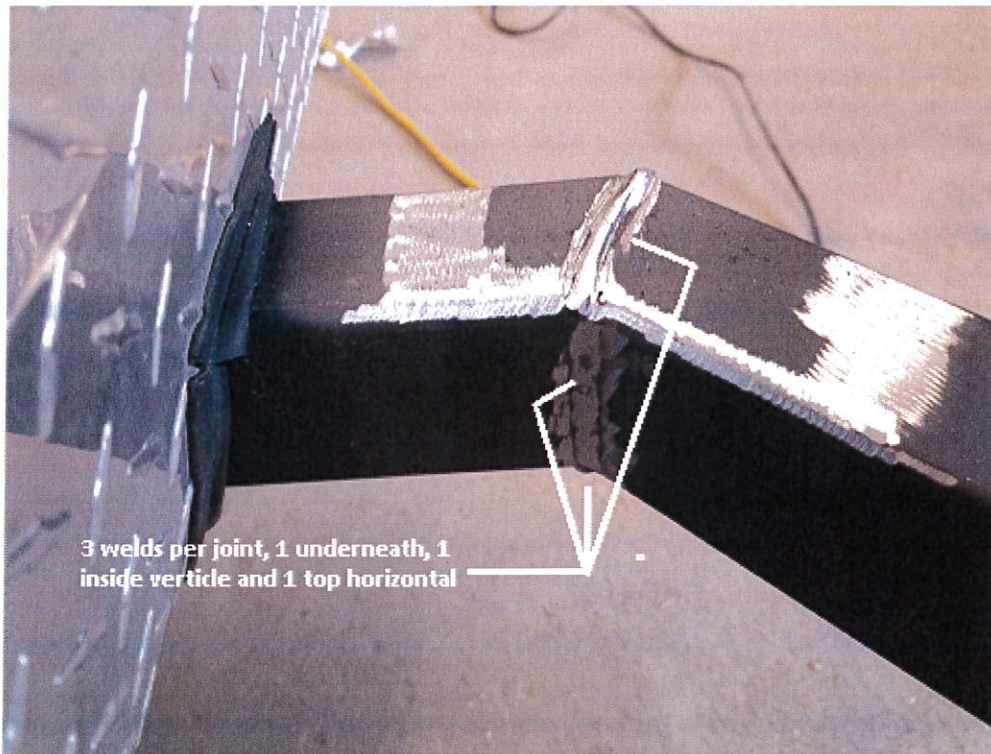


CHESAPEAKE/NEWPORT
FRAME REPAIR
INSTRUCTIONS

ALINER

The following instructions are to repair the Somerset/Aliner Chesapeake/Newport frames, these instructions are to assist the person making the repairs. CNW suggests that these repairs are carried out according to the instructions provided and performed by a certified welder. These modifications are to strengthen the welded joints to prevent them from failure.

The first step is to inspect all the welds correlating to the front tongue at each point per joint as (pictured here)



at 4 points per camper tongue.

After inspection of these joints show any type of crack, these 3 areas will need to be cleaned and re-welded before proceeding to the next steps in this manual.

Note: If your camper tongues are not welded but have bent tube tongues, these repairs are not necessary for your vehicle.

(Fig. 1) is the kit provided to repair the welded joints on the front of the campers tongue as shown in (Fig. 3), each side has a designation as to road side and curb side also shown in (Fig. 3), the corresponding brackets are shown in (Fig. 1) as to their designation.

(Fig. 4) shows the breakaway switch, this switch will need to be removed temporarily to proceed with the prep work as described later in this manual.

(Fig. 5) shows the road side bracket set into place with a traced outline of this bracket onto the frame, (Fig. 6) simply shows the traced outline once the bracket is removed. This outline gives you a reference as to where the paint will need to be removed to prep this area for welding. Once the area is completely paint free as shown in (Fig's 7 & 8), the brackets are now set into place with a weld splatter shield as shown in (Fig. 9), this shield will prevent weld splatter from damaging the front panel of the camper and is provided in the repair kit.

