# WORK INSTRUCTIONS
# MODEL G FIFTH WHEEL
# SIDEWALL REPLACEMENT

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|---|---|---|---|
| **WI:** | WI-014-2025 Model G and Z3610 Sidewall Repair Instructions | | |
| **PRODUCT:** | Model G Fifth Wheel | **REVISION:** | REV-C |
| **DATE:** | 7/21/2025 | **LABOR RATE:** | **Per Contract** |

**Applies to:**

This document refers to Brinkley Model G Fifth Wheel Trailers.

**Condition:**

Brinkley RV has determined that under certain conditions, minor cracks may form in the sidewalls, typically originating at the lower corners of a slideout opening.

**Correction:**

Brinkley RV has established a procedure to replace the sidewall, while providing additional support to minimize the possibility of future cracks.

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**⚠ WARNING**

**WARNING!** Because of the nature of this repair, use of ladders and other climbing and power equipment is required. Follow all ladder safety instructions posted on ladders and all equipment. It is required that professional technicians perform the repair, and a team of at least 4 - 5 people be used for certain parts of this procedure. Failure to do so could result in injury or death.

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**⚠ WARNING**

**WARNING!** Turn off all electrical power to the RV PRIOR to beginning repairs. Be certain the RV is unplugged from shore power and the batteries are disconnected PRIOR to beginning welding. Failure to do so could result in property damage and injury or death.

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**In addition to standard shop tools, the following specialized tools are required:**

1. Tape measure
2. Chalk line
3. Screw gun
4. 90 Degree drill adapter
5. #2 Square drive bit (various lengths)
6. Wire cutters
7. Circular saw (w/sharp blade)
8. Jig saw (w/sharp blade)


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2


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4


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6


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8


9

9. Hand grinder
10. Hand-held pneumatic reciprocating saw
11. 1/4” Drill bit
12. Flat bar
13. Pry bars
14. Razor knife
15. Pneumatic caulk gun
16. 3/8” spade bit
17. Oscillating multi-tool


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11


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13


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15


16


17

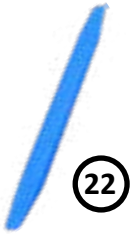

18

18. Weld blanket
19. 7/8” Hole saw
20. Ratchet strap
21. Foam gun
22. Polystick
23. Trowel


19


20


21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**PARTS INFORMATION**

**NOTICE: To perform the following sidewall replacement, parts are pre-shipped to your dealership.** There are no kits specific to these repairs; instead, Brinkley has sent sufficient parts to repair a given number of units, regardless of model or floor plan.

The parts shipment will include the primary and secondary components for this repair including, but not limited to, sidewall skin, trim, baggage doors, graphics, fascia, etc. Other items will need to be supplied by your Service Shop, including, but not limited to, cleaners, clean rags, floor coverings, plywood (3/4"X 4' X 8'), lumber (2"X 4", 2"X 6", various lengths), eight (8) 1/4"X2"X2" angle, in 12' lengths (Figure 112, page 48) and miscellaneous shop supplies. Where applicable/possible, this document will call out the appropriate parts for each given step.

Your service team may also have procedures and equipment in place for some of the steps outlined in this document (removing a slide-out or front cap for example). Procedures and equipment outlined in this document are examples, and may deviate somewhat from your established processes and equipment.

Please review the parts received with the packing information to be sure you received everything on the list, in the appropriate quantities. **If there are discrepancies or shortages, please contact your Brinkley Parts Representative BEFORE commencing repairs.**

**WARRANTY INFORMATION**

**ADVANCED CONTACT OR PRIOR AUTHORIZATION REQUIRED**
**CLAIM REIMBURSEMENT PROCESSING:**

All reimbursement requests with completed work orders, including any freight expenses and photographs, should be submitted via a claim in the Brinkley RV Dealer Portal.

**REQUIRED INFORMATION FOR IMMEDIATE REIMBURSEMENT PROCESSING INCLUDES:**

1. The full 17 digit VIN;
2. The Retail Name if retail sold;
3. Dealer Name;
4. Dealer Address;
5. Dealer Phone Number;
6. Dealer Hourly Labor Rate;
7. Work Order detailing the work performed and labor time, and
8. Photographs of the repair; specifically:
   - Existing wall cracks **BEFORE** starting work
   - Aluminum wall sub-structure **BEFORE** repairs
   - Aluminum wall substructure **AFTER** repairs

**Reimbursement checks for claims submitted with all requested information are issued weekly.**

**SAFETY**

This document provides general instructions. Many variables can change the circumstances of any procedure, i.e., the degree of difficulty involved in the service operation and the ability level of the individual performing the operation. This document cannot begin to plot out procedures for every possibility, but will provide the general instructions for effectively installing, removing or servicing the system. In the event the skill level required is too advanced or the procedure too difficult, a certified technician should be consulted before performing the necessary operation. Failure to correctly install, remove or service the system may result in voiding the warranty, inflicting injury or even causing death.

**⚠ DANGER**

This indicates an imminent hazard that, if not avoided or handled correctly, will result in death or serious injury.

**⚠ WARNING**

The "WARNING" symbol above is a sign that a procedure has a safety risk involved and may cause death, serious personal injury, severe product and/or property damage if not performed safely and within the parameters set forth in this document.

**⚠ CAUTION**

The "CAUTION" symbol above is a sign that a procedure has a safety risk involved and may cause personal injury, product and/or property damage if not performed safely and within the parameters set forth in this document.

**+ NOTICE**

This is used to address best practices that should be utilized and do not commonly result in injury but may lead to property damage if not careful.

## BEDROOM SLIDE-OUT REMOVAL

**⚠ WARNING**

**WARNING!** Turn off all electrical power to the RV PRIOR to beginning repairs. Be certain the RV is unplugged from shore power and the batteries are disconnected PRIOR to beginning welding. Failure to do so could result in property damage and injury or death.

### WORK INSTRUCTIONS:

1. **READ AND UNDERSTAND ALL INSTRUCTIONS PRIOR TO BEGINNING WORK.**
2. Remove all bedding and personal items from the bedroom slide-out area (Figure 1).
3. Remove the mattress from the bed platform and store elsewhere in the RV.(Figure 2).


Figure 1


Figure 2

4. Raise the bed platform to access the support struts below (Figure 3).
5. Disconnect the support struts from their brackets on the platform (Figure 4). Leave the struts attached to the to bed base.


Figure 3


Figure 4

6. Using a screw gun and a #2 square drive bit, remove the screws holding the bed platform to the hinge, and all of the screws holding the underlayment in place in the slide-out (Figure 5).
7. Remove bed platform and underlayment, and set aside (Figure 6a and 6b).


Figure 5


Figure 6a

8. Remove the drawers from the bed base and set aside (Figure 7).
9. Tape the bed struts in place and drawer openings to hold the drawer guides in place (Figure 8).


Figure 6b


Figure 7


Figure 8

10. Access wiring in slide-out; label or photograph for re-installation, and carefully disconnect wiring (Figures 9a, 9b, 9C, and 9D). Retain Wago and Molex connectors for later installation reconnection.

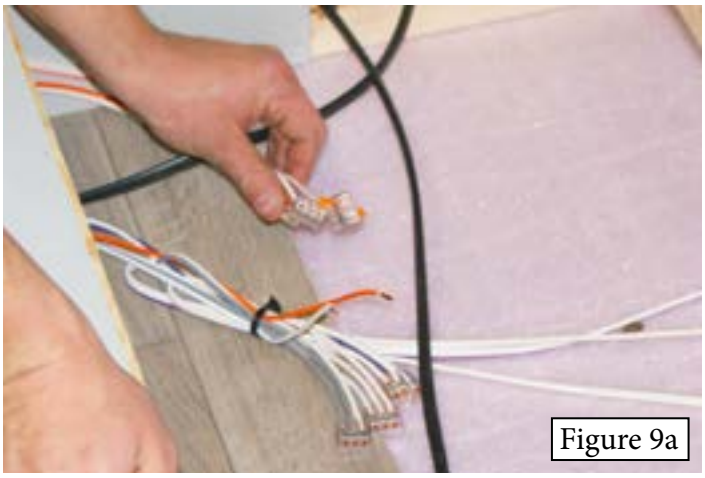
Figure 9a


Figure 9b


Figure 9c


Figure 9d

11. Using a screw gun and a #2 square drive bit, remove the end panels where the vent and recepts were located (Figure 10).

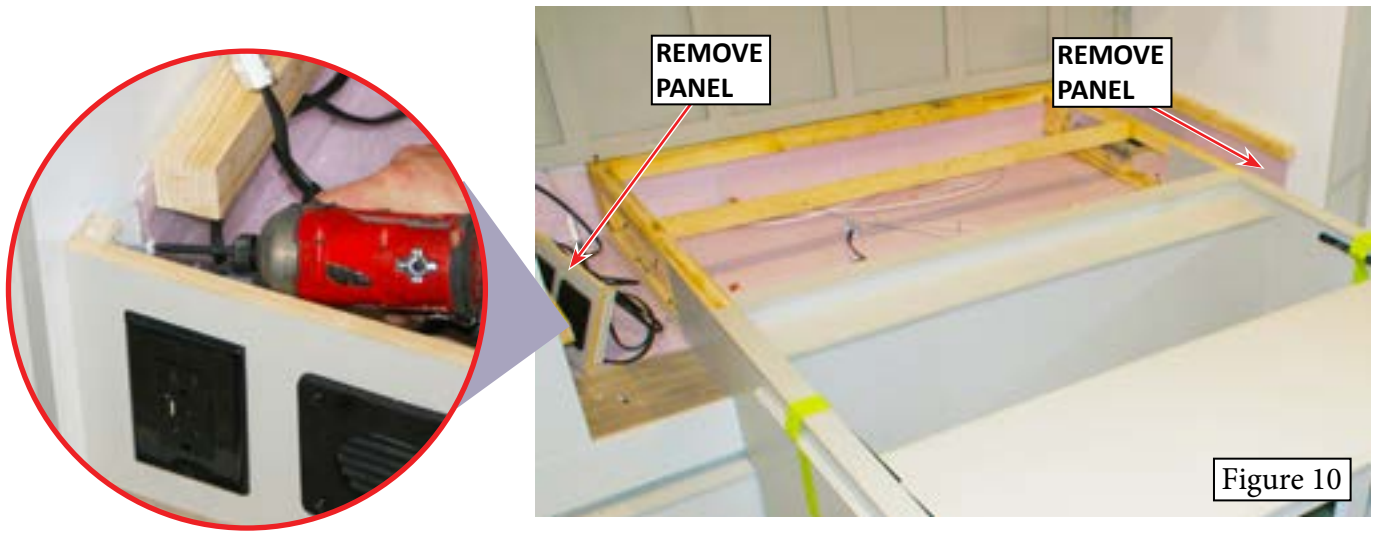

Figure 10

12. Cover the bedroom floor at the end of the bed base with carpet or cardboard to protect the linoleum during the next steps. (Figure 11) .

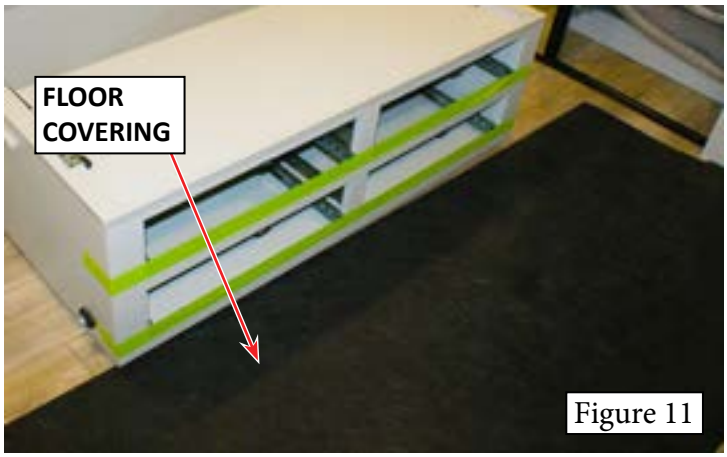

Figure 11

13. Remove all of the fasteners holding the bed frame to the slide-out (Figures 12a, 12b, and 12c).


Figure 12a


Figure 12b


Figure 12c

14. Once all fasteners are loose or removed, rotate the bed frame slowly out of the slide-out and stand it on end in the bedroom (Figures 13a, 13b, 13c and 13d) on the floor covering previously installed. Use caution not to hit the ceiling or air conditioner during this process.


Figure 13a

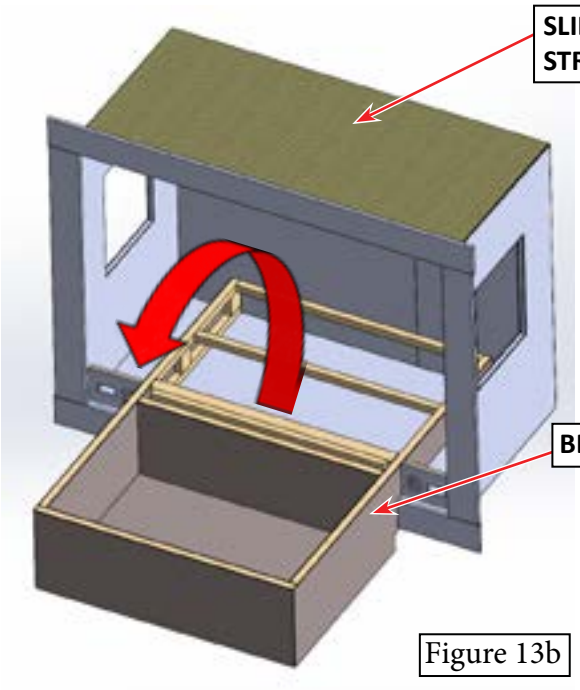


Figure 13b

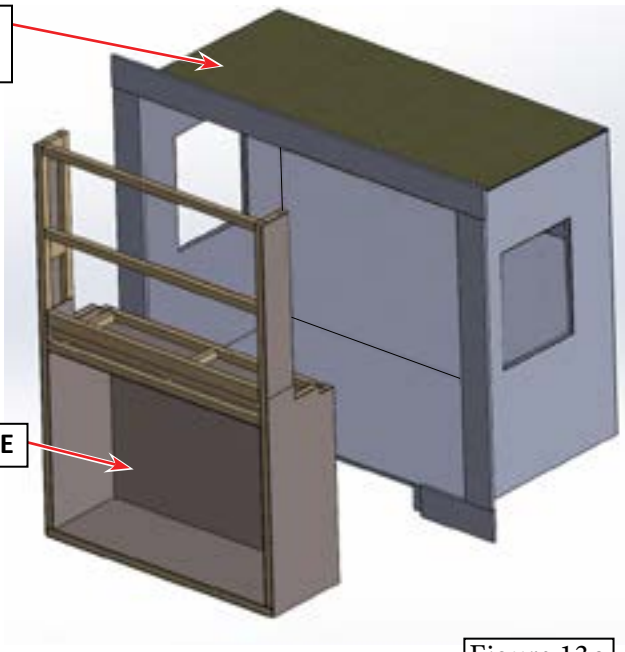

Figure 13c

Figure 13d

15. Retract the bedroom slide to a position where it is approximately halfway in (Figure 14) to access the back side of the fascias.
16. Using a screw gun and #2 square drive bit, locate and remove the screws located on the back side of the fascia panels (Figure 15).

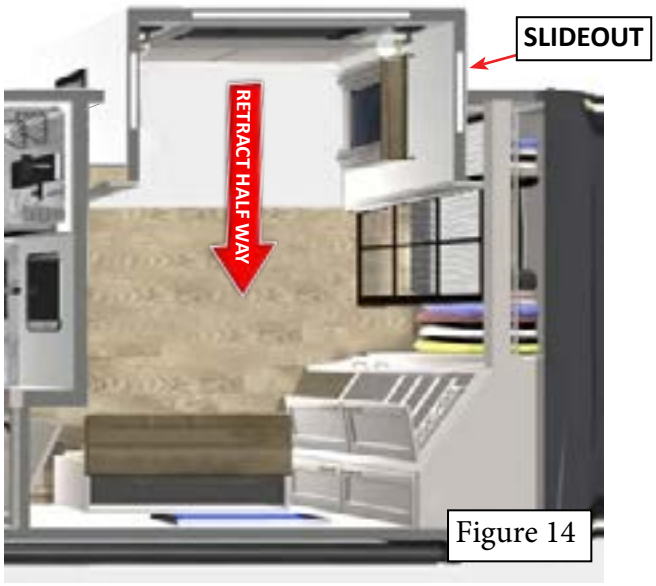

Figure 14

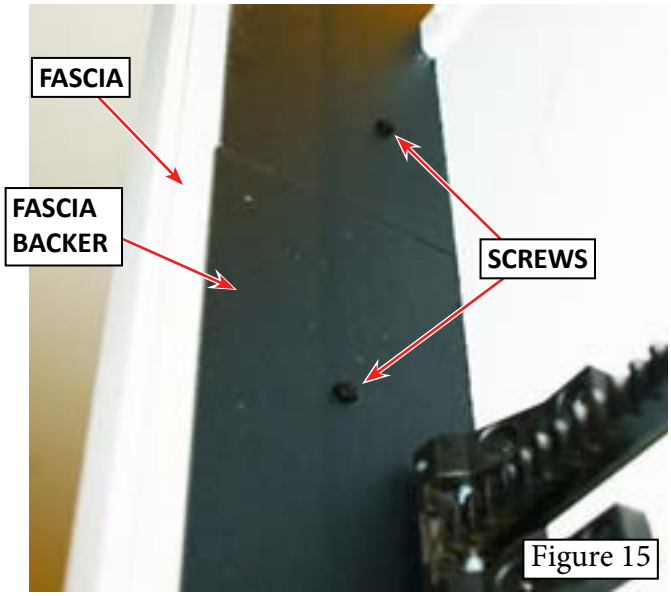

Figure 15

17. Pull the side fascias off by pulling out from the bottom of the fascia first (Figure 16), then pulling down to disengage the biscuit joint where the side fascia meets the top fascia (Figure 17). Note that there are spot applications of CHEM-X adhesive on the backs of the fascia boards, so it may require a prying tool to remove them from the backers. **Where possible, retain original fascia boards for later reuse.**


Figure 16

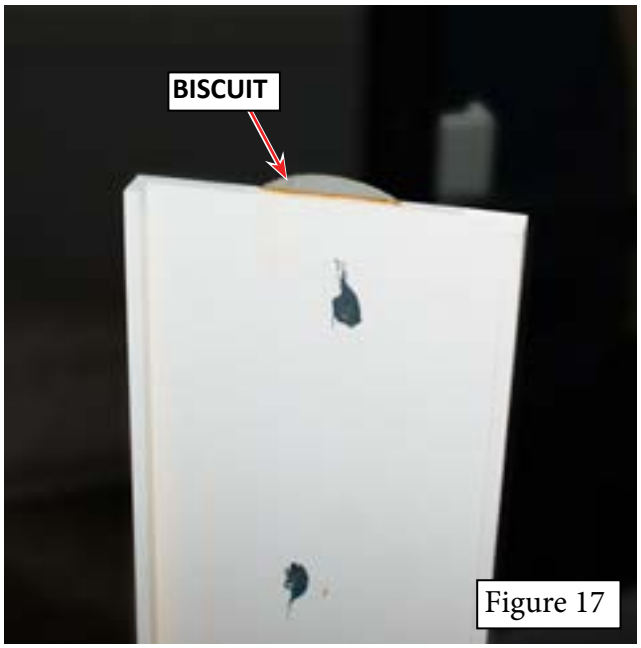

Figure 17

18. The top fascia has a channel on the backside of it that hooks over the top of the backplate. Pull out from the bottom first and then push up to pop the fascia off the backplate (Figure 18).

Figure 18

19. Using a screw gun and a #2 square drive bit, remove the fasteners holding the backer plates on the slide-out (Figures 19a and 19b). Remove the 5 individual backer plates used. The bottom corner pieces have longer screws than the rest of the plates. Retain plates and fasteners for later use.
20. Remove the T-Bracket from the exterior slide-out fascia (Figures 19c and 19d).

