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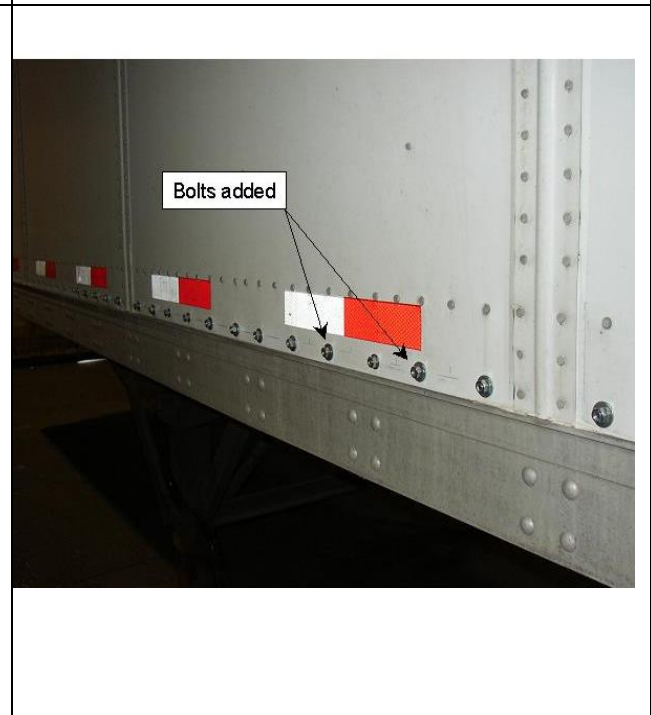
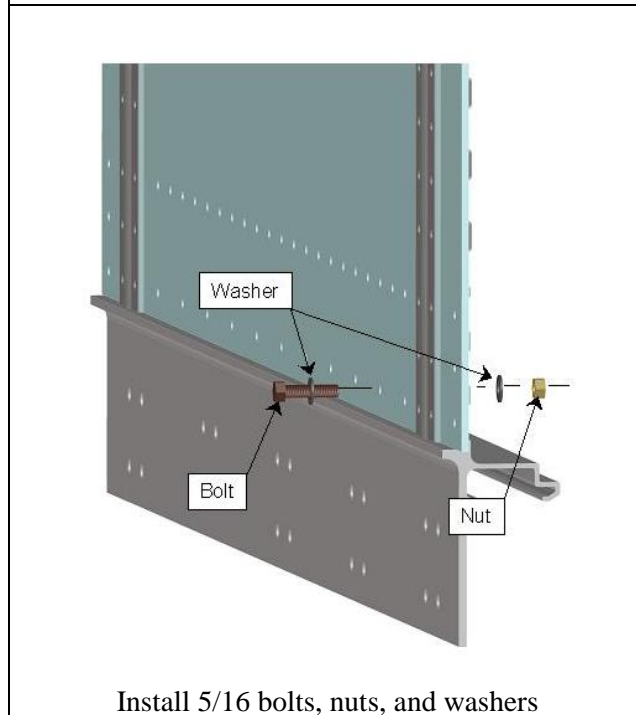
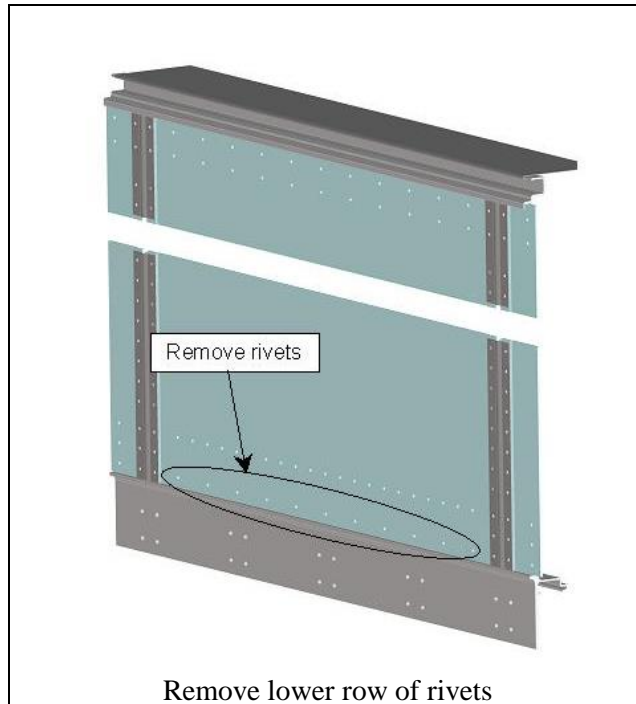
ZYPLEX Panel Rivet Replacement (Side Panels)

