



Form 220  
Rev A 8-2015

## Endura Plexiglass Installation Instructions

### All Widths & Lengths Trailers



- Always wear protective clothing and eyewear when operating tools.
- Observe safe tool operation as specified in tool operating instructions.

Locate and identify all components supplied with the Endura Plex Hardware Kit.

Quantity	Description
8	Foam Fillers
6	Door Fillers
50	Rubber Retainers
1	Drill guide



#### Tools required

Drill  
1/8" drill bit  
1/2" spade drill bit  
Saw to cut plex strip to length

In addition to the plex hardware kit, you will need the correct amount of Plexiglass (acrylic sheet) or other suitable filler material to fill the openings of the trailer. The plex track integrated in the trailer side is designed for 3/16" thick material. For standard Endura side openings, the plex should be cut to 7-3/16" width strips and is typically 96" long. Plex material 7-3/16" x 96" is available from Hillsboro Industries.

For best results, we recommend the butt joints between plex pieces be factory cut edges.

1. Install door fillers at each side of the escape door and rear gate openings, including roller door. To install the door fillers remove the liner for the adhesive tape of the door filler. Carefully place the filler against the inside-facing surface of the outer flange of the vertical member at the end of each door opening, See Figure 1.
2. Install the foam fillers at each end of the sidewall openings. Remove the liner from the foam filler and place the adhesive side against the forward or rearward-facing surface of the trough at each end of the sidewall openings. See Figure 2. On the trailer side with the escape door, the foam fillers will be placed in the side wall openings behind the escape door.



Figure 1

Door filler  
Placed at each end of  
escape door and rear  
gate openings.

Foam filler  
Placed at each end of  
sidewall openings

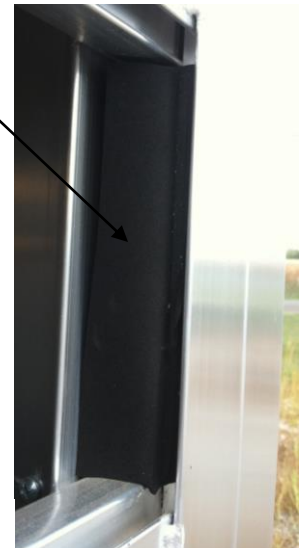
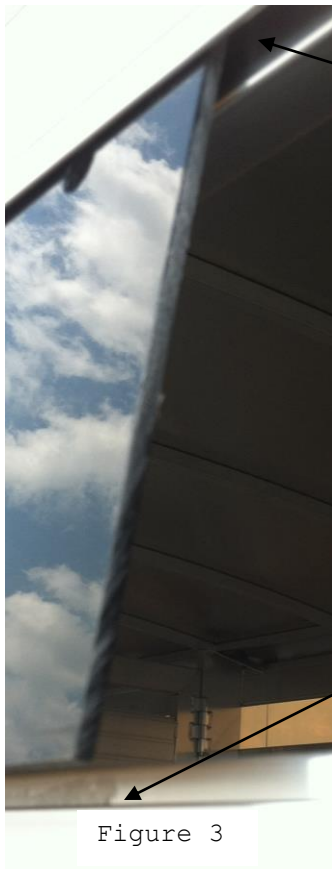


Figure 2

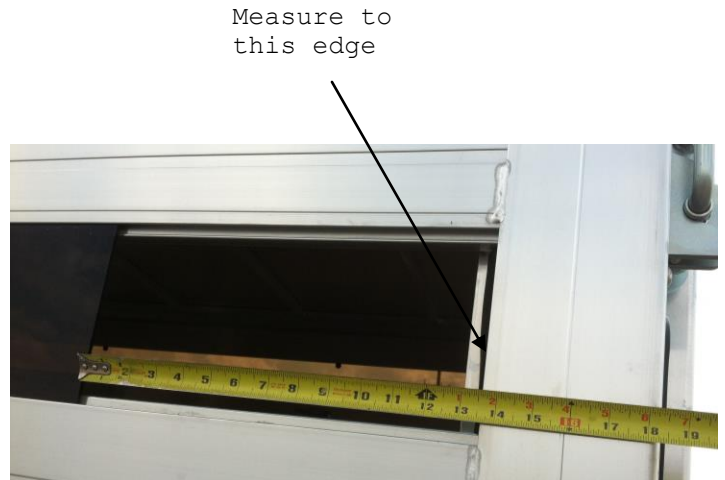
3. Make sure the plex slot at the bottom of the trailer sidewall openings do not contain dirt or debris. Install the first 96" plex filler in the trailer sidewall by placing the upper edge of the plex in the slot at the top of the trailer sidewall opening. Lift the plex until the bottom edge can be slid over the lip at the bottom of the trailer sidewall opening. The plex will then drop into the slot in the sidewall at the bottom of the trailer sidewall opening. The top of the plex should remain in the upper slot. See Figure 3.



