




Fresh Water Tank Support

Bulletin Type:	RECALL	Publication Date:	May 2019
Bulletin #(s):	19V-335 US 2019-211 CN	Make:	Jayco
Job Code:	9901433	Model:	Jay Flight 32ORLOK "TF"
Flat Rate(s):	RC024 Repair A – .8 hour RC025 Repair B – 1.2 hour	Model Year:	2019

PARTS KIT REQUIRED

Incident:	The support apparatus for the fresh water tanks require additional support
Affected Units:	<u>2019 Jay Flight 32RLOK "TF"</u> K1TF0050-0106, 0108, 0110-0112, 0114, 0120, 0124, 0127, 0129, 0136 -0137, 0144,-0145
Parts Kit:	<p>Parts Kit #:19V-335</p> <p>Contents:</p> <ul style="list-style-type: none"> 1 - Plastic, Lam 10" x 68" (underbelly material) 2 – Nut, hex flg 3/8-16 GR5 12 – Screw, Pan Qd #10 x 3/4" TEK3 w/washer 1 – Rod, thrd 3/8-16 x 9" long 1 – Sleeve, spacer steel 6.875" length
Misc. Tools & Supplies:	<ul style="list-style-type: none"> Screw gun with #2 square bit Drill with 3/8" bit (12 inches long) Deep well Socket – 9/16" with socket adapter 9/16" open end wrench Socket - 3/4" Utility Knife Torque wrench (Ft/lbs.) <div style="text-align: right; margin-top: 10px;">  <p style="font-size: small; margin: 0;">Rod & spacer sleeve</p> </div>
Parts Return Information:	Not applicable

NOTE: There are 2 sets of repair instructions.

Repair instruction (A) RC024 for trailers ***without enclosed underbelly.***

Repair instruction (B) RC025 for trailers ***with an enclosed underbelly.***

REPAIR INSTRUCTIONS A (**without enclosed underbelly**) .8hr



FIG 1A & 2A:

- Use 9/16" socket and screw gun to remove the middle nut and bolt from the straps securing the water tanks.
- Middle bolt location is circled in Fig 2A.

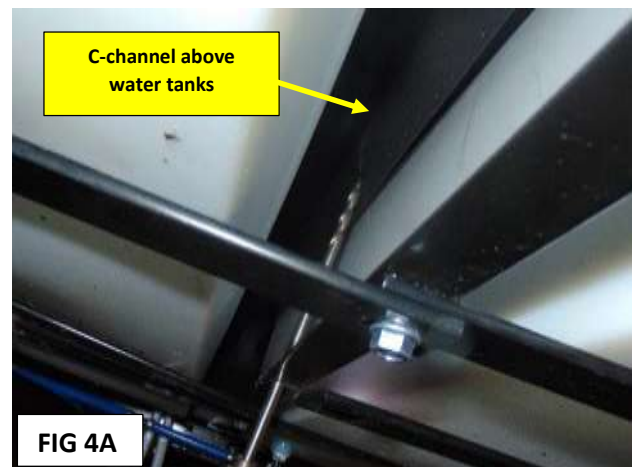
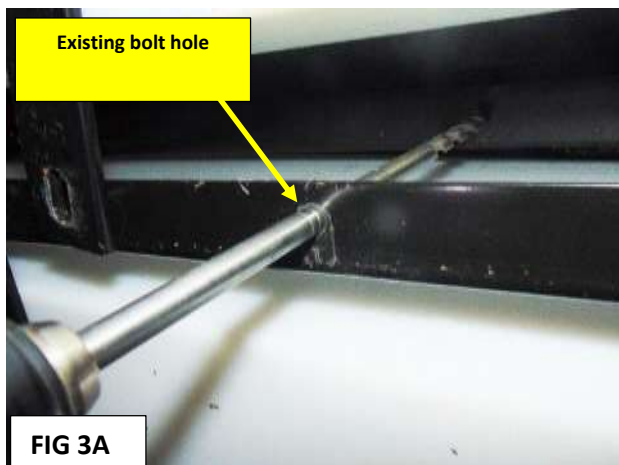


FIG 3A:

- Use the drill with the foot long 3/8" drill bit, and insert it into the middle bolt location on the tank strap.
- A 3/8" diameter hole needs to be drilled up into the bottom flange of the C-channel above the water tanks.
- The C-channel runs directly between the two water tanks.

