



REPAIR DOCUMENT

Ag Hopper Trailer – Tub crack at rear crossmember connection repair

Repair Document #: RD-00094

Date: March 9, 2020

Revision:

Revision Date: N/A

Contact Information:

If you have any questions about this Repair Document, please contact the Stoughton Trailers Customer Service Department by telephone (608)-873-2555 or by email (warranty@stoughtontrailers.com).

Subject:

Repair procedure for Ag Hopper trailers tub crack at rear crossmember connection. This repair for Ag Hopper trailers will connect cracked tub to rear crossmember and rear slope.

Models:

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

1. Model: AHV
2. Model Years: All

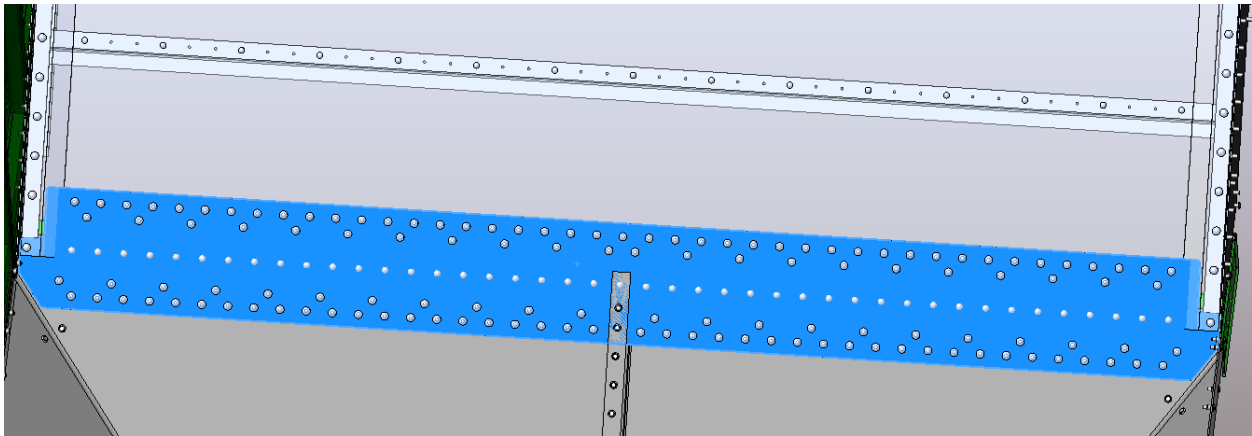
Issue:

The repair connects cracked tub to rear crossmember and rear slope (see image).



Remedy:

Add reinforcement plate RD-001969 (highlighted blue) to create new connection between hopper tub, rear crossmember and rear slope. Refer to repair RD-... if rear crossmember needs to be replaced. See below.

**Warning:**

During all steps of the repair and upgrade procedures one must use appropriate safety precautions.

- Use personal safety equipment when working on any trailer (i.e. safety glasses, hearing protection, safety shoes, etc.).
- Check to insure landing gear is in proper working order and providing proper support prior to upgrade.
- The trailer must be empty before any repairs or upgrades are made.

Parts Required:

<u>Part Number</u>	<u>Description</u>	<u>Quantity</u>
RD-001969	PLATE, HOPPER TUB REPAIR	1
04-97100-000-00	PIN, HUCKBOLT, 1/4D.250-.375GP	2
04-97116-000-00	COLLAR, HUCKBOLT, 1/4D, STEEL	2
04-98003-812-00	RVT, BR HD,1/4X13/16, 2117-T4 AL	90
04-98003-625-00	RVT, BR HD,1/4X5/8, 2117-T4 AL	140
04-85849-001-00	Grey Caulk	2 (tubes)