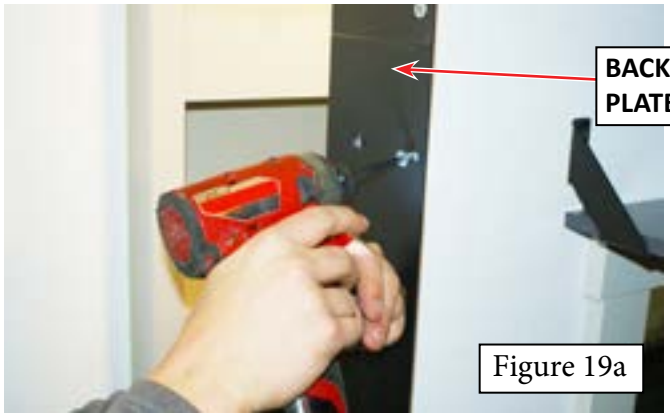

Figure 19a

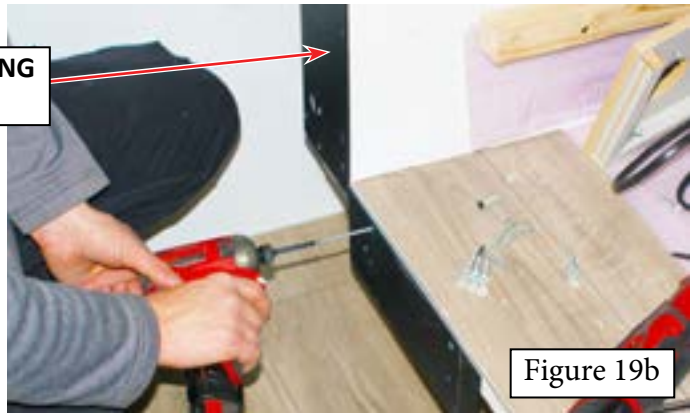
Figure 19b

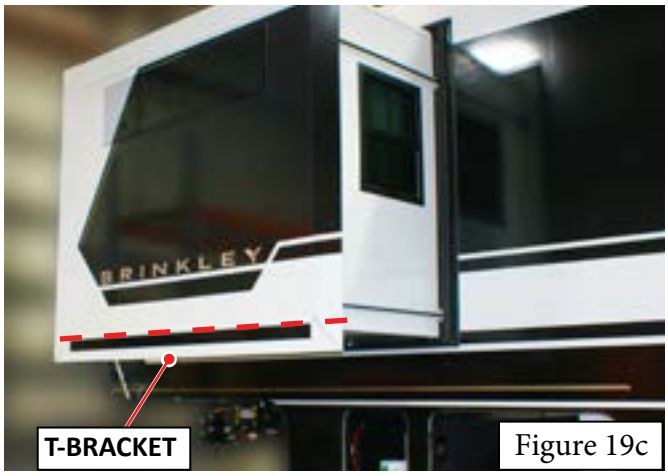

Figure 19c

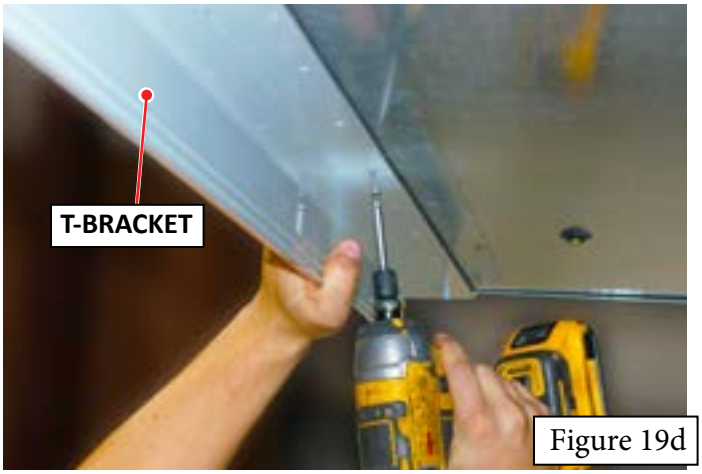

Figure 19d

## ⚠ DANGER

**DANGER!** Removing the slide-out room must be performed in the following steps to make sure it is removed safely. Read this entire section carefully and familiarize yourself with the procedure before attempting to remove the slide-out room. If additional information is required, refer to the Lippert Slim-Rack manual (included with but separate from these instructions - QR code on the right). **Failure to follow these directions will result in death or serious injury.**

21. Extend the room until it is a couple of inches short of full extension (to allow full access to the slide-out mechanism columns). **DO NOT EXTEND FULLY!**
22. Using a screw gun and a #2 square drive bit, remove all of the column screws (Figure 21a, 21b, 21c, and 21d). including the four (4) screws hidden behind the bulb seal on each side of the slide-out (Figure 21e and 21f, next page).

Figure 21a

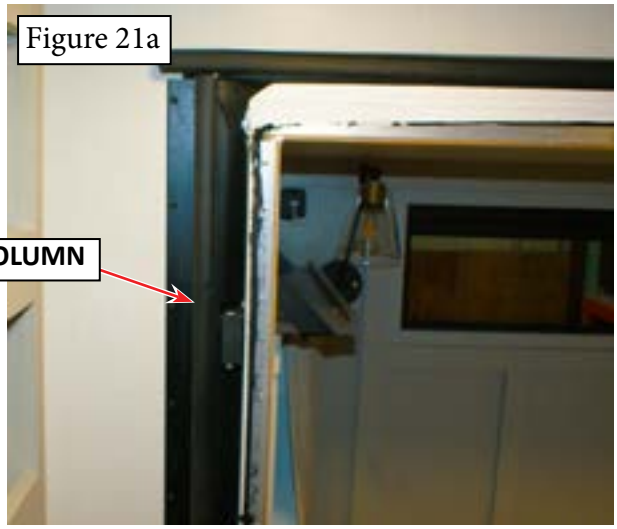


Figure 21b

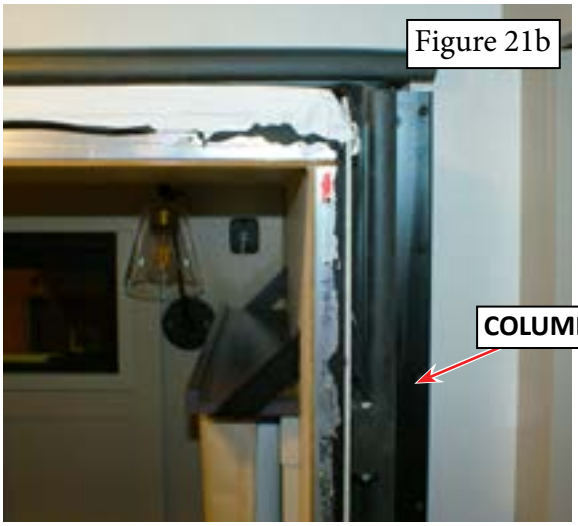


Figure 21c

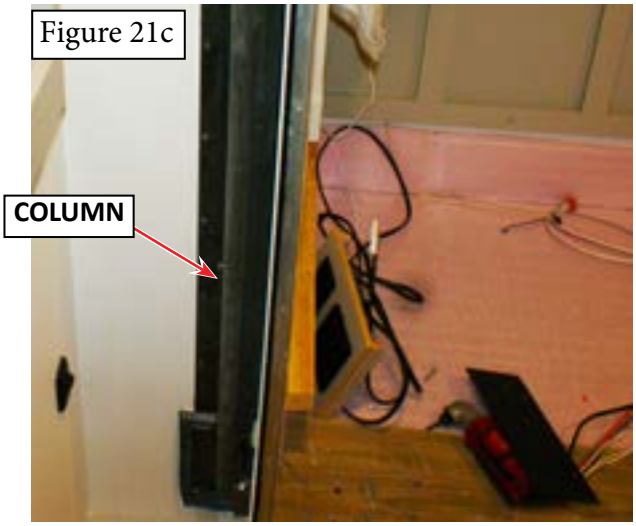


Figure 21d

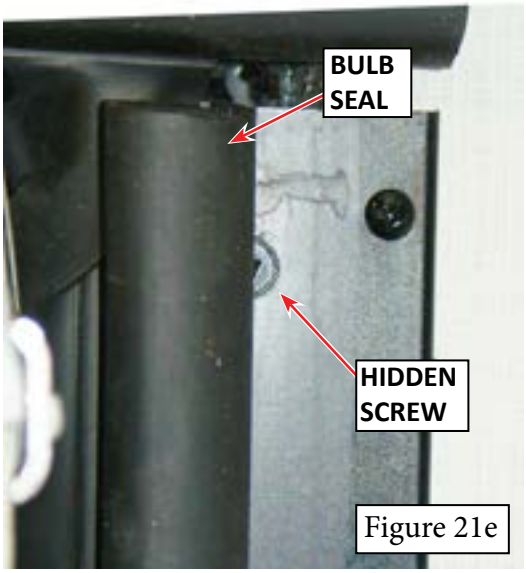

Figure 21e

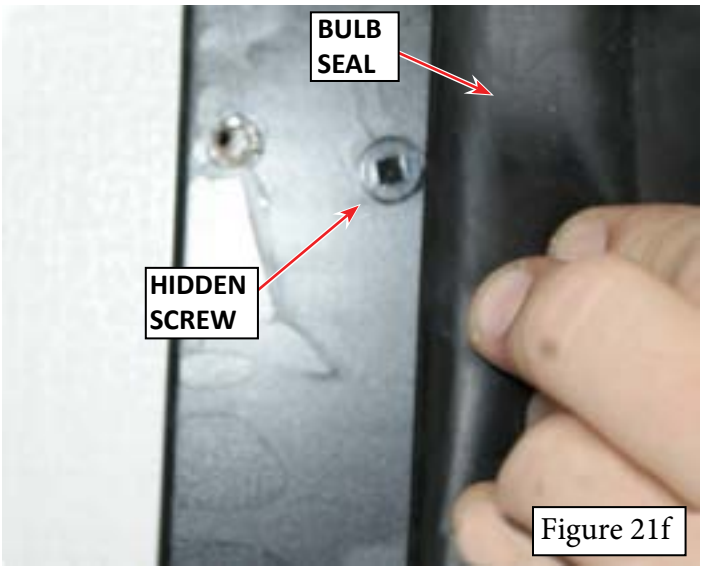

Figure 21f

23. Pull the interior portion of the column and wipe seal away from the wall. Disconnect the motor wire connector (Figure 22a) and feed the motor end of the connector through the hole in the wipe seal (Figure 22b).
24. Use a screw gun and a #2 square drive bit to remove wire clamp from slide floor (Figure 23). Repeat steps 23 and 24 on both sides.

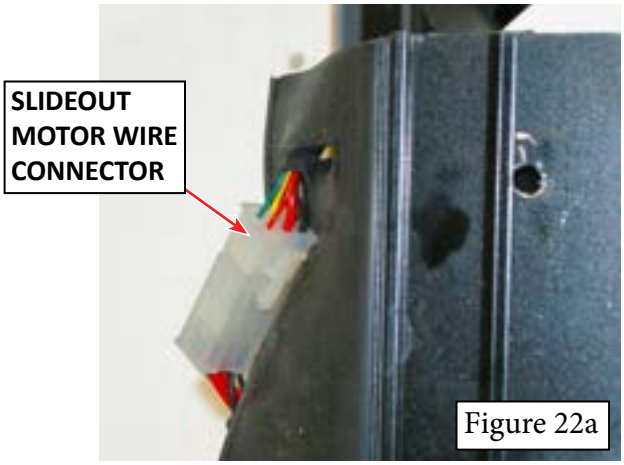

Figure 22a

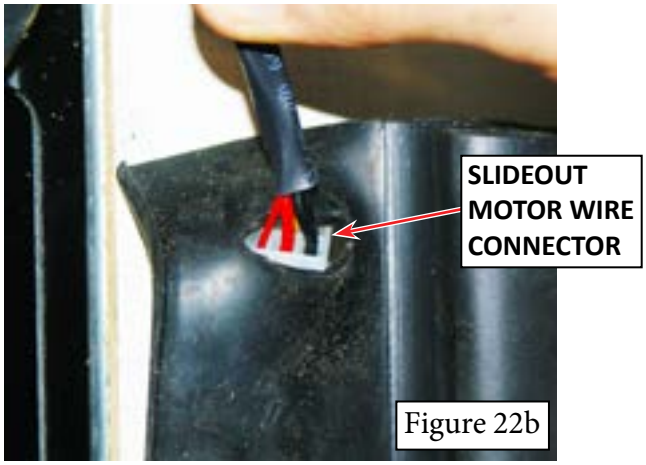

Figure 22b

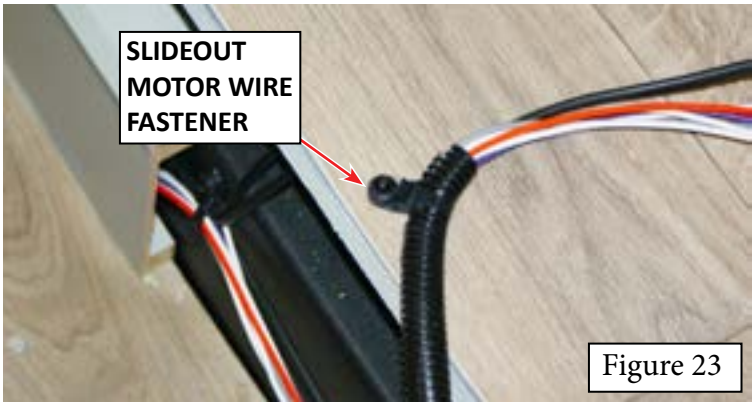

Figure 23

**⚠ WARNING**

**WARNING:** The next steps involve removing and moving the bedroom slide-out from the RV. Extreme caution should be observed during this process to make sure the slide-out is properly braced and supported to prevent it from falling. Failure to do so may cause death, serious personal injury, severe product and/or property damage if not performed safely and within the parameters set forth in this document. Approximate weight of the slide-out room is 400 lbs.

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25. Place lifting and support equipment under the slide-out room (Figure 24). Examples shown in photos use a forklift with a (approximately) 70" X 30" X 6" platform built from 2"X6" boards to support and move the room from below (Figure 25). When the platform is in place below the slide-out room, extend the room fully.


Figure 24

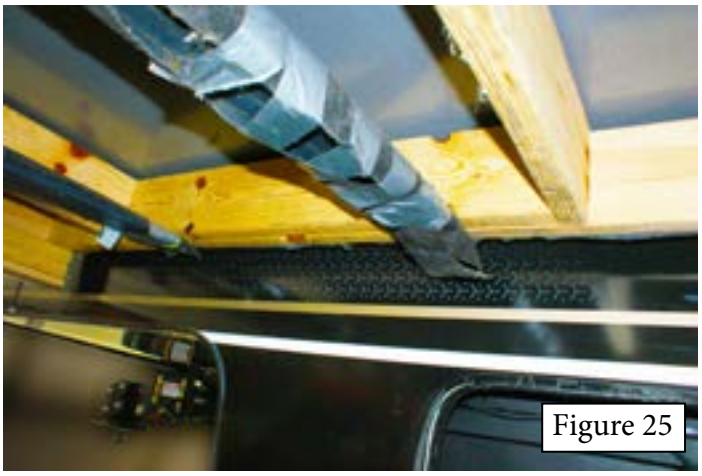
Figure 25

26. Use the lifting device to lift the room gently in the opening to take the weight off side-out drive mechanism in preparation for removal. Be certain the slide-out box is secure and will not shift or move unexpectedly. NOTE the slide-out in the unit is now being held in place by the exterior seals and vertical columns (not shown).
27. Once the room is safely and properly secured, use a razor knife to cut the TOP wipe seal at both ends to separate it from the side wipe seals (Figure 26a and 26b).

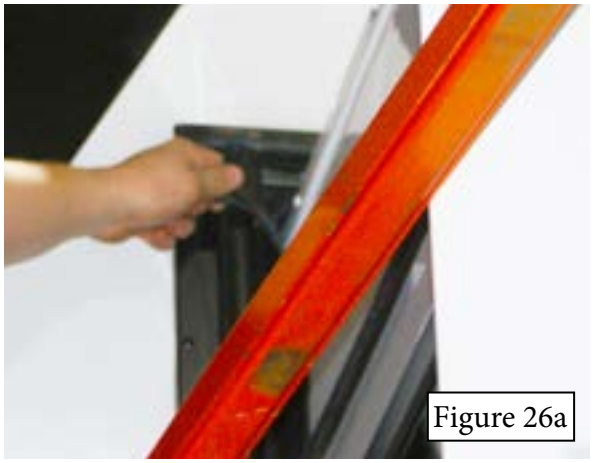
Figure 26a


Figure 26b

28. Using a screw gun with a #2 square drive bit, remove screws from the outside of the slide mechanism column (Figure 27).
29. Use a razor knife to cut the sealant away between the vertical columns and the sidewall (Figure 28), while using a prying tool to pry the vertical columns away from the sidewalls (Figure 29a and 29b).


Figure 27


Figure 28


Figure 29a


Figure 29b

30. Prepare two wooden supports from 2”x 6” boards, approximately 4’ x 6” x 6” on the floor to rest the slide-out box on, and cover top surfaces with styrofoam (or other soft material) to prevent damage to the exterior face of the slide-out (Figure 30).
31. Remove the slide-out from the RV and place it on the floor, then rotate the slide-out room face down onto the supports (Figure 31).

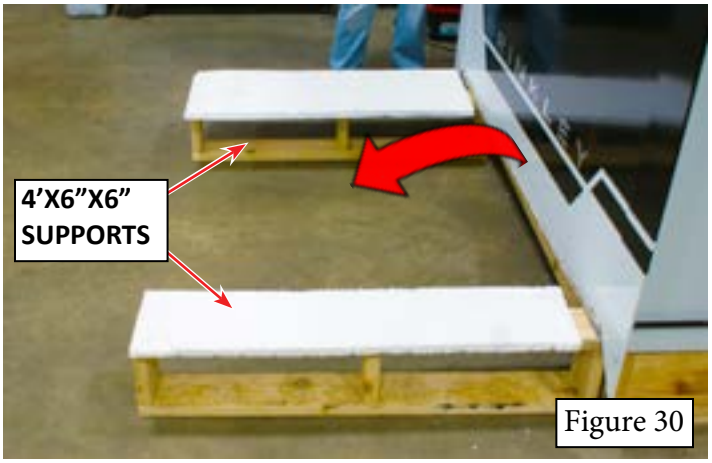

Figure 30


Figure 31

32. Remove the slide-out columns from the sides of the slide-out room (Figure 32) by sliding them out of their mounting brackets. NOTE that there is a small plastic rivet that will break while trying to remove the columns; this can be replaced during re-installation with another plastic rivet or a screw (not provided).

**+ IMPORTANT**

If the unit being worked on is **VIN 001091** or higher, skip now to **“FRONT CAP REMOVAL”** on page 26.

33. Using a screw gun and a #2 square drive bit, remove the fasteners holding the L-shaped bottom slide corners from the slide-out box (Figure 33).

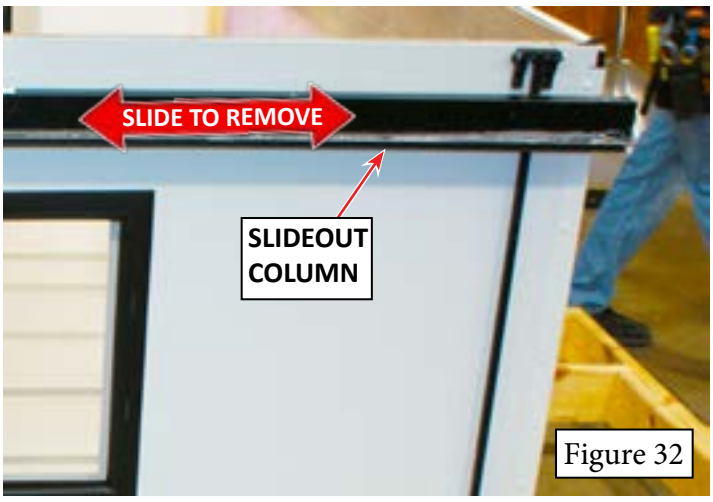

Figure 32

Figure 33

34. Once the fasteners are removed, remove the slide corners. You may have to pry the corners off the slide box (Figure 34). Note - if they are damaged during removal, replace them (replacements provided in initial parts shipment - P/N 105066).

35. Once the slide corners are removed, use a razor knife to cut the seam between the between the floor seal and the wall (Figure 35).

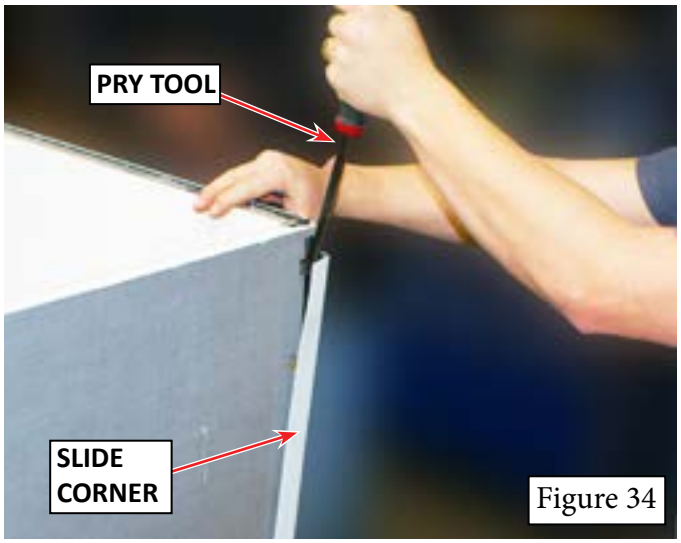

Figure 34

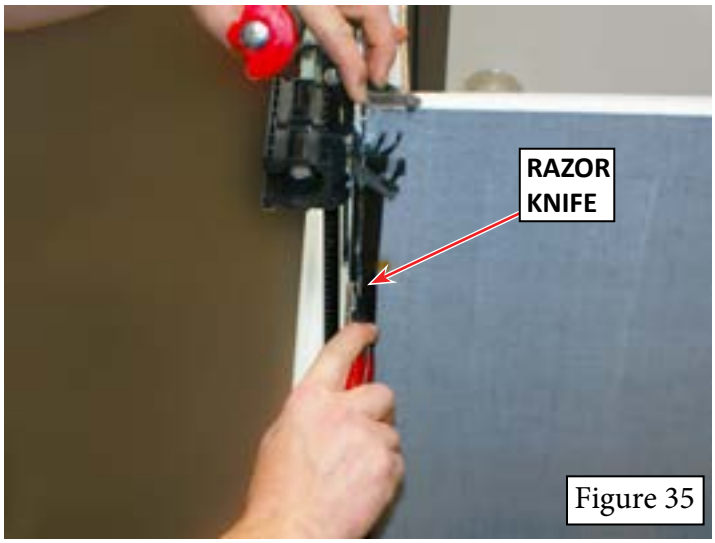

Figure 35

36. Using a screw gun and a #2 square drive bit, remove the fasteners that hold the slide-out floor to the slide-out sidewalls (Figure 36).

