



Solar Panel Detachment

Bulletin Type:	Recall	Publication Date:	July 2023
Bulletin #(s):	23V-404 USA 2023-327 Canada	Make(s):	Jayco, Entegra Coach
Job Code(s):	9903586	Model(s):	Ethos (20D), Ethos Li (20DL), Swift (20D), Swift Li (20DL)
Flat Rate(s):	9903586 1.50 HR - Labor - Solar Panel Support Installation	Model Year(s):	2023

Incident:	Solar Panel support tube becomes loose or detached from pop-up roof assembly.
Affected Units:	2023 Jayco Swift (20D), Swift Li (20DL); 2023 Entegra Coach Ethos (20D), Ethos Li (20DL)

Parts Kit:	<u>23V-404KIT1</u>	
Parts List:	<p><u>Installation Kit #1 – 1.5" Single Tubes</u> <u>(48V Solar Panels: 1 Unit)</u> 1 - ADHESIVE,SIKA-3121 490ML DKGRA/GRN 1 - GUN,ADH 2 PART 10:1 SIKA 490ML 1 - TIP,MIXING SIKA 3121 10:1 .394IDX8.75 ORN 2 - BRACKET,END CAP 1.50 14GA STL BLK D/S 2 - BRACKET,END CAP 1.50 14GA STL BLK P/S 2 – BRACKET,END CAP 3.00 14GA STL BLK 6 – BOLT,HEX .25-20X2.50 GR5 ZC 6 - NUT,LK .25-20 STNLS W/NYL INSR 12 – WASHER,SPCR NYL .25IDX.75ODX.063 2 FT - TAPE,FOAM .25X1.00X50' BLACK 16 - ANGLE,Z SOLAR PNL .13 AL BLK</p>	VIN affected: 1UJ P BBJOP1 XXXXXXXXXX

Parts Kit:	<u>23V-404KIT2</u>	
<p style="text-align: center;">Parts List:</p>	<p style="text-align: center;"><u>Installation Kit #2 – 1.5” Single Tubes (12V Solar Panel: 40 Units)</u></p> <p>1 - ADHESIVE,SIKA-3121 490ML DKGRA/GRN 1 - GUN,ADH 2 PART 10:1 SIKA 490ML 1 - TIP,MIXING SIKA 3121 10:1 .394IDX8.75 ORN 2 - BRACKET,END CAP 1.50 14GA STL BLK D/S 2 - BRACKET,END CAP 1.50 14GA STL BLK P/S 4 – BOLT,HEX .25-20X2.50 GR5 ZC 4 - NUT,LK .25-20 STNLS W/NYL INSR 8 – WASHER,SPCR NYL .25IDX.75ODX.063 2 FT - TAPE,FOAM .25X1.00X50' BLACK 4 - ANGLE,Z SOLAR PNL .13 AL BLK</p>	<p style="text-align: center;">VINS affected:</p> <p>1JSPEBBJ9P1 1JSPEBBJOP1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1JSPEBBJ8P1 1JSPEBBJXP1 1JSPEBBJ1P1 1JSPEBBJ3P1 1JSPEBBJXP1 1JSPEBBJ1P1 1UJPJBBJXP1 1UJPJBBJ1P1 1UJPJBBJ3P1 1UJPJBBJ5P1 1UJPJBBJ7P1 1UJPJBBJ9P1 1UJPJBBJOP1 1UJPJBBJ2P1 1UJPJBBJ4P1 1UJPJBBJOP1 1UJPJBBJ2P1 1UJPJBBJ4P1 1UJPJBBJ6P1 1JSPEBBJ3P1 1JSPEBBJ5P1 1JSPEBBJ7P1 1JSPEBBJ9P1 1JSPEBBJOP1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1UJPJBBJ8P1 1UJPJBBJXP1 1UJPJBBJ1P1 1UJPJBBJ3P1 1UJPJBBJ5P1 1UJPJBBJ7P1 1UJPJBBJ3P1 1UJPJBBJ5P1</p>

