

FRAMES AND CHASSIS

Preparation

THIS REPAIR SHOULD ONLY BE COMPLETED BY AN AUTHORIZED SERVICE TECHNICIAN.

▲WARNING

Remove all flammable material from the area to be welded. Any remaining flammable material that cannot be removed **MUST** be protected. Proper fire protection and control measures should be kept on hand.

▲WARNING

Lift coach by the frame and never the axle or suspension. Do not go under the coach unless it is properly supported by jack stands. Unsupported coaches can fall and may result in death, serious injury or property damage.

NOTE: In this service form dashed red lines indicate using a die grinder to remove components and solid red lines indicate using a welder to add components per instructions and image references.

Tools Required

- Die Grinder and Cut Wheel Attachments
- Welder
- Welding PPE (Helmet, Gloves, Sleeves, Etc.)
- Jack Stands
- Black Spray Paint (If Necessary)

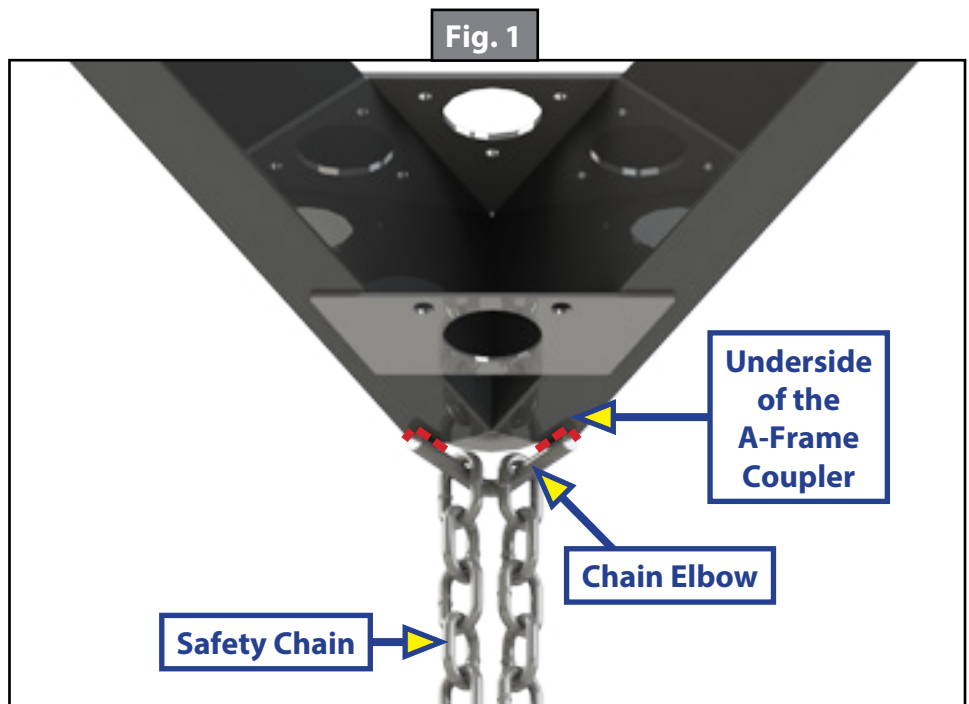
Hardware Required

- Safety Chains
- Chain Elbow

NOTE: The part numbers for the hardware will be different based on the trailer being repaired due to varying lengths and weight ratings.

Procedure

1. Use the die grinder with the cutting wheel attachment to remove the existing chain elbow from the underside of the A-frame coupler (Fig. 1).
2. The existing safety chains can be set aside with the chain elbow.



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3. Use the die grinder and grinding wheel attachment to grind the cut areas smooth (Fig. 2).
4. Feed the last link of each of the new safety chains onto the new chain elbow (Fig. 3).
5. Center the chain elbow and safety chain assembly under the A-frame coupler so that the ends of the chain elbow are touching the ends of the two A-frame tubes. The elbow should be pointing away from the trailer.

NOTE: Ensure that the new safety chains are not pinched between the chain elbow and the coupler. The safety chains **MUST** be able to move freely.

6. Weld each end of the chain elbow to the A-frame tubes completely (Fig. 4 and 5).
7. Test the movement ability of the safety chains to make sure they are able to move freely.
8. Spray paint any visible areas of the repair with black spray paint.

