9-4. FRAME REPAIR (Con't).

NOTE

- The following procedure may be used to replace any bracket, hanger, or support that attaches to frame.
- Ensure that any drivetrain, exhaust, and suspension components required to obtain direct access to any damaged bracket, hanger, or support are removed.
- When bolt is used to replace rivet on top or bottom flange of side rail, bolt must be installed from top down,

1. Remove rivet by shearing rivet head with rivet buster. Remove rest of rivet body from rivet hole using drift punch and hammer.
2. Install a 3/8 in. appropriate length hex head bolt, 3/8 in. "HEAVY" classification lockwasher, and 3/8 in. hex nut,
3. Tighten each nut to 30-40 lb.-ft. (41-54 N.m).

d. FRAME REINFORCEMENT

1. See TB 9-2300-257-40.

e. CRACK REPAIR

WARNING

Use only effective chip guarding and personnel protective equipment (goggles/shield, gloves, etc.) when using grinder. Failure to follow this warning may result in injury to personnel.

CAUTION

DO NOT use oxyacetylene welding equipment to repair cracks on CUCV Series truck frames. Failure to follow this caution may result in weld and/or frame failures.

NOTE

- Straight cracks may result from high concentrations of stress in small areas of frame, excessive bending movement, and torsional loading.
- Sunburst cracks are caused by high loads being applied to a mounting bracket or crossmember which is not securely or properly attached to rail,
- Crossmember mounting flange cracks may be repaired in the same manner as side rail cracks; however, ensure that weld bead is built up to provide a good, smooth radius.

1. Remove any component that will interfere with access to crack.