Parts Kit:	23V-404KIT3	
<p style="text-align: center;">Parts List:</p>	<p style="text-align: center;"><u>Installation Kit #3 – 3” Single Tubes (12V Solar Panel: 34 Units)</u></p> <p>1 - ADHESIVE,SIKA-3121 490ML DKGRA/GRN 1 - GUN,ADH 2 PART 10:1 SIKA 490ML 1 - TIP,MIXING SIKA 3121 10:1 .394IDX8.75 ORN 4 – BRACKET,END CAP 3.00 14GA STL BLK 4– BOLT,HEX .25-20X4.00 GR5 ZC PART THD 1.00 4 - NUT,LK .25-20 STNLS W/NYL INSR 8 – WASHER,SPCR NYL .25IDX.75ODX.063 2 FT - TAPE,FOAM .25X1.00X50' BLACK 4 - ANGLE,Z SOLAR PNL .13 AL BLK</p>	<p style="text-align: right;">VINS Affec</p> <p>1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1JSPEBBJ8P1 1JSPEBBJXP1 1JSPEBBJ1P1 1JSPEBBJ3P1 1JSPEBBJ5P1 1JSPEBBJ7P1 1JSPEBBJ9P1 1JSPEBBJ5P1 1JSPEBBJ7P1 1JSPEBBJ9P1 1JSPEBBJ0P1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1JSPEBBJ8P1 1JSPEBBJXP1 1JSPEBBJ1P1 1UJPJBBJ7P1 1UJPJBBJ9P1 1UJPJBBJ0P1 1UJPJBBJ2P1 1UJPJBBJ4P1 1UJPJBBJ6P1 1UJPJBBJ8P1 1UJPJBBJXP1 1JSPEBBJ8P1 1JSPEBBJXP1 1JSPEBBJ1P1 1JSPEBBJ3P1 1JSPEBBJ5P1 1JSPEBBJ7P1</p>

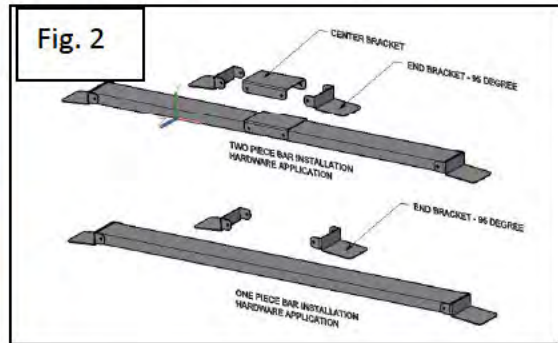
Parts Kit:	23V-404KIT4	
Parts List:	<p><u>Installation Kit #4 – 3” Split Tubes (48V Solar Panel: 18 Units)</u></p> <p>1 - ADHESIVE,SIKA-3121 490ML DKGRA/GRN 1 - GUN,ADH 2 PART 10:1 SIKA 490ML 1 - TIP,MIXING SIKA 3121 10:1 .394IDX8.75 ORN 3 – U-CHANNEL,BLK 3.38X5.00X1.06 14GA STL 6 – BRACKET,END CAP 3.00 14GA STL BLK 12 – BOLT,HEX .25-20X4.00 GR5 ZC PART THD 1.00 12 - NUT,LK .25-20 STNLS W/NYL INSR 24 – WASHER,SPCR NYL .25IDX.75ODX.063 3 FT - TAPE,FOAM .25X1.00X50' BLACK 16 - ANGLE,Z SOLAR PNL .13 AL BLK</p>	<p>VINS Affected:</p> <p>1JSPEBBJXP1 1JSPEBBJ1P1 1JSPEBBJ3P1 1JSPEBBJ5P1 1JSPEBBJ7P1 1JSPEBBJ9P1 1JSPEBBJ0P1 1UJPJBBJ2P1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ0P1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1JSPEBBJ8P1 1JSPEBBJXP1 1UJPJBBJ4P1 1UJPJBBJ6P1</p>

Parts Kit:	<u>23V-404KIT5</u>	
Parts List:	<p><u>Installation Kit #5 – 3” Split Tubes (12V Solar Panels – 36Units)</u></p> <p>1 - ADHESIVE,SIKA-3121 490ML DKGRA/GRN 1 - GUN,ADH 2 PART 10:1 SIKA 490ML 1 - TIP,MIXING SIKA 3121 10:1 .394IDX8.75 ORN 2 – U-CHANNEL,BLK 3.38X5.00X1.06 14GA STL 4 – BRACKET,END CAP 3.00 14GA STL BLK 8– BOLT,HEX .25-20X4.00 GR5 ZC PART THD 1.00 8 - NUT,LK .25-20 STNLS W/NYL INSR 8 – WASHER,SPCR NYL .25IDX.75ODX.063 2 FT - TAPE,FOAM .25X1.00X50' BLACK 4 - ANGLE,Z SOLAR PNL .13 AL BLK</p>	<p>VINS Affected:</p> <p>1JSPEBBJ9P1 1JSPEBBJ0P1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ7P1 1JSPEBBJ9P1 1UJPJBBJ6P1 1UJPJBBJ8P1 1JSPEBBJ0P1 1JSPEBBJ2P1 1JSPEBBJ4P1 1JSPEBBJ6P1 1JSPEBBJ8P1 1UJPJBBJXP1 1UJPJBBJ1P1 1UJPJBBJ3P1 1UJPJBBJ5P1 1UJPJBBJ7P1 1UJPJBBJ9P1 1UJPJBBJ0P1 1JSPEBBJXP1 1JSPEBBJ1P1 1JSPEBBJ3P1 1JSPEBBJXP1 1JSPEBBJ1P1 1UJPJBBJ2P1 1UJPJBBJ9P1 1UJPJBBJ0P1 1UJPJBBJ2P1 1UJPJBBJ4P1 1UJPJBBJ6P1 1UJPJBBJ8P1 1UJPJBBJXP1 1UJPJBBJ1P1 1UJPJBBJ3P1 1UJPJBBJ5P1</p>
Misc. Tools & Supplies:	<p>Drill with ¼” and 3/8” Drill Bits Screwgun with 3/8” and 7/16” Hex Head Nut Driver Socket 7/16” Wrench Pneumatic Air Caulk Gun Orbital Sander with 80 Grit Disc Putty Knife</p>	

