



# Coupling Plate Replacement Procedure

N° :  
REP-A-12

Description : Coupling plate replacement on ABS trailers MY2014 to MY2023

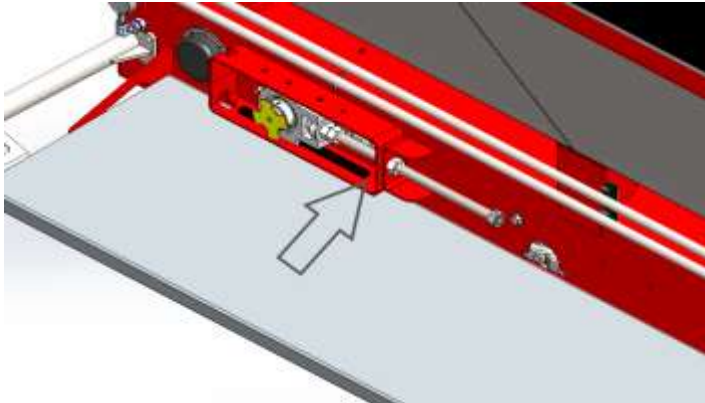
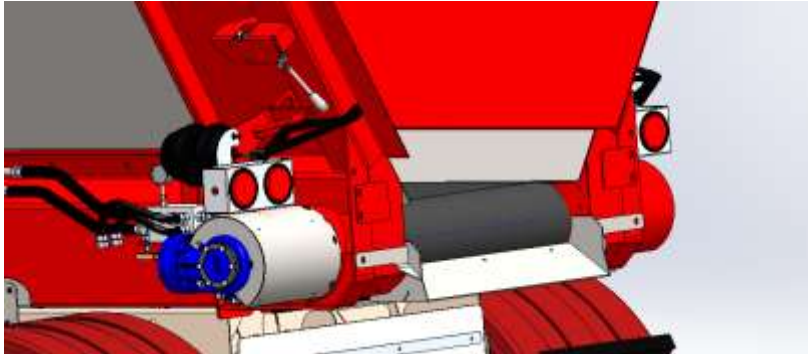
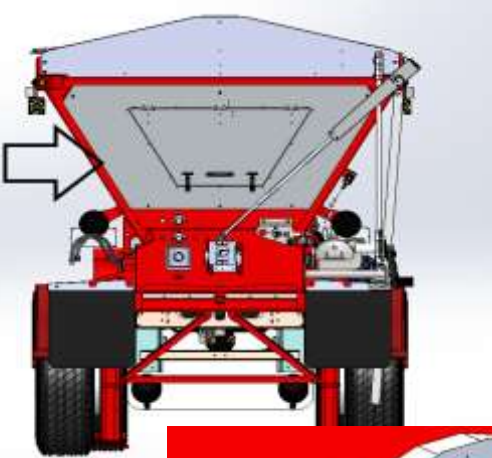
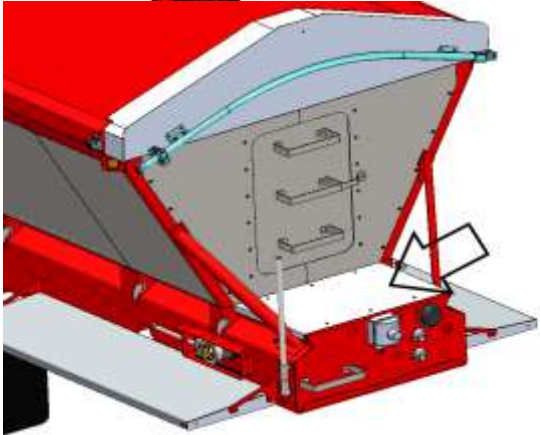
## Procedure Prerequisites

Concerned Model	Special Tooling	
All (RC, WC, LRC, LWC)	MY2020-22 GAB-DE-0-00027 & GAB-DE-0-00029	REP-A-12-000-4
	MY2014-20 GAB-DE-A-00008 G&D	
	Tooling	
	Plasma cutter	Welder with flux core wire
	Lift truck	Hydraulic unit
	Standard mechanic tools	

## MATERIAL

Part number:	Description :	Quantity:
REP-A-12-RC	Coupling plate model RC	1
REP-A-12-WC	Coupling plate model WC	1
PAINT		1
PRIMER		1