37. Remove the screws holding the slide-out floor to the outside slide-out wall (Figure 37). **NOTE that these screws may be hidden under seam tape** (Eterna-Bond tape - P/N 102405 - replacement tape supplied)**.**


Figure 36


Figure 37

38. Use wire cutters to cut the securing zip tie and remove the wire clamps for the under slide lights (Figure 38a) and disconnect the wires (Figure 38b).

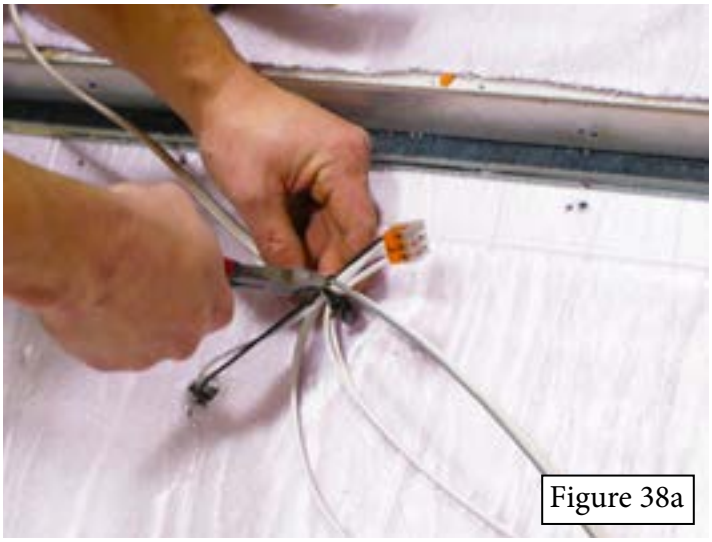

Figure 38a

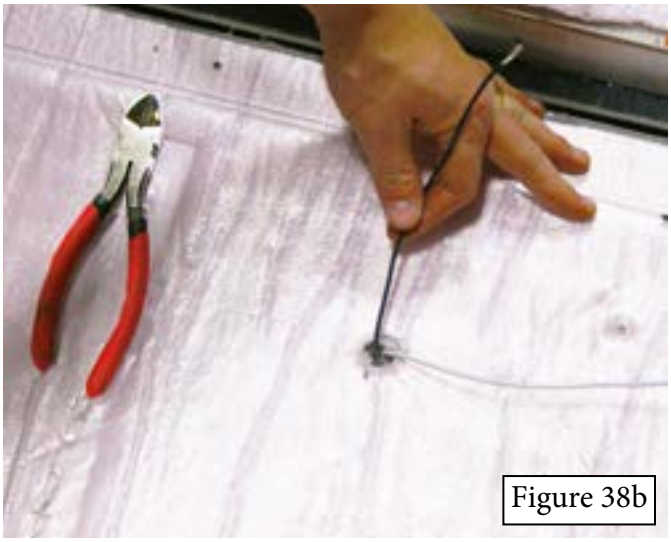

Figure 38b

39. Push the lights out of the floor and remove the grommets through the holes they are mounted in (Figure 39a). Retain lights and grommets for re-installation in new floor (Figure 39b).

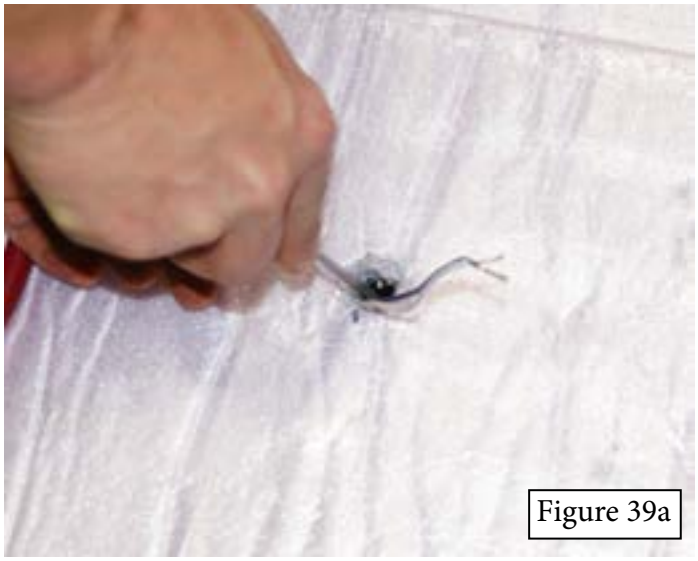

Figure 39a

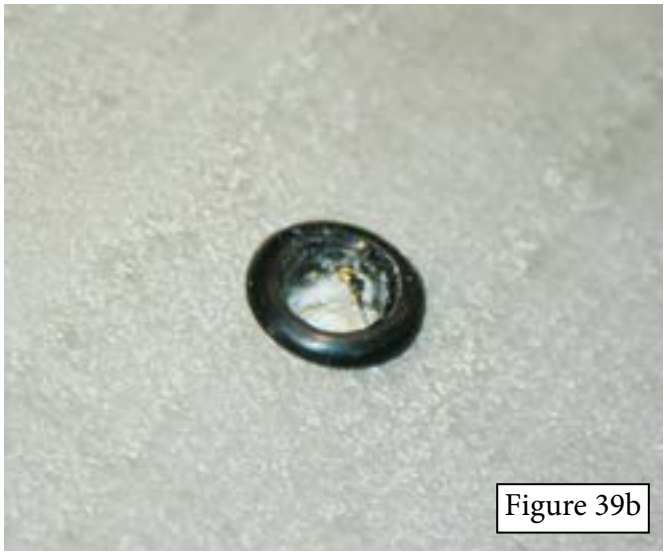

Figure 39b

40. Lay new slide-out floor on supports with the interior side facing up. Lay pink insulation (P/N 101851) over the floor and cut about an inch longer than the room. Peel the backing off of the adhesive on the pink insulation and flip the insulation so the adhesive side is down (Figure 40).
41. Apply insulation to the floor and trim to fit (Figure 41).

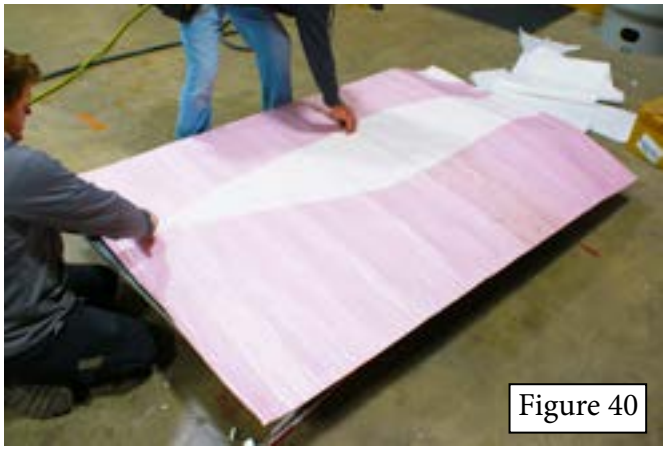
Figure 40

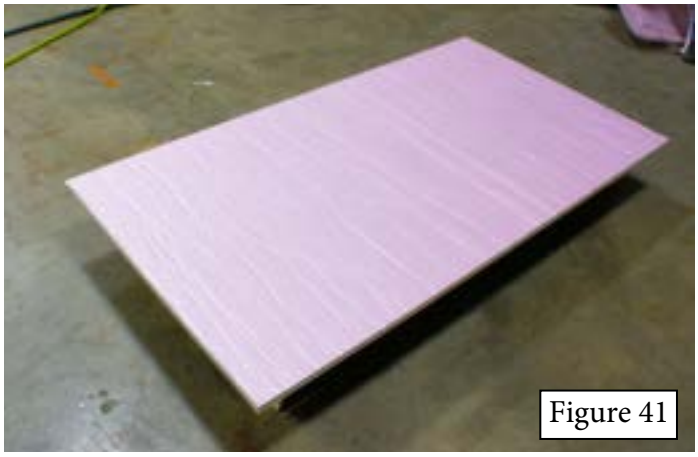
Figure 41

42. Flip the floor over. Measure out the hole centers for the under slide lights (6" in from the outside face edge of the floor and 18 ¼" in from the side edge of the floor) (Figure 42).
43. Use a power drill and a 3/8" spade drill bit to drill the holes for the LED lights (Figure 43).

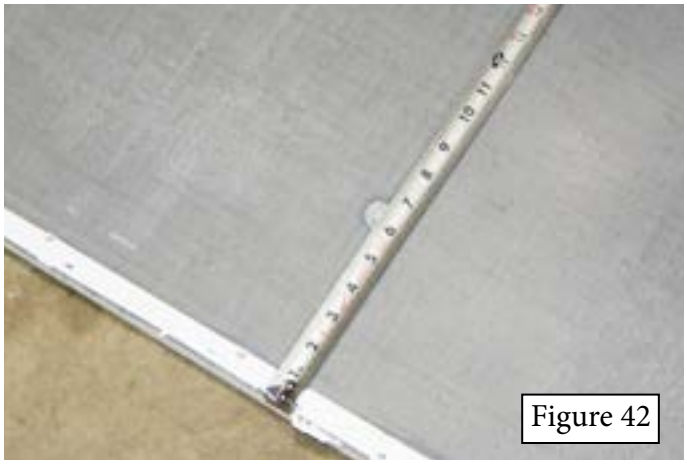
Figure 42


Figure 43

44. Lift the new floor and set into place against the bottom of the slide room walls. The holes for the lights should be near the outside face of the slide room and the pink insulation should be facing the ceiling of the slide room (Figure 44).
45. Line up the bottom corners of the floor with the slide room walls first (Figure 45).

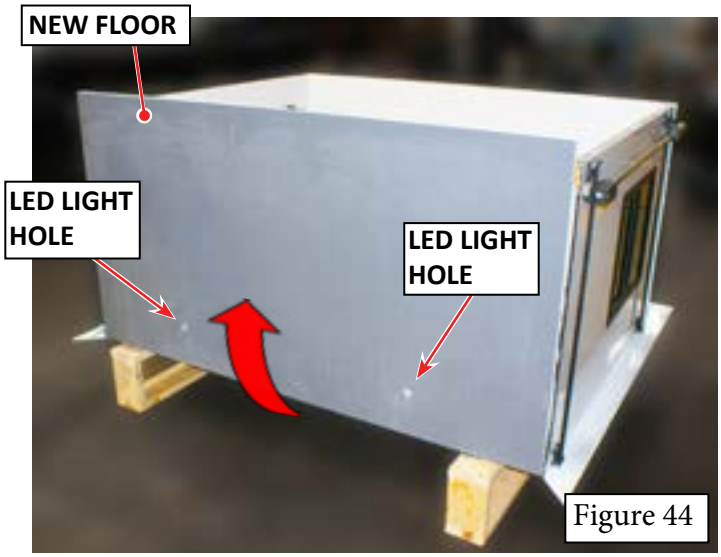

Figure 44

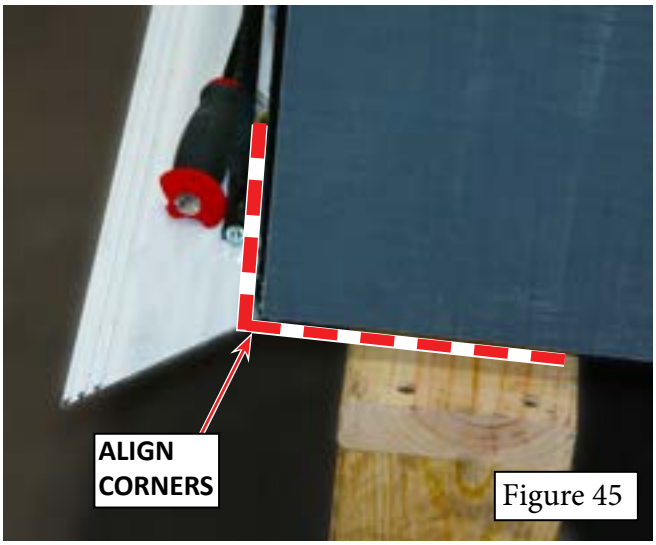

Figure 45

46. Using a screw gun with a #2 bit, secure the bottom corners of the room to the floor with one (1) 14 X 1.5 ZINC (P/N 100883) screw in each outside corner (Figure 46).
47. Align the walls with the floor and ensure the slide room remains in square. Secure the other two corners of the room with one (1) 14 X 1.5 ZINC (P/N 100883 - NOT provided) screw in each corner, **then secure the rest of the wall using at least four (4) of the same 14 X 1.5 ZINC screws per wall.**


Figure 46


Figure 47

48. Once the side walls are secure, align the outside wall and hold the removed T-Molding in place and mark the screw locations in the T-Molding. This will prevent from screwing the T-molding into an already existing screw from the floor (NOT shown).
49. Using a screw gun with a #2 square drive bit, attach the floor to the outside wall with eight (8) 10 X 3 screws (P/N 100880) (Figure 48). **There should be a minimum of 8 screws through the floor into the outside wall.**
50. Using an oscillating multi tool with a chisel blade (or equivalent), remove any old sealant along the floor line of the slide-out (Figure 49).

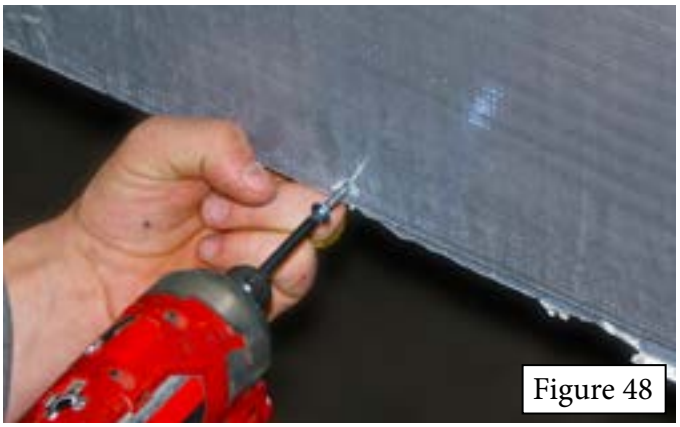
Figure 48

Figure 49

51. Place Eternabond seal strips (P/N 102489 ) over the side wall to floor corners of the slide room. Trim them around the T-molding. Make sure the strips completely cover the screw heads for the floor (Figures 50a and 50b).

Figure 50a

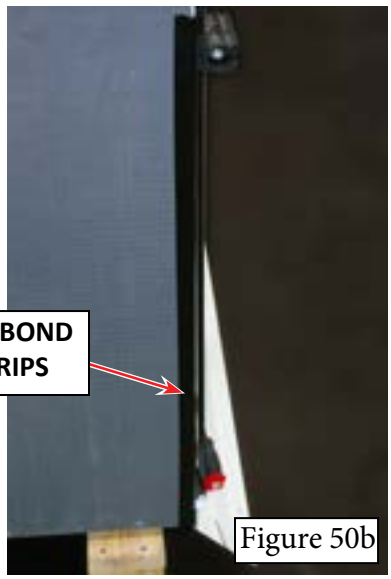
Figure 50b

52. The new floor will extend about 2 inches beyond the original wall lines. Mark the area to be notched out (Figure 51).
53. Use a reciprocating saw to notch the floor at the wall line (Figure 52).

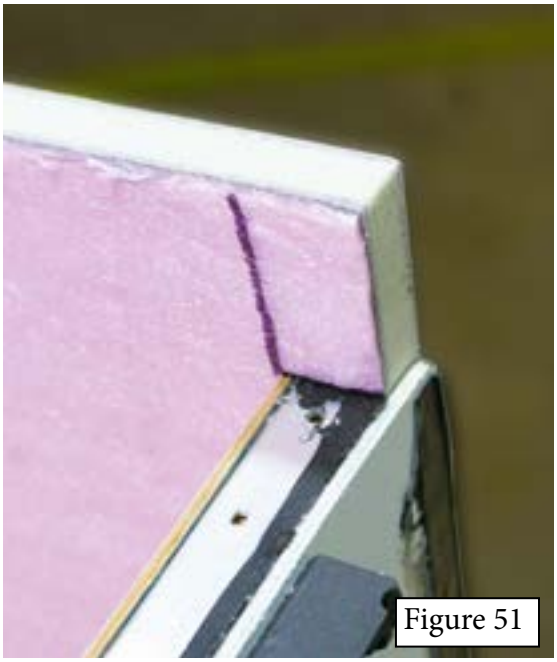
Figure 51

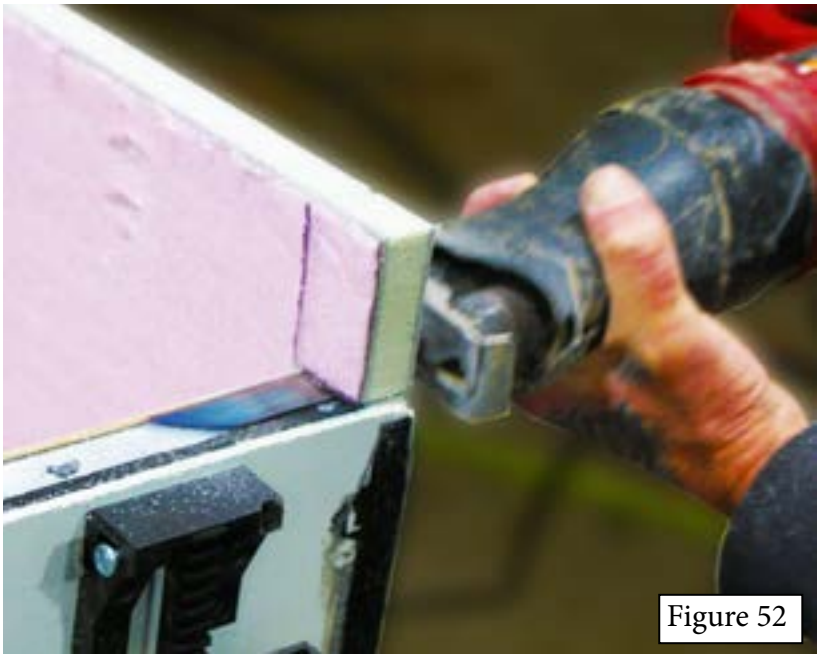
Figure 52

**SLIDE-OUT OPENING ROLLER MODIFICATIONS**

54. Use a screw gun with a #2 square drive bit to remove the original wall mounted slide-out rollers (Figure 53).
55. The first roller is placed 5" in from the left hand side of the opening. Measure and mark the cleat at 5" from the wall opening and cut the top panel at that mark (Figure 54).

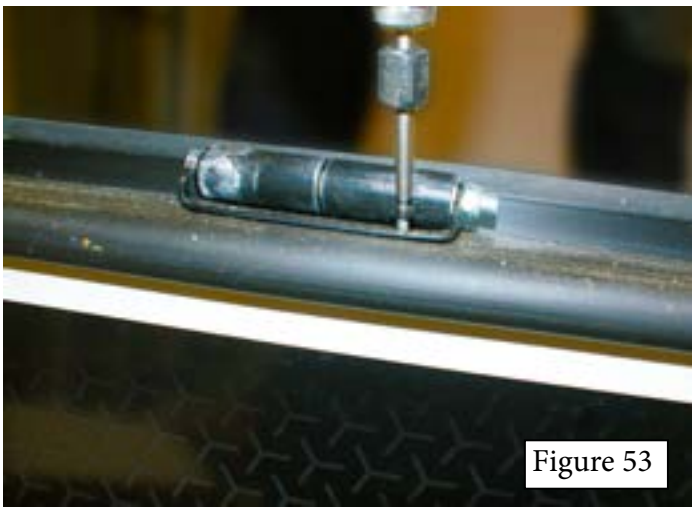
Figure 53

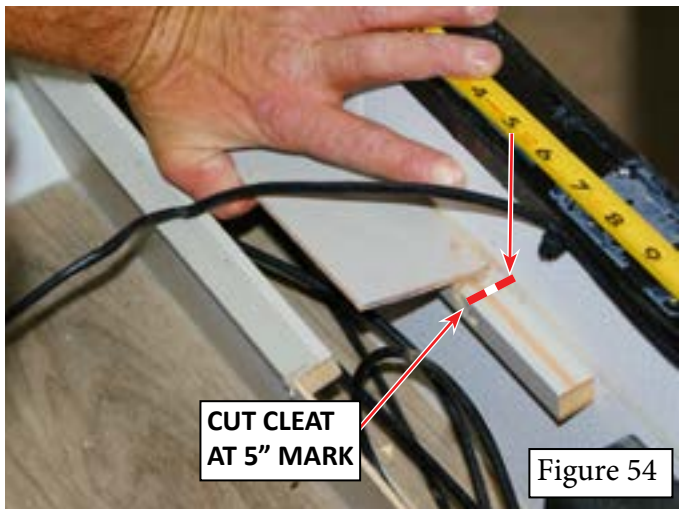

Figure 54

56. Use a knife to cut the silicone seal around the floor/wall cover panels, then pry the panels carefully apart to be able to reinstall (Figure 55a and 55b).