FIG 4A:

- Drill bit shown between water tanks, and ready to drill hole in the bottom flange of the C-channel above the tanks.

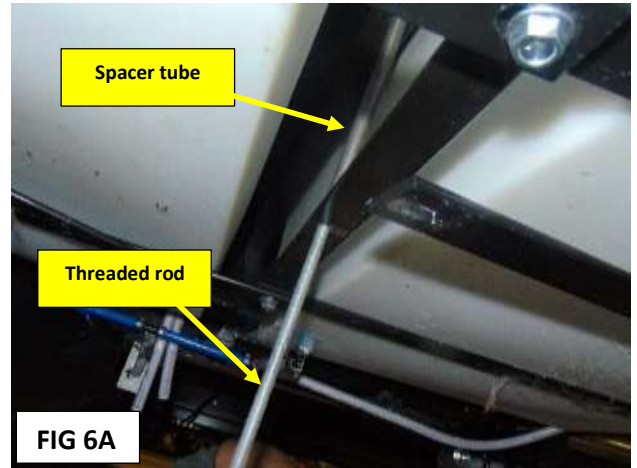
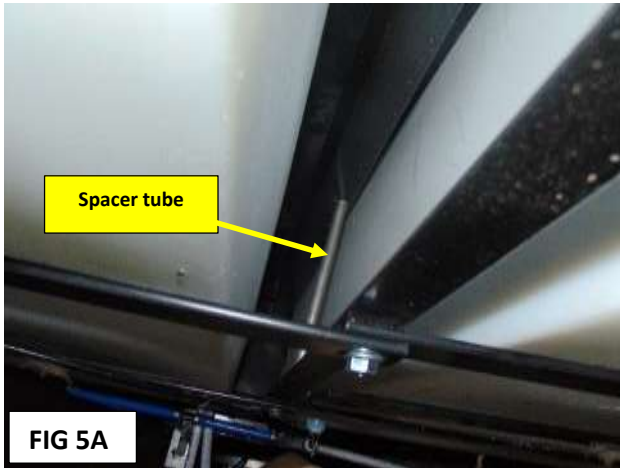


FIG 5A:

- Install the spacer tube between the tank strap and the bottom of the C-channel just drilled.

FIG 6A

- Insert the 9" long threaded rod into the spacer tube.
- Approximately $\frac{1}{2}$ " of the threaded rod should extend above the C-channel.

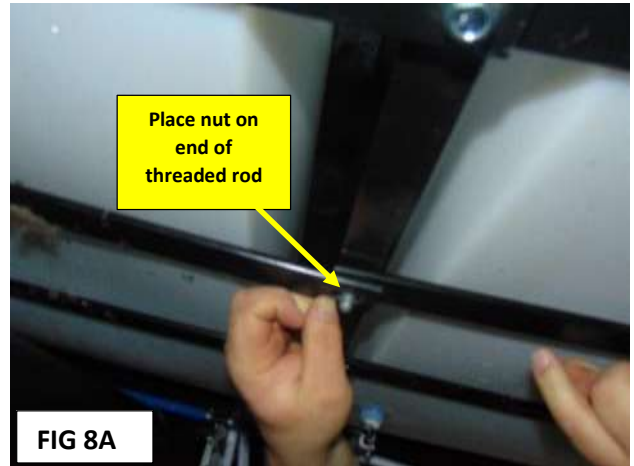


FIG 7A:

- Reach up between the tanks and install one of the $\frac{3}{8}$ " nuts from the kit on the end of the threaded rod on top of the C-channel.
- Make sure at least 2 or 3 threads of the rod extend beyond the top of the nut on top of the C-channel.