## STEP BY STEP DESCRIPTION

OPERATION	COMMENTS	IMAGES
Mechanic Preparation	<p>_Remove conveyor tension by loosening the threaded rods</p> <p>_Turn the conveyor slowly to bring the belt looseness at the back of the trailer</p> <p style="text-align: center;"><b>ATTENTION !!!</b></p> <p>_Make sure that the loose do not jam at the back when doing this operation</p>	
	<p>_Remove the front panel to get proper acces, sufficient light and let the smoke evacuate.</p>	
	<p>_Note: For lightweight model, do not remove the front plate. Remove the front deck instead.</p>	
		



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OPERATION

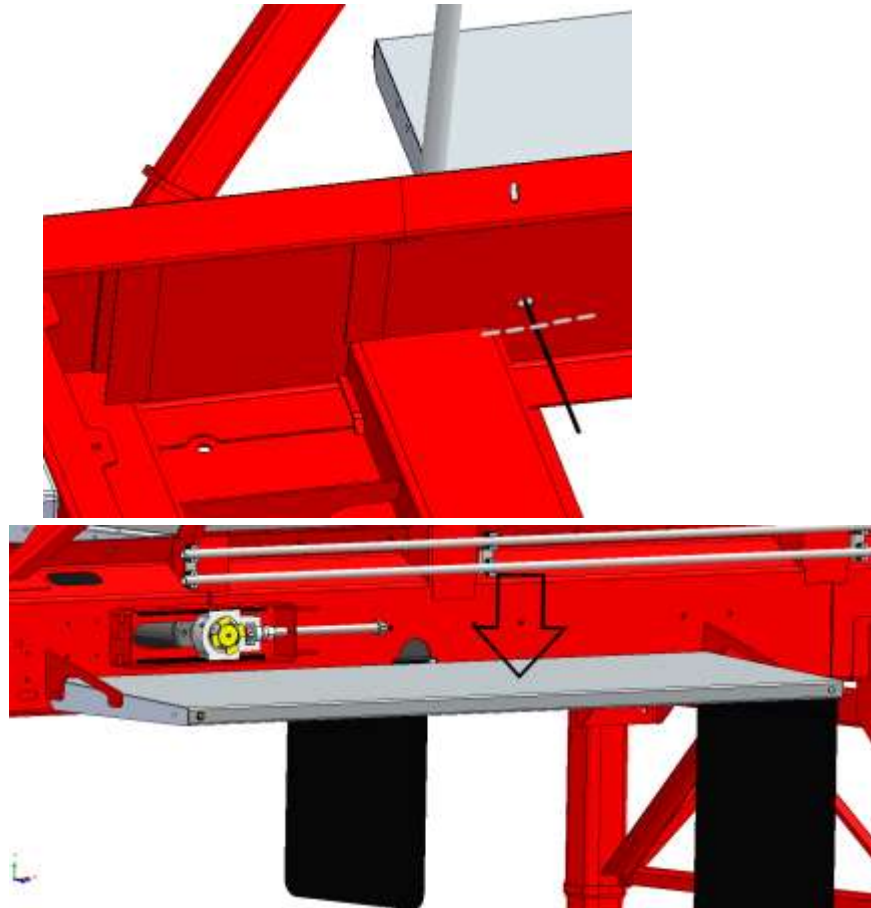
COMMENTS

IMAGES

Mechanic  
Preparation

\_Cut electric wire of the fender lights  
(both side)

\_Remove the fenders

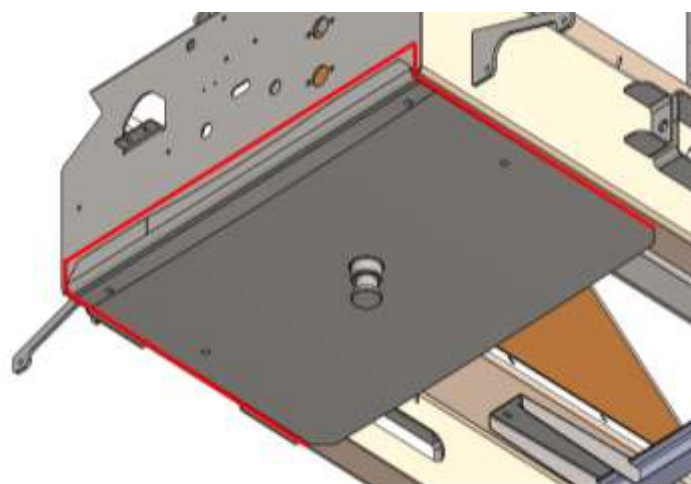


Structure  
Preparation

\_Make sure that all the wires and hoses are placed in a manner that they won't be cut during the plasma cutting. Use the aluminum plate REP-A-12-000-4 as a barrier.

