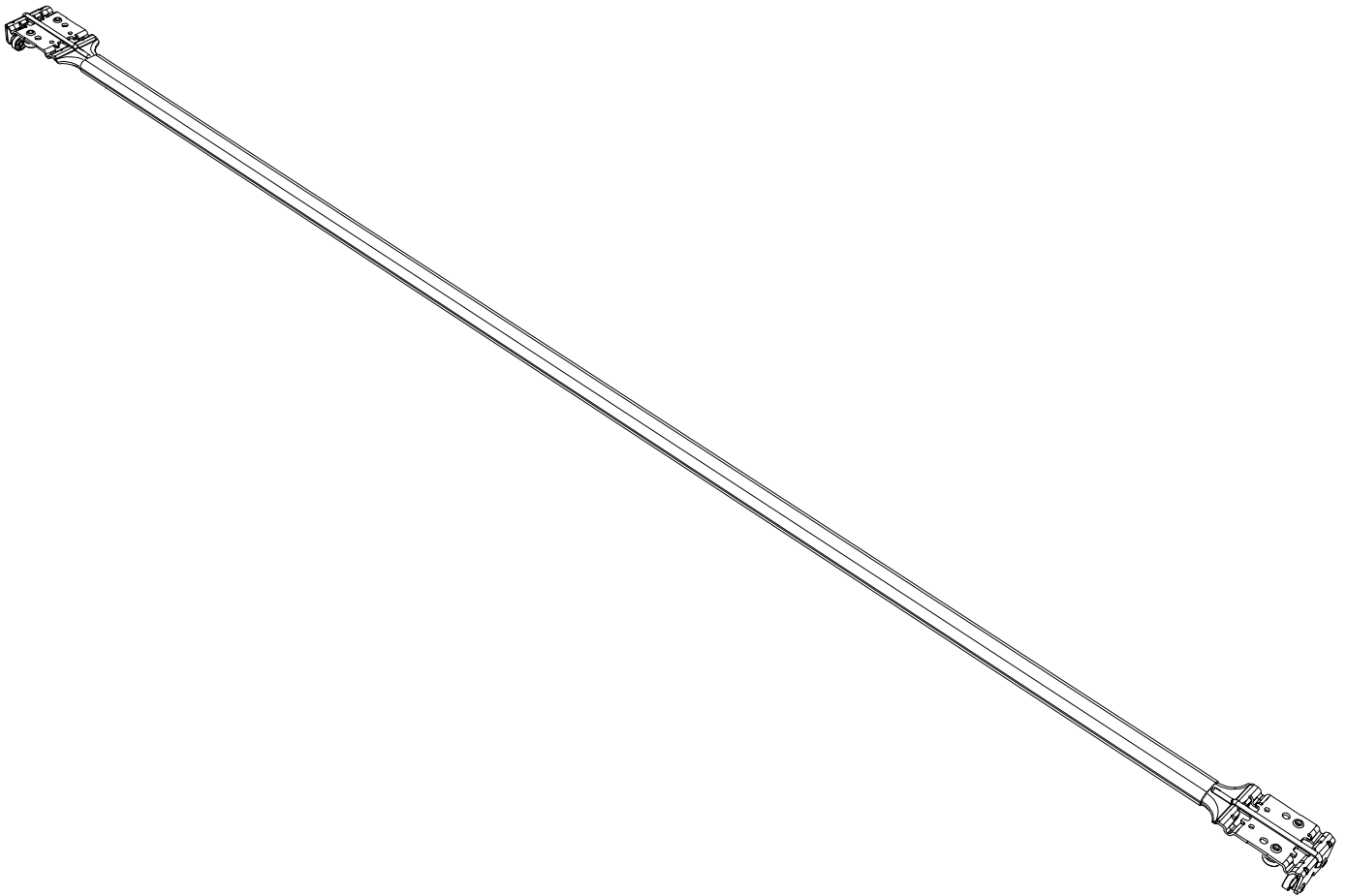


# Repair instruction crossbeam



Translation of the original repair instruction



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## General remarks

### Introduction to repair instruction

Alteration service: Yes

Staff: According to curriculum for apprenticeship as a body and vehicle mechanic and a body and vehicle construction mechanic.

This repair instruction is part of the delivery and an important help for a successful repair. So it must be available to the technician during the repair work,

Furthermore, the assembly guidelines of the applicable vehicle producers must be obeyed.