Figure 55a

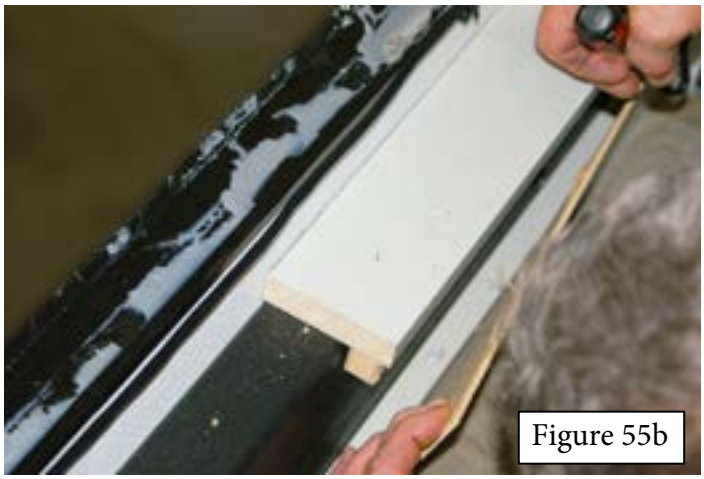
Figure 55b

57. Install the chassis tube extension (P/N 111820) into the end of the chassis tube with four (4) 3/8" self tapping screws (P/N 101332). The bracket should be oriented as shown and align with the steel frame rail at the end (Figure 56a and 56b).

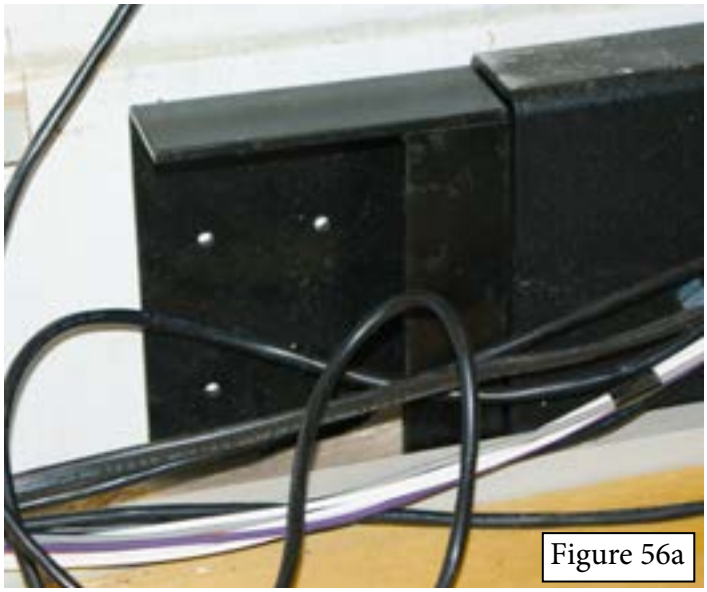
Figure 56a

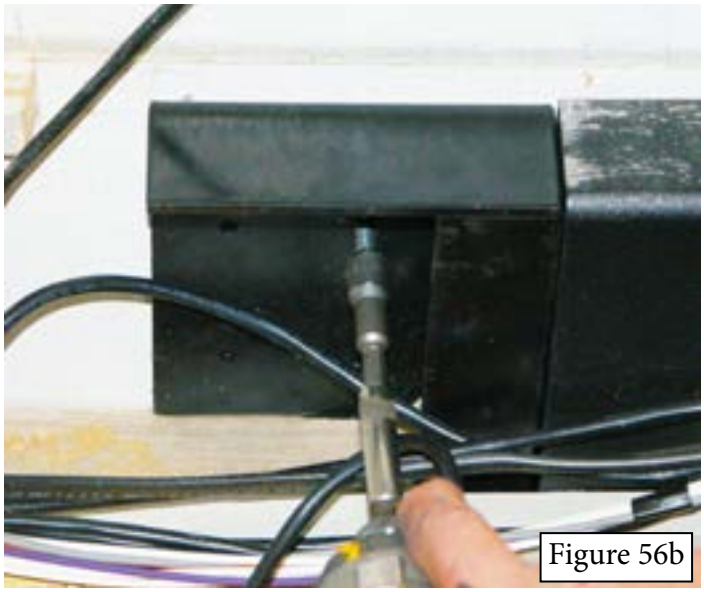
Figure 56b

58. Place the new roller bracket on the metal frame rail. The first roller is to be mounted 5” from the vertical edge of the slide-out opening (Figure 57). Use the bracket as a template and use a power drill with a 1/4” drill bit to mark the mounting hole locations on the frame rail.
59. Remove the roller bracket and complete the pre-drilling of the marked holes (Figure 58).

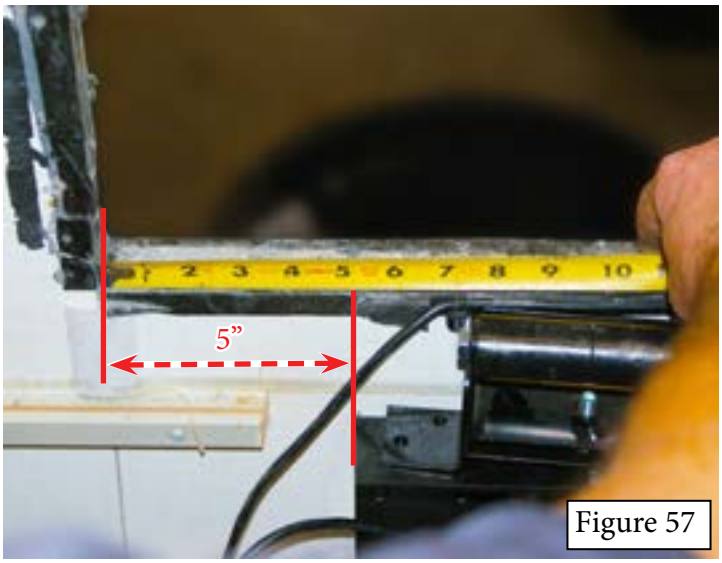

Figure 57


Figure 58

60. Install the first roller on the far left side of the slide-out opening (viewed from inside). Place the roller onto the rail over the pre-drilled holes. Insert a shim (P/N 111048) under the left side of the roller bracket (Figure 59) to bring the left side even with the right side on the rail.
61. Use four (4) 3/8” self tapping screws (P/N 101332) to attach the roller bracket to the metal frame rail (Figure 60).

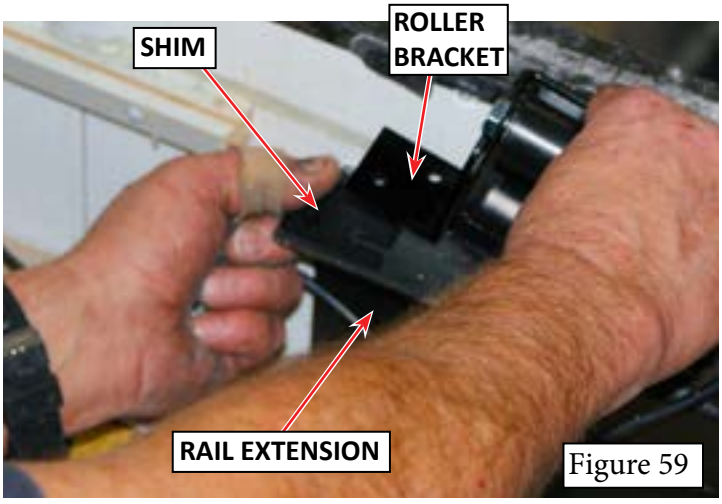

Figure 59

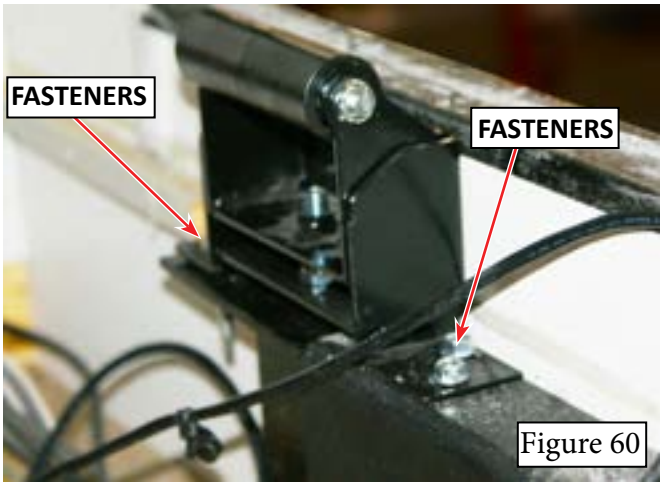

Figure 60

62. Inspect to make sure the roller is level with the slide-out opening (Figure 61).
63. If the roller needs vertical adjustment, use a 1/2" open end wrench to turn the adjustment bolt in the slide-out roller bracket to raise or lower the roller height (Figure 62).

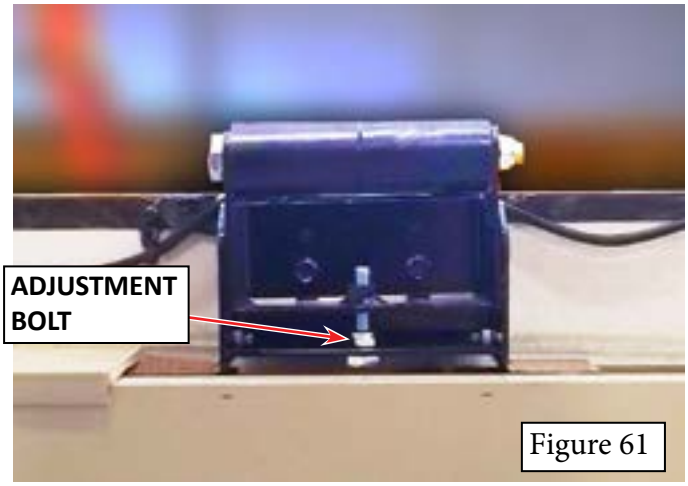

Figure 61

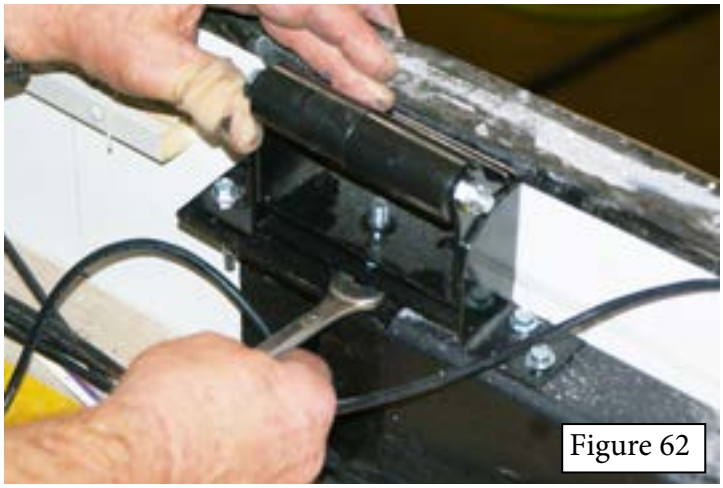
Figure 62

64. Once the roller height is set, use a screw gun with a 3/8" socket to install two (2) 3/8" self tapping fasteners (P/N 101332) to secure the slide-out roller bracket to the wall (Figure 63).
65. Measure from the vertical edge of the first slide-out roller 16". Place the next slide-out roller at this mark (Figure 64).

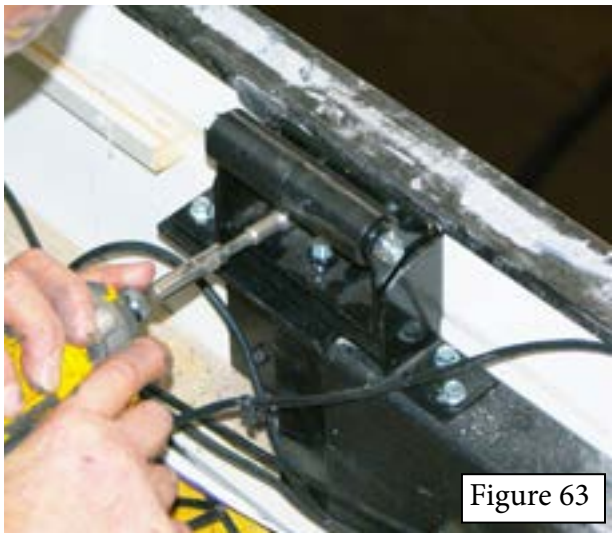
Figure 63

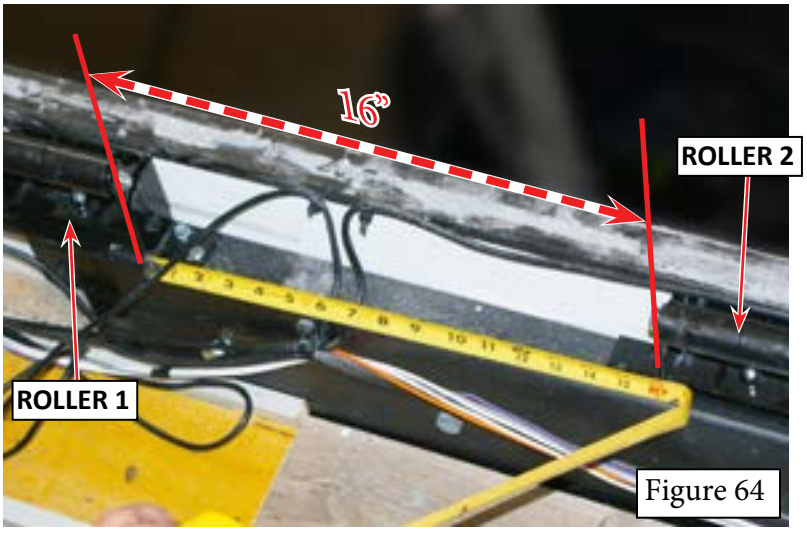

Figure 64

66. Use the bracket as a template and use a power drill with a 1/4” drill bit to mark the mounting hole locations on the frame rail (Figure 65). Remove roller bracket and pre-drill the holes (Figure 65).

67. Using a screw gun and a 3/8” socket, install the second roller using four (4) 3/8” self tapping fasteners (P/N 101332) and adjust height as necessary (Figure 66) as was done with the first slide-out roller bracket.


Figure 65


Figure 66

68. Install and adjust remaining two (2) rollers as set forth in the process above, for a total of four (4) slide-out rollers in the bedroom. Note the spacing on the additional rollers (Figure 67).

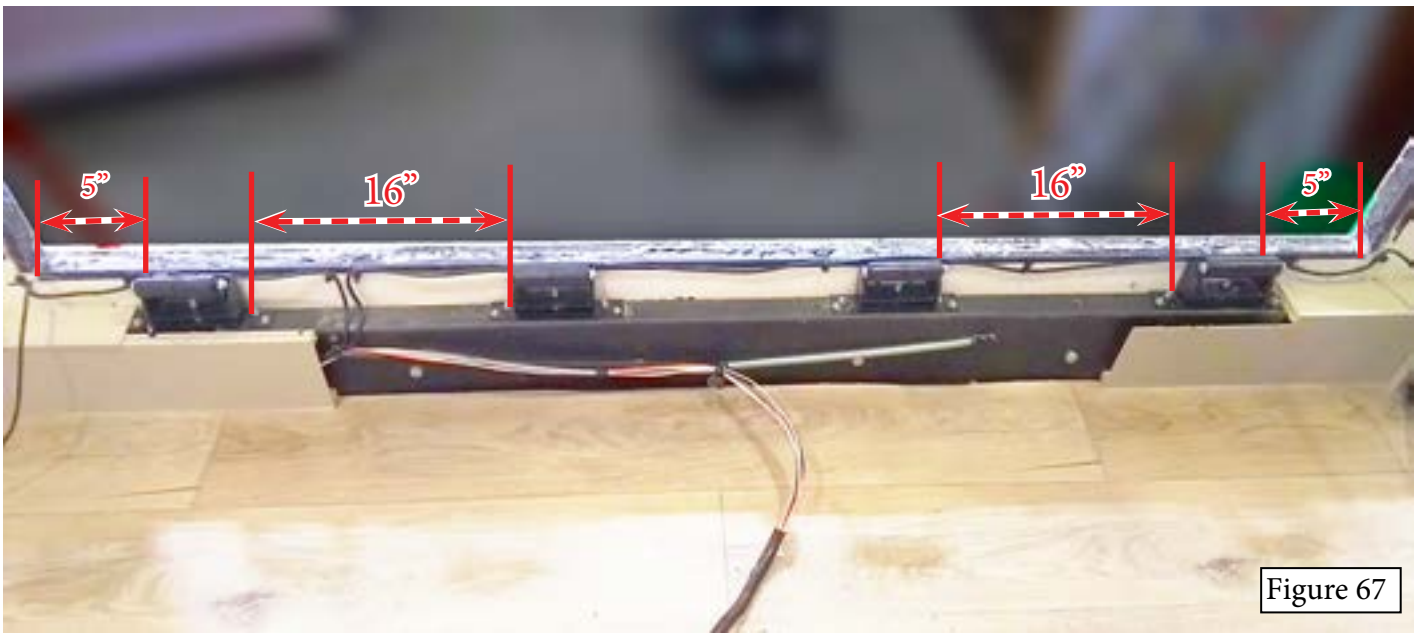

Figure 67

69. Route and secure wiring with zip-ties, and reinstall trim panels to cover the wiring as shown (see Figure 67 above).

**FRONT CAP REMOVAL**

1. Using a razor knife, score along both sides of the snap-on trim all the way around the cap and remove the sealant (Figure 68).
2. Using a screw gun with a #2 square drive bit, remove the screws from the ends and corners of the snap-on trim , then peel the trim away from the retainer all the way around the front cap (Figure 69).


Figure 68

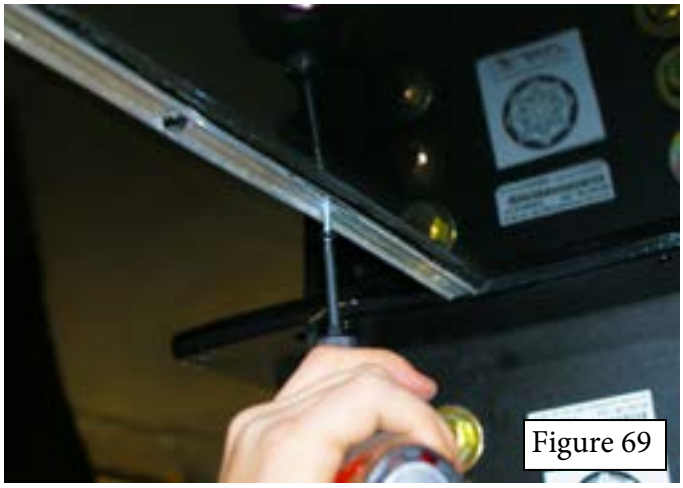
Figure 69

3. Using a screw gun and a #2 square drive bit, remove the screws from the pinbox shroud (Figure 70a and 70b). Note that some screws may require a 90° adapter to access (Figure 70b).


Figure 70a

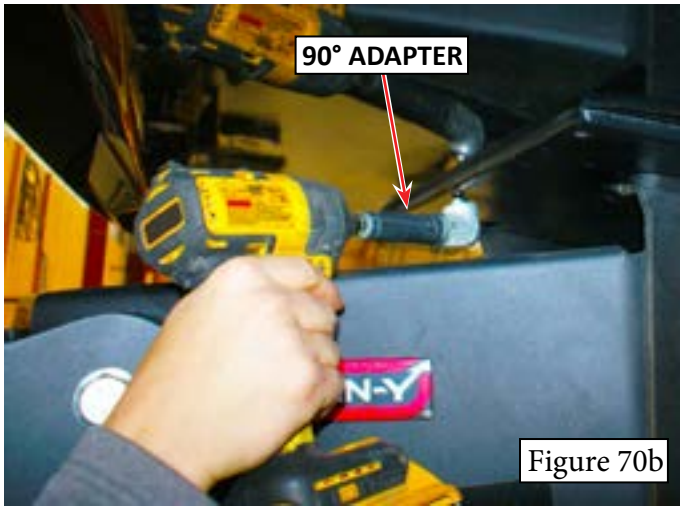

Figure 70b

4. Remove both pieces of the pinbox shroud and set aside safely (Figure 71).
5. Support the cap with a forklift that is padded to protect the cap (Figure 72).

