

SERVICE BULLETIN



SILVER EAGLE
MANUFACTURING COMPANY

5825 NE Skyport Way, Portland, OR 97218
(800) 547-6792 Fax: (503) 335-2171

BULLETIN NO.: SB03-003 REV
DATE: June 9, 2003
PAGE: 1 of 3

REFERENCE: **UPS CAMPAIGN 36-9027**
TP-60 DRAWBAR REPAIR

CAUSE FOR ACTION: Repair cracks and reinforce area.

UNITS INVOLVED: 100 UPS 1995 TP-60 Trailers

Units: 47076 - 47175
VIN: 1U3TP2829TV1233 - 1U3TP2820TBV1332

PARTS: Provided to Sparks MDC
No.: 15579 Kit
Reinforcement Drawbar Kit (1 required/trailer)
Cost: **N/C**

PARTS LIST:	P/N	Qty	Description
	15549	(1)	Reinforcement Bracket, CS, TP-60
	15578	(1)	Reinforcement Bracket, RS, TP-60
	15580	(2)	Capscrew, 1/4-20 x 1-1/4 button head cap
	18883	(2)	Nut, 1/4-20 UNC, Nyloc, HX, GR C, Pltd

TOOLS REQUIRED: - 5/32" Allen Wrench - 7/16" Open End Wrench
- Power Drill - 17/64" Drill Bit
- C Clamp - Wire wheel

ESTIMATED LABOR: Three (3) hours

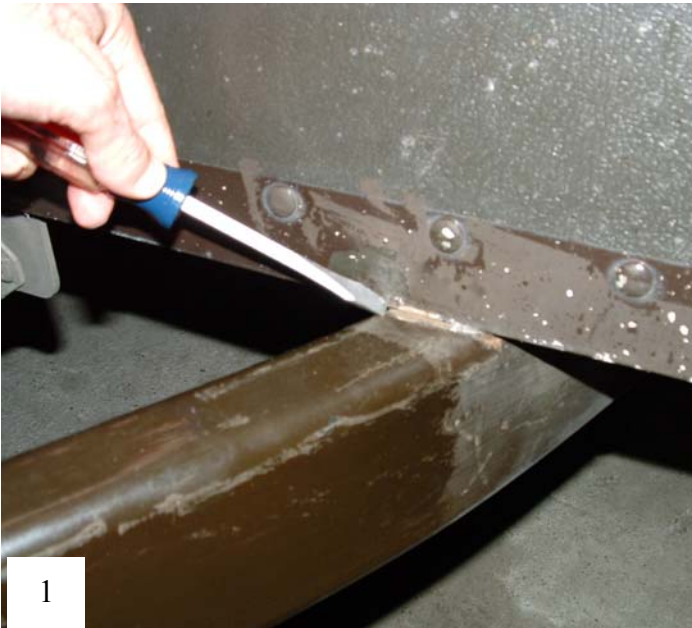


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UPS CAMPAIGN 36-9027 TP-60 DRAWBAR REPAIR



- Remove caulking from drawbar seam.



- Cut away a section of panel over the drawbar area to expose the weld.
- Cut through the aluminum skin only.
- Remove huck rivet above drawbar tube.



- Inspect drawbar for cracking at edge of weld.
- Using a wire wheel, clean up area around weld and drawbar.
- Grind crack area out preparing for full penetration weld.



- Place reinforcement flange on drawbar and mark from rear side for drilling.
- Drill 17/64" diameter hole through top flange of reinforcement flange as marked.



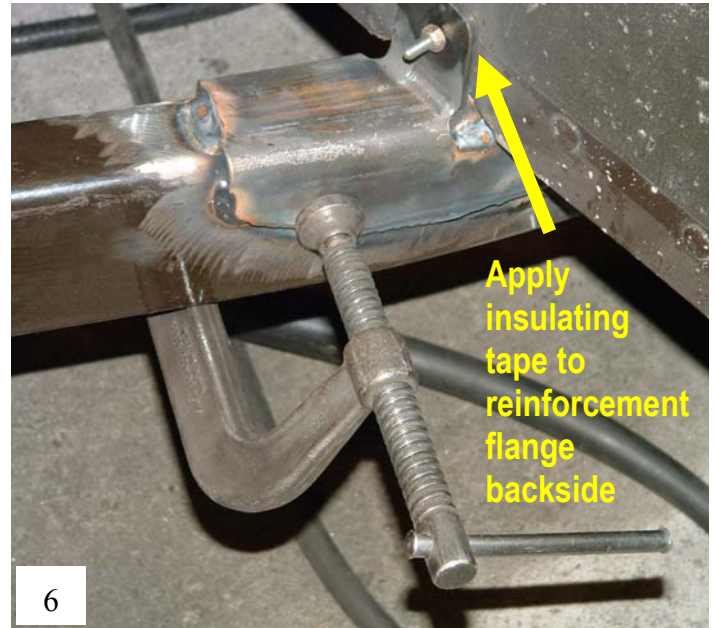
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- Remove paint from areas to be welded.
- Weld cracks in drawbar.



- Bolt reinforcement flange through hole created by removing rivet.
- C-Clamp sides of reinforcement flange to drawbar tube.



- Weld reinforcement flange to drawbar.
- Install bolt.



- Prime and paint.