### Copyright:

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### Instruction and training support

As an employer, you are obliged to inform and instruct your personnel about existing legal and accident prevention regulations.

The personnel must have understood these instructions, and it must be safeguarded that the instructions are obeyed.

Only in this way you will reach safety and danger awareness of your personnel at work.

## Example for training topics

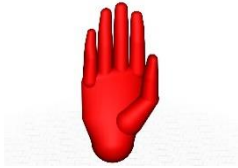
### 1. About safety

- Accident prevention regulations
- General legislation
- General safety hints
- Measures in emergency cases
- Personal protective equipment

### 2. Maintenance and repair regulations

- Correct use of cleaning agents and lubricants
- Special experience of the mechanic in maintenance, repair, cleaning and upkeep of the product

## Hints



### **Attention**

Texts with this symbol will warn you against possible mistakes in mounting and, therefore, against potential material damages.



### **HINT!**

Texts with this symbol will give you tips or additional information.



### **TIGHTENING TORQUE**

Texts with this symbol will give you the necessary tightening torques.

## Safety

### General

Although our products are in accordance with the state of the art, they may pose a risk if:

- they are mounted by unskilled personnel
- they are maintained improperly.

### Safety hints

This safety instruction informs you about the products of TSE Trailer System Engineering GmbH & Co. KG. It contains information about maintenance and repair of the parts and their components. The service instruction has only been written for skilled personnel of qualified and authorized specialized companies in motor vehicle crafts. The service instruction is not applicable for other target groups.

We want to support specialized companies with the present mounting instruction during the mounting works with our products.

TSE Trailer System Engineering GmbH & Co. KG accepts no liability for the installation of inapplicable or unreleased parts in their products. We do not accept any warranty for the correctness, completeness or currency of the given information. The contents and information of this mounting instruction are neither a warranty or warranted characteristics within the meaning of German legislation, respectively the German Civil Code (Bürgerliches Gesetzbuch (BGB)), nor can they be interpreted as such.

No claims can be derived from provision of information, recommendation or consulting. Liability for damages is generally excluded as far as we are not responsible in the sense of intent or gross negligence, or as far as this does not contradict mandatory legal provisions.

Texts and graphics are subject to our rights of use; copy rights or right of distribution in any form require our agreement.

Mentioned brand names, even if they are not marked as such in every case, are still subject to the regulations of the trade mark law.

If any disputes of legal nature occur from applying information found in this mounting instruction, they shall solely be subject to the regulations of German law.

The Amtsgericht Stuttgart (Local Court in Stuttgart) is deemed to be agreed on as place of jurisdiction. If some clauses of this declaration about limitation of liability do not or no longer comply with the applicable legal provisions, the validity of the other clauses shall remain unaffected thereof. Read the information in this mounting instruction carefully. Especially, obey the hints for your own safety.

All technical information, descriptions and pictures shall be valid from the day of their printing - respectively the day of any supplements hereto - on.

We reserve the right to make changes due to steady further development.

No claims can be derived from applications and explanations of this publication.

#### **Safety hints for the technician:**

Unauthorized people are not allowed to enter the vehicle and the area around it.

Your working area should be in good order.

Only works which you are commissioned and acquainted with have to be executed.

Increased caution is advisable in dangerous areas.

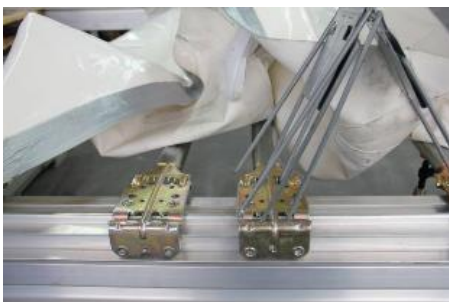
Obey the producer's information and safety hints for the applicable product when you deal with operation materials (oils, grease etc.).

Only applicable lifting devices may be used.

## Dismantling of the roof tarp and scissor lift packages

**1****Dismantle the roof tarp**

Dismantle the roof tarp by means of a **Torx key 40** in the area of the castor.

**2****Dismantle the scissor lift packages**

Dismantle the scissor lift packages at the applicable crossbeam.

## Dismantling the castor

**1****Dismantle the castor**

Drill the rivets with a drill  
 $\varnothing 10$  and remove them with a  
punch, if necessary.