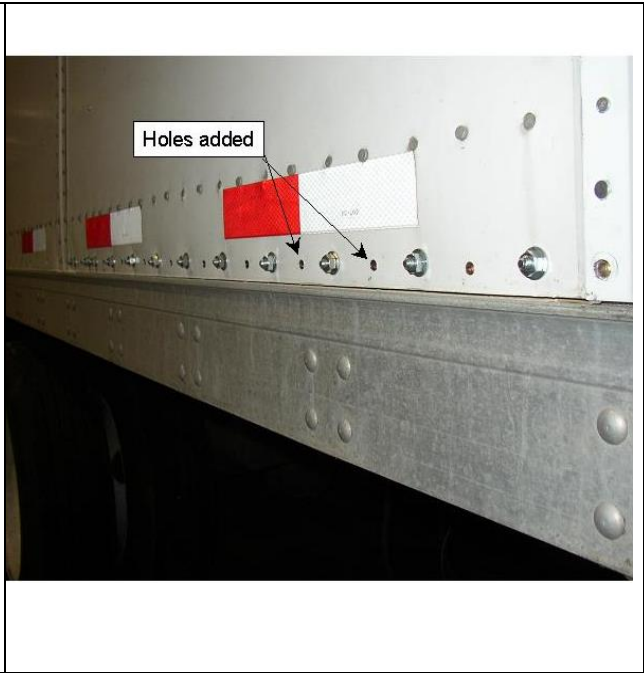
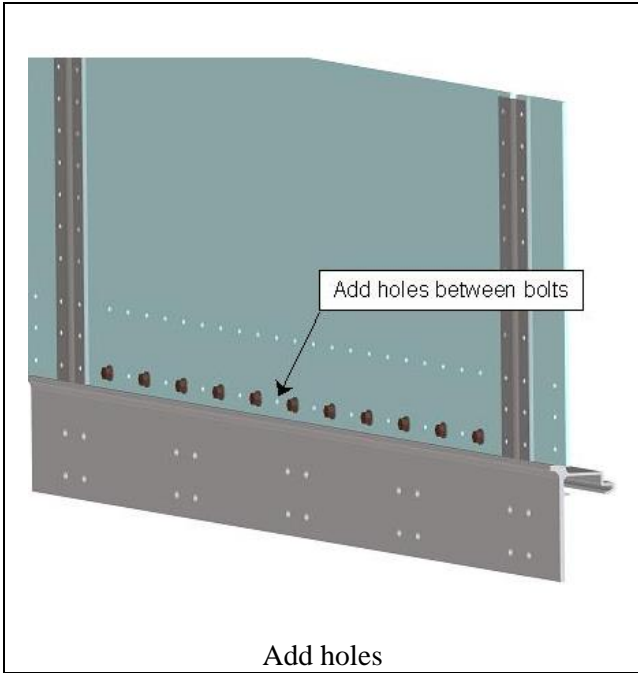
The following is a procedure for replacing the rivets connecting the Zyplex side wall panel to the lower rail. This procedure is intended for use in cases where panel(s) have experienced a degree of swelling. Before using this procedure, pre-approval is required by Stoughton Trailers, LLC or Dofasco, Inc. (the manufacturer of Zyplex panels). At a minimum, documentation including photographs or samples will be required before approval is given. Please contact Stoughton Customer Service (608-873-2565 or 608-873-2555) or Dofasco for further information.

