

XLII SLIDE-OUT SIDE PANELS FASTENING

MATERIAL

Kit #470035 includes the following parts:

Part No.	Description	Qty
502872	Rivet, pop 1/8" X 0.313	40
D470731	Diagram	1
IS-06028	Instruction Sheet	1

PROCEDURE

⚠ WARNING ⚠

Park vehicle safely, apply parking brake, stop engine and set battery master switch(es) to the OFF position prior to working on the vehicle.



REQUIRED TOOLS

Part No.	Description	Qty
684217	Drilling jig	1 per customer
680532	Sikaflex 221 gray 305 ml (10.3 oz)	1 per customer
680673	Rivet countersinking bit, 120° angle	1 per 15-20 vehicles
683097	Sika Cleaner 205 1L (33oz)	1 per customer
683131	Drill bit #30	1 per 2 vehicles

NOTE

Material can be obtained through regular channels.

1. Extend the slide-out to its full "out" position.
2. Place a masking tape strip on the lower side of the slide-out as shown on figure 1. This masking tape strip will be used to mark drilling jig positional references (fig 2).
3. Using a pencil, mark the drilling positions on the masking tape using the drilling jig. Always measure from the slide-out face panel. Position the first reference mark 1 inch from the face panel. Position the second mark with the 2nd notch on the drilling jig (see figure 2). Position other drilling reference marks according to figure 5 (9 holes/side on the front slide-out, 7 holes/side on the rear slide-out). For the

front slide-out, it may be difficult to drill the 9th hole because of interference between the drill, the riveting tool and the rubber fender trim. If it's the case, avoid this drilling.

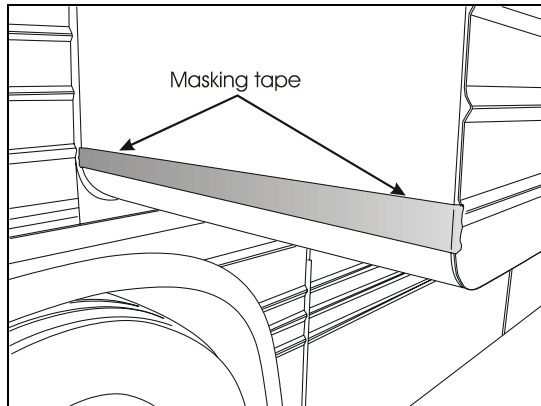


FIGURE 1: MASKING TAPE POSITON

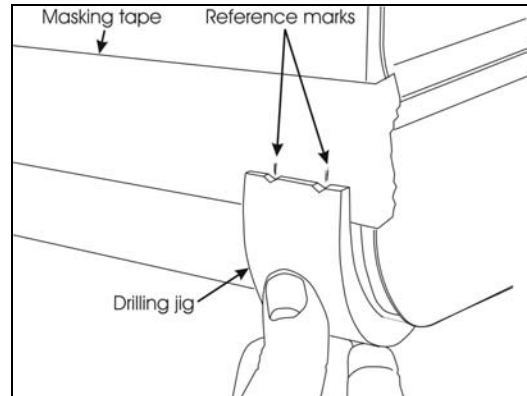


FIGURE 2: FIRST & SECOND REFERENCE MARKS

4. Position drill bit #30 (P/N 683131) into the chuck so it doesn't exceed the drilling jig more than 15/32" (12mm) (figure 3). This must be done in order to avoid contact between the drill bit and internal rib of the aluminum extrusion.

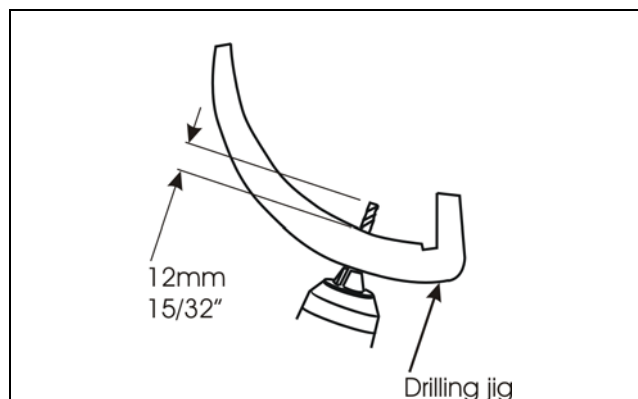


FIGURE 3: PROPER DRILL BIT POSITION IN CHUCK

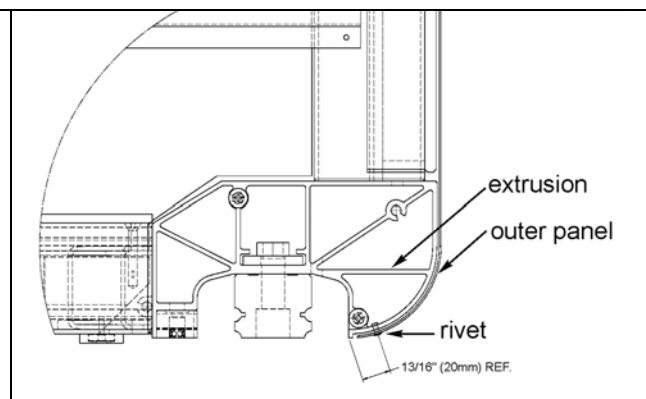


FIGURE 4

NOTE

For the next steps, if you notice a loss of adhesion of the slide-out outer panel, proceed to the drilling and countersinking of one hole and then install the corresponding rivet. Once done, you can proceed with the next drilling.