**2****Clean the rail**

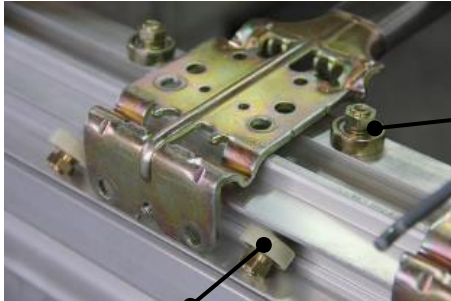
Now the console can be removed without problems.



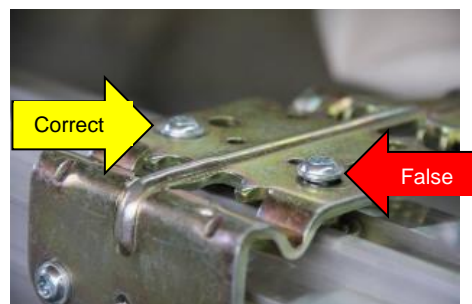
The rail must be cleaned after dismantling the castor.



## Mount the castors

**1**
**Mount the castors**


Castor Ø =26mm plastic


 Castor Ø=26mm steel  
 TSE-no.: 300-51.169

 Castor Ø =26mm plastics  
 TSE-no.: 300-51.168

 Fillister head screw M6x16  
 TSE-no.: 000-06.402

**Torque 16,5Nm**

Screws have to be fixed by means of a **Torx key 40** and an open-end wrench with **wrench size 14**.

When mounting the castors, the correct placement of the screws has to be obeyed.

## Mounting of the roof tarp and scissor lift packages

**1****Mount the scissor lift packages**

Now reinstall the scissor lift packages.

