



REPAIR DOCUMENT

Ag Hopper Top Rail Rivet Upgrade

Repair Document #: **RD-00033**

Date: August 17, 2012

Revision: None

Revision Date: N/A

Contact Information:

If you have any questions about this Repair Document please contact the Stoughton Trailers warranty/customer service department by telephone (608)-873-2555 or by email (warranty@stoughtontrailers.com).

Subject:

Stoughton Trailers LLC recommends inspecting and adding additional fasteners to the top rails of all MY2009 and most MY2010 Ag Hopper Trailers the next time they come in for repair or service. The fasteners on the top horizontal surfaces of the top rails on these Model years are spaced 12 inches apart. This upgrade calls for adding more rivets to the top rail, resulting in rivets on 4 inch centers as opposed to 12 inch. This will improve the durability of the top rail in demanding environments.

Models:

Trailers that qualify for this upgrade can be identified by the following:

1. Model: AHV
2. Model Years: 2009, 2010
 - a. VIN Model Year Date Codes of 9 or A
3. Date of Manufacture: December 2007 thru October 2009
4. Reference Appendix A for a complete list of units covered.

Code	Year	Code	Year
Y =	2000	A =	2010
1 =	2001	B =	2011
2 =	2002	C =	2012
3 =	2003	D =	2013
4 =	2004	E =	2014
5 =	2005	F =	2015
6 =	2006	G =	2016
7 =	2007	H =	2017
8 =	2008	J =	2018
9 =	2009	K =	2019

Figure 1: Model Year Date Code

MFD BY **STOUGHTON**
STOUGHTON TRAILERS, LLC
STOUGHTON, WI, USA

DATE OF MANUFACTURE **08/11** → DATE OF

GVWR **31751** KILOGRAMS **70000** POUNDS

CAWR 9072 KILOGRAMS (20000 POUNDS)
ALL AXLES WITH 11R22.5 (G) TIRES, 22.5X8.25" RIMS
AT 621 KPA (90 PSI) COLD DUAL

CERTIFICATION - THIS VEHICLE CONFORMS TO ALL APPLICABLE FEDERAL MOTOR VEHICLE SAFETY STANDARDS IN EFFECT ON THE DATE OF MANUFACTURE SHOWN ABOVE.

VIN **1DW1A422XG331405** → ORDER
UNIT
MODEL YEAR DATE
Model: AG HOPPER

OVERALL HEIGHT **10'-4"** WITH 10" WHL HT. **48"**

MODEL **AHV-12 HOPPER-A**
TYPE - TRAILER

Figure 2: Stoughton Trailers VIN plate

Upgrade Description:

Stoughton Trailers recognizes that Ag Hopper Trailers will not always be operated in optimal conditions. The ground condition, road quality, and load all vary for each user. These variations can impart added loads throughout the unit resulting in accelerated wear of some components. On MY2009 and MY2010 trailers accelerated wear and loosening has been noted on rivets connecting the top horizontal legs of the two top rail halves. A visible indicator of this is black oxidization (smoking) forming around the heads of the rivets. Over time this could lead to rivets breaking, or the top rails cracking. When one of these trailers is brought in to a Stoughton dealer the trailer should be inspected and upgraded with added fasteners.

This upgrade involves the installation of additional rivets between the existing rivets in the top rail. Currently the top rail rivets are at 12 inch centers. After the upgrade the rivets will be on 4 inch centers. This will improve the durability of the trailer, allowing it to function longer in the difficult conditions an Ag Hopper Trailer experiences.

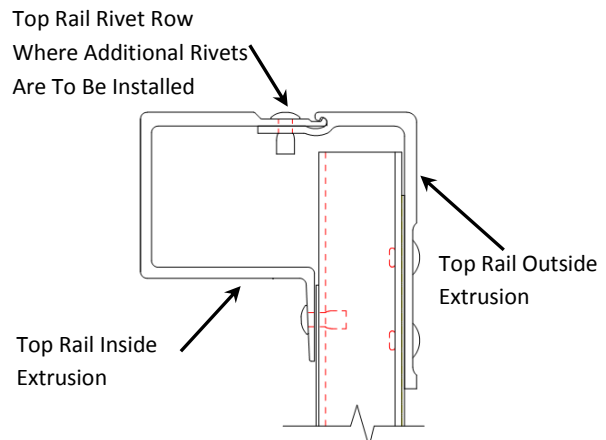


Figure 3: Top Rail Cross Section

Warning:

1. During all steps of the upgrade procedure one must use appropriate safety precautions.
 - a. Use personal safety equipment when working on any trailer (i.e. safety glasses, hearing protection, safety shoes, etc.).
 - b. The trailer must be empty before the upgrade is installed.
2. This upgrade will not change the load capacity of the Ag Hopper Trailer. Failure to comply with the unit's load capacity could lead to structural failure.