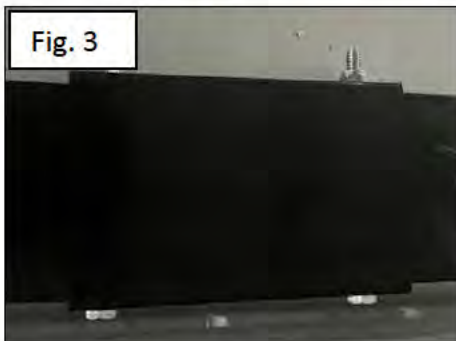
SOLAR PANEL SUPPORT INSTALLATION INSTRUCTIONS

1. With a Screw Gun and a 3/8” Hex Head Nut Driver Socket, remove the solar panel(s) mounted to the mounting tubes. (Figure 1 – Shown with the two-piece bar installation)

2. If the mounting tubes are a single bar installation (bottom of Figure 2), continue at step 7. Otherwise, hold the center bracket in place and mark the mounting tube in four locations (each mounting tube).



3. Drill a 1/4 inch hole through the previously marked locations.
4. Change to a 3/8 inch drill bit and enlarge the previously drilled holes.
5. Install the center brackets with the 1/4- bolt and 1/4-20 Nylon Lock Nut (Figure 3). These should be tightened to allow the mounting tubes to flex as-needed. The bolts should rotate freely and full compression of the bracket to the mounting tube is not required.
6. At each end of the mounting tubes, place the mounting brackets so that the foam pad is against the end of the mounting tube.
7. Hold the end bracket in place and mark the mounting tube in two locations (each end of every mounting tube).
8. Drill a 1/4 inch hole through the mounting tube on both sides. (Figure 4)



9. Change to a 3/8 inch drill bit and enlarge the previously drilled holes.
10. Remove all metal shavings.
11. Install the end brackets with the 1/4- bolt, nylon washers and 1/4-20 Nylon Lock Nut loosely.
NOTE: Nylon Washer should be between the mounting tube and the end bracket.
12. Apply a masking tape to each bracket location to utilize as a guide for sanding. (Figure 5)
13. Using a low speed orbital sander with 80 grit sand paper, remove the paint and primer from the pop-top roof (Figure 6). To prevent any damage, it is recommended to keep the sanding inward of the masking tape by 1/8 inch.



14. With all of the bracket locations sanded, blow off any excess dust and remove the masking tape.
15. Wipe down the bottom of the mounting bracket and the pop-up roof assembly with rubbing alcohol to clean the bonding surfaces. Allow time to flash off.

16. Apply SikaFast-3121 directly to bottom of the mounting bracket (Figure 7) and smear to an even coat with a putty knife/stick (Figure 8).

NOTE: Application temperature should be within 50-95°F and there is approximately 5-10 minutes for Open Time to install.

17. Push the bracket down into place.

NOTE: It is critical to bond the surfaces as quickly as possible.

18. Using a putty knife/stick, clean off any excess adhesive surround the bracket (Figure 9) and tape the bracket down (Figure 10).

NOTE: It is recommended to allow the bracket adhesion 12 hours to cure before completing additional steps.



19. With the brackets mounted and cured, the mounting bolts can be tightened (Figure 11). These should be tightened to allow the mounting tubes to flex as-needed. The bolts should rotate freely and full compression of the bracket to the mounting tube is not required.

20. The solar panel can be re-installed with new mounting brackets provided (Figure 12).



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