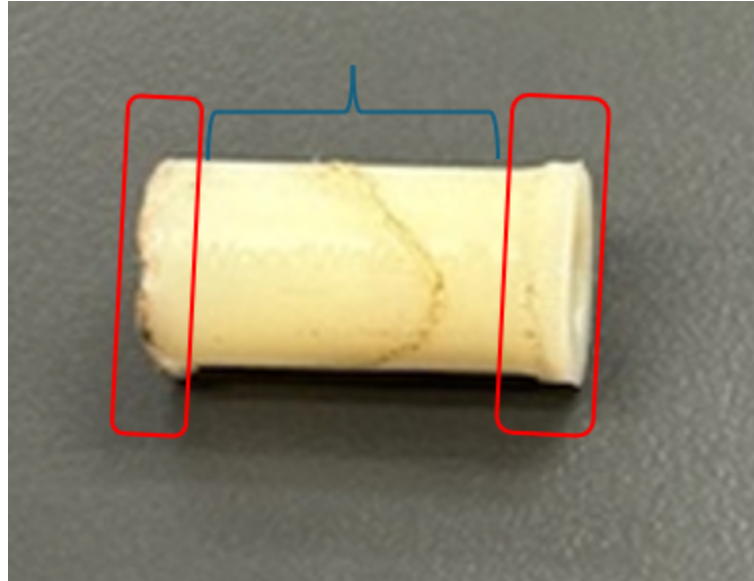


- Slip-joint pliers
- Stir-stick (for mixing/applying epoxy)
- Lint-free cloth
- Torque driver (capable of 1.5–2 Nm)

Procedure

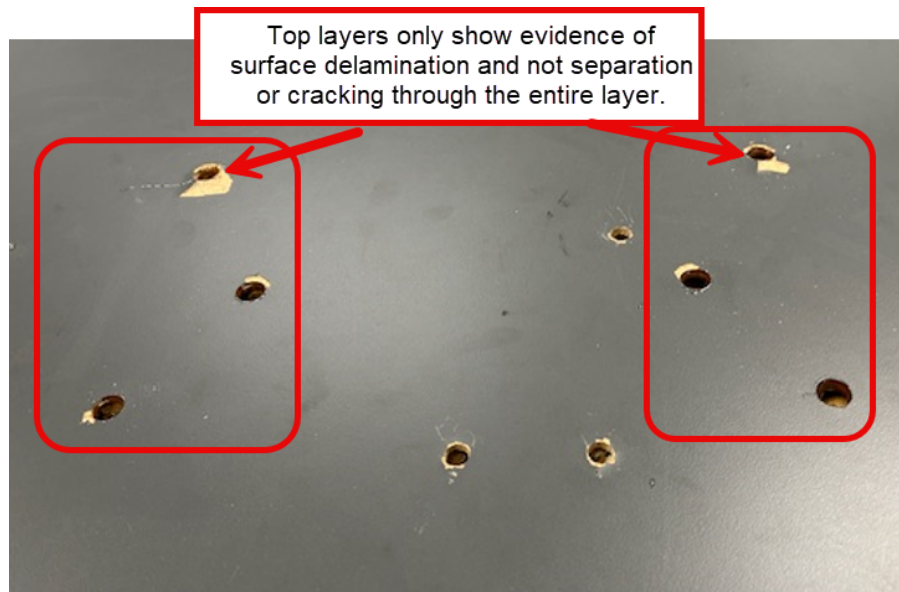
Preparation

1. Remove insert from screw.



NOTE: To remove screw: Grip insert in central region (Blue Bracket) with slip-joint pliers to prevent damage to the interfacing surfaces(red boxes).

2. Confirm hole condition is suitable for repair (surface delamination only, **see image below**).



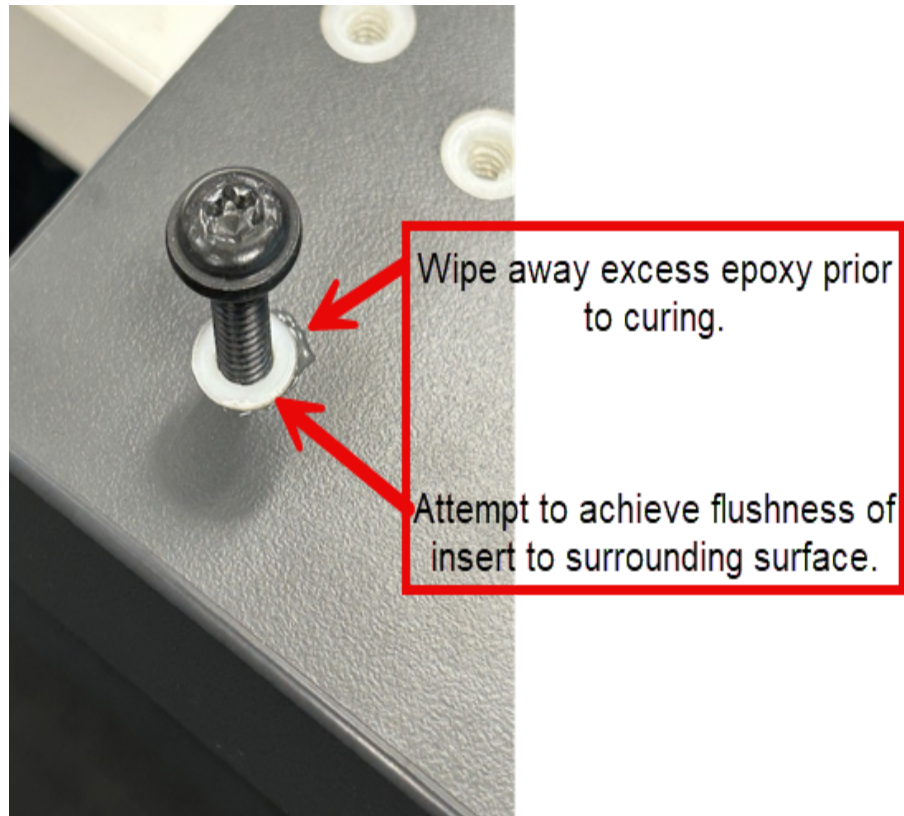
Repair Steps

1. **Mix epoxy** per JB Weld instructions.
2. **Apply epoxy to hole:**
 - Coat bottom surface.
 - Cover all inner surfaces with a thin, even layer.

- Smooth excess on painted surface if needed.

3. Reinstall insert:

- Partially thread screw into insert.
- Use screw to press insert into original hole.
- Ensure insert sits flush with surrounding surface.
- Wipe away excess adhesive.



4. Cure: Allow adhesive to set for **30 minutes minimum**.

Reassembly

1. After curing, finger-start screws into repaired inserts.
2. Torque screws to **1.5–2 Nm**.
3. Verify insert is flush and secure.

Related links and attachments

No links or attachments available



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