

Floor Cracks Repair

Rear Panel
VN, VT**FSB 811-006, Floor Cracks Repair (Rear Panel)**

(October 2012)

For VN and VT vehicles requiring rear floor panel repair due to early stage cracking, utilize the following procedure to complete the repair.

Required Parts

- 1 - 85105092 Floor Panel
- 2 - 85109453 Floor Panel Re-inforcement

Note: Information is subject to change without notice.
Illustrations are used for reference only and can differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

Procedure

You must read and understand the precautions and guidelines in Service Information, group 8, "General Safety Practices, Cab" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.



WARNING

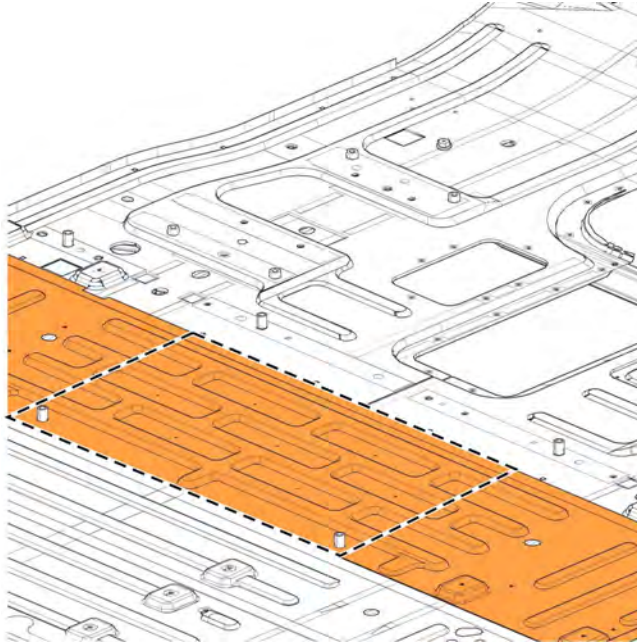
When disassembling cab components, sudden movements, caused by stresses in the structure, can occur. Surrounding components can shift or fall down when components are removed.

Note: This repair procedure is designed to be preformed with the cab installed on the chassis.

Note: This procedure begins with the interior removed. For information on how to remove the interior, see Function Group 85.

- 1 Secure the vehicle for service by parking it on a flat level surface, applying the parking brake, chocking the rear wheel, and placing the transmission in neutral.
- 2 Disconnect all cables from the negative (ground) and positive battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
- 3 If applicable, remove the transmission shifter panel.

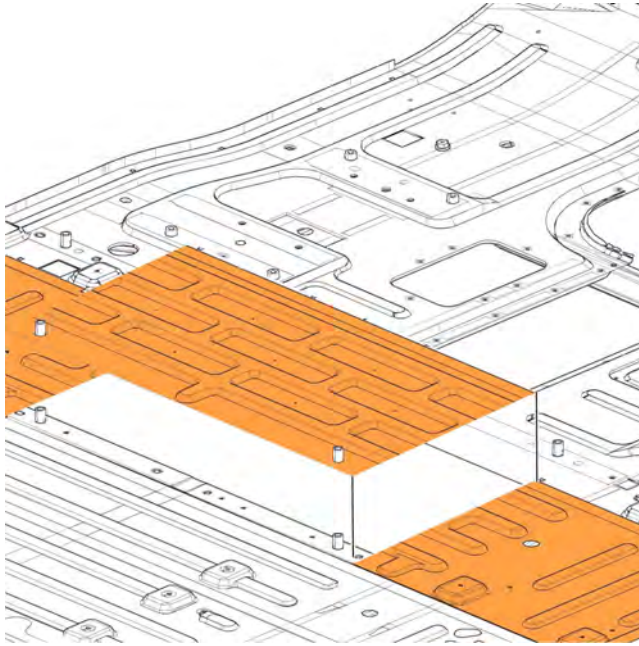
- 4 Remove the drive shaft.
- 5 Mark the location for the patch panel to be replaced.



