TRANSITION WELD/CRACK REPAIR PROCEDURE

The following repair procedures should be followed if welds are broken or cracked sheet metal around the transition area.

1. Inspect area for damage beyond weld or crack. Verify that the transition reinforcement is installed properly (Reference figure 3).

Figure 1 – Sheet Metal Crack

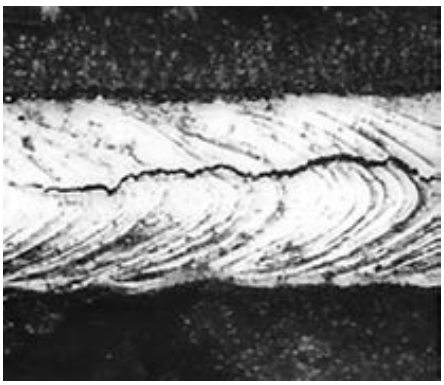

Figure 2 – Weld Crack

2. Remove any components that will be damaged during the welding process, shelving, tool boxes, wiring, etc...

3. Remove paint or bedliner from those locations. In the case of a weld failure, remove all the old weld using a grinder.

4. Weld up crack or the removed weld location per ASTM D-1. If replacing a broken weld, reference figure 3 for weld details. (If sheet metal is cracked or separated, align the two pieces so they are flush before welding. If needed clamps and metal working equipment will be helpful.)

5. If welding up a crack, grind down welded surface flush to material on both sides if possible.

6. If reinforcement is missing or incorrectly installed, install new reinforcement (P/N: 772013200) once the crack has been repaired per figure 3.

TRANSITION WELD/CRACK REPAIR PROCEDURE

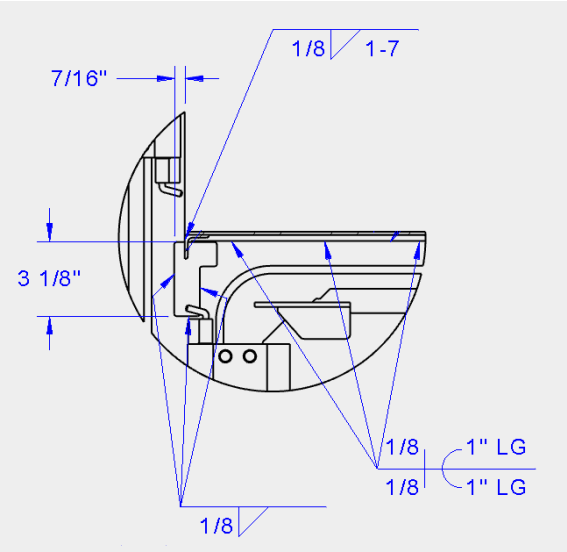

Figure 3 – Reinforcement Weld Detail

7. Inspect weld before paint. Inspect Sheet metal repair before paint. If any Pin holes are found after weld, grind down weld and refill as needed.

8. Repaint or bed line per Paint Manufacturer's Product Data Sheet and ACS 200 standard. Contact Auto Crane for a copy of the ACS 200 standard.

9. After paint or bedliner is complete reinstall components that have been removed for the repair to be completed.

10. Final inspection of the area to confirm it is defect free.