\_Cut the coupling plate at the location indicated by the red line on the image aside.

**ATTENTION !!!**  
\_Do not cut frame beam on each side



**ABS Remorques  
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Structure  
Preparation

**ATTENTION!!!**

\_Place a support under the coupling plate. It will fall down once the crossmembers will be cut.

\_Cut the crossmembers at an angle of 45 degree as shown on the image.

IF EQUIPPED:



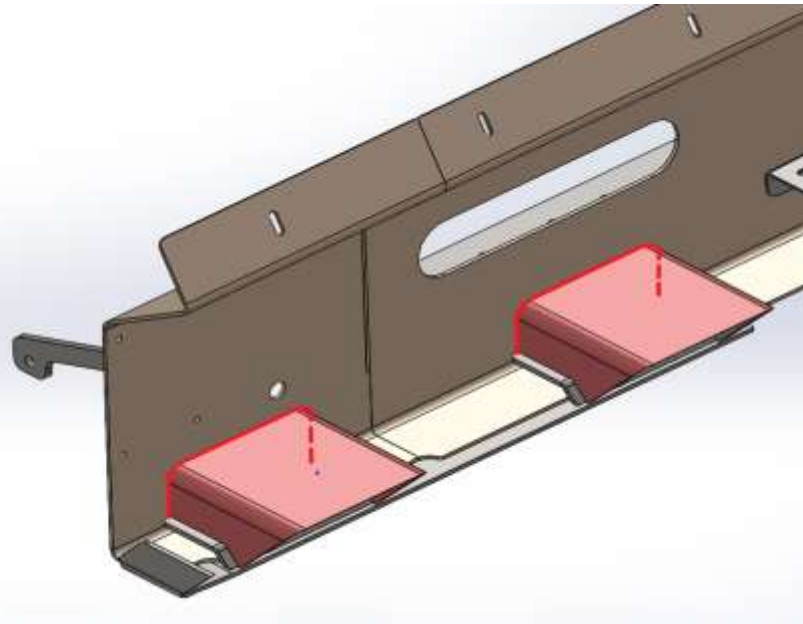
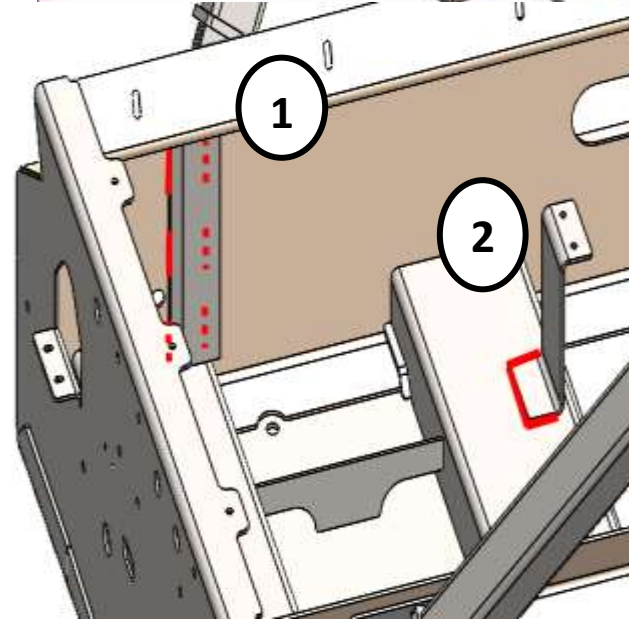
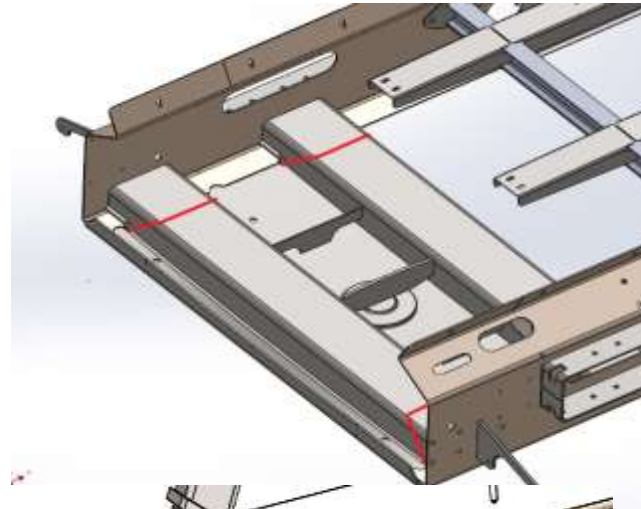
- 1) Remove the I-beams by cutting the welds
- 2) Remove the tank bracket by cutting the welds. Keep the bracket because it will be reinstalled on the new coupler.