FIG 8A:

- Install the other $\frac{3}{8}$ " nut from the kit on the bottom end of the threaded rod at the tank straps.
- At least 2-3 threads of the rod should extend beyond the top of the nut.
- Tighten the bottom nut with the ratchet and a $\frac{9}{16}$ " socket, and the top nut with a $\frac{9}{16}$ " open end wrench above the tanks.
- Finish with a torque wrench and the $\frac{9}{16}$ " socket (on the bottom nut) and **TORQUE THE FLANGE NUT TO 22 FT/LBS.**

REPAIR INSTRUCTIONS B (with enclosed underbelly) 1.2 hr

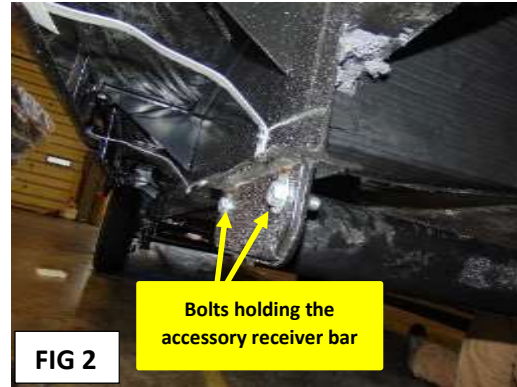
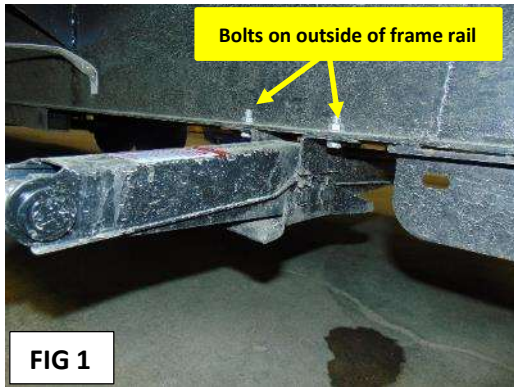


FIG 1:

- Remove both rear stabilizer jacks.
- Remove two bolts on outside of the frame rail. (9/16" socket, socket adapter & screw gun)
- Remove 2 lag screws on the inside of the frame rail. (9/16" socket, socket adapter & screw gun)

FIG 2:

- Remove the accessory receiver bar from the rear of the trailer (if equipped).
- **NOTE: in the photos that follow the receiver bar was left in place, but it is much easier if it is removed.**
- Use the 3/4" socket to remove the 2 bolts on each end of the accessory receiver bar.
- Save the hardware for re-installation.

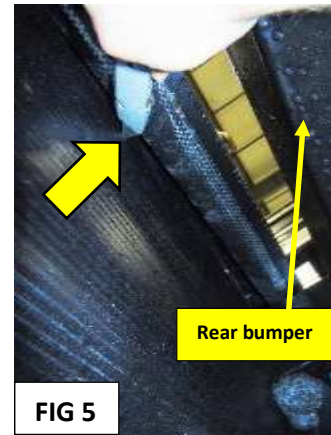
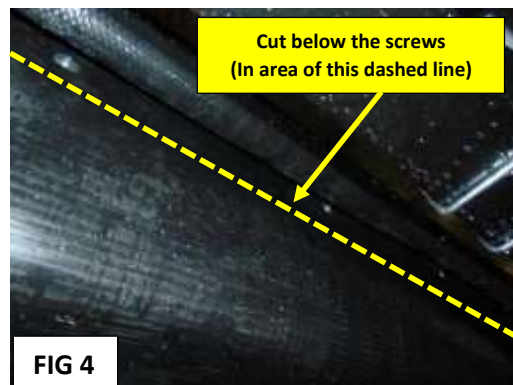


FIG 3:

- Hard plastic underbelly cover must come down to access water tanks.
- Remove enough underbelly screws to allow 5 feet of it to be pulled down from rear of trailer.