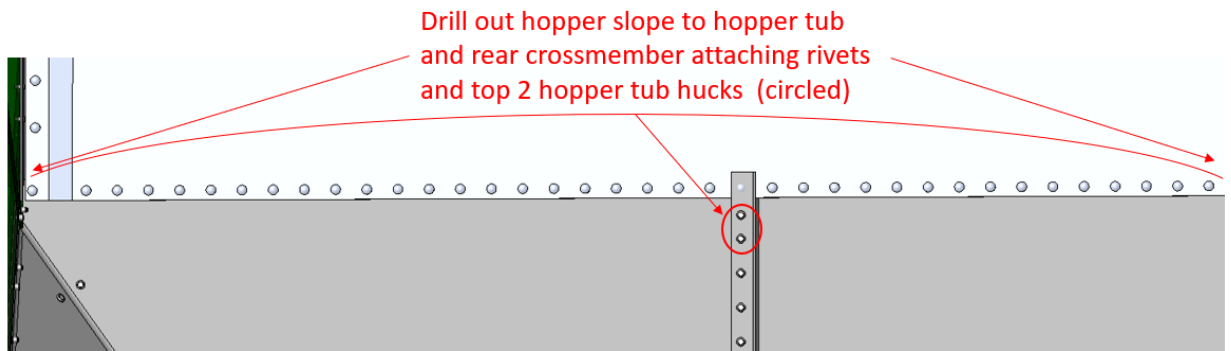
Tools

- Drill
- Rivet Gun

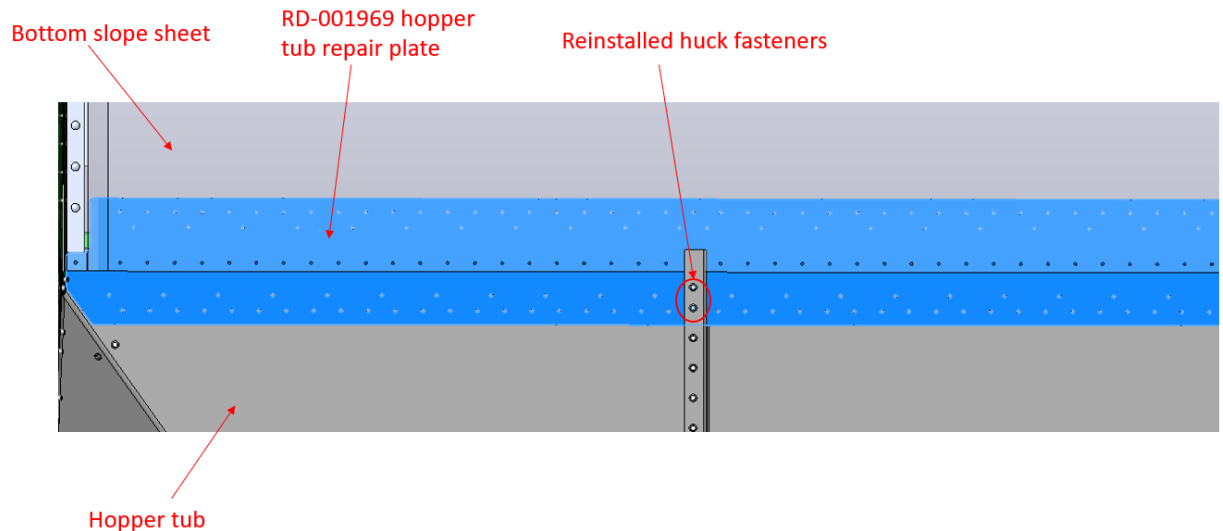
- Huck Gun
- Caulk Gun

Procedure:

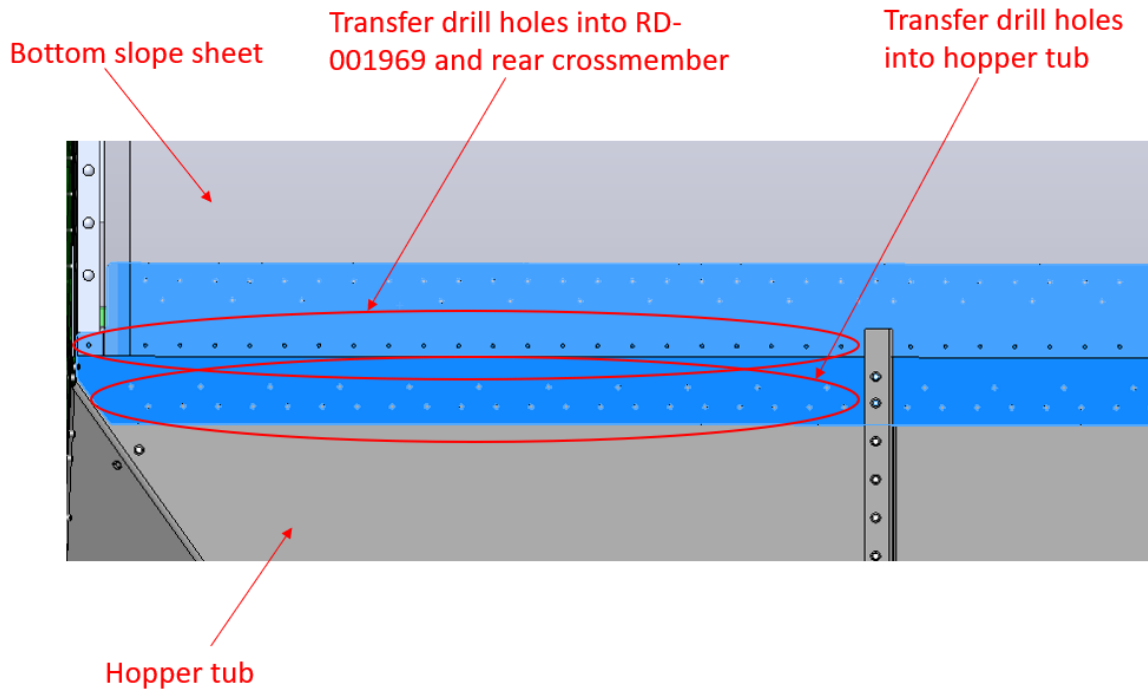
1. Drill out (45) hopper slope to hopper tub and rear crossmember attaching rivets and top (2) hopper tub hucks (circled) (see below). Smooth out sharp edges of cracked tub to prevent cuts.



