

DOORS

Purpose

This document outlines the procedures to replace two side extrusions or side and top extrusions on a rear ramp door. If more than two extrusions need to be replaced or if the bottom or hinge side extrusion is to be replaced, contact Lippert. The procedure is only applicable to ramp doors with corner keys and external fasteners.

Safety

⚠ CAUTION

The "CAUTION" symbol above is a sign that a procedure has a safety risk involved that may cause personal injury and/or product damage, including voiding of warranty, if not performed safely and in accordance with the safety procedures stated herein.

⚠ CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

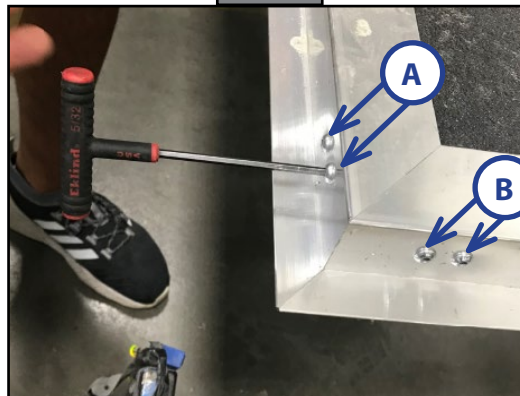
Resources Required

- Replacement extrusions, maximum of two
- Cordless or electric drill or screw gun
- Appropriate drive bits
- $\frac{5}{32}$ " T-handle
- Rubber mallet
- Five-way tool
- Putty knife
- Screw extractor
- White gunnable glue
- Glue gun
- Caulk
- Caulk gun
- Clamps

Procedure

1. Use T-handle to remove screws on the corner keys from each end of the damaged extrusion to be replaced (Fig. 1A).

Fig. 1

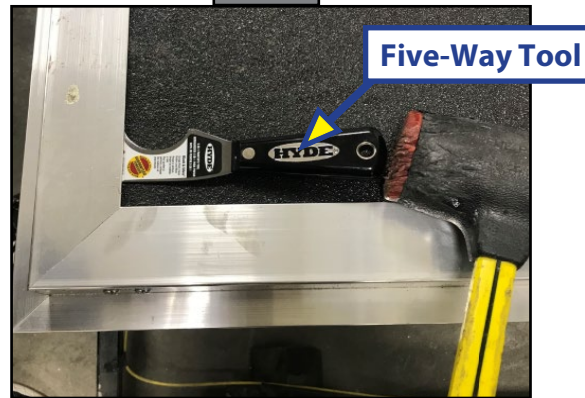


2. Remove the screws from the adjacent extrusion (Fig. 1B) so the damaged extrusion can slide out.

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3. On the interior side of the door, slide a five-way tool under the extrusion channels and tap with a rubber mallet every 4" along the channel to loosen the extrusion from the core (Fig. 2).

Fig. 2

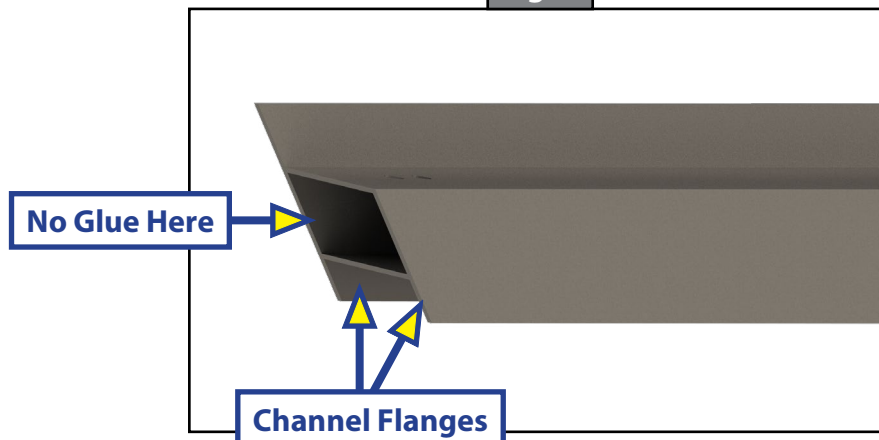


4. If the tool and tapping procedure doesn't break the extrusion free, turn the door over and repeat the procedure on the exterior side of the door.

NOTE: Take care not to scratch the fiberglass.