FIG 4 & 5:

- There are screws holding the main underbelly material up above the rear bumper, you must cut the underbelly material below these screws in the area shown by the dashed line in **Fig 4**.
- Cut across the rear of the underbelly material above and behind the rear bumper with a utility knife (arrow) (**Fig 5**).
- Pull down the main underbelly from the end of the frame at the rear, and pull toward the front of trailer approximately 5 feet.
- There is expanding foam around the stabilizer jacks and other areas that must be chipped away so the underbelly can be pulled down from frame rails.



FIG 6 & 7:

- Underbelly pulled down exposing the water tanks.
- Use 9/16" socket and screw gun to remove the middle nut and bolt from the straps securing the water tanks.
- Middle bolt location is circled in **Fig 7**.

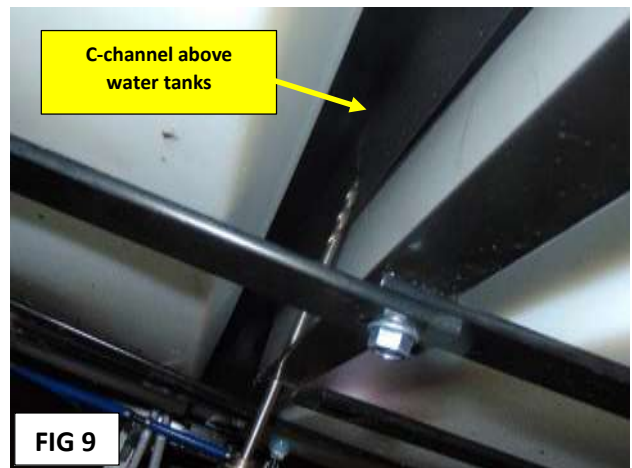
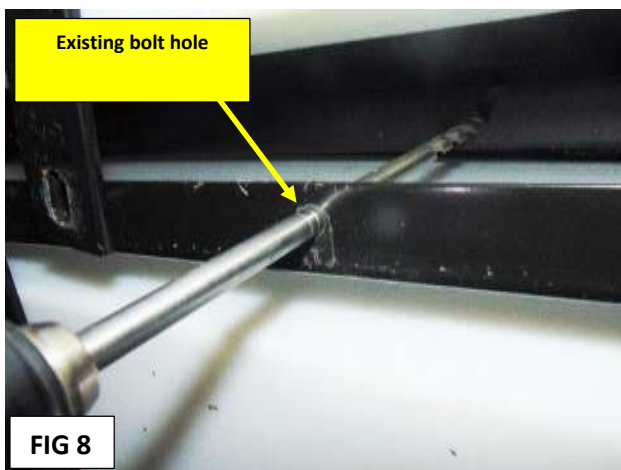


FIG 8:

- Use the drill with the foot long 3/8" drill bit, and insert it into the middle bolt location on the tank strap.
- A 3/8" diameter hole needs to be drilled into the bottom flange of the C-channel above the water tanks.
- The C-channel runs directly between the two water tanks.

FIG 9:

- Drill bit shown between water tanks, and ready to drill hole in the bottom flange of the C-channel above the tanks.

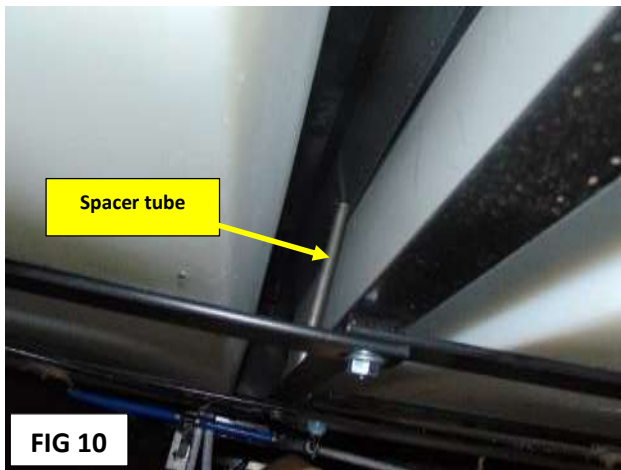


FIG 10:

- Install the spacer tube between the tank strap and the bottom of the C-channel just drilled.