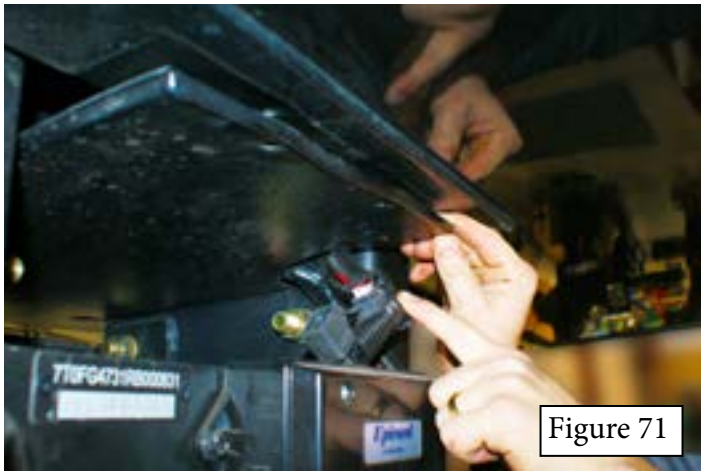
Figure 71


Figure 72

6. Pry around the edges of the cap to loosen the sealant and separate the cap from the side walls and roof Figures 73a, 73b, 73c and 73d). Check for hidden screws under the sealant.


Figure 73a


Figure 73b

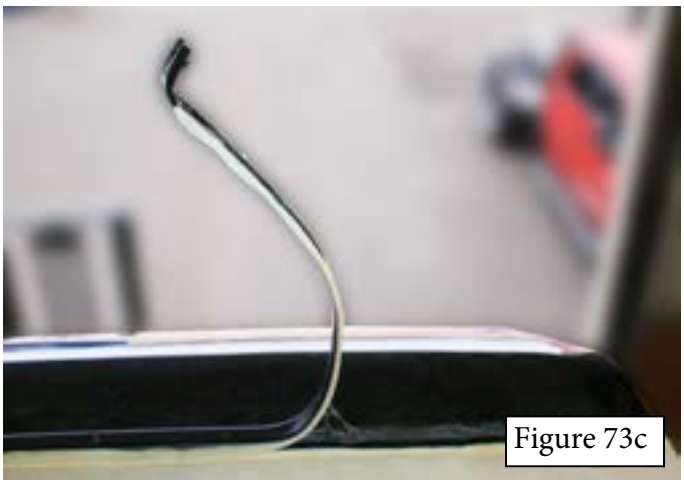
Figure 73c


Figure 73d

7. Pull cap back and disconnect the lighting wiring from the cap (Figure 74a and 74b).
8. Set cap safely aside and protect it for re-installation (not shown).

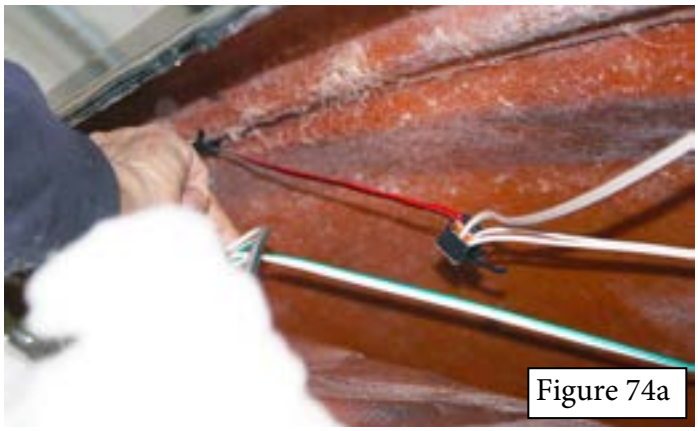
Figure 74a


Figure 74b

**SIDEWALL FIBERGLASS SKIN REMOVAL**

1. Use a screw gun with a #2 square drive bit and prying tools to remove the fasteners and peel off the rubber drip rail trim along the roof line to the back of the kitchen slideout (Figure 75).
2. Using prying tools, remove the drip rail j-channel from the roof line (Figure 76 and 77).

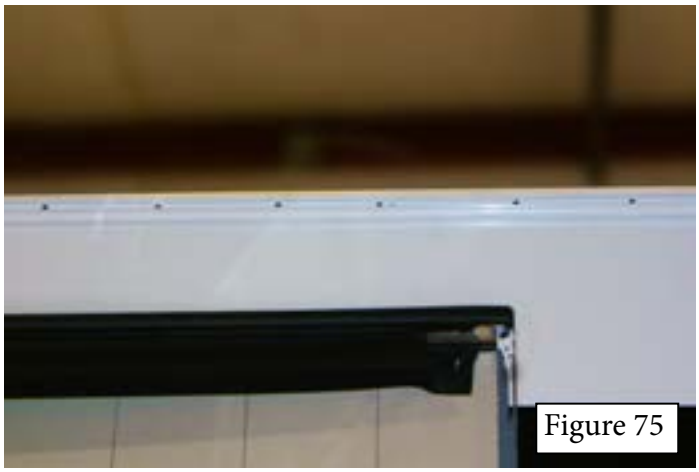
Figure 75

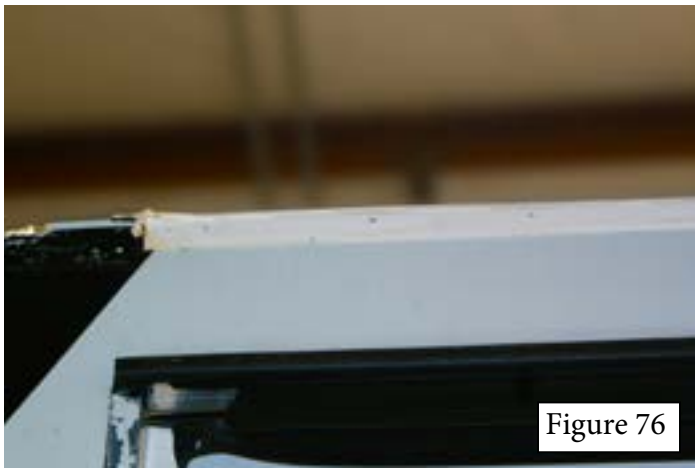
Figure 76

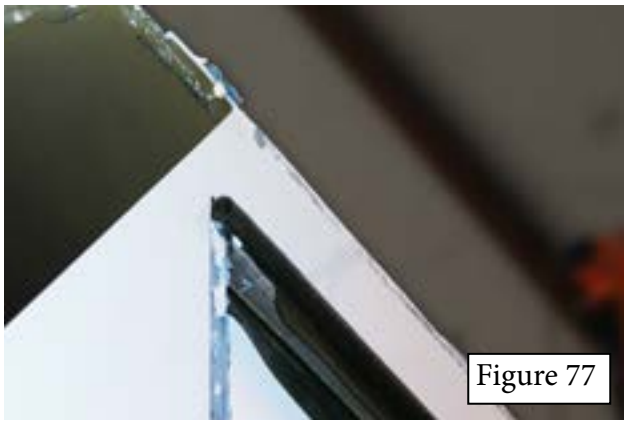
Figure 77

3. Use a screwgun and #2 square drive bit to remove the ladder bracket and exterior light from the side wall (Figure 78a and 78b).

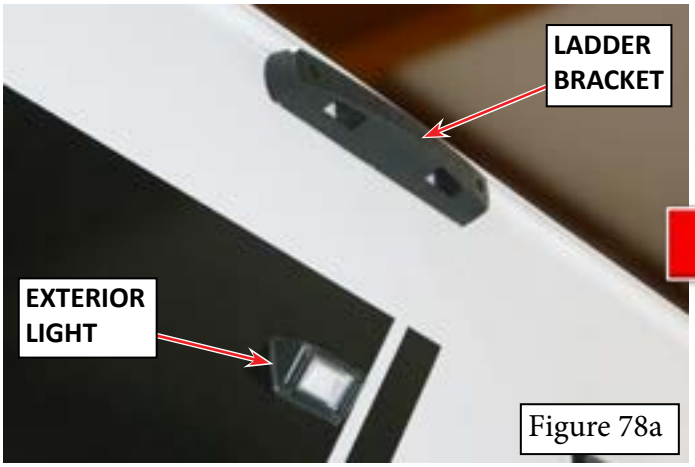

Figure 78a

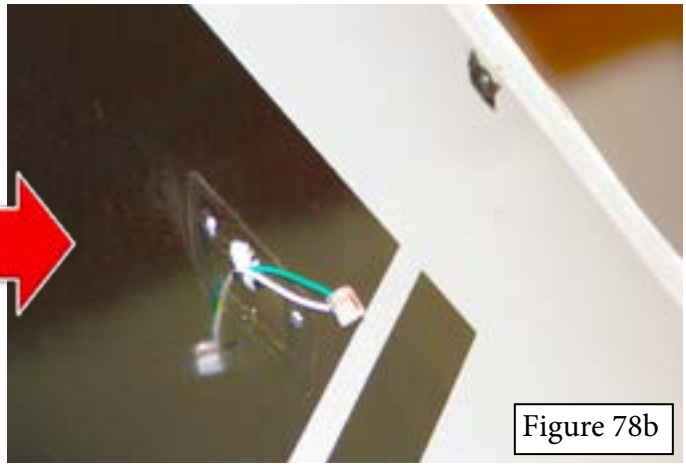
Figure 78b

4. Remove all of the baggage doors and water heater covers from the side wall. The doors are held in place with #2 square drive fasteners: **NOTE that some of the fasteners are hidden under weatherstrips and trim (Figure 79a, 79b, 79c and 79d).**


Figure 79b

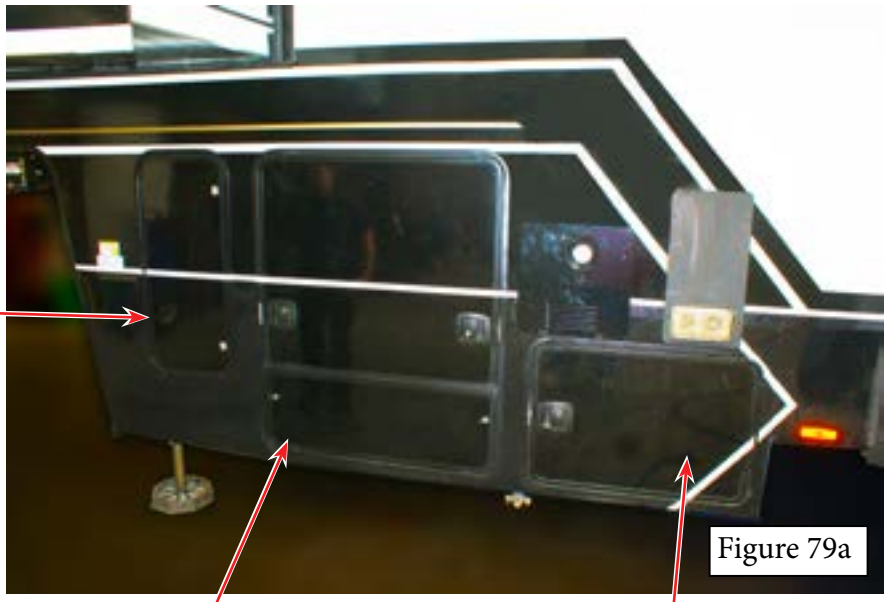
Figure 79a


Figure 79c

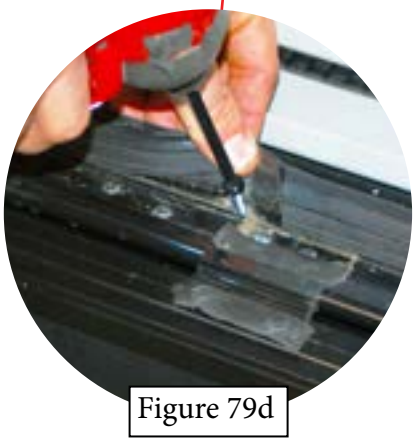
Figure 79d

5. Using a screw gun and a #2 square drive bit, remove the skirting along the lower side wall of the unit up to the kitchen slideout (Figure 80). Some prying may be required to remove the skirting.
6. Peel back the edge of the rubber roofing that hangs over the edge of the side wall (Figure 81). Use a plastic prying device (like a Polystick) that will not puncture or otherwise damage the roofing material.


Figure 80


Figure 81

7. Create a template from scrap fiberglass, plywood, or cardboard to aid in uniform cuts to the existing fiberglass skin. Cut the narrow end at a radius to help with alignment and seam repair when the new fiberglass skin is installed. Use the template and a grease pencil to mark the cut line for the fiberglass above the kitchen slideout (Figure 82a and 82b).

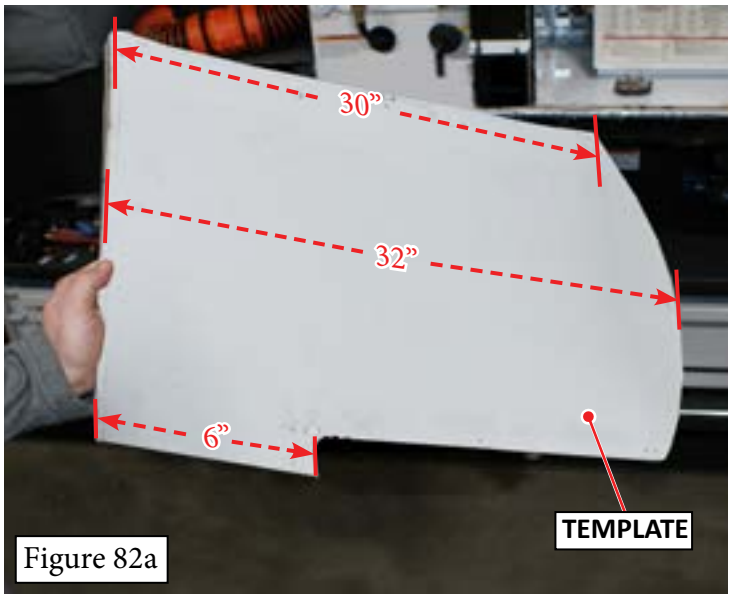

Figure 82a

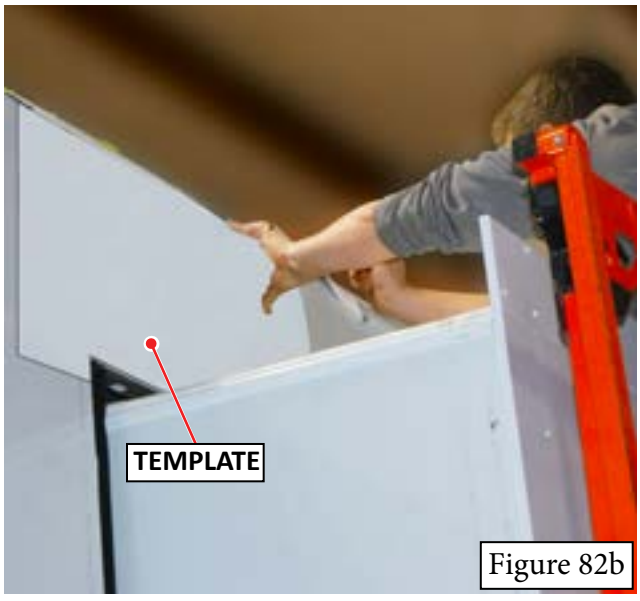

Figure 82b

NOTE: Sample measurements are approximate, but work with most floorplans.

**+ NOTICE**

In the following steps, cut ONLY the fiberglass sidewall. DO NOT cut foam, structure or aluminum supports as this may lead to structural damage. There are metal structural components, and sometimes wiring in this area. Cutting deeper than the fiberglass risks damaging anything behind it.

8. Once the fiberglass is marked, use a hand held pneumatic saw to cut the fiberglass along the curved mark (Figure 83a and 83b). NOTE: Cut ONLY the fiberglass - DO NOT cut any structure or support.

Figure 83a

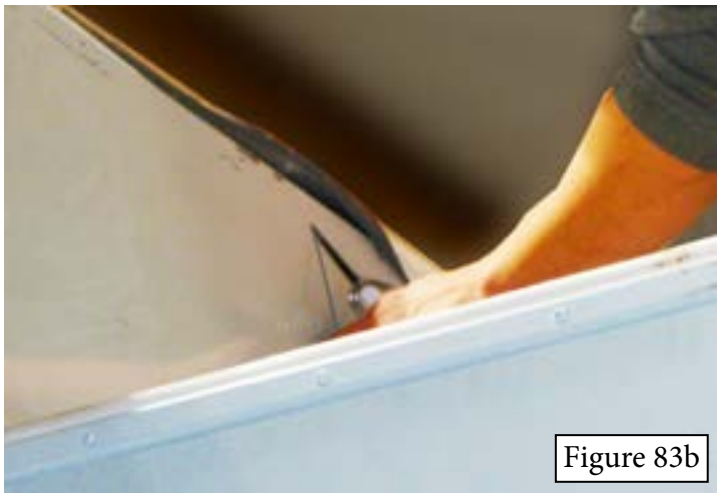

Figure 83b

9. Using prying tools, separate the fiberglass exterior from the aluminum and foam structure (Figure 84a, 84b, 84c, and 84d). Safely pry and pull the exterior fiberglass off of the aluminum frame structure as necessary.

Figure 84a

Figure 84b

Figure 84c

Figure 84d

10. The fiberglass is backed with an azdel material which may separate from the fiberglass and stick to the structure. Once all of the fiberglass has been removed, use a putty knife, oscillating multi-tool or a grinder to REMOVE ALL of the azdel and any residual adhesive from the aluminum wall structure (Figure 85a and 85b).

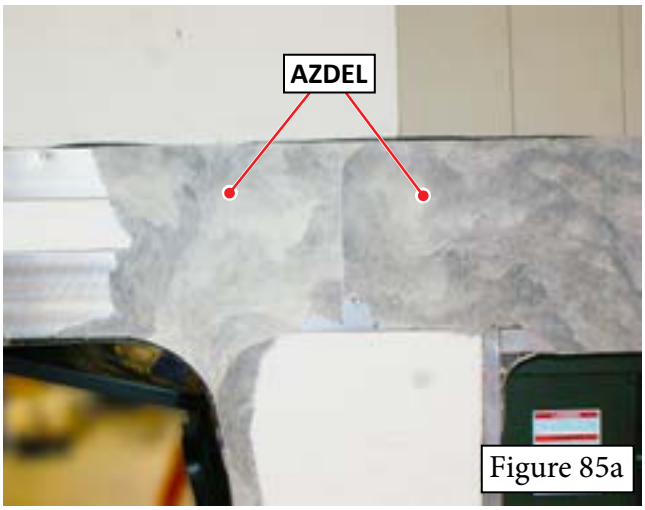


Figure 85a

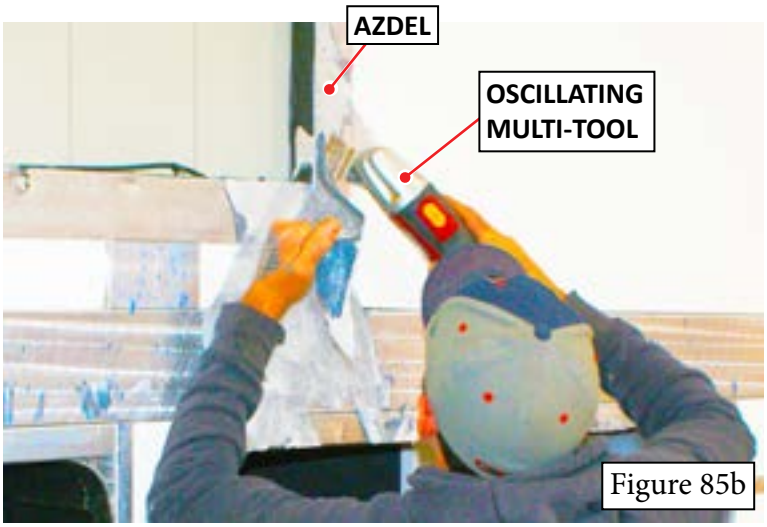


Figure 85b

## SIDEWALL STRUCTURE MODIFICATIONS

### ⚠ CAUTION

**CAUTION: WEAR PROTECTIVE EQUIPMENT** while welding. Burn injury from weld spatter, and blindness can occur from looking at the weld in progress without proper protective equipment. NEVER stare into or look directly at the sparks and/or weld without a welding mask that protects eyes and skin. Wear a protective sleeve to cover clothing and skin. Failure to heed these guidelines can result in serious injury, blindness, or death!

