

Installing IFS Gussets

If top frame gussets are not in place, follow the instructions below to weld them in place.

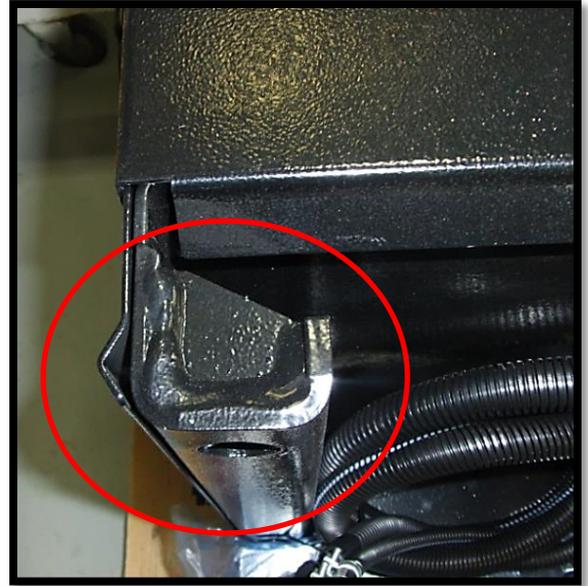
Preparation:

1. Carefully inspect the frames per Inspection Instruction #61283. If you detect tearing or cracking, remove the APU from the truck and call IFS customer service. If no cracks were determined continue to step #2.
2. Remove the IFS APU from the truck's frame prior to welding the IFS frame gusset into place. The IFS APU should be removed from the truck's frame to isolate the electrical circuit (welding current) from the truck's electrical system.
3. The Truck's grounding cable (truck's battery box) should be removed prior to welding the top frame gusset into place.
4. The welding of the gussets on the top of the IFS frame **can be** done **without removing the coolant hoses or the refrigerant lines**.
5. The gusset installation will include the replacing of the frame mounting bracket and the frame mounting bolts if required.

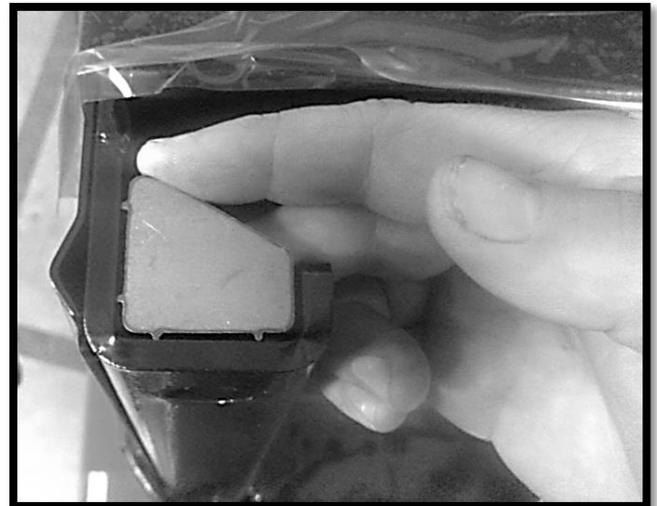
Installation:

- 1) Place table jack (for lifting APU) or transmission jack under the IFS APU and lift just enough to relieve pressure from APU mounting bolts.
- 2) Remove the APU mount bolts to reduce strain on the APU frame.
- 3) Use a wire wheel to clean off the paint on the upper (inner) corner of the APU upright, (**make sure that the paint is removed**).
- 4) Hold the gusset (as shown) and tack weld into place. The gusset includes location points to allow for proper fit and weld penetration.
- 5) Place the gusset so that the 4 location legs are in contact with the APU frame in the orientation (shown to the right).
- 6) Weld the gusset along the 3 edges of APU frame contact. Use a continuous weld with a fillet of 0.12 and ensure contact between the gusset and frame.
- 7) Paint the welded gusset area with black spray paint.
- 8) Repeat these procedures for the second gusset installation.

REV C, 06/2015



Frame gusset in place



Frame Gusset being held in place

Remounting:

1. DO NOT REUSE MOUNTINGHARDWARE.
2. Replace the mounting back brackets and the frame mount bolts as described in the mounting installation instructions (#61284)