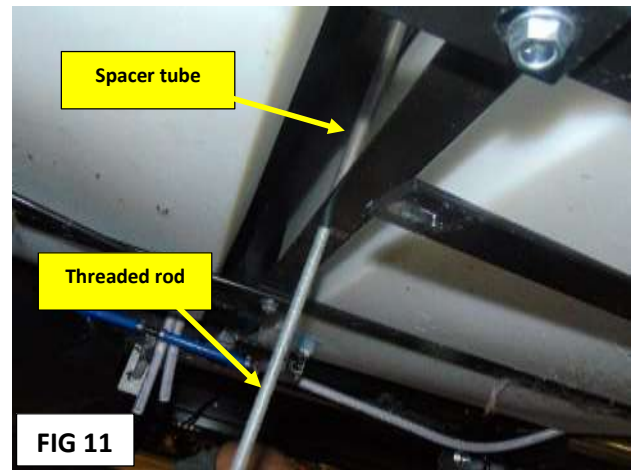


FIG 11:

- Insert the 9" long threaded rod into the spacer tube.
- Approximately 1/2" of the threaded rod should extend above the C-channel.



FIG 12:

- Reach up between the tanks and install one of the 3/8" nuts from the kit on the end of the threaded rod on top of the C-channel.
- Make sure at least 2 or 3 threads of the rod extend beyond the top of the nut on top of the C-channel.

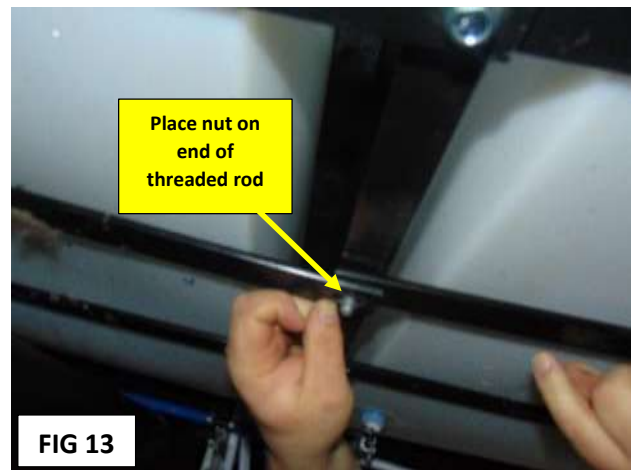


FIG 13:

- Install the other 3/8" nut from the kit on the bottom end of the threaded rod at the tank straps.
- At least 2-3 threads of the rod should extend beyond the top of the nut.
- Tighten the bottom nut with the ratchet and a 9/16" socket, and the top nut with a 9/16" open end wrench above the tanks.
- Finish with a torque wrench and the 9/16" socket (on the bottom nut) and **TORQUE THE FLANGE NUT TO 22 FT/LBS.**

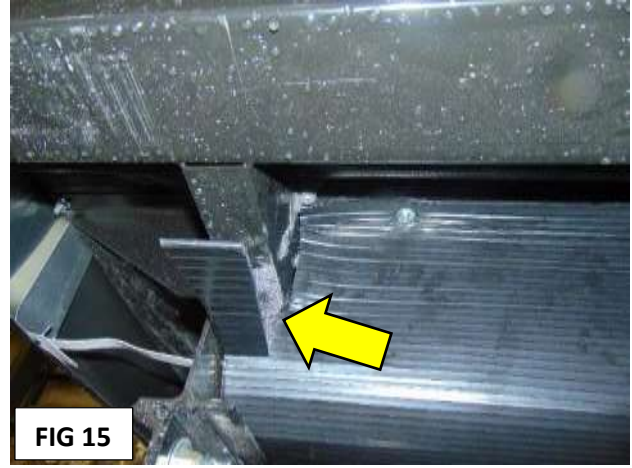


FIG 14:

- Insert the 10" x 68" piece of underbelly material under the tanks, resting on the frame rails.
- This underbelly piece will be bent up and secured to the piece of angle being pointed to in **Fig 14** (arrow).