Procedure: (Refer to the Rivet Replacement Procedure figures that follow)

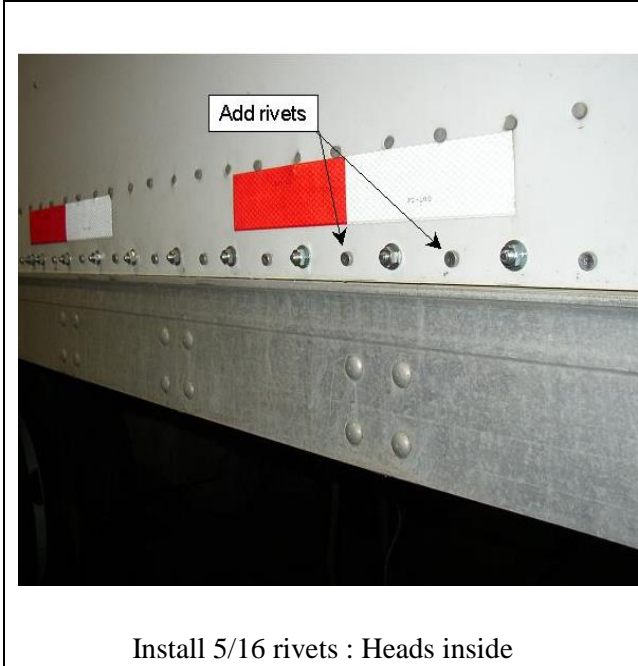
- Remove the lower row of rivets by drilling them out from the inside using a 1/4" drill bit.
- Enlarge those holes by drilling out from the outside with a 5/16" bit. Be sure to use the hole in the panel as the pilot, then drill the rail as required.
- Install 5/16 bolts, nuts, and washers and secure panel tight to lower rail.
- Add a 5/16 hole midway between each bolt at same height from panel edge.
- Install 5/16 x 7/8" long 6053-T61 aluminum rivets. Buck rivets (heads inside of trailer).
- Remove bolts and install the 5/16" rivets into those locations also.
- Repeat this procedure until that lower row of rivets is approximately 2" on-center along the lower edge of the affected panels.
- Inspect the rivets directly above those that were just installed. Some or all of those rivets in the upper row may need to be replaced in a manner similar to that described above. More specific instructions are available after review of documentation.

Rivet Replacement Procedure:

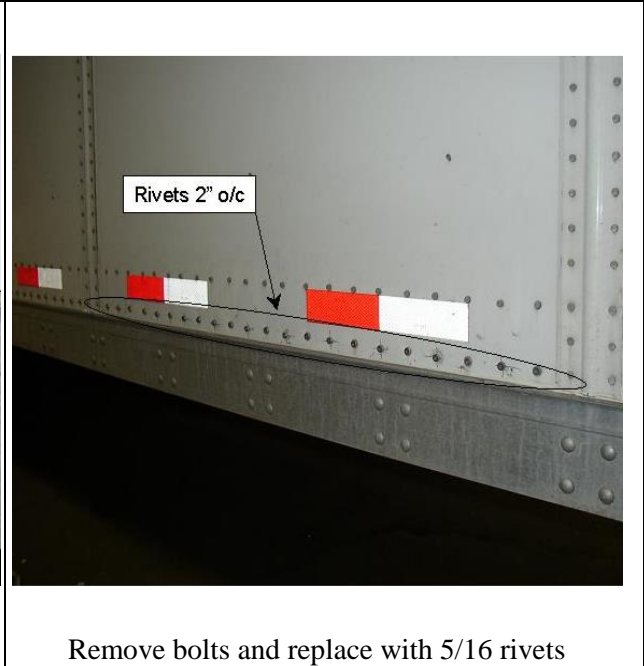




Add holes



Install 5/16 rivets : Heads inside



Remove bolts and replace with 5/16 rivets