(Fig. 10) shows where the entire perimeter of the supplied bracket will be welded, (Fig. 11) shows this is a vertical down weld overlapping the existing weld for added strength. **Note: before any welds are to be done on the roadside bracket closest to the front of the camper wall, have a bucket of cold water handy with a rag. This bracket must be cooled immediately after each individual weld around the perimeter of this bracket, inside this frame tube on the road side only is a bargeman cable that runs from the front of tongue of the camper to the rear of the camper, this cooling process will keep from damaging this cable with the heat generated during the welding process, failure to do so as instructed will damage the cable and will need replaced. The curbside is free of any cables and will not need to be cooled as in the same manner the road side does.**

(Fig. 12) depicts the placement of the front gusset plates as provided in your kit, this is to be set into place and traced out as shown in (Fig. 13). The next step is to clean these surfaces free of paint as shown in (Fig. 14).

(Fig. 15) shows the front bracket welded into place and it is welded completely around the perimeter of the plate. After all welding has taken place, all surfaces

are to be ground smooth as shown in (Fig. 16), after welds have cooled to the touch, all bare metal is to be prime coated with a red oxide steel primer as shown in (Fig. 17 & 18), noting the splatter shield being used for overspray at this point and is supplied in your repair kit as well. (Fig. 19) shows the finished job complete with a coat or 2 of a flat black rustoleum paint or equivalent.

After all repairs are made, the breakaway switch will need re-installed, it will need to be attached to the upper half of the tube 2-1/2" back from its original location to clear the newly installed gusset plate you have just installed, make sure it is attached to the upper portion of the tube from its original location at the bottom portion of the tube, this will prevent the mounting screw from damaging the cable running inside this frame tube when it is screwed in.

Lastly the Propane warning sticker supplied will need to be re-installed in its original location if it were damaged or removed in the process.

Note to welder: The frame tubing thickness is 1/8"

If your camper has already failed at any joint to the point beyond a cracked tube, please consult your local weldshop as to a permanent fix to this problem and consult with our customer service department on how to proceed with the necessary repairs.

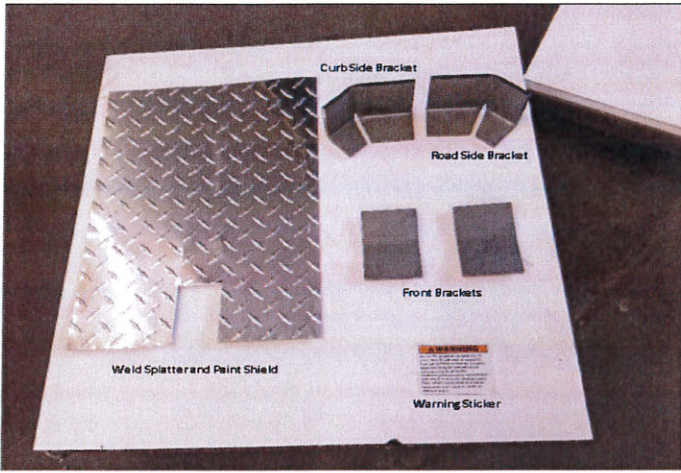
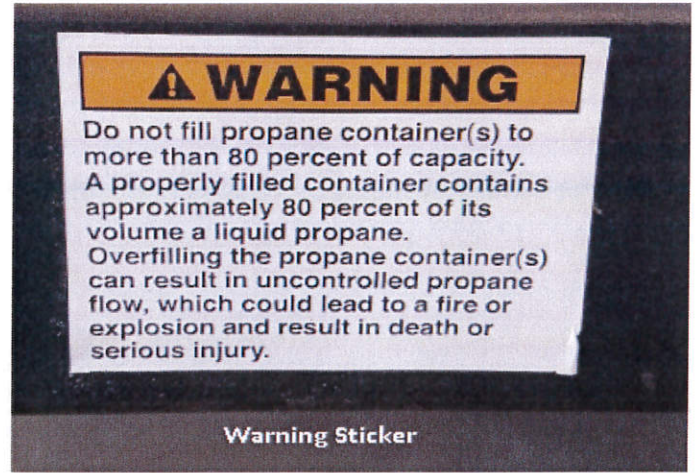