FIG 15:

- 10" x 68" underbelly piece will need to be trimmed around the bumper support tube (on each end of the bumper) (arrow).

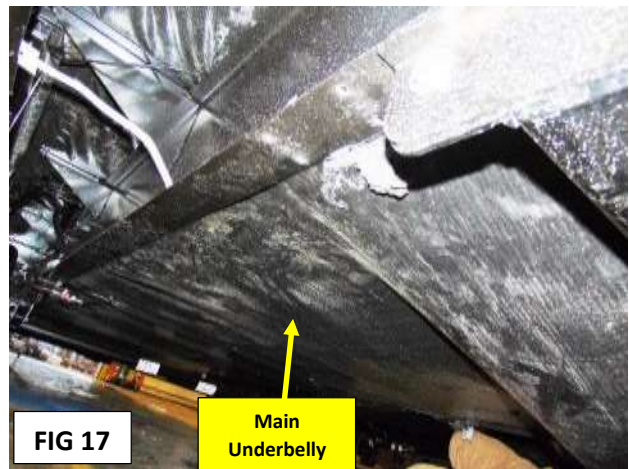
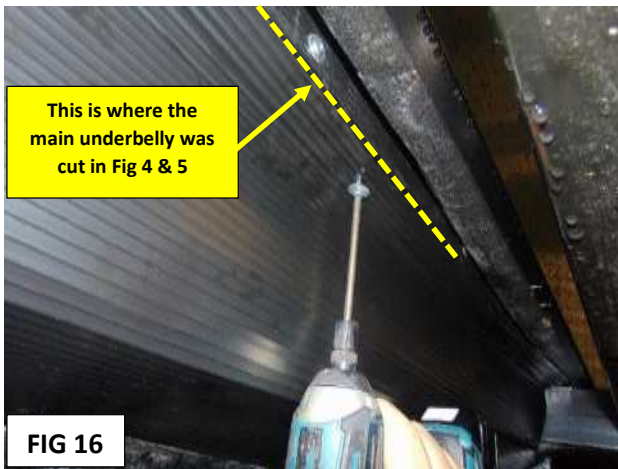


FIG 16:

- Secure the 10" underbelly piece to the angle steel (**Fig 14**) using $\frac{3}{4}$ " screws and washers from the kit.
- It will take approximately 10 screws to secure the underbelly piece to the angle.

FIG 17:

- **NOTE:** if there was any insulation batting between the tanks and the underbelly reinstall that now before securing the underbelly in place.
- Reinstall the main underbelly up between the frame rails
- Underbelly needs to be pulled tight at the rear of the trailer.
- Reinstall the underbelly screws.



FIG 18:

- At the rear of the trailer: pull the main underbelly underneath the 10" piece installed previously.



FIG 19:

- The main underbelly will need to be cut off with the utility knife and secured to a steel angle where the 10" piece (installed previously) bends upward. (See Fig 20 & 21)

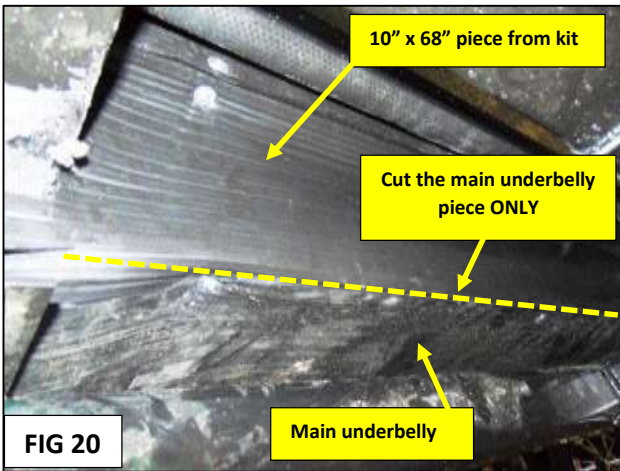


FIG 20:

- The main underbelly piece will be cut off in the area of the dashed line, which is right where the 10" piece bends upward. **DO NOT CUT THE 10" PIECE THAT WAS INSTALLED AT FIG 14.**