Inspection:

All MY2009 and MY2010 Ag Hopper Trailers that come in for service should be inspected.

1. Check the top rail to determine if rivets are on 12 inch centers.
 - a. Some MY2009 and MY2010 Ag Hopper Trailers have top rails with rivets on 6 inch centers from the factory or previous upgrades. These trailers require no modification.
2. Confirm there are no original structural pull rivets missing
 - a. If a rivet is missing replace with new rivet.
3. Look for "smoking" rivets.

- a. Smoking rivets (Fig 4) have black oxidation around the head indicating movement between the rivet and the aluminum extrusion. The addition of new rivets will eliminate the movement.
- b. Check if “Smoking” rivets can be moved by hand, if so they are loose. Loose rivets must be removed and replaced.

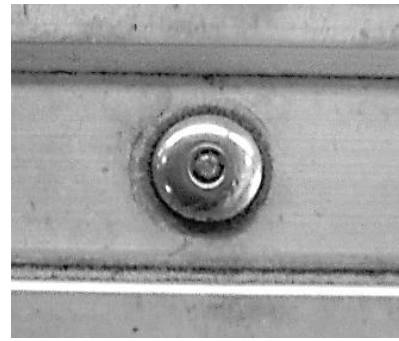


Figure 4: “Smoking” top rail rivet.

Upgrade Procedure:

All Ag Hopper Trailers found to have top rail rivets at 12 inch centers should have this upgrade.

<u>Part Number</u>	<u>Description</u>	<u>Quantity</u>
04-97072	Huck 1/4 in Mono-bolt SS	160

Tools

Drill with 17/64 in bit
Mono-bolt Rivet Gun

Procedure:

1. Clean top rail to so that debris does not affect installation of rivets.
2. Drill 17/64 holes on 4 inch centers between existing rivets (Fig. 5).
3. Install 1/4 inch mono-bolts in holes so that rivets on both top rails are now on 4 inch centers.

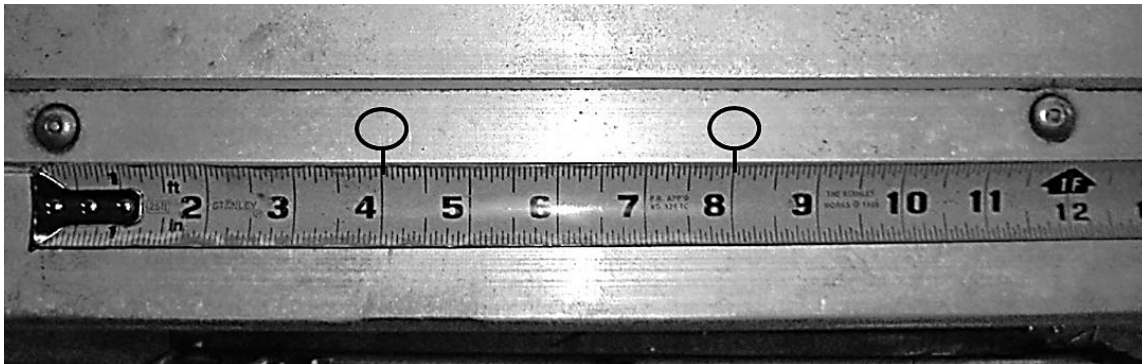


Figure 5: Placement of rivets during upgrade.

Appendix A.
Affected Units

2009 Affected Unit Vin Numbers

1DW1A40209S078901	1DW1A40279S125504	1DW1A422X9S125610	1DW1A40299S137802	1DW1A402X9S142913
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1DW1A42279S108201	1DW1A40209S125506	1DW1A42239S125612	1DW1A40229S137804	1DW1A40239S142915
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2010 Affected Unit Vin Numbers

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2010 Affected Unit Vin Numbers

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