FRUEHAUF

PROCEDURE FOR REINFORCEMENT GUSSET INSTALLATION FOR STAINLESS STEEL REAR IMPACT GUARD (BUMPER)

Parts supplied:

(2) SS Gusset Reinforcements

(4) ¾ dia. x 1 ¾" length grade 8 Bolts

(4) ¾" grade 8 Hex Head Lock Nuts

(8) ¾" hardened washers

(2) 1 1/2" dia. x 3" length Solid Steel Stop Bar

Step No. 1 – Inspect original Rear Impact Guard and attachment connections free of any damage –If any damage is found, document with pictures and description of damage and send to OEM prior to repair.

Step No. 2 Remove rear stop bar

- Cut stop bar off inside of the "Z" slider rail on both sides
- Grind surface smooth inside slider rail free of burrs
- Keep remainder part of stop bar in place welded on external side of slider rail – (as shown)

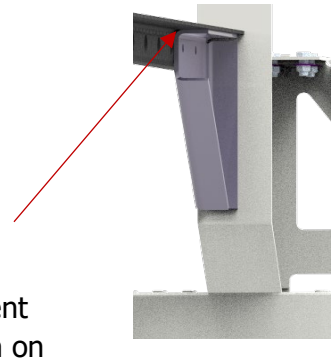
Cut bar in this section

Keep stop bar welded in place on outside of "Z" rail

Step No. 3 Clamp in correct position reinforcement gusset to Z slider rail and vertical impact guard (as shown below)

Reinforcement gusset tight to vertical impact guard plate

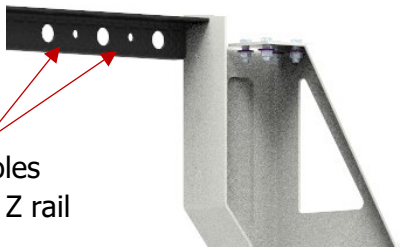
Locate reinforcement gusset flush on top surface of rail



Step No. 4 Drill (2) 13/16" diameter holes in each Z slider rail using reinforcement gusset as template.

- Use a reinforcement gusset as a template and punch mark inside of Z rail for hole locations
- Drill two 13/16" diameter holes per punch mark (both rails)

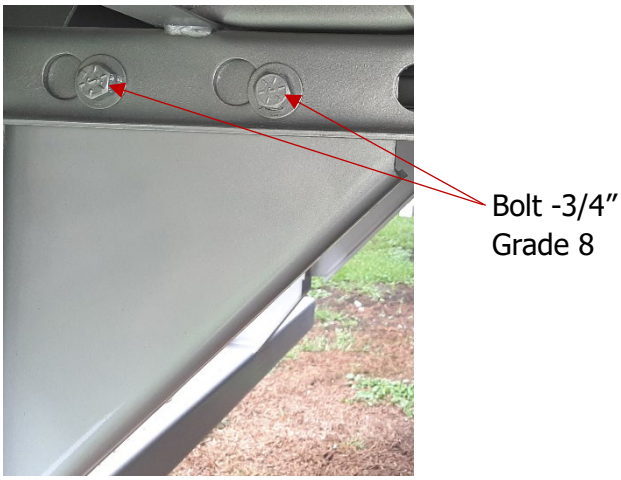
Punch mark (2) holes on Z rail



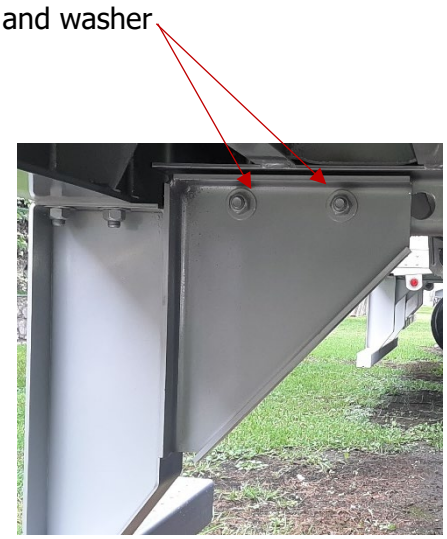
Drilled (2) holes shown in c/s Z rail

Step No. 5 Attachment installation

- Attach the reinforcement gusset to each rail with a 3/4" diameter, grade 8 bolt, 3/4" lock nut, grade C and (2) hardened washers per each bolt and nut.
- Torque of the bolts should be at 223 lb.-ft.



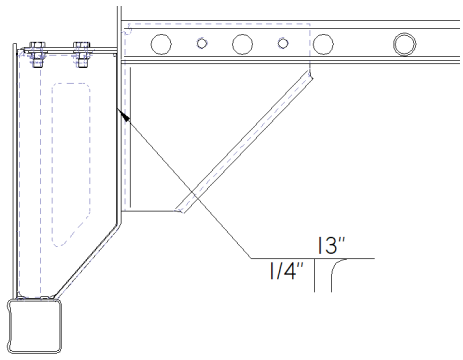
Outside View



Inside View

Step No. 6 Welding the gusset

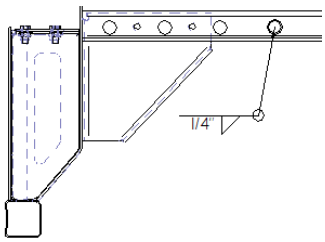
- Weld the vertical flange on the bumper.
- Use stainless steel welding 308 LSI (recommended MIG, wire Diam. 0.045”)



Step No. 7 Weld stop bar -

- Install the 1 ½" x 3" stop bar in the fourth hole from rear of the "Z rail" - each rail (see picture)

Weld all around the stop bar on outside of the "Z" slider rail



- Use steel welding ER-70S-6 or 7018

- Clean weld and surface and paint with polyurethane paint