



A Tradition of Quality. Since 1905

STANDARD WORK INSTRUCTION

Document: MBW SWI 463 GTT Final Assembly Operation

Standard Work Process Owner: Defense Production Manager 10/31/16	ISO Management Rep. Approval: QA & CI Director 10/31/2016	Revision: 002	Page 1 of 16
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1 Purpose:

To provide a process for properly building the GTT body during the final assembly operation within Marion Body Works, Inc.

2 Application:

This work instruction applies to all GTT bodies built within Marion Body Works, Inc.

3 Reference Documents:

N/A

4 Procedure:

4.1 Attach reflectors and bumpers

4.1.1 Tap all holes with ¼" tap.

4.1.2 Attach amber reflector (69200603) at the front of side rail on both sides of body. Tighten until reflectors do not spin.

4.1.3 Attach a red reflector (69200602) at rear of side rail in front of hinge pin on both sides of body. Tighten until reflectors do not spin.





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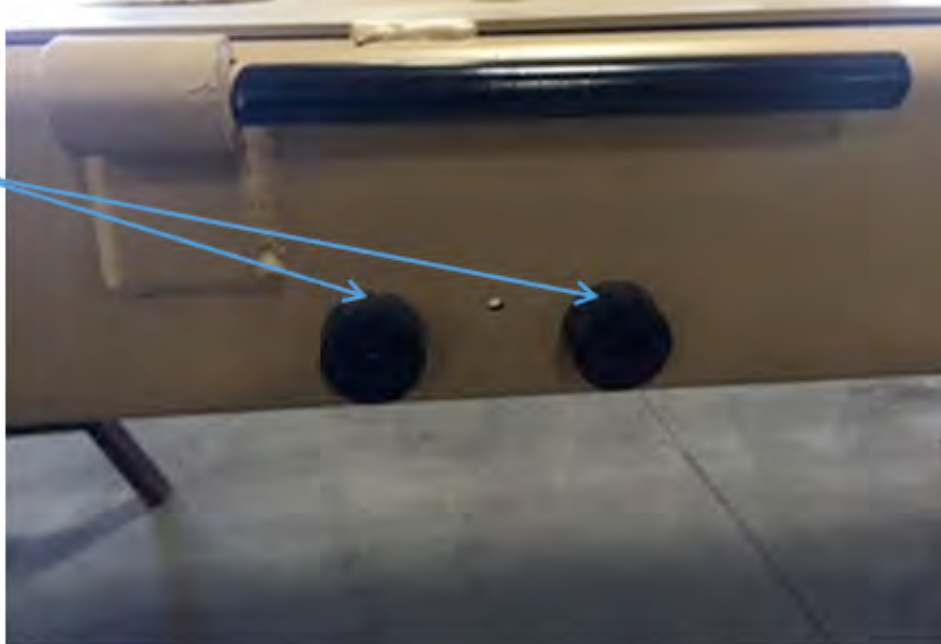
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4.1.4 Attach red reflectors (69200602) at rear of body in front of hinge pin on each side. Tighten until reflectors do not spin.

4.1.5 Attach four rubber bumpers (79200009) on each side of body underneath hinge pins.

Attach
here at
center



4.1.6 Attach two bumpers (79200009) on each end at rear of body underneath hinge pins.



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Reflectors in
front of hinge
pin



Bumpers
below hinge
pin

4.2 Attach marker lights.

4.2.1 Place a amber marker light (69200560) on front of side rail through light mount on both sides.

4.2.1.1 Insert wires through light bracket hole.

4.2.1.2 Attach gromet around hole.

4.2.1.3 Place light into grommet.

4.2.2 Place a red marker light (69200559) on rear of side rail through light mount on both sides. Use process 4.2.1.1-4.2.1.3 for instalation.

4.2.3 Place five red marker lights (69200559) along rear of body in light bracket holes. Use process 4.2.1.1 – 4.2.1.3 for instalation.



