



RECALL CAMPAIGN

NHTSA# 18V072

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TC# 2018-070

Job Code 9901372

Series/Flat Rate .5 Hr

REQUIRES PARTS KIT

ACTION REQUIRED

Remove underrated 11,700 lbs safety chains and replace with 16,200 lbs safety chains.

AFFECTED UNITS

2017-2018 Eagle 333BHOK (EC)

H1EC0050-0098

J1EC0051-104

PARTS KIT

18V-072

Note: Kit can only be ordered using the order form included with this bulletin.

2 - Safety chains 16,200lbs 27 inch length

2 - Chain Elbows

Misc. Tools and Supplies

4-1/2" Grinder with cutoff wheels

Welder

Welding gloves and helmet

Safety glasses

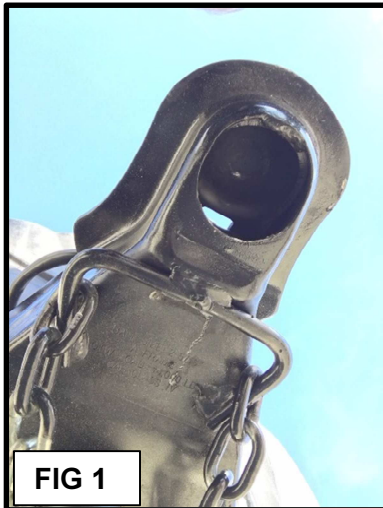
Chain Elbow



16,200lb tag

Repair must be completed by a qualified welder, typically an individual that has been trained and certified to perform this type of welding by a recognized authority, such as American Welding Society.

INSTALLATION OF TWO ELBOWS ON BOTTOM MOUNTED COUPLER



Step 1:

FIG 1: Locate the safety chains and the chain elbow under the hitch coupler.

FIG 2: Hang chains off the sides of the elbow as shown.

Use the grinder and cut the elbow in the locations shown.

WARNING: Wear safety glasses and gloves to prevent injury from flying debris.

KEEP CHAINS AWAY FROM AREA YOU ARE CUTTING.

Step 2:

After cutting the elbow in 2 locations, slide the 2 chains off the elbows.

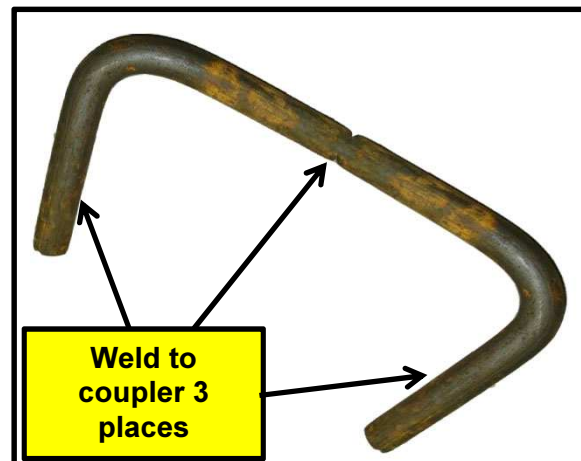
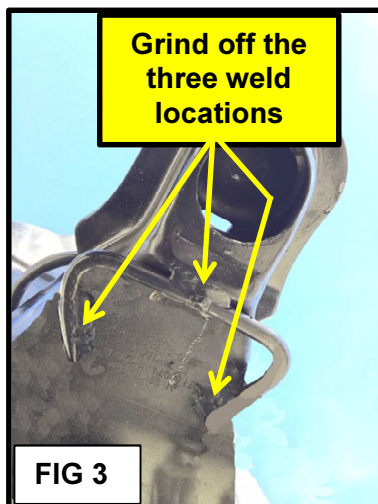


FIG 3: Grind off the three weld locations where the elbow was attached to the coupler.

The old welds must be ground off smooth for re-attaching new elbows.

Discard the old elbow pieces.

FIG 4: Place 2 new elbows configured as shown here on the coupler.

The 2 new elbows should be positioned to look the same as in Fig 3.

Slide a replacement chain on each elbow piece.

Lay the center joint of the elbows on the higher part of the coupler.

Chains *MUST* be free to move on each elbow piece

Weld the tail pieces of the elbows to the coupler.

Welds are recommended to be 100% - 1/4" fillet all sides.

Step 3:

Weld the center joint of the elbows to the higher part of the coupler.
All welds must be welded inside and outside each elbow.

CHAINS MUST BE FREE TO MOVE.



Step 4:

FIG 7: The new chains and elbows should look similar to picture.

One chain on each elbow, and the junction of the two elbows welded to the higher part of coupler.

Step 5:

Once welds have cooled, paint all welds and elbows with a good quality black paint (like Rustoleum).
Make sure chains are free to move.