









Instr. Title:	Repair for Titan Bonded Z-post FRP Wall		Release Date:	6/23/2015	
Originator:	Kyle Hartman	WI #:	107	Revision Level:	6/8/2015
Department Affected:	Manufacturing		WI Owner:	Corp. Engineering	
Required PPE:	PPE required for the area work being performed in.				
Required Tools/Materials:	Drill, 3/8" drill bit, square bit, T-30 bit, pry bar (wedge), heat gun, rivets, ECC fasteners, titan glue				

Job Steps	Visual Reference	
STEP 1 Verify if wall is repairable. If the Z-posts are bent and/or a hole smaller than 2' square exists then the wall is most likely repairable. If repairing a hole one should combine this instruction with WI-101 PW-HC Repair Manual.	NOTE: WI-089 can be used to repair surface damage and cracks in the gel coat. WI-053 may be used to replace a complete wall.	
STEP 2 Remove all items connected to the z-post in need of repair (e-track, wood slats, kick plates. Ect...) Drill out rivets as shown (using a 3/8" drill bit)		
STEP 3 Using the square bit drive remove the temporary screws in the Z-posts.		
STEP 4 Using the T30 bit remove the upper and the lower wall fasteners.		



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STEP 5
Using the heat gun. Begin heating the glue that is bonding the Z-post to wall. While heating the the glue wedge a pry bar or wedge between z-post and wall.



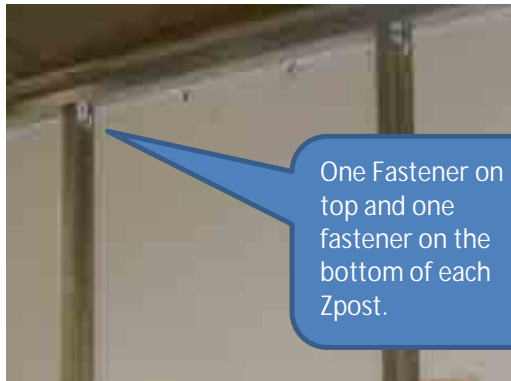
STEP 6
Continue heating the glue along the z-post. Begin to pry up the z-post using a wedge or pry bar. The glue will begin to separate from the wall.



STEP 7
After z-post is removed use the heat gun and a scraper to remove all glue residue from the wall surface.



STEP 8
Install NEW Zposts with one ECC fastener at the top and one at the bottom.



One Fastener on top and one fastener on the bottom of each Zpost.



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STEP 9
Mark locations of E-track 6" above and below the E-track. NOTE: The Titan glue MUST be applied between the Zpost and FRP under each E-track and a minimum of 6" above and below the E-track.

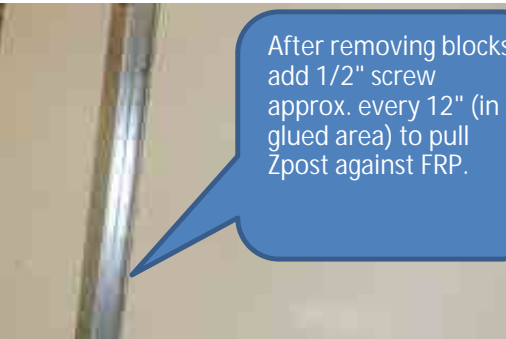
Step 10
Stick a block behind each Z-Post to hold it away from the FRP. Wipe surface with Acetone. Dispense small amount of Titan material to verify it is a mediam grey.



Step 11
Dispense a 1/4" bead of Titan adhesive under the Z-post according to the locations described in step 9 above.



Remove the wood blocks and allow the Zpost to rest against the FRP. Add a 1/2" screw every 12" (in the glued area) to pull the Zpost against the FRP.



Remove any extra Titan glue before it sets with a putty knife. Install E-track and scuff using the normal process. Apply Titan glue at a minimum of 50F degrees for at least 3 hours. Wait 3 days before normal use.