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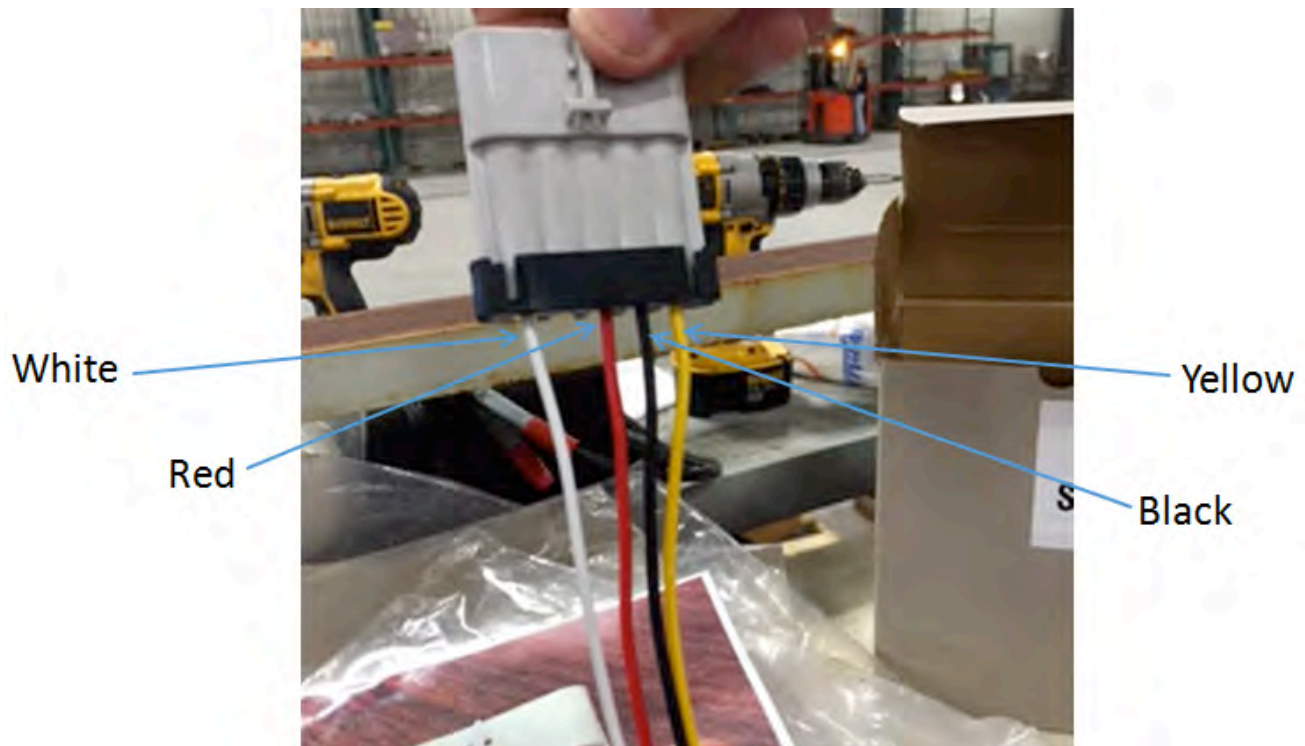
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4.3 Install tail lights.

4.3.1 Lights to be wired as shown in picture.



4.3.2 Attach light at rear of body in tail light pockets with the white ground wire being attached to the inside bottom stud on the light. Use a 7/16" wrench to tighten nuts on stud.



