



Process Sheet

Repair front bottom end. (10737/1)



Sealant



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Van Types	Caravan
Zone	Repair ()
Assembly Lines	Repair
Product Groups	T2 , T3

Tooling



Clean Lint Free Cloth



Knife



Power Drill



Sealant Gun

Additional tooling: Scraper, Wedges, 6mm drill bit 1/2" Counterbore

Risk Assessment

No risk assessment required

Materials/Consumables

Part Number	Description	Quantity	Steps
1063017	Cleaner - Pdi Smp 206 2005 Spec	A/R	7
1072923	Strap Roof Finisher W249 Dd1177 To Drg Cgcm0072 (2007 Spec) Finisher Profile	A/R	8
1075885	Sealant-Str 360 White 600Mi 2007 Spec Sealant	A/R	5,8
1075903	Primer M 500Mi Can 2007 Spec	A/R	8
1407597	Pu Constuction Adhesive 500G Pur Adhesive 501 2014 Spec	A/R	4
1407979	Screw M6x60 Pozi Csk C/Board 2013 Spec	A/R	6
1500636	Screw-10X1 Pan St Ss Pz H De-Greased (96 Spec)	A/R	8
1711131	Screw 4.8(No10)X75mm Decking	A/R	9

COSHH



Dispose in Designated Bins



Dust A2 Type Mask



Grade 3 Eye Protection



Keep Skin Covered



Polythene or Nitrile Gloves



Shower if Heavily Soiled



Wash After Skin Contact



Well Ventilated

No additional COSHH

Revision History

Revision	Description	By	On
001	Created	Lee Atkinson	31 Jan 2018



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Step 1

With caravan parked and all 4 jack legs down. Access the gas locker box. If aluminium angle is visible remove fixing screws and remove angle. If angle is behind false panel carefully cut around sealant and remove flexible rubber then prise false panel away. On Door side it will require the BBQ pipe to be removed if fitted, then remove aluminium angle.

Clean and keep the panels / angle but discard the screws.



Step 2

Remove caps from front awning end caps and wheel spats. Remove Screws and carefully remove caps and spats - these will be held in place with tape behind the fixings. If "old" type spats used no fixings will be visible and the spat is adhered to clips around the wheel box - a scraper will be required to cut through the sealant. **Note Wheel spats may be left if rails or skirts can be removed carefully.**

Remove insert from front rub rails remove screws. Using a scraper carefully prise the rub rails off the jig side care to be taken not to delaminate the Sides.

If plastic skirts fitted lift the skirt of the carrier - it is stuck to the carrier in several positions so a knife / scraper will be required. Using a scraper carefully prise the rub rails off the jig side care to be taken not to delaminate the Sides.





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Step 3

Carefully remove all the sealant from the jig sides. Check for any damage caused by removal of skirts and repair if necessary. Remove all the floor / jig side M6 screws from the jig side - several may have snapped. Remove all from the front to the wheelarch.



Step 4

Check bottom of jig side for any damaged or loose PU rails. If the rail is badly damaged scrape out damaged section and replace with a new section of rail using PUR adhesive. If the rail is just loose re glue in place with PUR adhesive. Note this adhesive is a "foaming" adhesive so care should be taken not to let the glue contaminate any other part of the van, also the rail will need holding (Tape) in place as the adhesive may push it out.

Part Number	Description	Quantity
1407597	Pu Constuction Adhesive 500G Pur Adhesive 501 2014 A/R Spec	





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Step 5

Carefully wedge the floor away from the jig side and inject STR360 into the joint - care to be taken not to inject too much as this will show inside the van.

Part Number	Description	Quantity
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1075885	Sealant-Str 360 White 600Mi 2007 Spec Sealant	A/1
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Step 6

Remove the wedges from the floor. Using either the vans jacks or a separate jack align the jig side with the bottom of the floor. Redrill holes for fixing using a 6mm drill bit at least 20mm away from existing holes - ensure new holes are not on the joints of any repaired PU rails. Drill extra holes between existing to "double up" the number of fixings. Using a 1/2" counter bore re-drill the holes so the screw head will sit flush with the GRP. Fix Jig Side to floor with M6 x 60 CSK screws.

Note - there may be metal/plastic plates under the van which position the jig side onto the floor these should contact the jig side if in the vicinity of the repair

Part Number	Description	Quantity
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1407979	Screw M6x60 Pozz Csk C/Board 2013 Spec	A/1
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Step 7

Check inside / under the van for any STR360 that may have squeezed out of the joint and is visible, remove with a cloth dampened in PDI cleaner as required.

Part Number	Description	Quantity
1063017	Cleaner - Pdi Smp 206 2005 Spec	A/R

Step 8

Prime the aluminium angle and contact points on the jig side / front bottom end and the false panel (if fitted) with a clean lint free cloth dampened with Prep M and allow 5 mins to flash off.

Apply STR 360 to both faces of the angle, position onto the joint and screw in place with No 10 x 1" SS Pan Hd screws.

Apply STR 360 to the rear of the false panel (if fitted) and position into the corners and firmly push in place. Cut a length of roof finisher and stick it over the joint.

Part Number	Description	Quantity
1075885	Sealant-Str 360 White 600Ml 2007 Spec Sealant	A/R
1075903	Primer M 500Ml Can 2007 Spec	A/R
1500636	Screw-10X1 Pan St Ss Pz H De-Greased (96 Spec)	A/R
1072923	Strap Roof Finisher W249 Dd1177 To Drg Cgcm0072 (2007 Spec) Finisher Profile	A/R





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Step 9

Inside the van remove the front Binnacle and the L section from the front bottom shelf.

Check the shelf is correctly attached to the front bottom end add extra fixings to pull up as required.

Replace L section and Binnacle.

Check the remainder of the screws into the front bottom end under the van. If any of the screws are missing or loose check the rail for damage and if no damage fit new screws adjacent to the current screw. If the rail is damaged replace the rail as per the side rails and refit the screws.

Part Number	Description	Quantity
1711131	Screw 4.8(No10)X75mm Decking	A/R





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Step 10

Refit all removed parts - reference appropriate process sheet for re fitting.

BBQ pipe to be reconnected if required. Only suitably qualified personnel can carry out this operations and van gas tested.

Wheel spats tin skirt 10394

Tin skirts 2168

Tins skirt end caps 1862

Wheel spat plastic skirt similar to 10509 without the metal brackets

Plastic skirts 10207

Plastic skirt end caps 10475

Rub Rails - same as awning channel 10018

All materials to be reused except fixing screws which must be replaced.