\_Remove the remaining crossmembers sections

\_Repair all the cracks on the frame by welding and grind each of them to get an even surface. Do not forget under the frame.

**ATTENTION!!!**

**\_NE PAS COUPER LE LONGERON DU FRAME**





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Structure  
Preparation

\_Use the appropriate cutting template for the trailers year. Note that the plasme was design for a cutting nozzle of  $\varnothing 3/8$ ".  
\_Place the template and cut the slots as shown on the drawing.

MY2020-22: GAB-DE-0-00027 & GAB-DE-0-00029

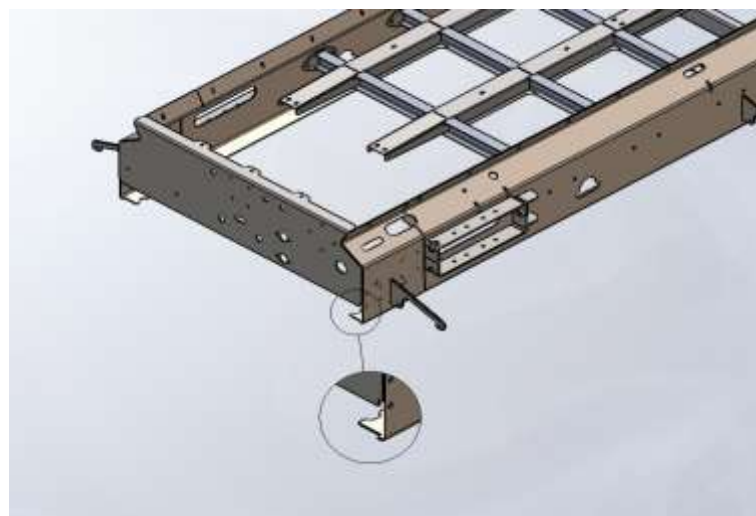
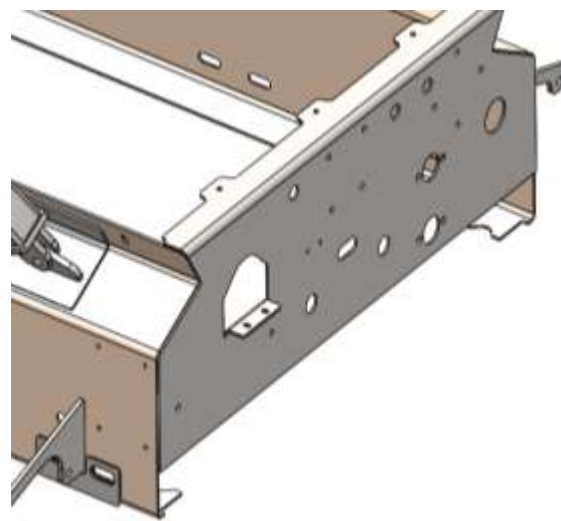
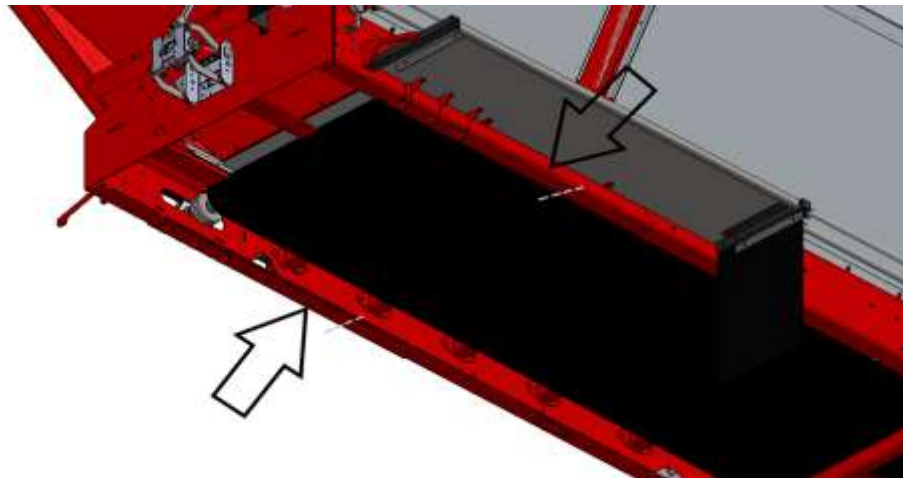
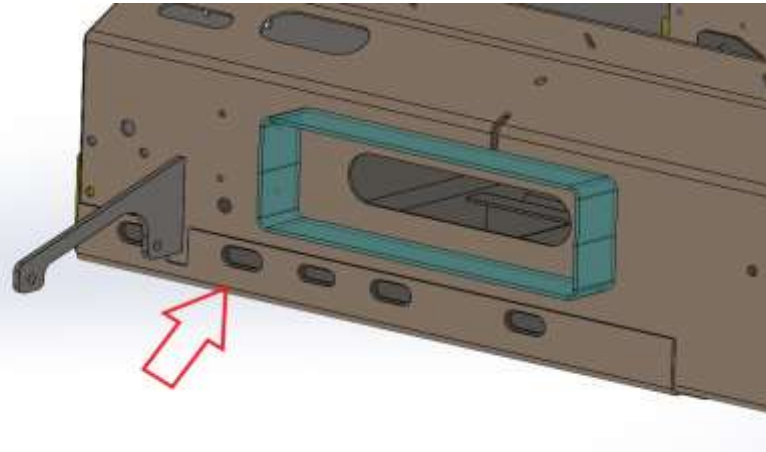
MY2014-20: GAB-DE-A-00008 G&D