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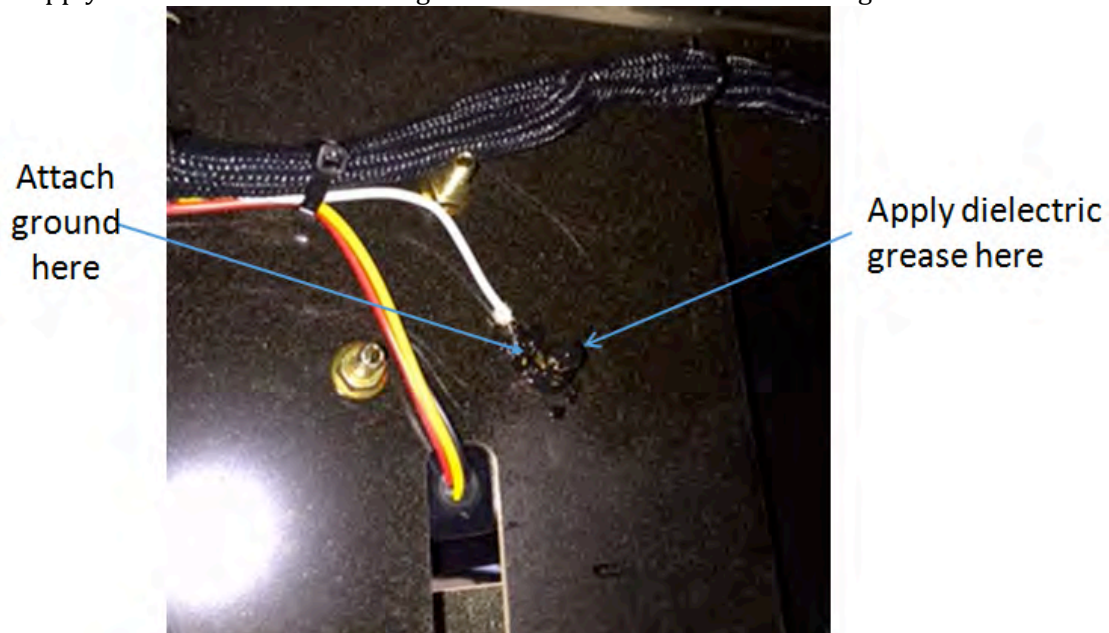
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4.3.3 Apply RTV electrical sealant to ground wire and stud on both tail lights.



4.3.4 Repeat on opposite side tail light.

4.4 Attach Wire Harness

4.4.1 Run wire harness above stringer at rear of body leaving main plug on driver's side of body.

4.4.2 Run wire through cutouts along the edge of side rail to the front of the body. Repeat on opposite side.



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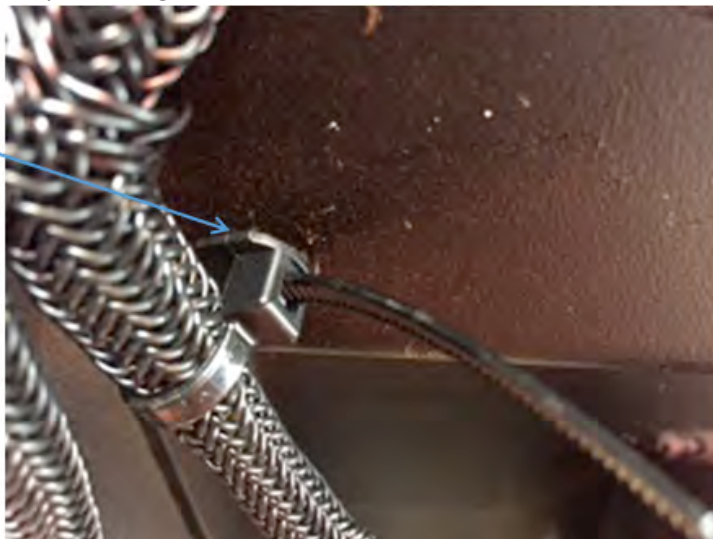
Run harness
through hole

of stringer at rear



- 4.4.3 Attach front two amber marker lights and rear seven red marker lights to harness by connecting black wire to black wire and white wire to white wire.
- 4.4.4 Attach two rear tail lights by plugging connections together.
- 4.4.5 Attach clip on harness to top of tail light mount bracket on both sides

