**A. Purpose:**

This work instruction provides detailed steps on how correct trailers with roll door operation issues caused by a rear frame post-to-post dimension below the design standard, using a controlled rear frame expansion process with an expander tool.

**B. Scope:**

This work instruction applies to previously measured dry vans and refrigerated trailers with a rear frame post-to-post dimension under 92.86”.

**C. Responsibilities & Authorities:**

The director of operations, or designate, is the owner of this process and is responsible for maintaining and enforcing this work instruction.

All Stoughton personnel and departments are responsible for following this procedure as specified.

**D. Definitions:**

Rear Frame -The rear structural frame of the trailer, where the roll door is installed and operates.

Roll Door - A rear rolling door that must open and close smoothly without interference.

Expander Tool - Manual expansion tool with an expanding arm used to apply lateral force and widen the rear frame.

**E. Work Instruction**

1. Ensure the trailer is parked on a level surface and confirm the rear frame post-to-post dimension is less than 92.86”.

   **Note:** Measurement method is flexible, but laser tape is recommended.

2. Position the expander tool onto the rear frame.

   2.1. Place the expander tool inside the trailer between the two rear frame side posts.

   2.2. Check that the tool is aligned and firmly seated against both posts, noting the flat edge of the bracket should be flush with the back of the door frame.

   ***Safety note***: Keep your hands clear of pinch points *(Figure 1).*



*Figure 1. Expander tool placed*

3. Temporarily expand frame.

3.1. Operate the tool and begin gradual expansion of the rear frame. The expansion should be controlled with no sudden movement. *(Figure 2)*



*Figure 2. Gradual expansion of the tool.*

3.2. Measure post-to-post dimension during expansion. Measurement approaches 94.5". *(Figure 3)*



*Figure 3. Measure post-to-post dimensions.*

3.3. Stop the expansion when the pump pressure reaches 6 TONS (approximately)

3.4. Verify that the distance between the posts reaches 94.5 inches; do not over-expand. *(Figure 4)*



*Figure 4. Pressure reaches 6 TONS (approximately)*

4. Remove the expander tool.
   4.1. Slowly release the hydraulic system using the relief valve to retract the ram.
   4.2. Remove the tool from the frame. *(Figure 5)*



*Figure 5. Releasing and removing the hydraulic system*

5. Re-measure the post-to-post dimension after relaxation to confirm the dimension is now between 92.86” and 93.13”. *(Figure 6)*

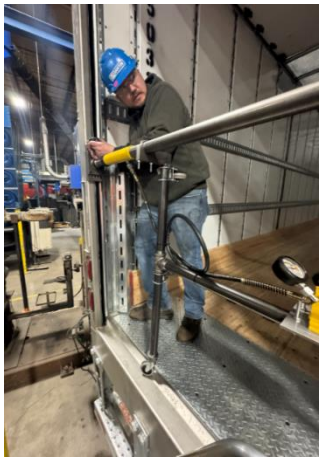


*Figure 6. Re-measuring post-to-post dimensions*

6. Operate the roll door to confirm door opens and closes smoothly.

**F. References:**

| Doc ID Referenced | Name | Location |
|---|---|---|
| **N/A** | | |
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