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### ⚠ CAUTION

**CAUTION:** Install a cover on the slide-out opening into the bedroom, as well as the openings for the storage doors. Remove anything flammable or explosive from the storage compartments, and cover those as well during the welding process. This protects these areas from damage/weld spatter while the sidewall structure is being modified. Failure to do so may cause potential damage or fire to these areas, resulting in property damage and possible personal injury.

---

1. Mark the sidewall structure for additional 2” x 6” bracing. Starting at the edge of the kitchen slideout, measure as indicated on the attached prints and mark the foam insulation for installation of braces. Vertical braces are typically installed on 48” centers. NOTE on the prints that RED means ADD this reinforcement, YELLOW means ADD IF NOT ALREADY THERE (Figure 86 - this is an example structural modifications - actual prints are attached to the end of this document).

Figure 86

2. Use a magic marker pen (or equivalent) and a 2” x 6” aluminum brace tube to lay out the modifications to the sidewall (Figure 87).
3. Once the vertical, horizontal and diagonal structure bracing marks are layed out on the sidewall structure, use a razor knife to cut along the lines, then use a 6” putty knife to chisel the styrofoam out for installation of the braces (Figure 88a and 88b).


Figure 87


Figure 88a

4. Cut the styrofoam out of the each corner and joint where the original structure was built. Inspect for broken welds (Figure 89). Inspect ALL original welds on the exposed sidewall and mark for repair as needed.

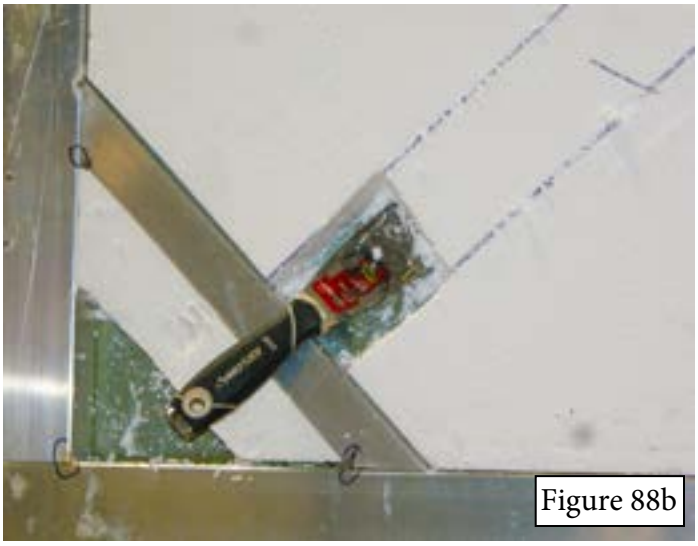
Figure 88b

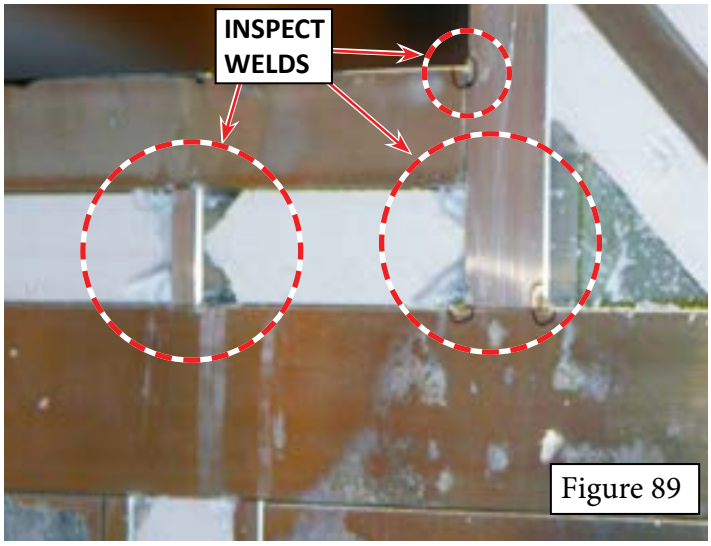

Figure 89

5. Cut the 2” x 6” braces to size for each opening and test fit (Figure 90).
6. Install the bracing in the sidewall using Chem X adhesive (P/N 100650) (Figure 91).

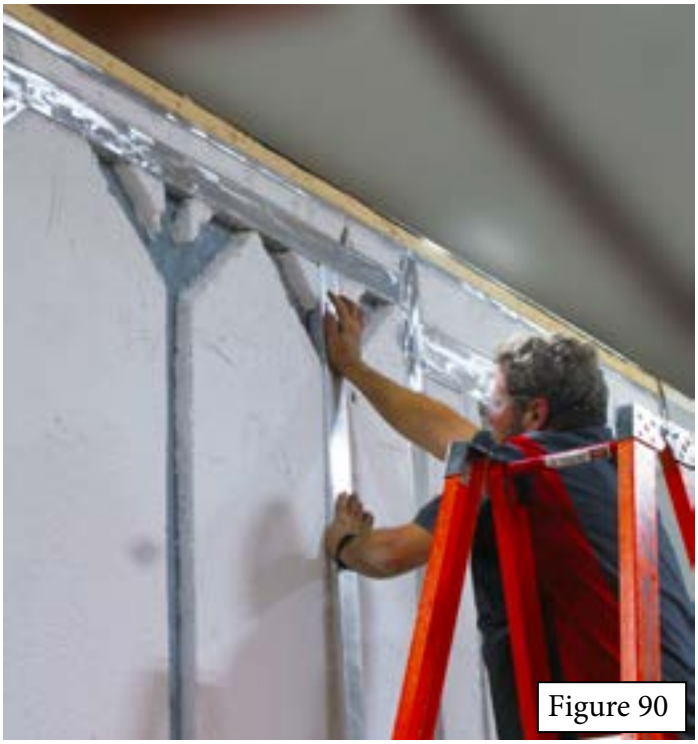
Figure 90


Figure 91

7. Tape the braces in place to hold them while the Chem X sets typically overnight unless the brace is welded in shortly after application (Figure 91).
8. Cover any openings and finished surfaces with a weld blanket to prevent weld spatter from causing damage (Figures 92a and 92b).

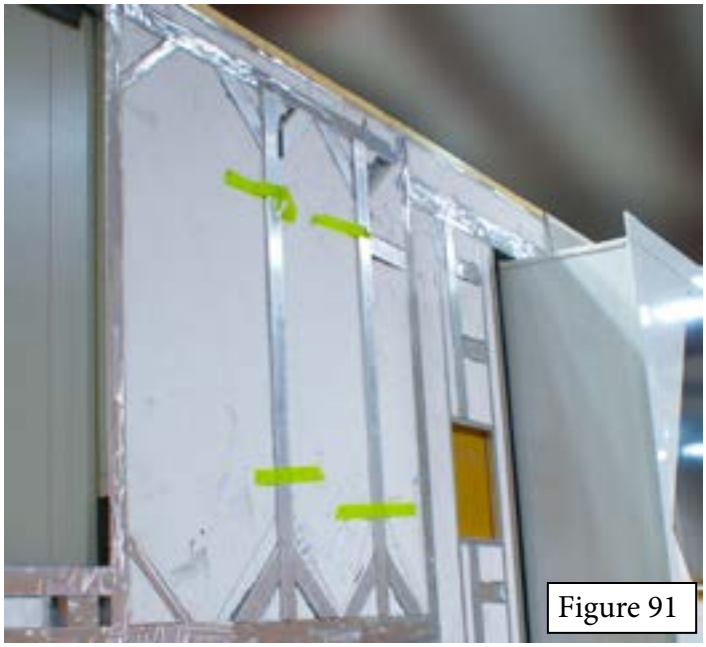
Figure 91

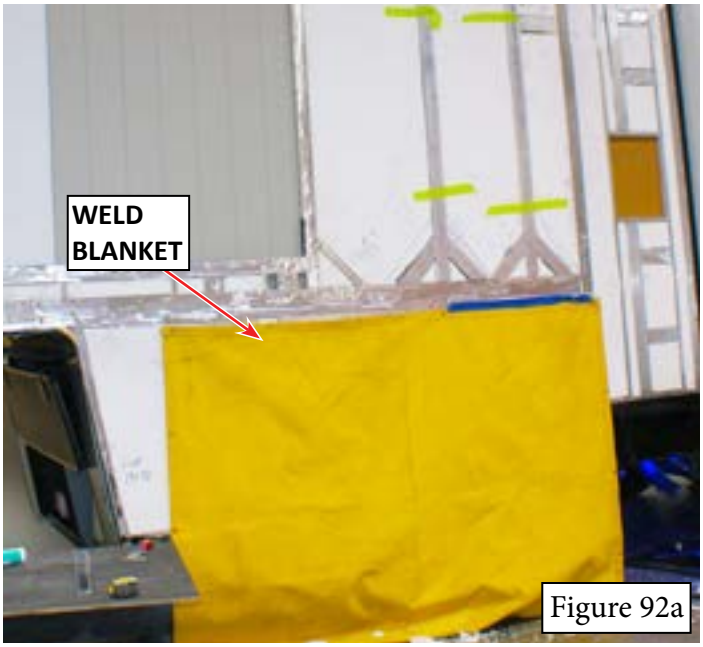

Figure 92a

9. Lift the unit by the pinbox using  tripod or forklift BEFORE welding begins(Figure 93a).
10. Prepare the structure for welding by installing a bolt on the sidewall structure for the welder (Figure 93b). Attach the lead from the welder to this point.

Figure 92b


Figure 93a

11. When the braces are all in position, begin welding them to the existing sidewall structure (Figure 94a, 94b, and 94c). Repair any original welds that were broken at this time as well.

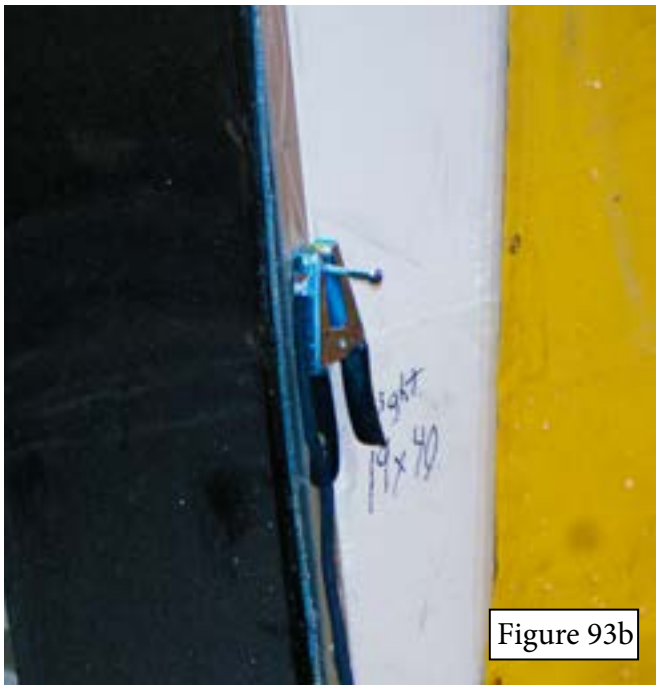
Figure 93b


Figure 94a

Figure 94b

Figure 94c

12. When all the welds are complete, inspect them thoroughly for gaps and holes that may have occurred during the process (Figure 95).
13. When satisfied with the quality of the welds, use a power grinder and a T-29 aluminum grinding disc (not supplied) to grind the welds flush (Figure 96a and 96b).

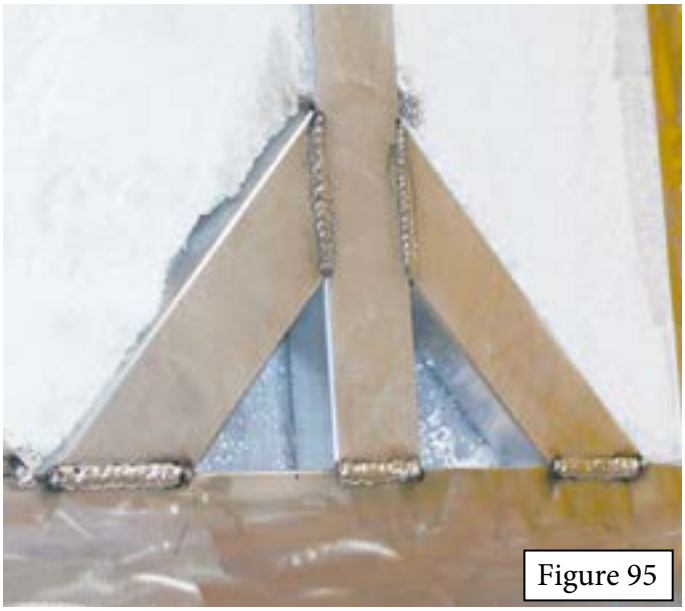

Figure 95


Figure 96a

Figure 96b

14. Once all of the welds have been ground flush, inspect each weld for gaps, holes, or breaks (Figure 97 - sample - all welds should be flush like this example).
15. Use expanding foam (not supplied) to fill the gaps and voids in the styrofoam insulation that were created to inspect the original welds (Figure 98).

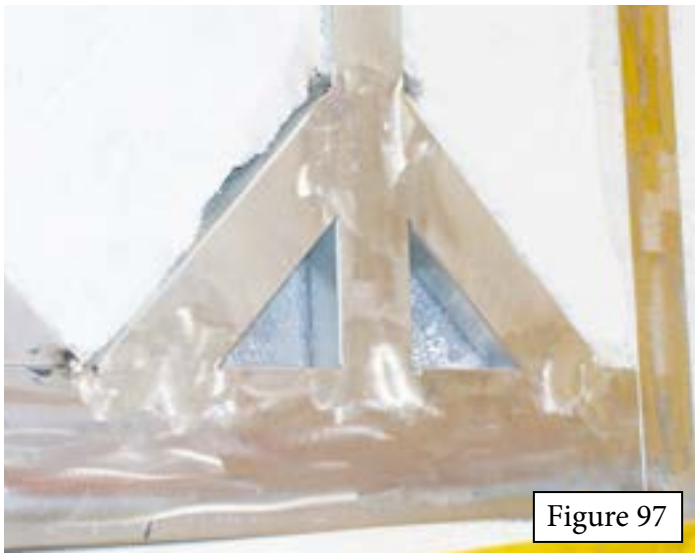

Figure 97

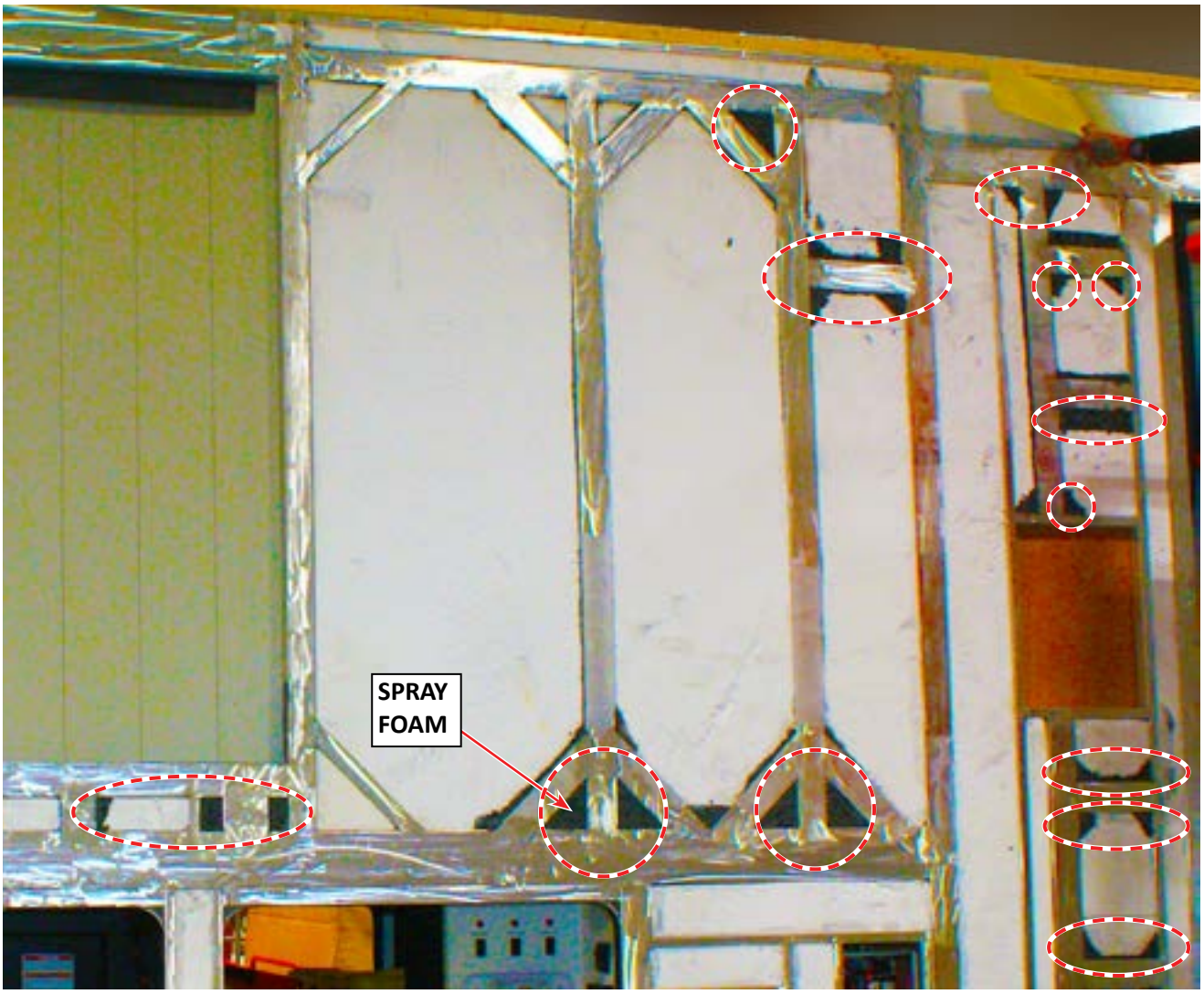


Figure 98

16. Use CHEM X (P/N 100650) or similar adhesive to install EGS (Electro Galvanized Steel) backer panel covering the stryofoam above the through-frame slide-out (Figure 99a and 99b). Tuck the right end behind the existing fiberglass at the curved cut, and press it flat into the opening.

Figure 99a

Figure 99b

17. Once all holes are filled, use a power grinder and a T-29 aluminum disc (P/N 111955) to scuff all of the aluminum surfaces where they will contact adhesives to improve adhesion (Figure 100a and 100b).


Figure 100a


Figure 100b

**FIBERGLASS WALL INSTALLATION**

1. With the new sidewall layed flat, use the original template to mark the cuts for the slide-out opening, and the curved end at the top that mates to the existing sidewall over the kitchen slide- out. Use a circular saw with a sharp blade to cut the straight opening for the slide-out (Figure 101).