**2****Mount the roof tarp**

Fix the tapite screw with a  
**Torx key 40.**



**Torque 14,0Nm**



When the complete  
crossbeam is exchanged, the  
console will also be changed



## Annexes Assembly preloads and tightening torques of screw connections according to VDI guideline 2230

Measure	Strength class	Assembly preloads for mounting $F_T$ in kN für $\mu_G =$							Tightening torques $M_A$ in Nm for $\mu_K = \mu_G =$						
		0,08	0,10	0,12	0,14	0,16	0,20	0,24	0,08	0,10	0,12	0,14	0,16	0,20	0,24
<b>M 4</b>	8.8	4,6	4,5	4,4	4,3	4,2	3,9	3,7	2,3	2,6	3,0	3,3	3,6	4,1	4,5
	10.9	6,8	6,7	6,5	6,3	6,1	5,7	5,4	3,3	3,9	4,6	4,8	5,3	6,0	6,6
	12.9	8,0	7,8	7,6	7,4	7,1	6,7	6,3	3,9	4,5	5,1	5,6	6,2	7,0	7,8
<b>M 5</b>	8.8	7,6	7,4	7,2	7,0	6,8	6,4	6,0	4,4	5,2	5,9	6,5	7,1	8,1	9,0
	10.9	11,1	10,8	10,6	10,3	10,0	9,4	8,8	6,5	7,6	8,6	9,5	10,4	11,9	13,2
	12.9	13,0	12,7	12,4	12,0	11,7	11,0	10,3	7,6	8,9	10,0	11,2	12,2	14,0	15,5
<b>M 6</b>	8.8	10,7	10,4	10,2	9,9	9,6	9,0	8,4	7,7	9,0	10,1	11,3	12,3	14,1	15,6
	10.9	15,7	15,3	14,9	14,5	14,1	13,2	12,4	11,3	13,2	14,9	16,5	18,0	20,7	22,9
	12.9	18,4	17,9	17,5	17,0	16,5	15,5	14,5	13,2	15,4	17,4	19,3	21,1	24,2	26,8
<b>M 7</b>	8.8	15,5	15,1	14,8	14,4	14,0	13,1	12,3	12,6	14,8	16,8	18,7	20,5	23,6	26,2
	10.9	22,7	22,5	21,7	21,1	20,5	19,3	18,1	18,5	21,7	24,7	27,5	30,1	34,7	38,5
	12.9	26,6	26,0	25,4	24,7	24,0	22,6	21,2	21,6	25,4	28,9	32,2	35,2	40,6	45,1
<b>M 8</b>	8.8	19,5	19,1	18,6	18,1	17,6	16,5	15,5	18,5	21,6	24,6	27,3	29,8	34,3	38,0
	10.9	28,7	28,0	27,3	26,6	25,8	24,3	22,7	27,2	31,8	36,1	40,1	43,8	50,3	55,8
	12.9	33,6	32,8	32,0	31,1	30,2	28,4	26,6	31,8	37,2	42,2	46,9	51,2	58,9	65,3
<b>M10</b>	8.8	31,0	30,3	29,6	28,8	27,9	26,3	24,7	36	43	48	54	59	68	75
	10.9	45,6	44,5	43,4	42,2	41,0	38,6	36,2	53	63	71	79	87	100	110
	12.9	53,3	52,1	50,8	49,4	48,0	45,2	42,4	62	73	83	93	101	116	129
<b>M 12</b>	8.8	45,2	44,1	43,0	41,9	40,7	38,3	35,9	63	73	84	93	102	117	130
	10.9	66,3	64,8	63,2	61,5	59,8	56,3	52,8	92	108	123	137	149	172	191
	12.9	77,6	75,9	74,0	72,0	70,0	65,8	61,8	108	126	144	160	175	201	223
<b>M 14</b>	8.8	62,0	60,6	59,1	57,5	55,9	52,6	49,3	100	117	133	148	162	187	207
	10.9	91,0	88,9	86,7	84,4	82,1	77,2	72,5	146	172	195	218	238	274	304
	12.9	106,5	104,1	101,5	98,8	96,0	90,4	84,8	171	201	229	255	279	321	356
<b>M 16</b>	8.8	84,7	82,9	80,9	78,8	76,6	72,2	67,8	153	180	206	230	252	291	325
	10.9	124,4	121,7	118,8	115,7	112,6	106,1	99,6	224	264	302	338	370	428	477
	12.9	145,5	142,4	139,0	135,4	131,7	124,1	116,6	262	309	354	395	433	501	558
<b>M 18</b>	8.8	107	104	102	99	96	91	85	220	259	295	329	360	415	462
	10.9	152	149	145	141	137	129	121	314	369	421	469	513	592	657
	12.9	178	174	170	165	160	151	142	367	432	492	549	601	692	769
<b>M 20</b>	8.8	136	134	130	127	123	116	109	308	363	415	464	509	588	655
	10.9	194	190	186	181	176	166	156	438	517	592	661	725	838	933
	12.9	227	223	217	212	206	194	182	513	605	692	773	848	980	1092
<b>M 22</b>	8.8	170	166	162	158	154	145	137	417	495	567	634	697	808	901
	10.9	242	237	231	225	219	207	194	595	704	807	904	993	1151	1284
	12.9	283	277	271	264	257	242	228	696	824	945	1057	1162	1347	1502
<b>M 24</b>	8.8	196	192	188	183	173	168	157	529	625	714	798	875	1011	1126
	10.9	280	274	267	260	253	239	224	757	890	1017	1136	1246	1440	1604
	12.9	327	320	313	305	296	279	262	882	1041	1190	1329	1458	1685	1877

Quelle: VDI-Richtlinie 2230 Blatt 1 S. 109

Montagevorspannkraft  $F_{MTab}$  und Anziehdrehmomente  $M_a$  bei  $\nu = 0,9$  für Schaftschrauben mit metrischem Regelgewinde nach DIN ISO, 68, DIN ISO 724, DIN 13-19; Kopfabmessungen von Sechskantschrauben nach DIN EN ISO 4014 bis DIN EN ISO 4018, Schrauben mit Außensechsrund nach DIN 34 800 bzw. Zylinderschrauben nach DIN EN ISO 4762 und Bohrung „mittel“ nach DIN EN 20 273

Assembly preload  $F_{MTab}$  and tightening torque  $M_a$  with  $\nu = 0,9$  for shank bolts with metric standard thread according to DIN ISO, 68, DIN ISO 724, DIN 13-19; head dimensions of hexagonal bolts according to DIN EN ISO 4014 to DIN EN ISO 4018 hexalobular external driving head bolts according to DIN 34 800 or cylindrical bolts according to DIN EN ISO 4762 and hole „medium“ according to DIN EN 20273



## Revision status

Revision Status	Kind of change	Date	Name
00	New creation of repair instruction	12 April 2019	Laib / Maier