

# **XPO**Logistics Manufacturing

## **ANCRA Track Replacement**

November 29, 2018

If an ANCRA Lift-A-Deck track is damaged or has exceeded maximum allowable wear in the groves, the track will need to be replaced. This document details the procedure for replacing tracks that are attached to the composite sidewalls with rivets and adhesive.

1. Using a chisel, drill, or other available tool, remove the head of the rivet from the inside of the trailer. Then use a punch to drive the rivet body through the sidewall panel, from the inside.
2. Use a heat gun on the surface of the ANCRA track to weaken the adhesive. Use a thin piece of wire or a putty knife behind the track to pry the track away from the panel. The heat gun and wire/putty knife will have to be used at the same time to work from one end of the track to the other (starting at the top and working down).
3. Remove any remaining adhesive from the panel using the heat gun and a scraper.
4. Clean the panel and the rear surface of the replacement ANCRA track with alcohol.
5. Apply a bead of adhesive (3/16" in diameter) to the rear of the ANCRA track. Try to keep the bead centered in the middle of the track.
6. Line the track up with the existing holes and press the track against the wall. Take care not to pick the track up once it has been placed as this can create air bubbles which can weaken the adhesive. The track can be slid from side-to-side to help align the holes without causing any issues.
7. Replace all rivets (6300174 8-8) from the inside. Put a 1/4" flat washer on the stem of the rivet on the outside of the panel to ensure a good seal. If 6300174 is not available a solid rivet can be used in its place (6300112 8-8).
8. Avoid using the replaced track for at least 12 hours to allow the adhesive plenty of time to cure. Colder climates will slow the curing process.