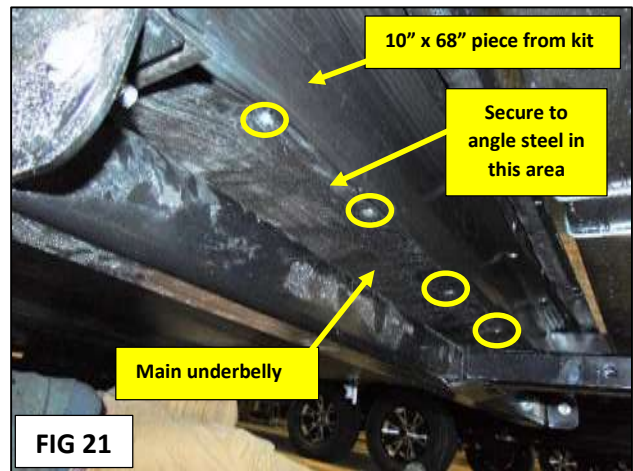


FIG 21:

- Secure the main underbelly piece to a steel angle which is covered by the 10" underbelly piece.
- Use 3/4" screws with washers from the kit (shown circled in the photo).
- It will take approximately 6 screws to secure the main underbelly piece.

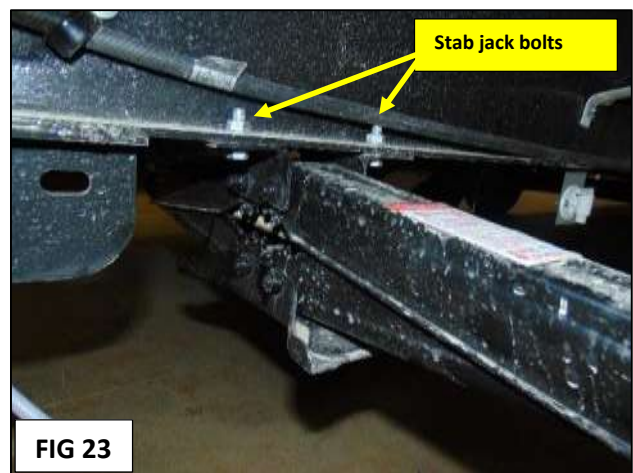
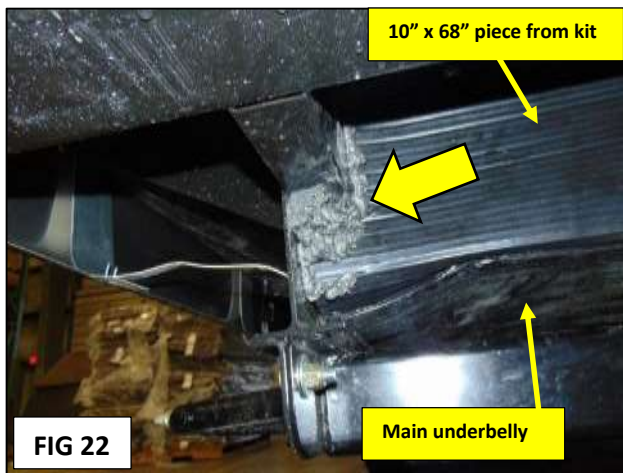


FIG 22:

- Apply expanding foam back in areas where it was chipped away previously.
- Also apply expanding foam at each corner of the frame rail where the underbelly was notched (large arrow).

FIG 23:

- Reinstall the stabilizer jacks under the trailer.
- Install the lag screws on the inside rail of the frame first, but don't tighten them completely.
- This will allow some play to install the bolts on the outside rail of the frame.
- Install the bolts on the outside rail of the frame, tighten those wrench tight (no torque spec).
- After tightening the two bolts, the lag screws can be fully tightened (wrench tight), again no torque spec.

Reinstall the accessory receiver bar (if equipped).

Replace the 4 bolts and nuts that were removed previously.

Hardware can be re-used for this installation.

Use the torque wrench and 3/4" socket and torque the nuts on the accessory receiver bar to 85 ft. /lbs.

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