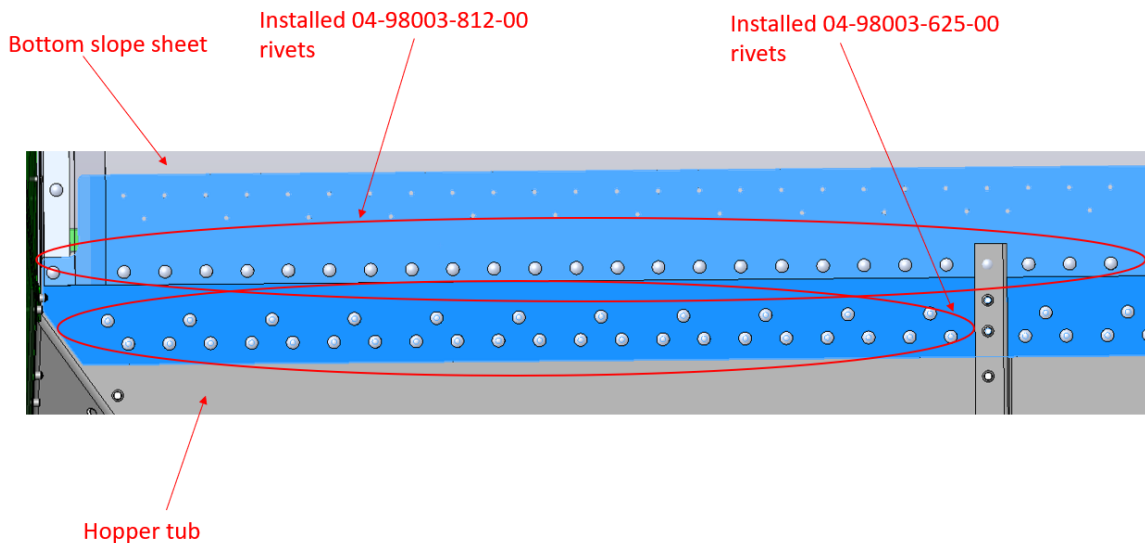
2. Install RD-001969 hopper tub repair plate under bottom slope sheet and over hopper tub sheets and fasten with (2) supplied 04-97100-000-00 hucks and 04-97116-000-00 collars in the same hopper tub center seam location as circled hucks removed in step one (see below) (bottom slope sheet is transparent for clarity on all views below).



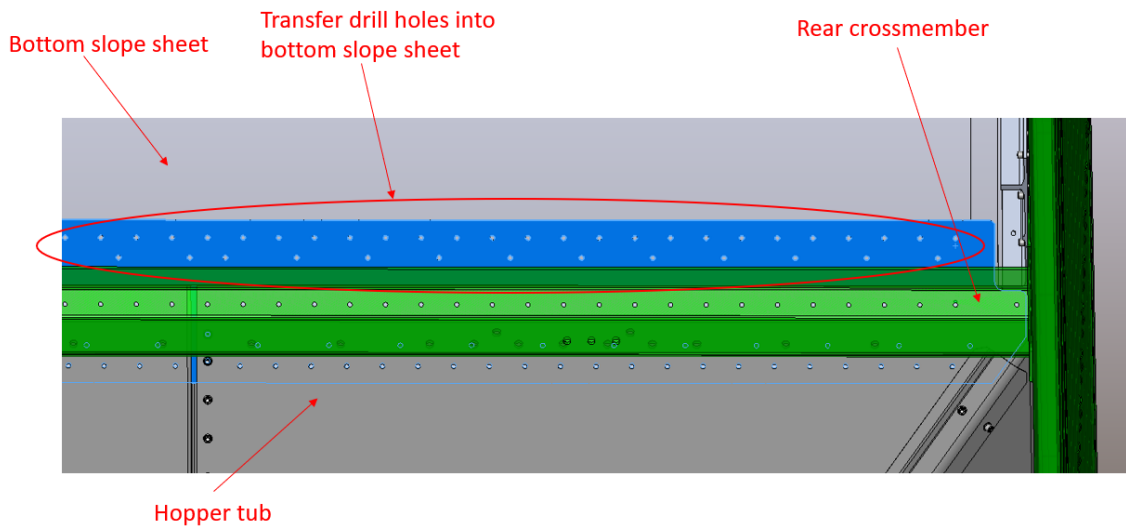
3. From the inside of the trailer, using holes in RD-001969 hopper tub repair plate- transfer drill holes into hopper tub, and using holes in bottom slope sheet- transfer drill holes into RD-001969 and rear crossmember (see below).