IF EQUIPPED:



\_For trailer MY2014-20 cut the frame lining at the dimensions shown on the drawing.

\_Do the linear cut and the notches on the front plate (See print for the dimensions)





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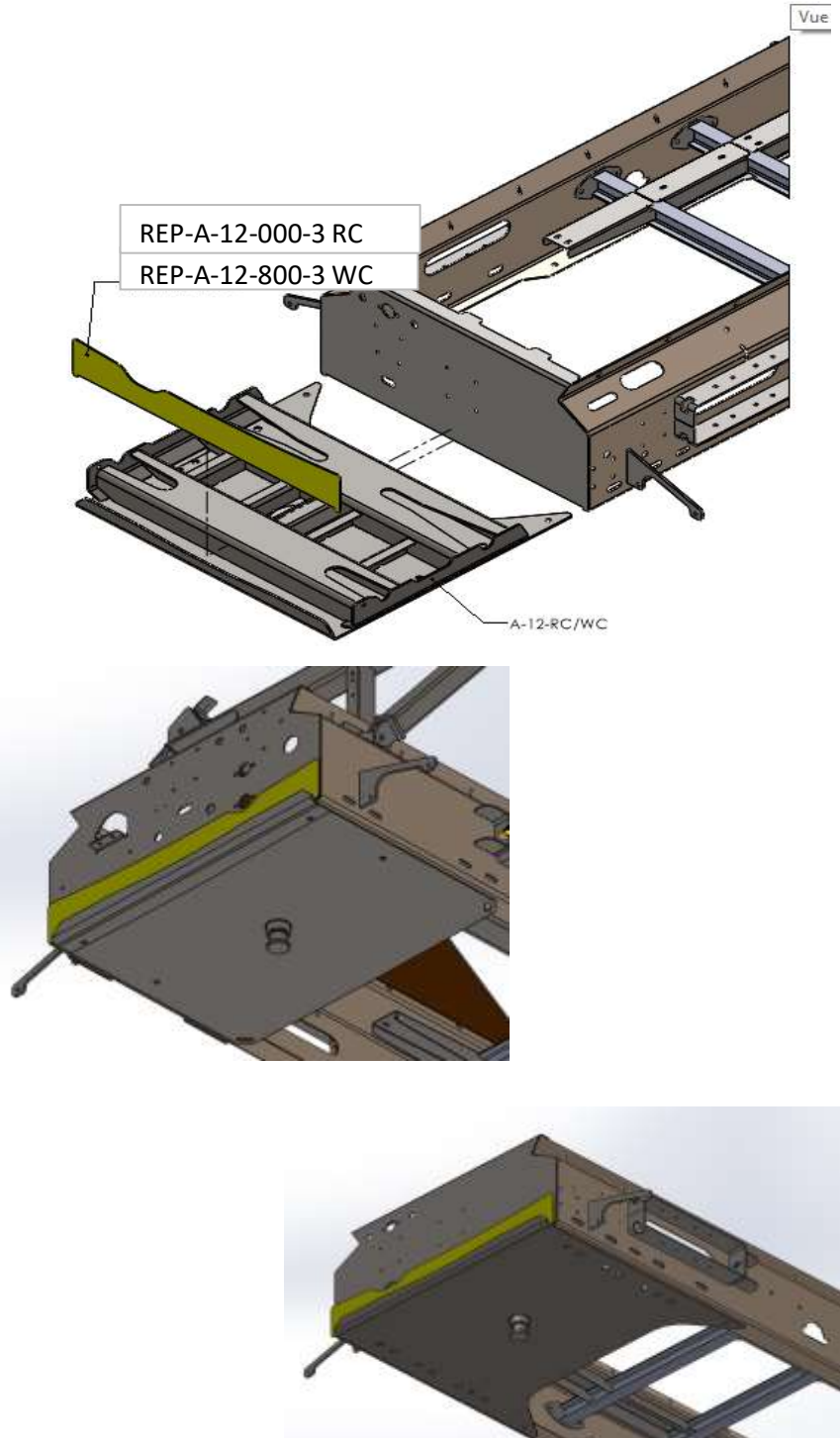
OPERATION