Insert top  
edge of plex  
into slot

Lift plex  
until bottom  
edge clears  
lip, move  
plex in and  
drop into  
slot

Figure 3



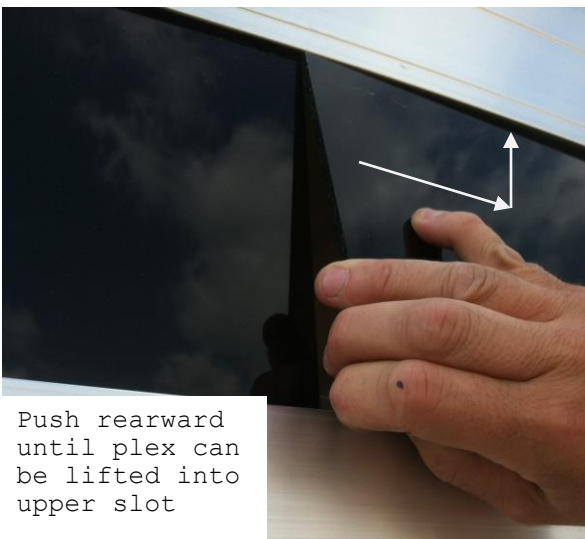
Measure to  
this edge

Figure 4

4. Slide the installed plex until it just touches the foam filler of the front of the trailer sidewall opening. Continue to install plex pieces until the remaining gap length is less than 96". Measure the distance from the rear edge of the last plex piece to the edge of the lip at the rear stake, cut a plex piece to this dimension. See Figure 4.
5. To install the rearmost piece of plex, remove the plex immediately in front of the rearmost piece, then install the rear piece and slide rearward against the foam filler. See Figure 5. Install the last plex piece in the remaining gap by placing rear upper corner in the plex slot at the top of the trailer sidewall opening. See figure 6. Using the plex being installed, push rearward to compress the rear piece of plex into the foam filler. Once the front upper corner of the plex being installed clears the rear edge of the next plex forward, slide the upper edge into the plex slot at the top of the opening. See Figure 7. Finish installing the plex by tilting the bottom inward until the bottom edge can be slid down into the plex slot at the bottom.



Figure 5



Push rearward  
until plex  
can be lifted  
into  
upper slot

Figure 7



Insert rear  
corner into  
upper slot

Figure 6

6. Measure the gap between vertical members of the escape door and rear gates. Cut plex pieces  $\frac{1}{8}$ " less than the measured dimensions for each gap. See Figure 8.

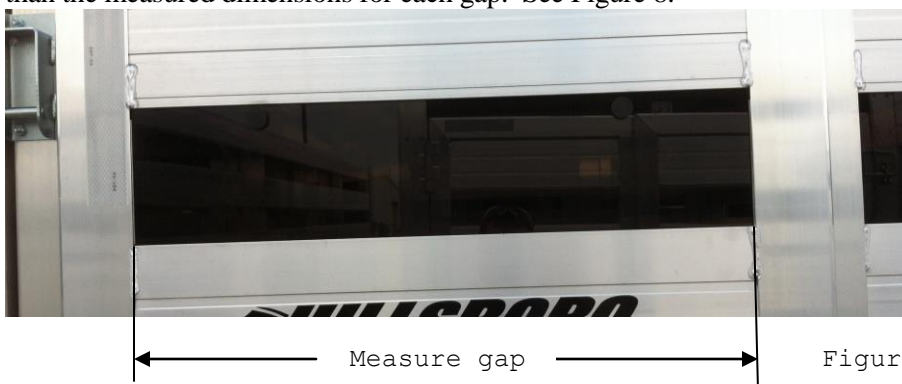


Figure 8

7. For plex pieces 96" long, position the drill guide on the plex with HOLE AT THE TOP and the drill guide up against the lip at the top of the trailer sidewall opening and 24" from one end of the plex. See Figure 9. Using the hole in the drill guide, drill 1/8" hole through plex, repeat at other end of plex piece. For plex pieces less than 96" long, position the drill guide 6" from one end of the plex, repeat at each end. Repeat this drill operation on each piece of plex, including escape door and rear gates.
8. For best results, plex pieces should always be installed in the same locations. Remove the plex from the trailer and drill 1/2" holes at all pilot drill locations. For best results deburr the hole edges on both sides of plex. The drill guide can be used as a debur tool as shown in Figure 10. Insert a corner of the drill guide and rotate with medium pressure against the plex. Remove protective cover from plex.



Figure 9



Figure 10

9. Reinstall all plex pieces in their original locations. Secure the plex in the trailer by installing the rubber retainers from the outside of the trailer in each of the 1/2" holes in the plex. See Figure 11. Twisting the rubber retainers while pressing them into the hole helps to seat them. Check that the rubber retainers restrict the plex from moving upward far enough to allow the plex to come out of the bottom slot.



Figure 11