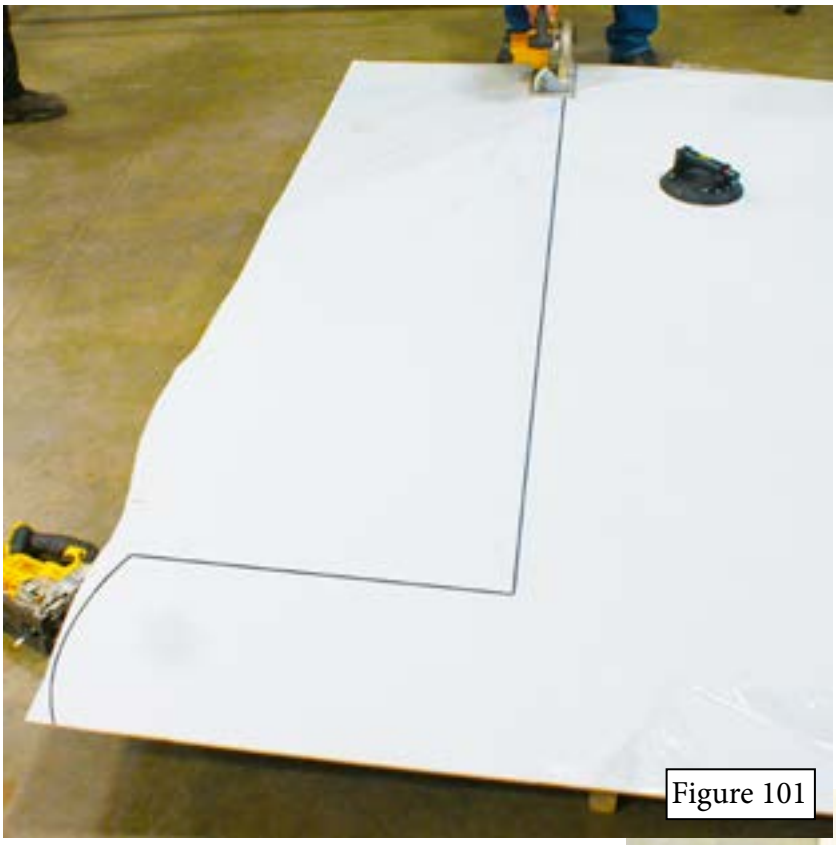

Figure 101

2. Use a jig saw with a sharp blade to cut the curved section that goes over the kitchen slide-out (Figure 102).

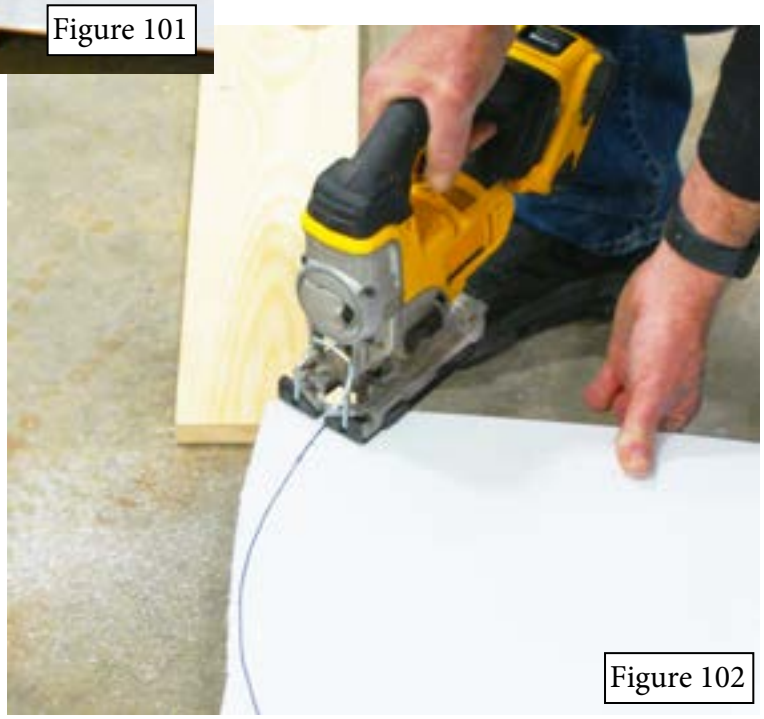

Figure 102

3. Thoroughly clean the mating surfaces of the aluminum sidewall structure using Alodine (P/N 101444) and clean shop rags or microfiber towels (not shown). Allow to thoroughly dry before applying adhesives. Rotate or replace wiping clothes regularly during the cleaning process.
4. Screw two (2) 2"X4"x 24" boards to the sidewall area 104" from the top of the roof edge to rest the sidewall on when installing it (Figure 103). These are TEMPORARY supports for the sidewall during installation.

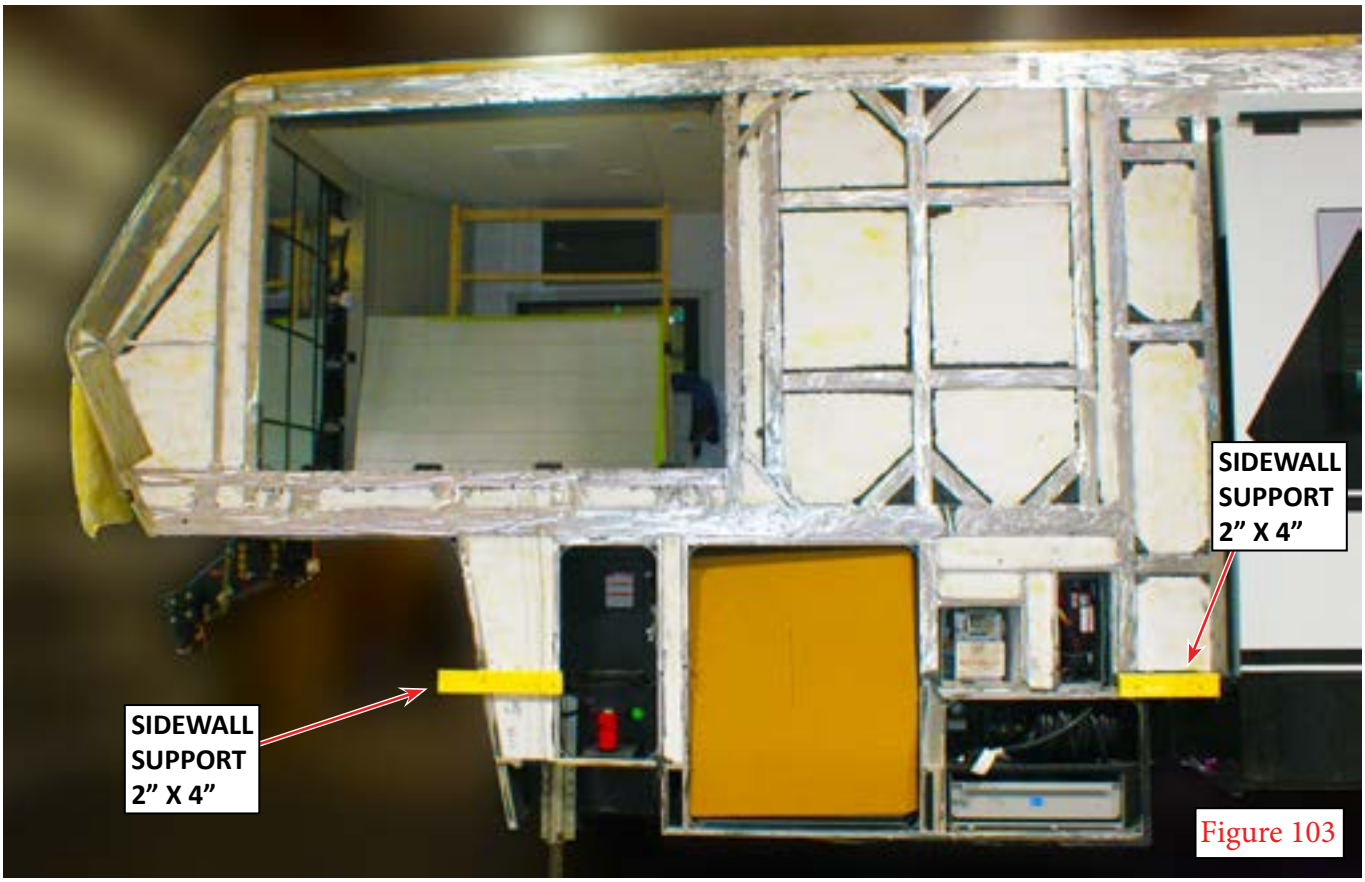

Figure 103

5. Lift the sidewall into position to test fit (Figure 104a). If the shop does not have a hoist, a minimum of 5 technicians are required. Place it on the 2"X4" support rests, and make sure it covers everything, and the cut curved joint above the kitchen slide-out mates properly to the curved cut in the existing wall (Figure 104b).

Figure 104a

Figure 104b

+ NOTICE

**The adhesive being used** - KORAPUR urethane adhesive sealant (P/N 112154) - has a set up time of 6 hours on initial application, and a curing time of 24 hours. Refer to the manufacturer's instructions for safety and clean-up procedures.

6. Once the test fit is confirmed, pull the sidewall fiberglass down and set carefully aside (not shown).
7. Using a pneumatic gun, apply KORAPUR urethane adhesive sealant (P/N 112154) on ALL aluminum structure that will contact the new fiberglass exterior wall (Figure 105a, 105b, 105c, 105d, and 105e).


Figure 105a


Figure 105b


Figure 105c


Figure 105d


Figure 105e

8. Once the adhesive is applied, use a trowel to throughly spread it for maximum contact and adhesion (Figure 106a, 106b and 106c).

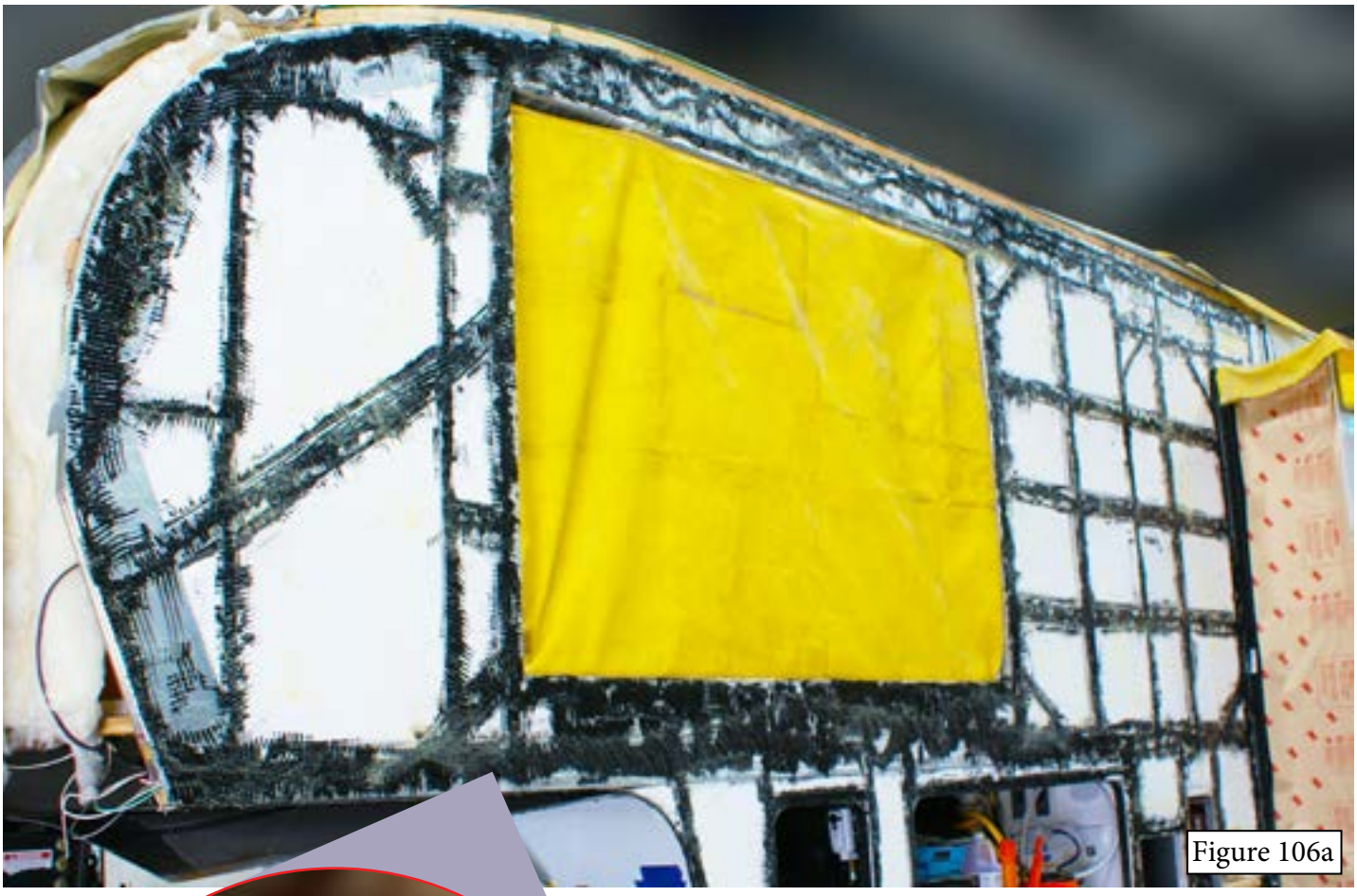

Figure 106a

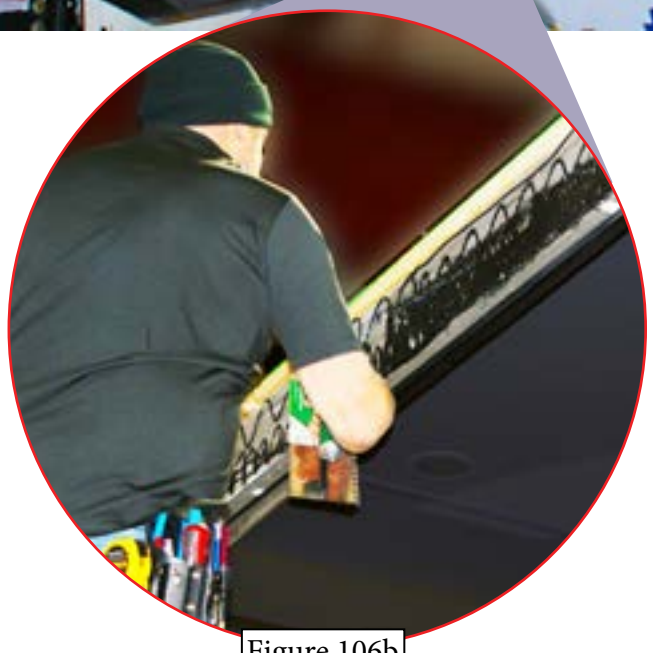

Figure 106b

Figure 106c

+ NOTICE

**NOTICE:** The adhesive used to hold the fiberglass to the sidewall structure is PRESSURE ACTIVATED, and must have the proper pressure applied to adhere to and cure on both surfaces. The following instructions outline the procedure to apply sufficient pressure to activate the adhesive.

To initially apply pressure, prepare a 12' long 2"X6" board by gluing felt (P/N 100537) on one side (shown in use on page 45, in Figure 109a and 109b).

Prepare six (6) 4'X8' Sheets of 3/4" finished plywood by covering one side in felt (Figure 110d, page 46). These will be used to secure the wall at the top and bottom for curing. For easier installation at the front of the unit, trim one of the panels to the contour of the front cap opening (as seen in Figure 112, page 48),

To press the wall firmly for the extended curing period (24 hours), have eight (8) 1/4"X2"X2" angle, in 12' lengths (Figure 112, page 48). Additional pressure is applied to the sidewall while the adhesive is curing by inserting shims between the angle pieces and the plywood panels (Figure 115c, page 50).

To expedite the final steps of the fiberglass installation, prepare these items in advance, and have them at the ready before applying the adhesive to the sidewall structure.

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9. Lift the sidewall into position and rest on top of the 2"X4" supports. Slide the wall into position on these supports BEFORE pressing the fiberglass back onto the adhesive (Figure 107).

Figure 107

10. Once the sidewall is positioned properly, press the sidewall firmly against the adhesive on the sidewall structure (Figure 108).

Figure 108

11. Using a felt covered 2”X6” board approximately 12’ long, a technician on the ground, and one on the roof, walk the length of the sidewall pressing the sidewall firmly into the adhesive at least two (2) times (Figure 109a and 109b).


Figure 109a


Figure 109b

12. Using a screw gun with a #2 square drive bit, begin attaching the 4'X8' sheets of felt covered plywood over the fiberglass. Fasten the panels in place using 2-1/2" wood screws (P/N 100904) - fasten the top of the fiberglass to the wooden roof sill (Figure 110a, 110b, and 110c). Sample felt covered plywood (Figure 110d).

Figure 110a

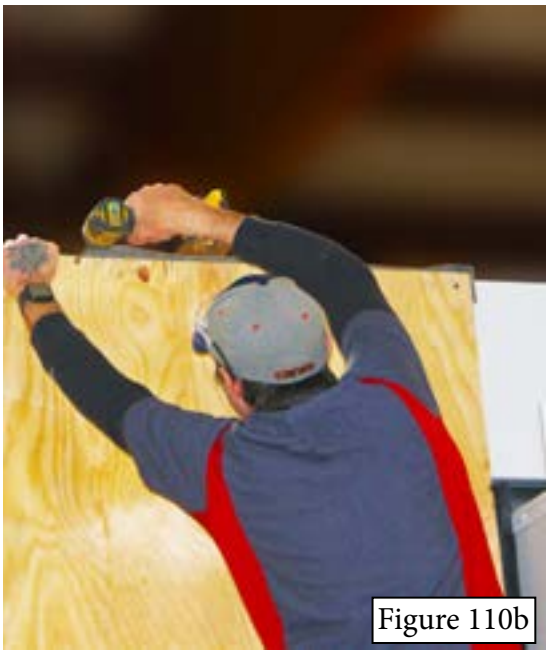


Figure 110b

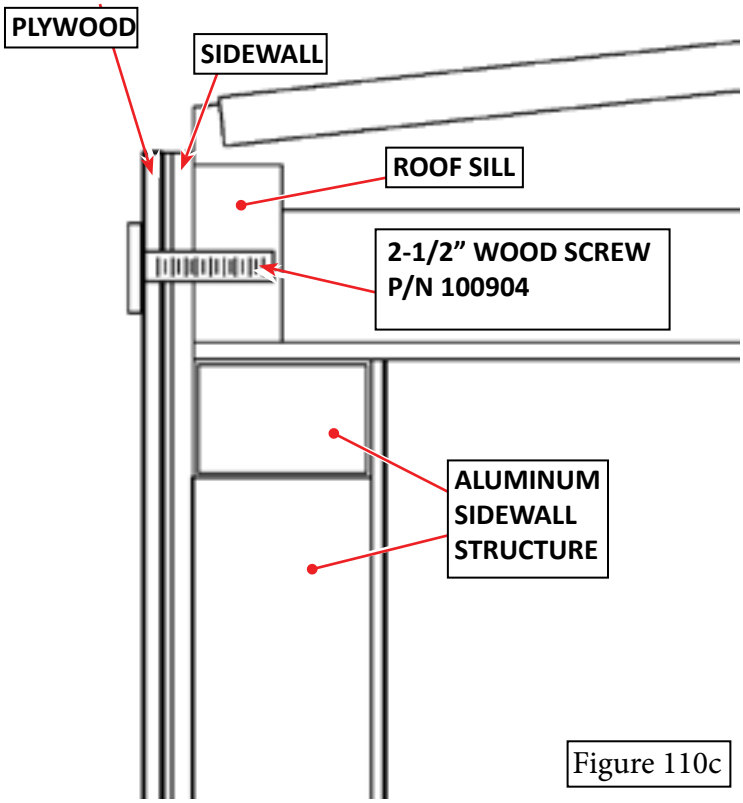



Figure 110c

SIDEWALL/ROOF CROSS SECTION


Figure 110d

13. Continue installing plywood covers until the sidewall is covered. (Figures 111a, 111b), Cut panels and cover with felt to attach above and below the slide-out opening and above the slide-out over the curved cut section (Figures 111c, and 111d). NOTE: It is often easier to hang the front plywood covers if they are cut for the front angled section of the sidewall where the front cap attaches, as well as cut out where the storage compartment doors are located.

Figure 111a

Figure 111b

Figure 111c

Figure 111d

14. Use a screw gun and #2 square drive bit, attach the vertical L-brackets over the plywood panels using 3” #10 wood screws (P/N 104187) (Figure 112). Secure them at the top into the roof sill, and at the bottom into the exposed structure BELOW the sidewall. Secure the forward most L-bracket with a ratchet strap to the pin box (page 49, figure 114).
15. Drill holes in the sidewall from inside the bedroom at each corner of the slide-out opening for reference. Screw the sidewall in around the perimeter of the slide-out opening, approximately every 6” with 2-1/2” wood screws (P/N 100904)(Figure 112 - dotted line).

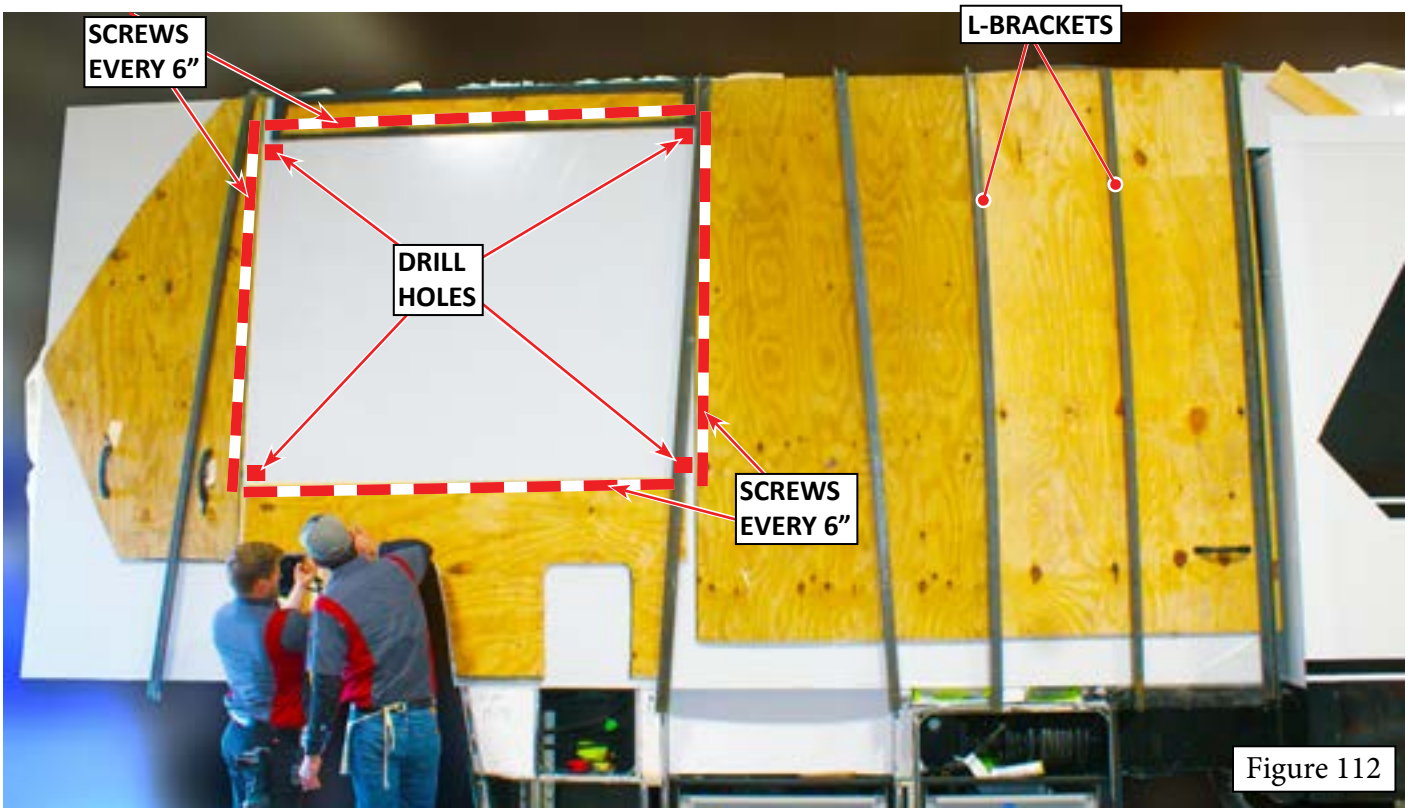


Figure 112

16. Use a pneumatic hand saw (or similar tool) to cut out the excess fiberglass from the 5th wheel alcove area (Figure 113a and 113b) and around the storage doors.