COMMENTS

IMAGES

Assembly

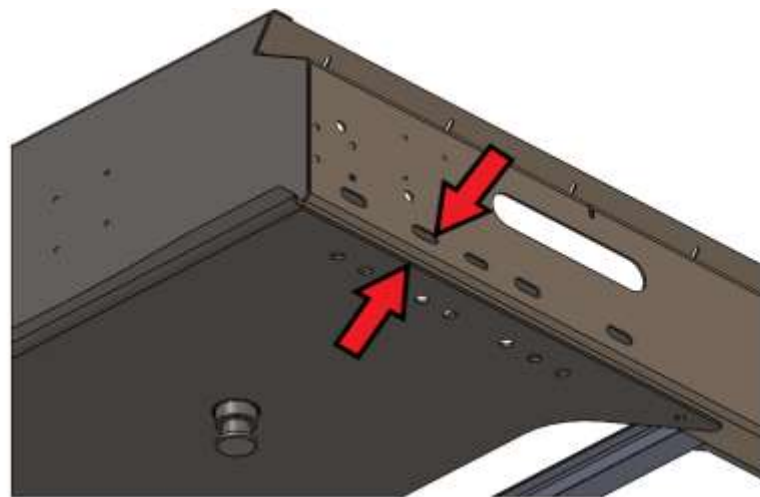
\_Insert the new coupling plate with the front capping plate



Welding

\_Weld the new coupling plate following the print requirements.

**ATTENTION!!!**  
\_No gap allowed between the frame and the coupling plate





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<p style="writing-mode: vertical-rl; transform: rotate(180deg);">Final assembly</p>	<p><b>OPTIONAL :</b>             _ For lightweight model, bolt the calcium tank support bracket as shown on the print.</p> <p>_ Sand and paint the surfaces burnt or damaged during the repair process.</p> <p>_ Use the <math>\varnothing 3/4</math>" hexagonal bolt to fix the rear of the coupling plate with the frame. The nut must be inside of the frame.</p> <p>_ Reinstal the fenders</p> <p>_ Reconnect the wires of the fender light</p> <p>_ Replace the wires and hoses</p> <p>_ Reinstal the front plate or deck in place</p> <p>_ Adjust the conveyor tension</p>	
<p>Made by: Dérek De La Conception</p> <p>Rev.: 1</p> <p>Date : 12/01/2023</p>	<p style="text-align: center;"><b>Approved by:</b></p> <p style="text-align: center;">Samuel Frédette</p>	<p style="text-align: center;"><b>DATE :</b></p> <p style="text-align: center;"><b>12/01/2023</b></p>