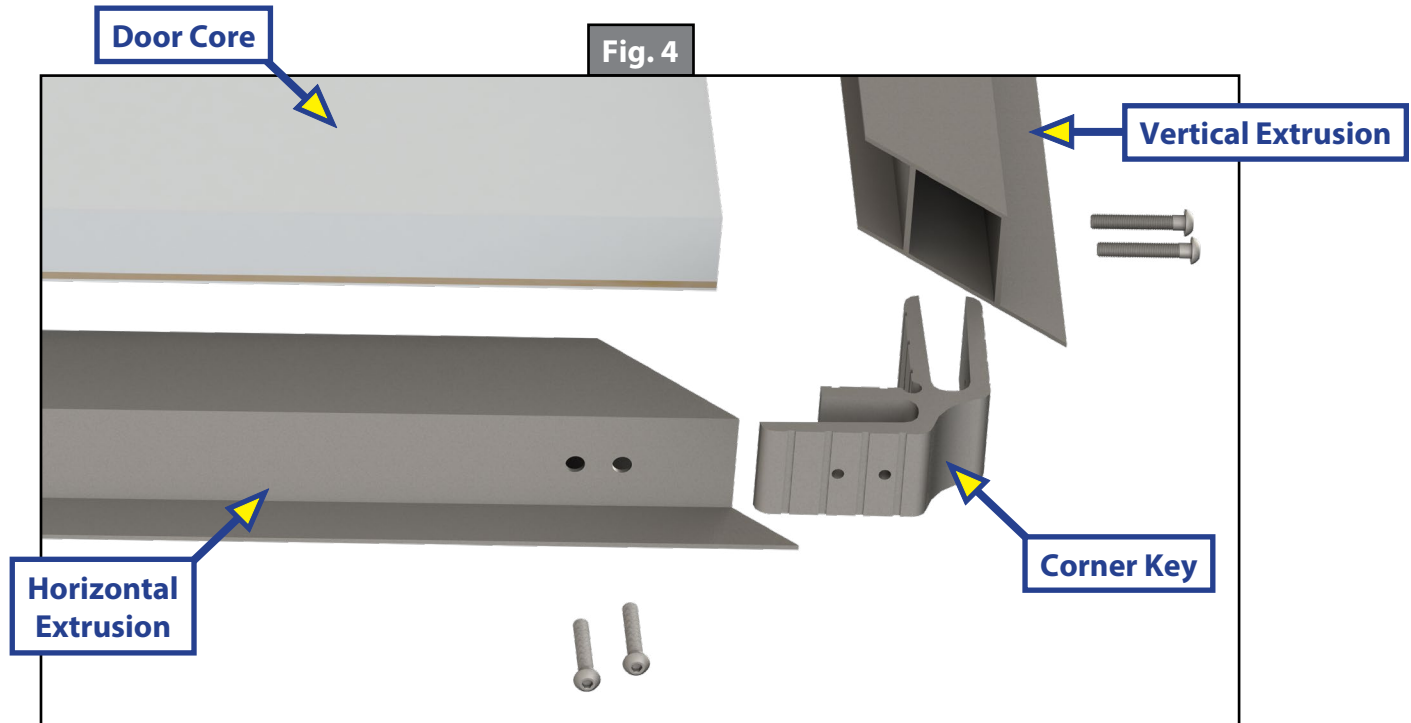
5. Remove as much glue as possible without damaging the anti-skid black structure. Make sure that the corner key is removed from the old extrusion.
6. Use a putty knife to remove remaining glue from the exterior side of the core.
7. Apply white glue end to end on both sides of the inside lip on the extrusion channels without leaving voids. The glue must be located only on the inside of the channel flanges (Fig. 3) and not in the corners.

Fig. 3

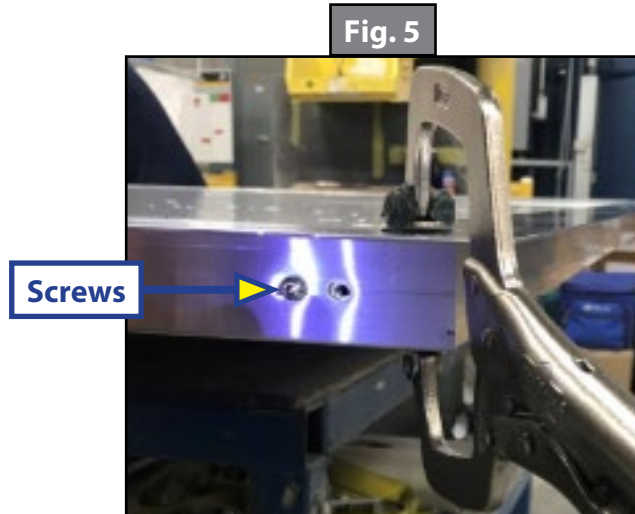


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8. Place corner keys into the ends of extrusions (Fig. 4) and then install the extrusion on the edge of the core. Seat extrusion with a rubber mallet. Corners must line up.



9. Make sure corner keys are fully seated into the ends of the corresponding extrusions.
10. Install screws through the extrusions (Fig. 5). The screws must be installed flush with the extrusions.
11. Using a caulk gun, reapply caulk on the seams on both sides of the door.





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Follow proper safety practices. If in doubt, consult a professional RV technician.