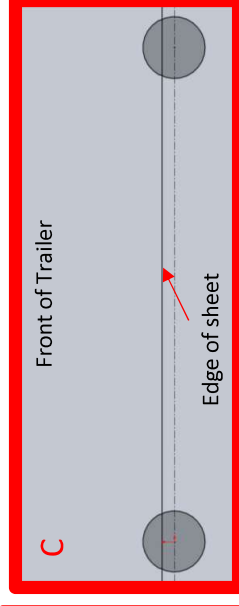
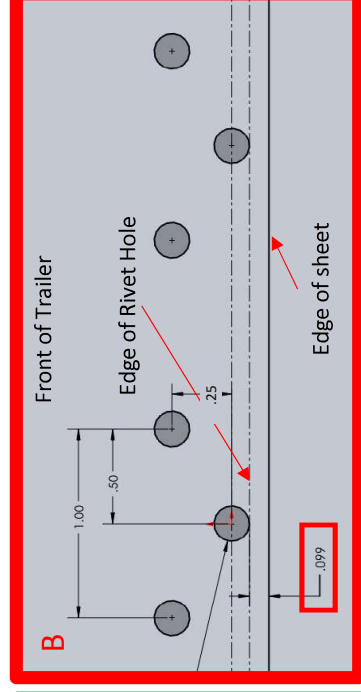
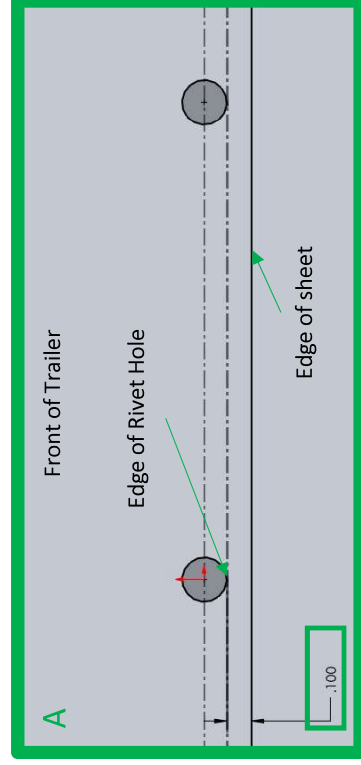


Repair Rivet Process

When inspecting trailer roof to rear frame header for flushness determine the rework steps using the following:

1. After removing the j mould inspect for caulking and foam tape underneath roof sheet. Apply if missing
2. Measure each hole using calipers from edge of rivet hole to the edge of the roof sheet.
 - A. If roof sheet extends more than .100" on all rivet holes, install j mould, and go to step 6
 - B. If roof sheet extends less than 0.100" but extends past centerline of rivet hole, put a tick mark above the rivet so that the position will be visible after j mould installation. Go to step 3
 - C. If roof sheet does not extend past the centerline of the rivet holes contact warranty / corporate quality
3. Clean surface of roof and j mould. Apply Manus 2-part epoxy (42301421 & 42301422) and install j mould
4. Mark/measure 2 points that are $\frac{1}{4}$ " toward front of trailer spaced 1" apart centered over the rivet.
5. Drill hole for 42204302 magna lock, dunk 42204302 magna lock in caulking and install into header
6. Reseal edges using caulking and cover tops of rivets using neoprene
7. Caulk inside of trailer header to roof sheet



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