FIG 1



Warning Sticker

FIG 2

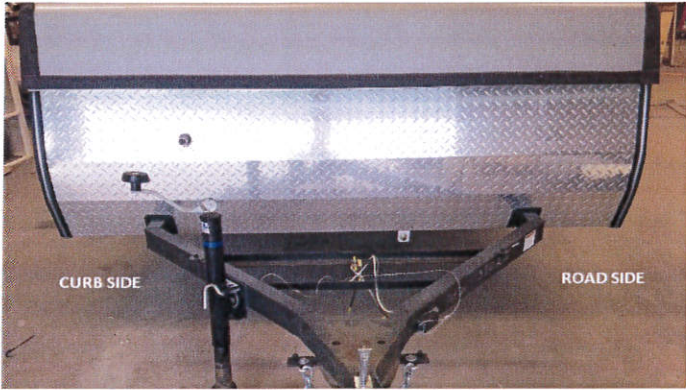


FIG 3

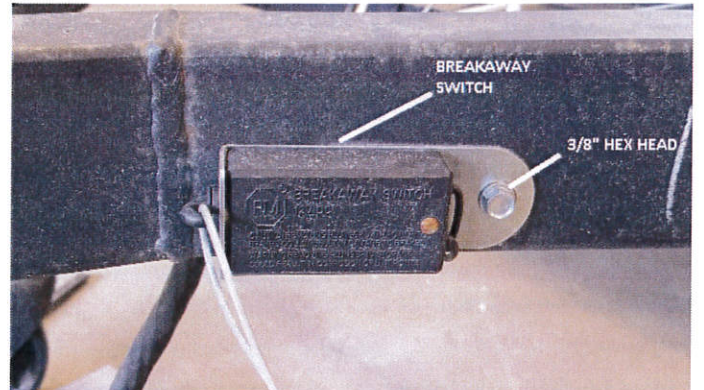


FIG 4

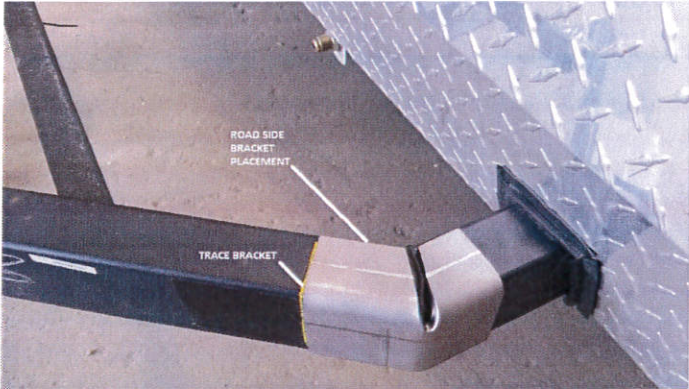


FIG 5

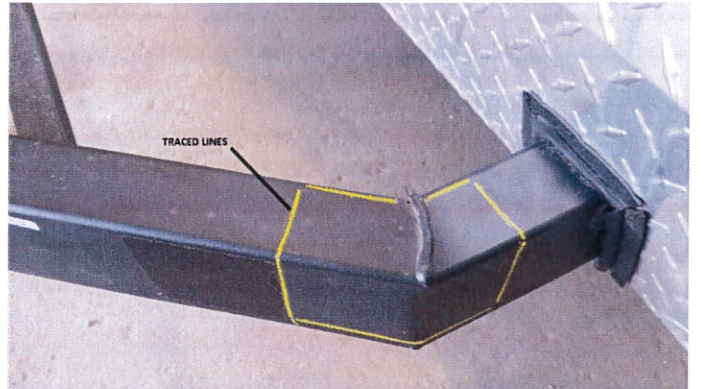