Attaches
in hole





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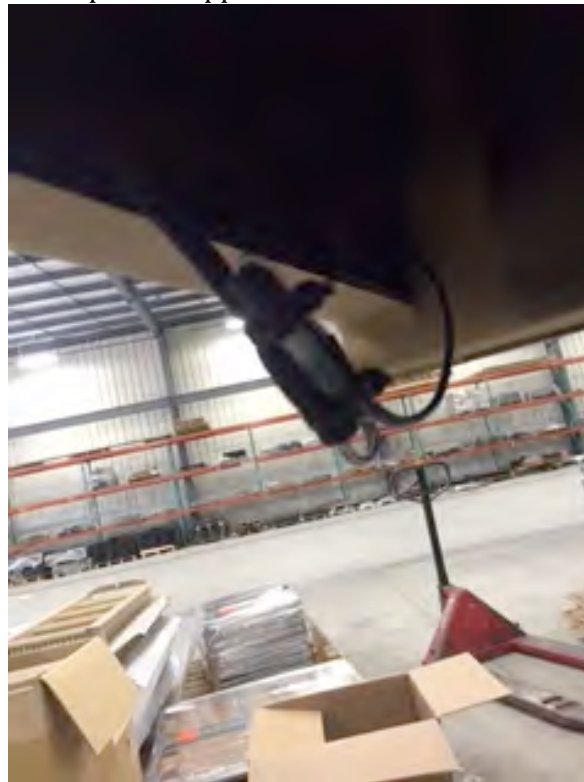
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4.5 Zip tie wires.

- 4.5.1 Fold access wire around front amber marker lights forward and then back again. Zip tie bundle of wire with two zip ties. Repeat on opposite side.



- 4.5.2 Fold access wire around tail light forward and then back again. Fold next to main harness line and zip tie together. Repeat on opposite side



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- 4.5.3 Take main harness line from tail light to rear side narjer and zip tie main harness to side marker wires.



Zip tie
here



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4.5.4 Take main connection at rear on drivers side, loop twice and attach to main line.





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4.5.5 Driver side center marker light, take access wire and fold towards center of body and back. Use two zip ties and zip tie behind light bar mount.

4.5.5.1 Remaining two center marker lights, take access wire fold towards center and then back again. Use two zip ties and zip tie behind light bar mount.





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4.6 Attach doors on bulkhead.

4.6.1 Use six rivets (61200995) to rivet door to side of bulk head. Latch lock is always to the top of body.



Latch lock
to top



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- 4.6.2 Attach seal around inside of door starting seal in the bottom center of door. Make sure to get seal tight in corners.

Start seal
at bottom





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4.7 Attach Ladder.

4.7.1 Attach ladder pin with drill. Bend always goes down with tab facing the drivers side.



Attach as
shown

4.7.2 Use a 9/16" wrench and a 6mm allen wrench to attach ladder.



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4.8 Apply touch up paint where needed with sponge brush.

4.9 Test lights

4.9.1 Connect tester's plug to the main connection on the wire harness at the rear drivers side of body.



Connect to
plug in at
driver side
rear of body



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- 4.9.2 Flip switches on for back up lights and marker lights. Check to see that light are all working properly.

Flip Switches On



- 4.9.3 Keep marker lights on and flip switch on for left turn signal. When left turn is switched on, check to see that the left turn signal light gets a brighter illumination and light always remains on while running.



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- 4.9.4 Flip off left turn switch and flip on right turn switch. Check to see that right turn signal light gets brighter when right turn is on and light always remains on while running.

Flip Switches On



5 Change History

<u>Date</u>	<u>Reason</u>	<u>Revision Level</u>
2/25/16	Initial Release	DRAFT
9/8/2016	Release after draft changes made.	001
10/31/2016	Changed Names to Titles	002