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- 6 Drill out the spot welds in the repair area.
Note: The amount of spot welds can differ for each repair.
- 7 Using a cut off tool, cut out the damaged floor section.
- 8 Prep the edge of the floor panel where the defective panel was removed.
Note: Remove any bur's from the cut edge of the floor panel. Also round any sharp edges to prevent stress cracks from forming.
- 9 Layout the patch panel.
Note: The patch panel must have a minimum of 25 mm (1 in.) overlay on all side of the area being patched.
- 10 Clean the welding surfaces free from paint and E-coat.

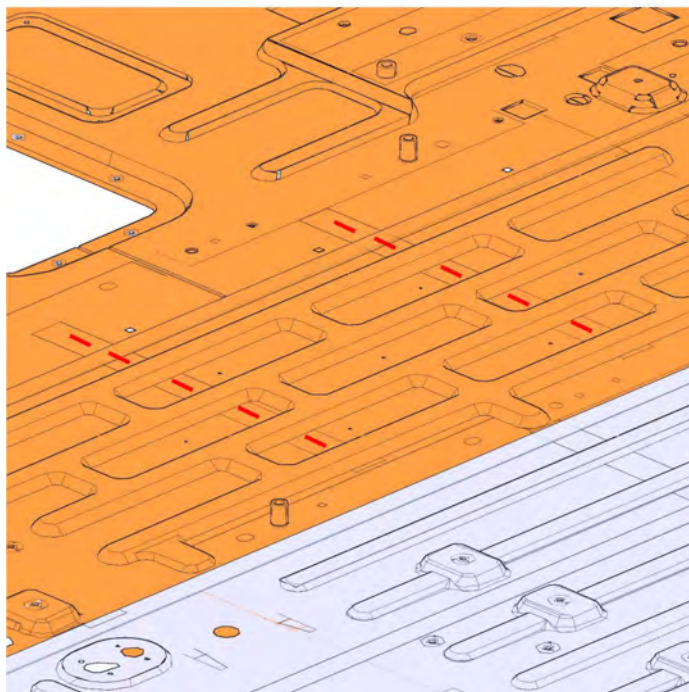
- 11 Using clamps as needed, install the patch panel into position. To secure the patch panel, spot weld as needed.



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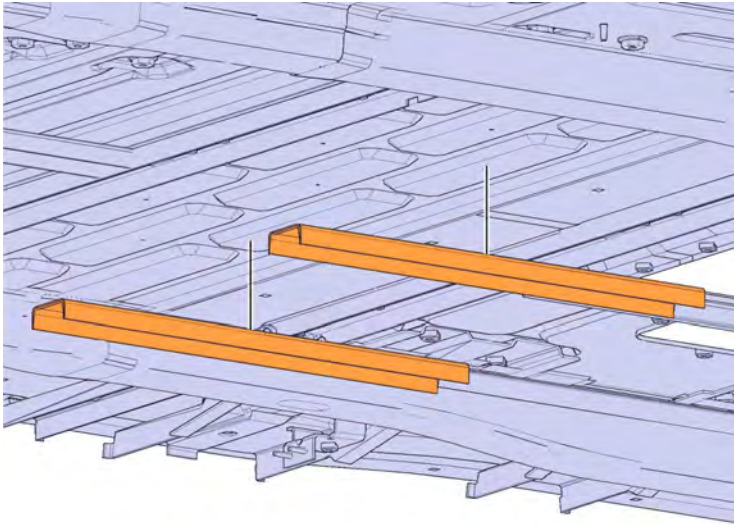
- 12 For the rear floor stiffing brackets installation, measure and mark the locations on the rear cab floor and cab floor cross supports 406 mm (16 in) off center of the rear panel bracket. This location is directly behind the floor patch panel.