FIG 6

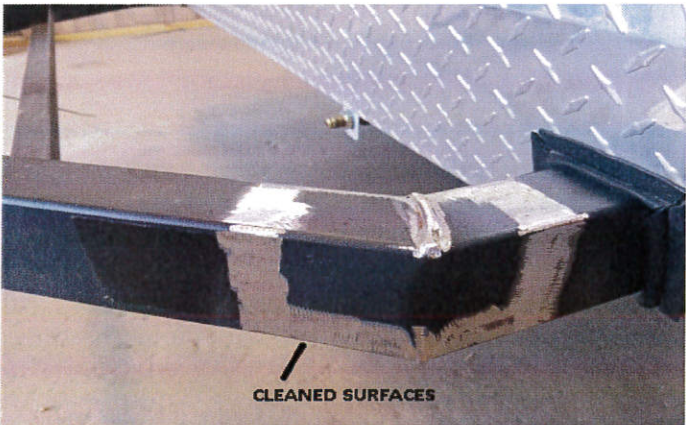


FIG 7

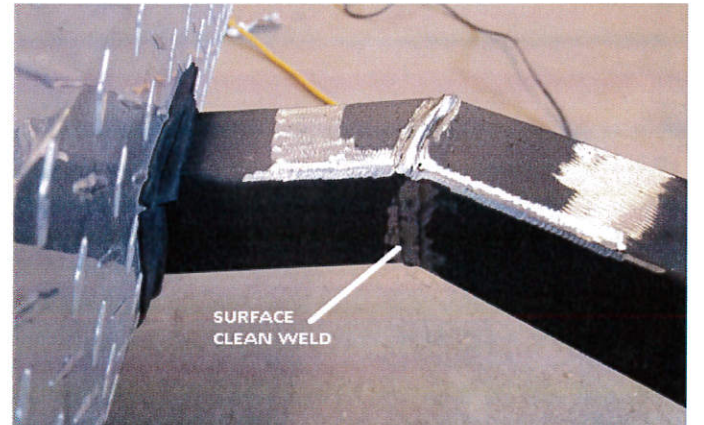


FIG 8

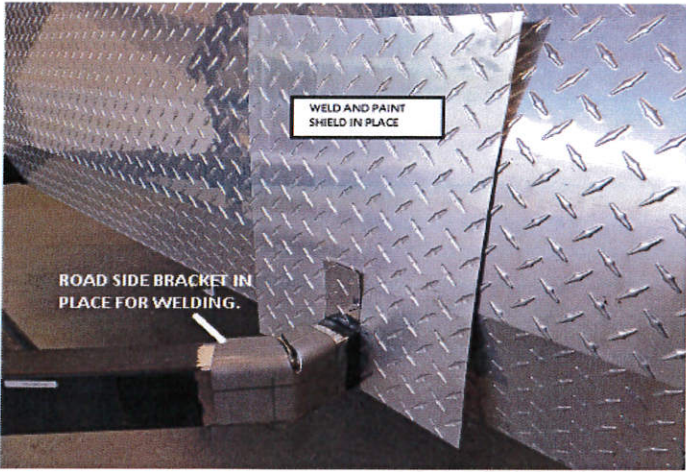


FIG 9

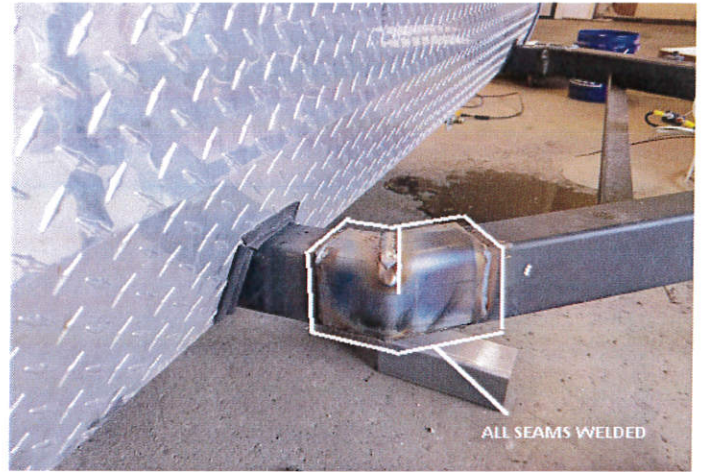