⚠ CAUTION ⚠

It is essential to use the drilling jig to perform appropriate drillings. If not, holes in the metal sheet and the extrusion may not coincide, for this reason, rivets may be difficult to install. Also, the metal sheet may not be perfectly in contact with the aluminum extrusion once riveted and buckling may remain.

5. Position the drilling jig with the first two reference marks. Press firmly on the drilling jig to make sure that the outer panel is leaning against the extrusion, there must be no gap between the outer panel and the extrusion.
6. Drill the first hole using the jig bushing. While doing this, keep pressure on the metal sheet to hold it against the extrusion.

NOTE

While doing the countersink, hold the drill perpendicular to the surface in order to have a perfectly round countersink.

7. Countersink the rivet hole to 120° in order to have a diameter of 0.297" (7.5mm). The rivet head must be flush with the metal sheet surface.
8. Put a small quantity of gray Sikaflex 221 (P/N 680532) inside the hole. Put a small quantity of Sikaflex under the rivet head and install it. Fill the rivet center hole with Sikaflex and with a clean cloth, remove excess of Sikaflex. Clean surface with Sika Cleaner 205 (P/N 683097).
9. Repeat the previous steps to complete the next drilling and so on.

NOTE

Install rivets on each side of the front and rear slide-outs.

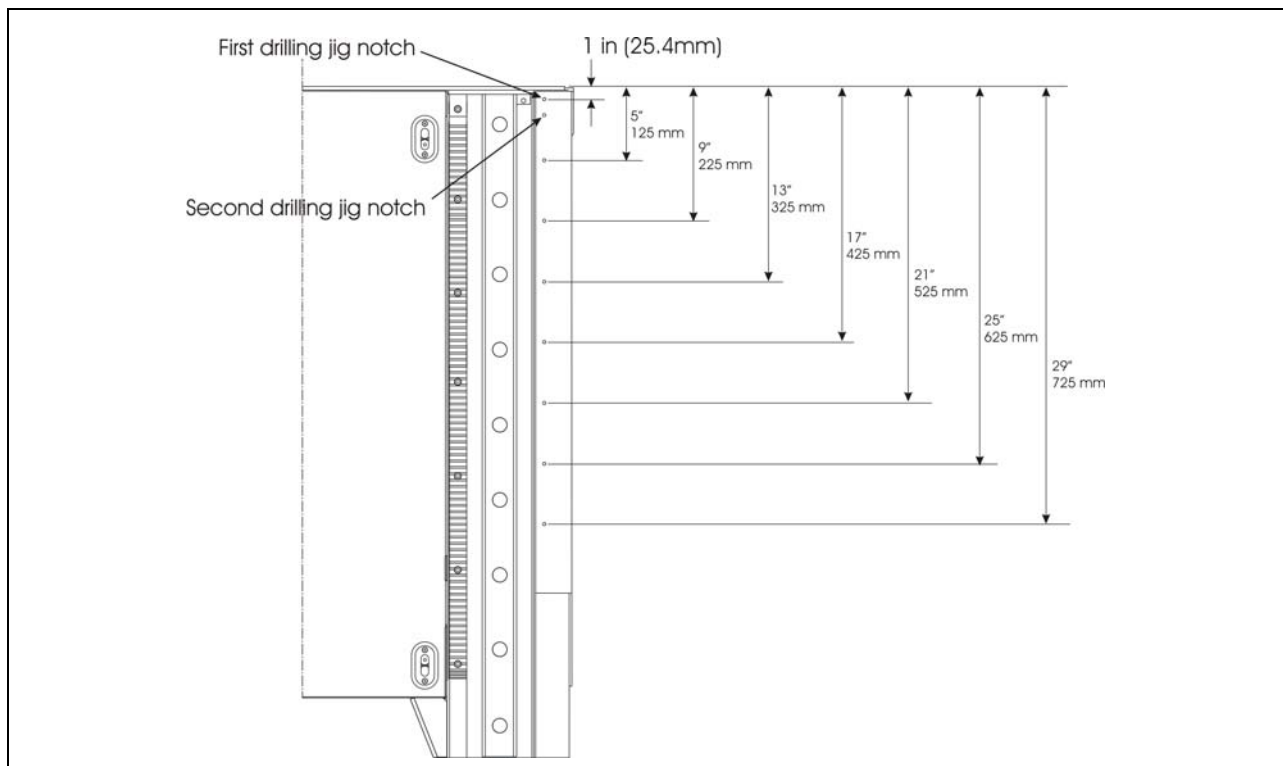


FIGURE 5: DRILLING POSITIONS FOR FRONT & REAR SLIDE-OUT. SKIP 9TH & 8TH HOLE ON REAR SLIDE-OUT AND 9TH HOLE ON ENTERTAINER'S SLIDE-OUT. ALL DIMENSIONS ± 1/16".

If side panel replacement is required, use the following parts:

Part No.	Description	Qty
470031	XLII-45 MTH pre-drilled side panel (front slide-out)	2
470034	XLII-45 MTH pre-drilled side panel (rear slide-out)	2
470032	Entertainer pre-drilled slide-out side panel (engine side)	1
470033	Entertainer pre-drilled slide-out side panel (driver side)	1