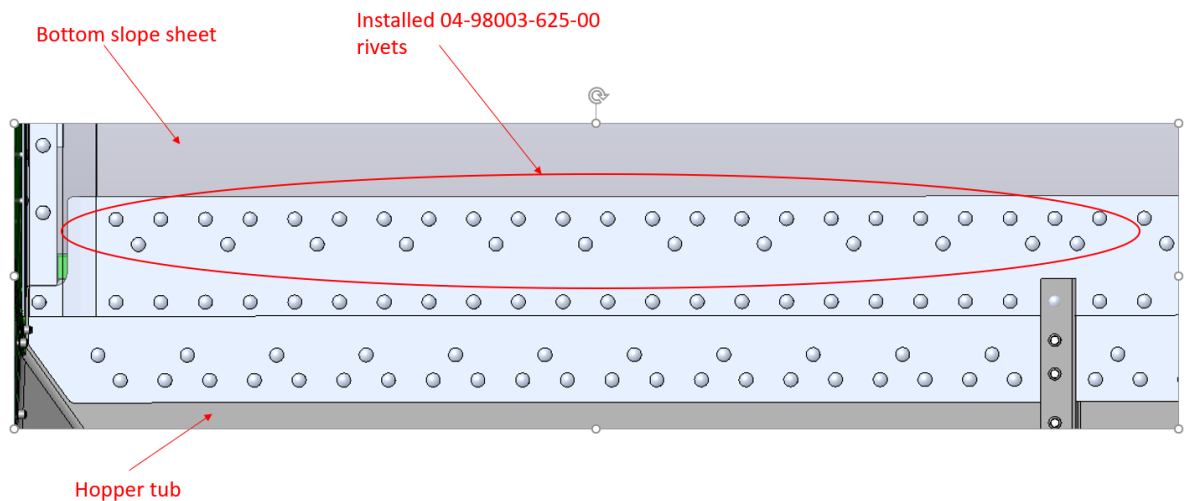
4. Install supplied rivets 04-98003-625-00 at RD-001969 to hopper tub connection. Install supplied rivets 04-98003-812-00 at bottom slope sheet to RD-001969 and rear crossmember connection (see below).



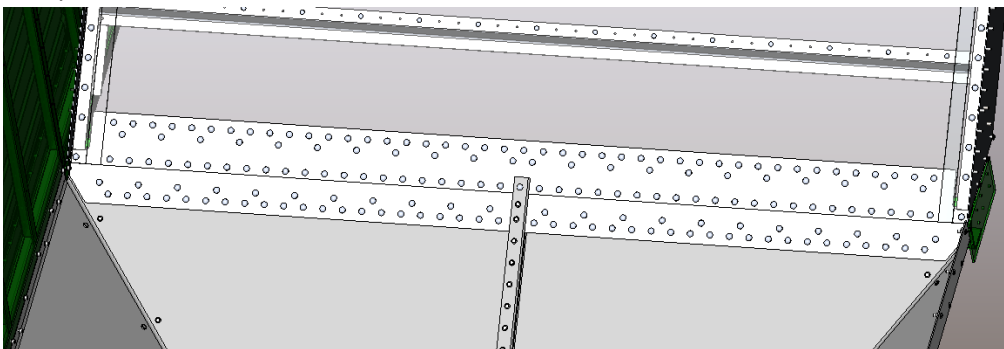
5. From the outside of the trailer, using holes in RD-001969 hopper tub repair plate- transfer drill holes into bottom slope sheet (see below).



6. Install supplied rivets 04-98003-625-00 at RD-001969 to bottom slope sheet connection. (see below, view from the inside of the trailer).



7. Complete installation.



8. From the outside of the trailer- caulk around top and side edges of RD-001969 and top edge of hopper tub (use caution: this edge will be sharp from previous crack).