FIG 10

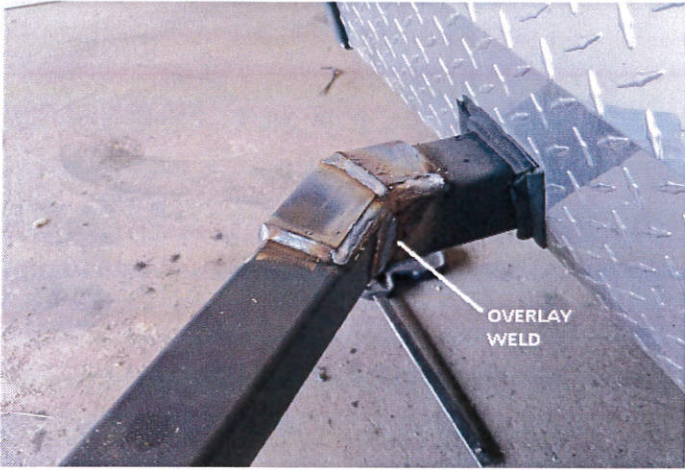


FIG 11

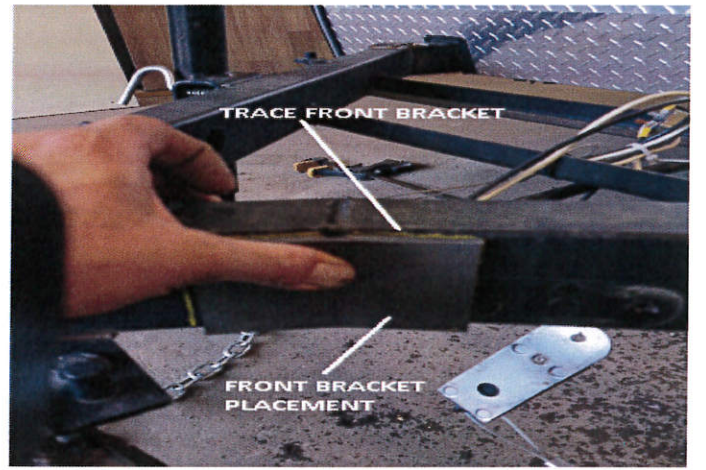


FIG 12

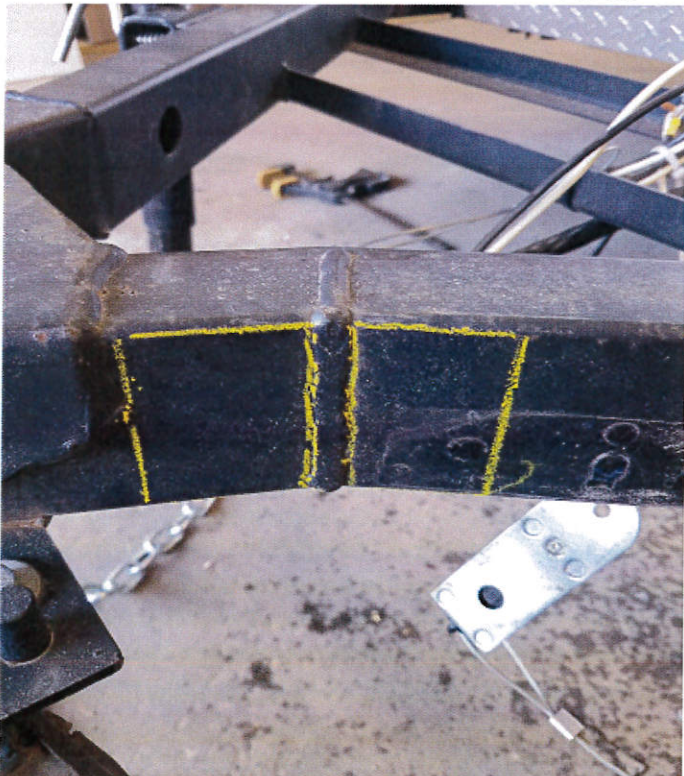


FIG 13



FIG 14



WELD ALL SEAMS

FIG 15