13 To attach the floor patch panel to the rear support braces, mark and drill in the ten (10) plug welds.



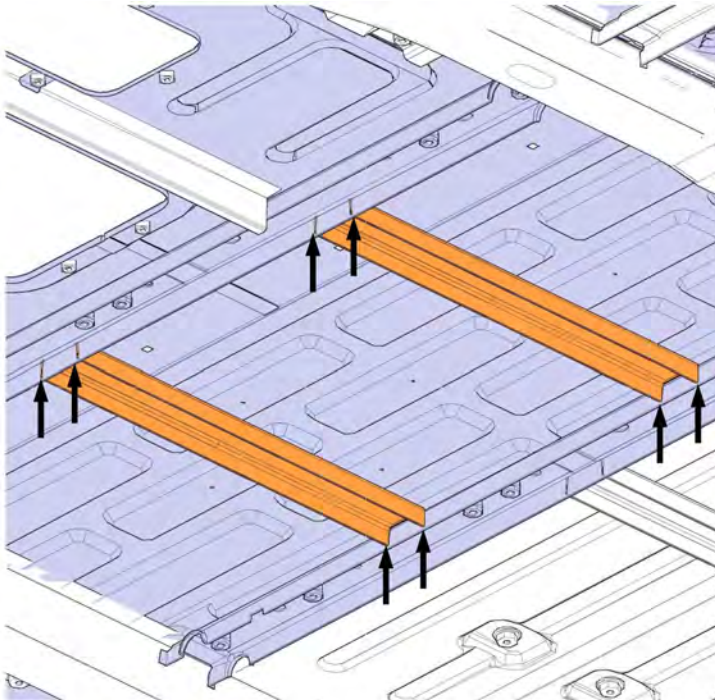
14 Grind off and prepare the surfaces to be welded.

- 15 Underneath the rear patch panel, using clamps as needed, position the rear cab support floor brackets. Place the rear brackets 406 mm (16 in) off center of the rear panel bracket directly behind the floor patch panel.



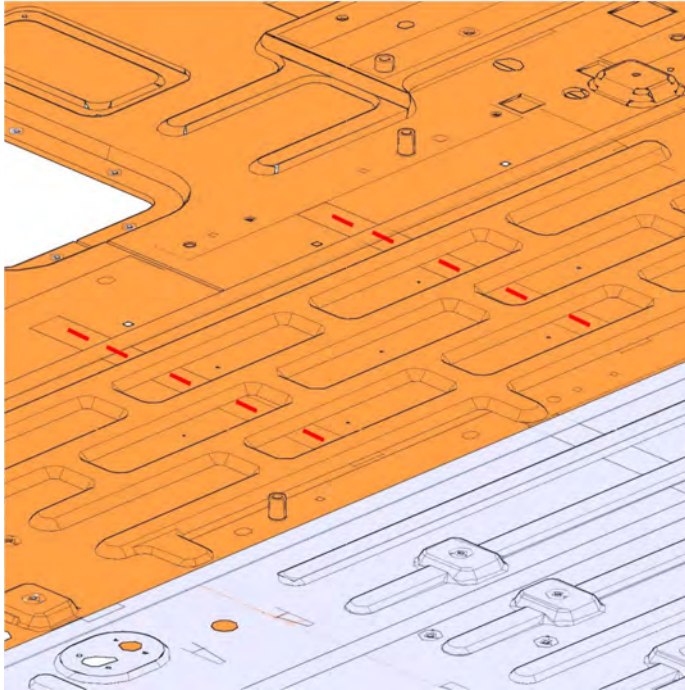
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- 16 Weld all four (4) corners of each bracket to the cab floor support crossmembers.



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17 Plug weld all ten (10) locations securing the rear floor patch panel to the rear cab support floor brackets.



18 After the welding has been completed grind all the welds and seams for prep and paint.

19 Apply primer coat to both sides of the repaired area.

20 Apply paint to both sides of the repaired area once the primer has cured.

21 Install interior. For information on how to install the interior, refer Function Group 85.

22 If applicable, Install the transmission shifter.

23 Reconnect all previously removed cables to the negative (ground) battery terminals.

Reimbursement

This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	W
Labor Code	
Primary Labor Code	81103-2-00 16.9 hrs.
Causal Part	85105092

Volvo Trucks North America engages in a continuous program of testing and evaluating to provide the best possible product. Volvo Trucks North America, however, is not committed to, or liable for updating existing chassis.