Figure 113a


Figure 113b

17. Once the front alcove is clear of excess fiberglass, attach the bottom of the front L-bracket to the pin box with a ratchet strap and pull it tight to compress the sidewall in that area (Figure 114).

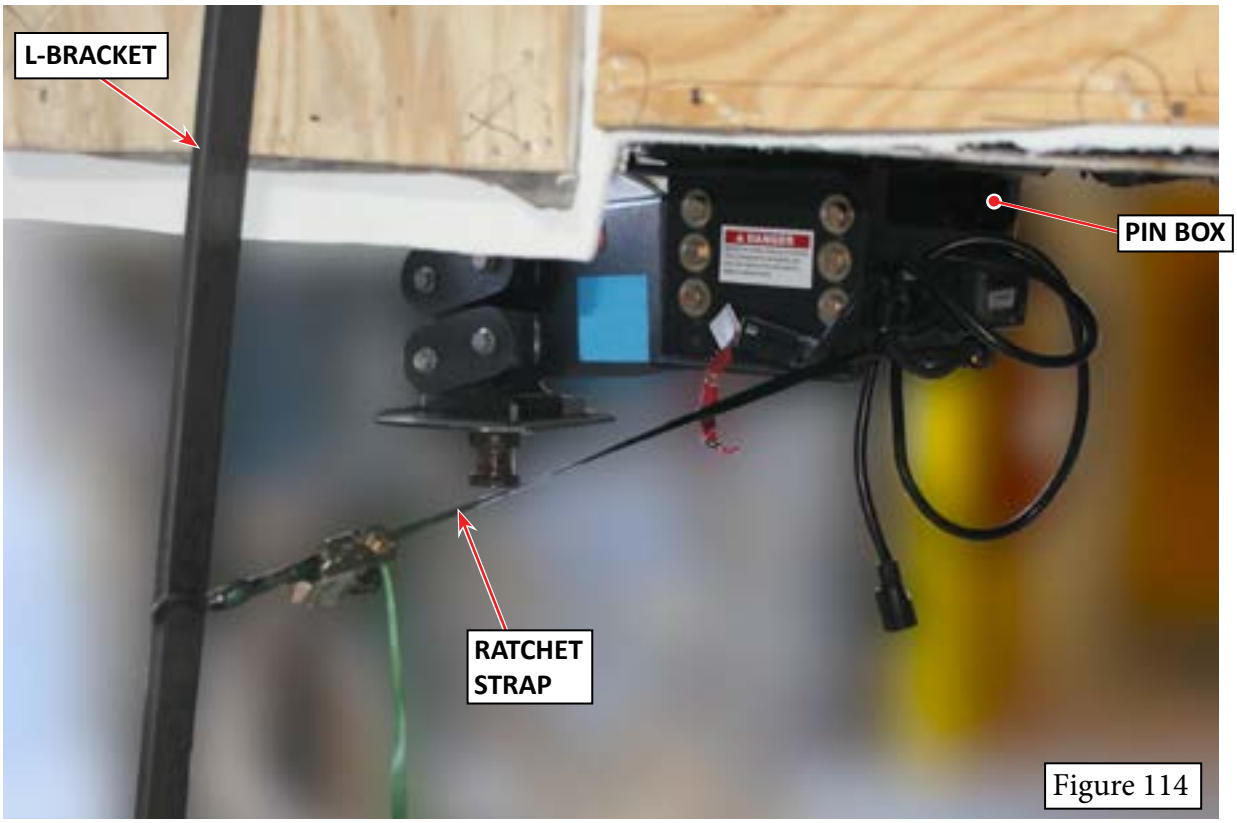


Figure 114

18. Insert shims between the L-brackets and plywood panels to provide additional pressure on the sidewall to further activate the adhesive (Figure 115a, 115b and 115c).

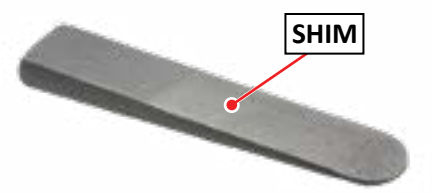




Figure 115a


Figure 115b

+ NOTICE

The cure time for the supplied adhesive is 24 hours. DO NOT remove bracing until cure time has passed.

**FIBERGLASS INSTALLED, BRACED AND SHIMMED FOR CURING (FIGURE 116)**


Figure 116

## REASSEMBLY AND PREP FOR PAINT

1. Once the adhesive has had sufficient time to cure, remove all of the L-brackets and plywood bracing from the side of the RV (not shown).

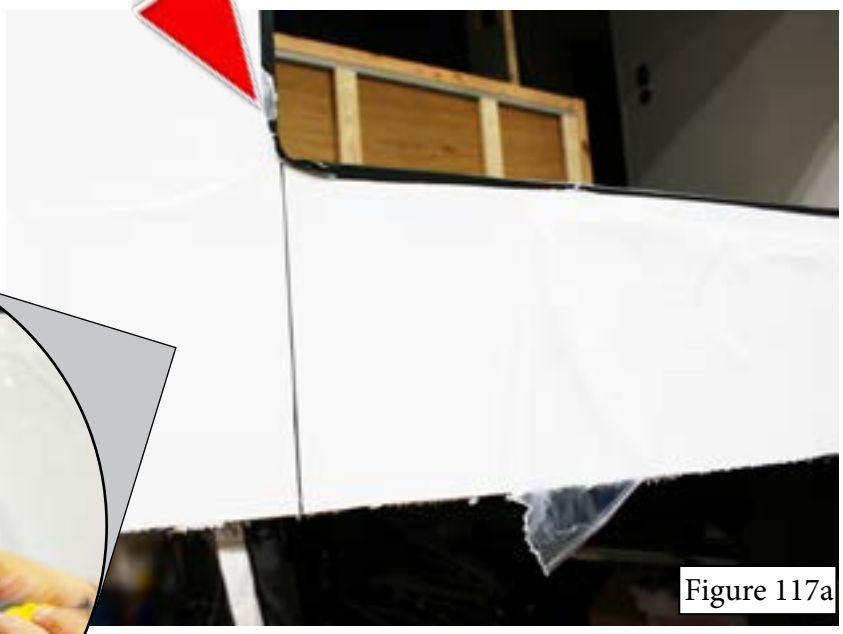


Figure 117a

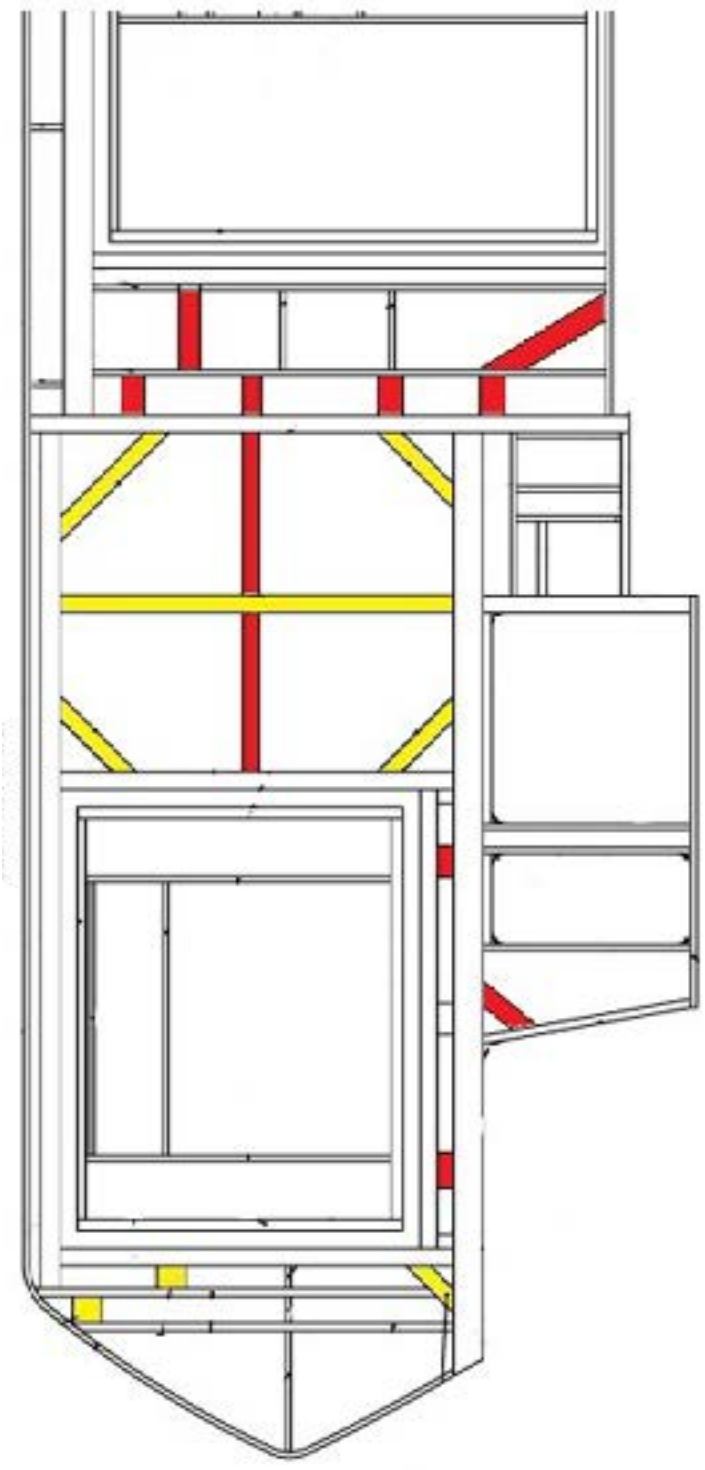
Figure 117b

2. Cut out the opening for the bedroom slide-out (not shown).
3. Using a hand held mini-saw, make a vertical relief cut at the front lower corner of the slide-out opening. Cut 3/16" deep to ensure ONLY the skin and backer are cut (full material depth is approximately 0.250" or 6.35mm) DO NOT cut into the metal sidewall structure under the skin. (Figure 117a and 117b).

**REASSEMBLY AND PREP FOR PAINT (CONT'D)**

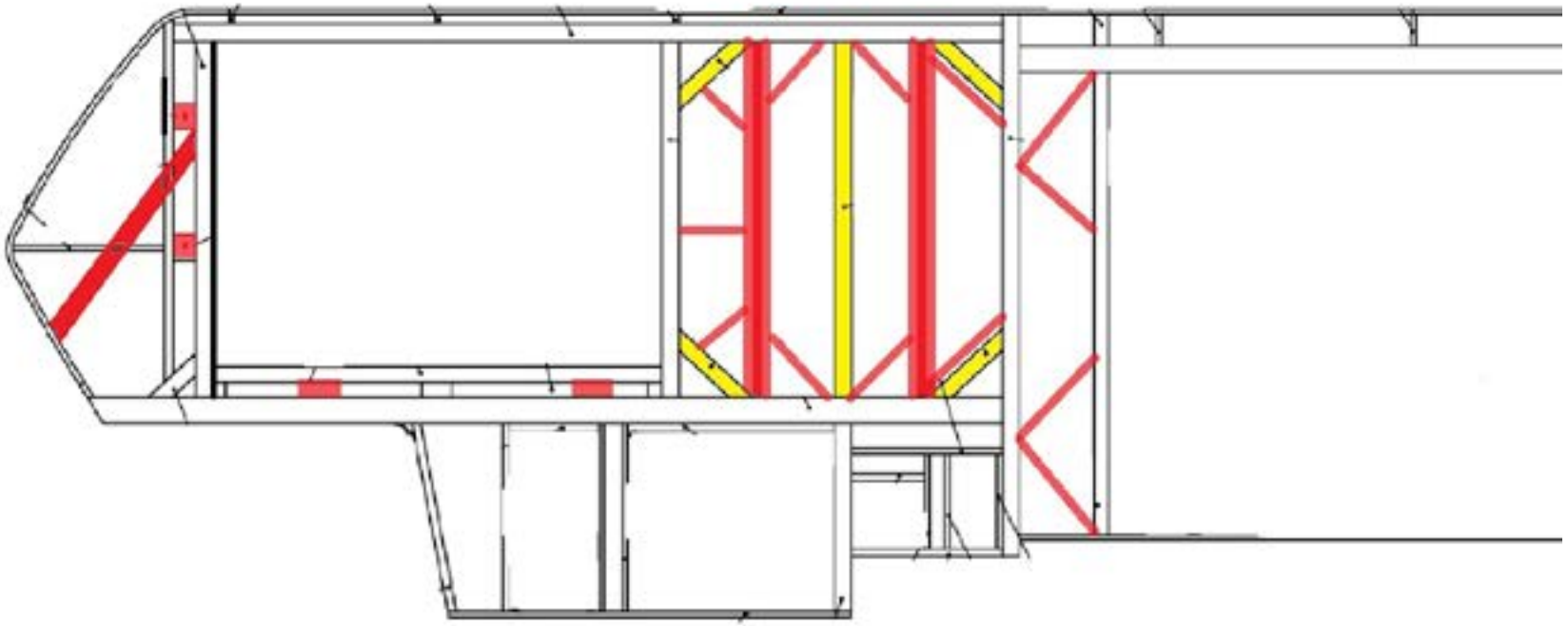
4. In preparation for fiberglass work and final application of paint and graphics, the following steps need to be performed. Refer to the prior removal instructions if there are questions about fit, measurements or fasteners.
    - Installation of the front cap - connect all wiring, then tuck the roof membrane along the back edge and sides of the cap prior to securing the cap in place. Install trim and seals prior to paint.
    - The roof membrane can be rolled over onto the sidewall, but should not be secured. DO NOT install the roof rail at this time. The roof rail must be loose for paint and fiberglass work.
    - Installation of the bedroom slide-out - all interior and exterior components of the bedroom slide-out should be installed, adjusted, and working properly when the unit goes to paint. The room should operate as normal, traveling completely in and out when sent to paint.
    - Installation of cargo and appliance doors - these should be secure, adjusted for proper operation and locking, sealed, and ready for paint prior to sending to the paint shop.
5. Perform body and paint work. Repair any defects in fiberglass, screw holes, and sealant prior to painting.
6. Install graphics as necessary.
7. Final inspection, leak test and detailed review of body work, paint and exterior sealants.
8. lnstallation complete. File claim through Brinkley Dealer Portal or through Brinkley Customer Care Department at CustomerCare@Brinkleyrv.com.

**G3500 WALL STRUCTURE**



| G3500 STRUCTURE COLOR KEY | | | |
|---|---|---|---|
| COLOR | EXISTING STRUCTURE | ADD IF NOT THERE | ADD STRUCTURE |
| WHITE | X | | |
| YELLOW | | X | |
| RED | | | X |

**G3250/G3950 / G4000**
**WALL STRUCTURE**



| G3250 / G3950 / G4000 STRUCTURE COLOR KEY | | | |
|---|---|---|---|
| COLOR | EXISTING STRUCTURE | ADD IF NOT THERE | ADD STRUCTURE |
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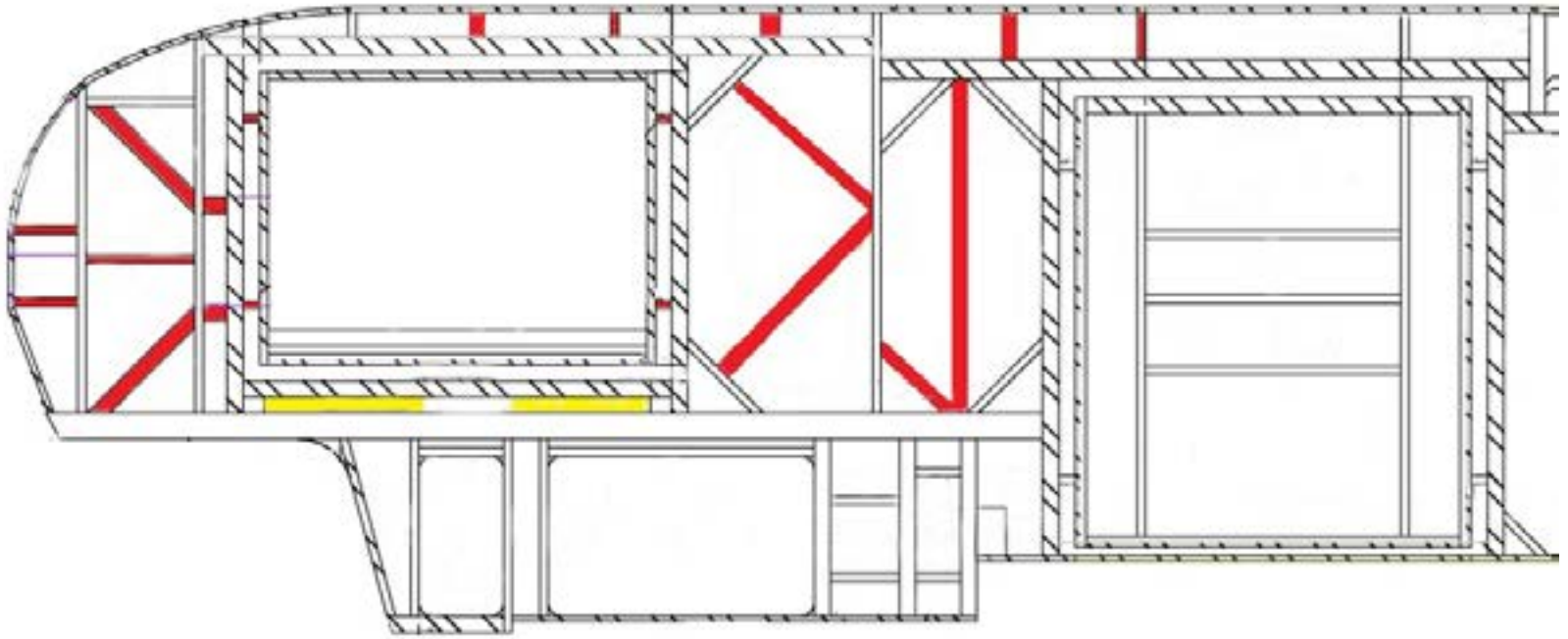
| YELLOW | | X | |
| RED | | | X |

## Z3610 WALL STRUCTURE



| Z3610 STRUCTURE COLOR KEY | | | |
|---|---|---|---|
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| YELLOW | | X | |
| RED | | | X |

## ADDITIONAL VENDOR INFORMATION ACCESS

Additional information is available on various systems and components you may encounter while performing the repairs in this document. The QR codes listed below provide links to the various manufacturer's service and/or installation information. **If there is a discrepancy between the instructions provided by Brinkley in this document and the component manufacturers information, default to the component manufacturers instructions.**

If you have additional questions, please contact Brinkley Customer Care at 888-502-3460, or 574-501-4280, Mon-Fri, 8AM to 5 PM EST, or email: "CustomerCare@BrinkleyRV.com".

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**Lippert Slim-Rack Slide-Out Progamming, Installation and Service Manual**

**Installation and Service Instructions**

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**KORAPUR urethane adhesive sealant (Brinkley P/N 112154)**
**Adhesive Information**

**General Information**

**Safety Data Sheet**

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**EternaBond MicroSealant Tape (Brinkley P/N 102489)**
**Information**

**Installation Instructions**

**Safety Data Sheet**