GRIND ALL SURFACES SMOOTH

FIG 16

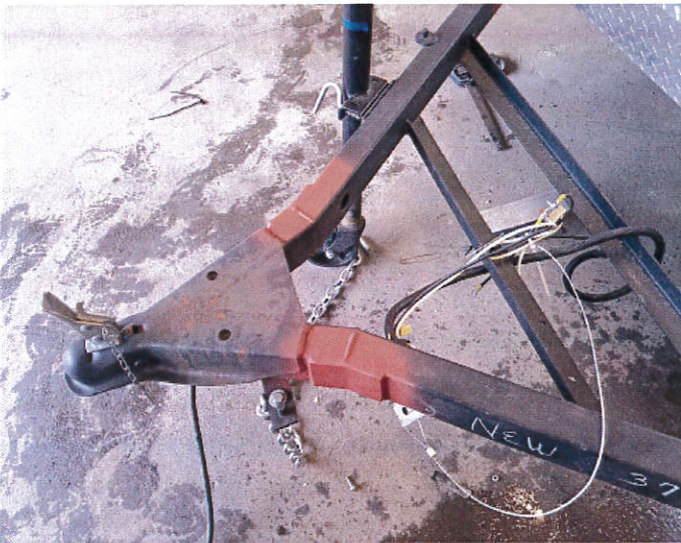


FIG 17

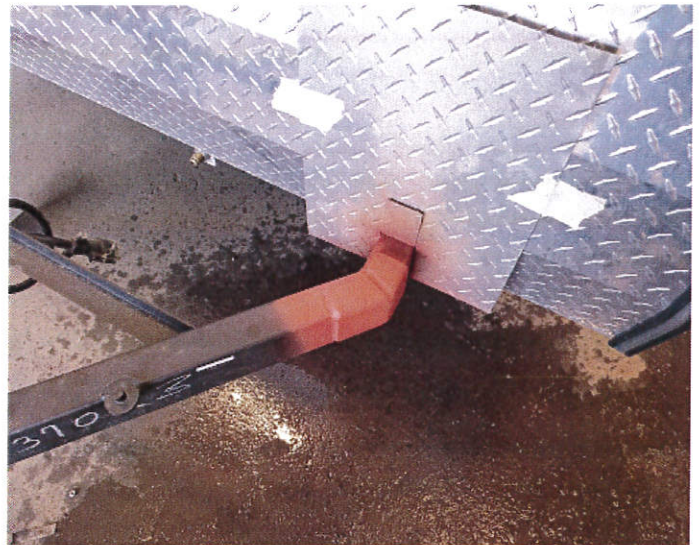
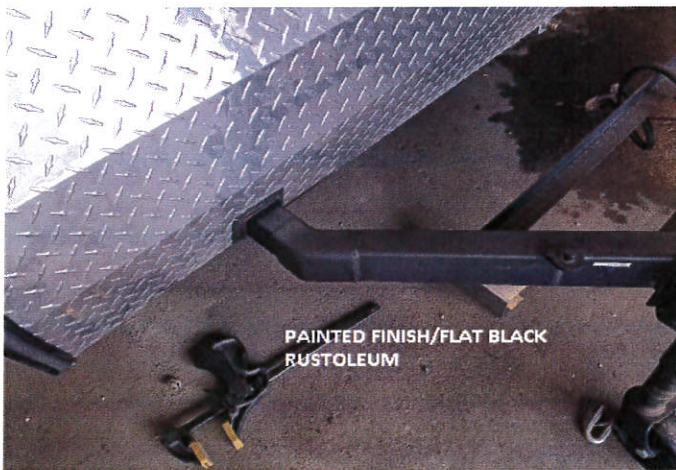


FIG 18



PAINTED FINISH/FLAT BLACK
RUSTOLEUM

FIG 19