

## EBB-60 TRAILERS manufactured between 2020 and 2022: Tongue Replacement

### Background

All EBB-60 trailers manufactured between 2020 and 2023 must have their tongue assemblies replaced with a strengthened tongue assembly. This Service Bulletin covers that process.

**Time required: 8 hours**

### Parts required:

PART NUMBER	DESCRIPTION	QUANTITY
65327.400	REPLACEMENT TRAILER TONGUE	1

### Tools required:

SIZE	DESCRIPTION	QUANTITY
2,000# EACH	JACK STANDS	7
STANDARD	WHEEL CHOCKS	4
STANDARD	CUTTING TOOL (plasma cutter, oxy-acetylene torch, cutoff wheel, etc.)	1
SUITABLE	WELDER (and associated safety PPE)	1
STANDARD	WELDING CLAMPS	8



**MAKE SURE THAT THE TRAILER UNIT IS PARKED  
ON A LEVEL SURFACE WITH THE WHEELS  
CHECKED.**

## Replacing an EBB Trailer Tongue

**IMPORTANT:** The welding work on this procedure **MUST BE COMPLETED BY A WELDER CERTIFIED IN THE WELDING PROCESS USED AND THE POSITION USED.**

1. Park the EBB trailer on a **LEVEL SURFACE**.
2. **FULLY CHOCK** at least one wheel on each axle.
3. **LEVEL** the trailer frame **FRONT TO BACK** with the tongue jack.
4. Place **JACK STANDS** under the front and rear of the trailer frame.  
**NOTE:** Make sure that the trailer is also **LEVEL SIDE TO SIDE** on the jack stands.
5. Place a **JACK STAND UNDER THE FRONT** of the tongue assembly and then place a **JACK STAND UNDER EACH ARM** at the back of the tongue assembly.
6. **REMOVE** the **ELECTRICAL WIRING JUNCTION BOX**, on the inside of the left tongue rail. Carefully remove the wires from the cushion clamps and remove the cushion clamps. Set the junction box and wiring aside, away from the tongue assembly and any potential welding heat.



**ELECTRICAL  
WIRING JUNCTION  
BOX**

**CUSHION  
CLAMP**

7. **REMOVE** THE **BREAKAWAY BATTERY BOX**, bolted to the front of the frame rail near the tongue assembly. Between the breakaway battery box and the breakaway cable box, **CUT THE WIRES MIDWAY** between the the two boxes. **REMOVE** THE **BREAKAWAY CABLE BOX**. Set the two breakaway boxes aside, away from the tongue assembly and any potential welding heat.

**NOTE:** There must be enough wire on both cut ends to allow the wires to be routed back through the tongue rail and spliced back together after the new tongue assembly has been installed.



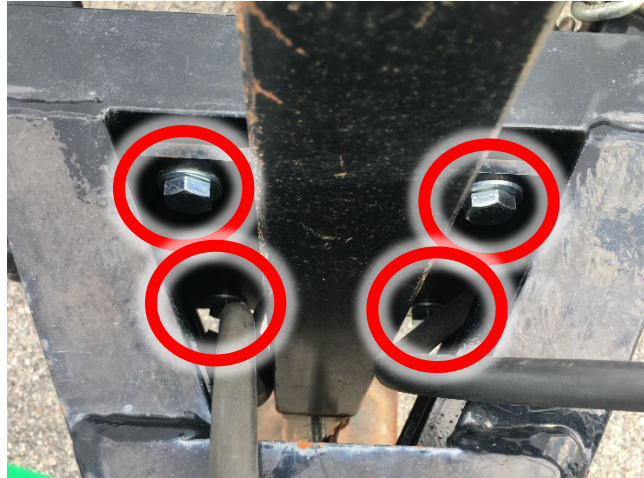
**CABLE BOX  
AND  
WIRING  
THROUGH  
TONGUE  
RAIL**

- REMOVE THE HITCH COUPLER from the tongue assembly by loosening and removing the two (2) bolts/washers/nuts that secure the coupler to the tongue assembly.

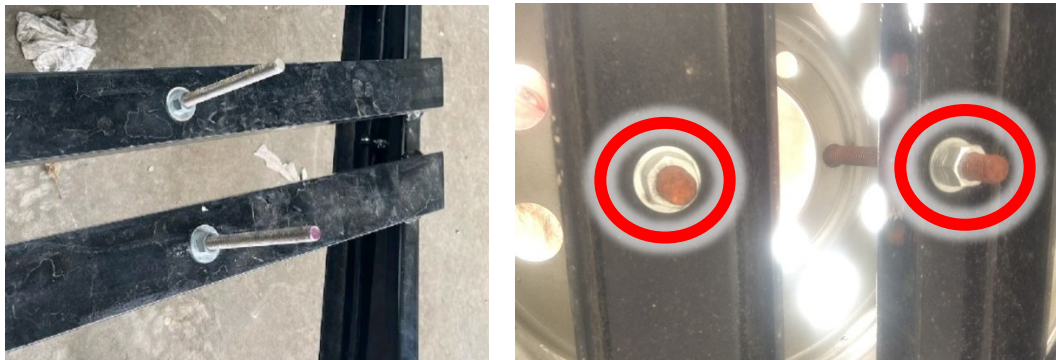
**NOTE:** Notice that one bolt is threaded on the right side and the other bolt is threaded on the left side. This will also need to be done on reassembly of the new tongue assembly.



9. REMOVE THE TONGUE JACK from the tongue assembly by loosening and removing the four (4) bolts/washers/nuts that secure the jack to the tongue assembly.



10. REMOVE THE SPARE TIRE from the spare tire mounting rack. From underneath the spare tire mounting rack, REMOVE THE TWO (2) BOLTS that secure the spare tire mounting bolts to the tongue assembly.



11. THE SAFETY CHAINS STAY ON the original trailer tongue assembly as NEW SAFETY CHAINS ARE INCLUDED on the new strengthened tongue assembly (65327.400).

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**IMPORTANT: BEFORE REMOVING TONGUE ASSEMBLY** from the trailer, record measurements and mounting points and take photographs of the existing tongue installation. Make special note of the original weld locations, weld bead lengths, and weld bead contours in order to better replicate the mounting of the new trailer tongue assembly.

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12. After fully documenting the original trailer tongue installation, use a cutting tool (plasma cutter, oxy-acetylene torch, cutoff wheel, etc.) to eliminate the welds between the trailer frame and tongue assembly.

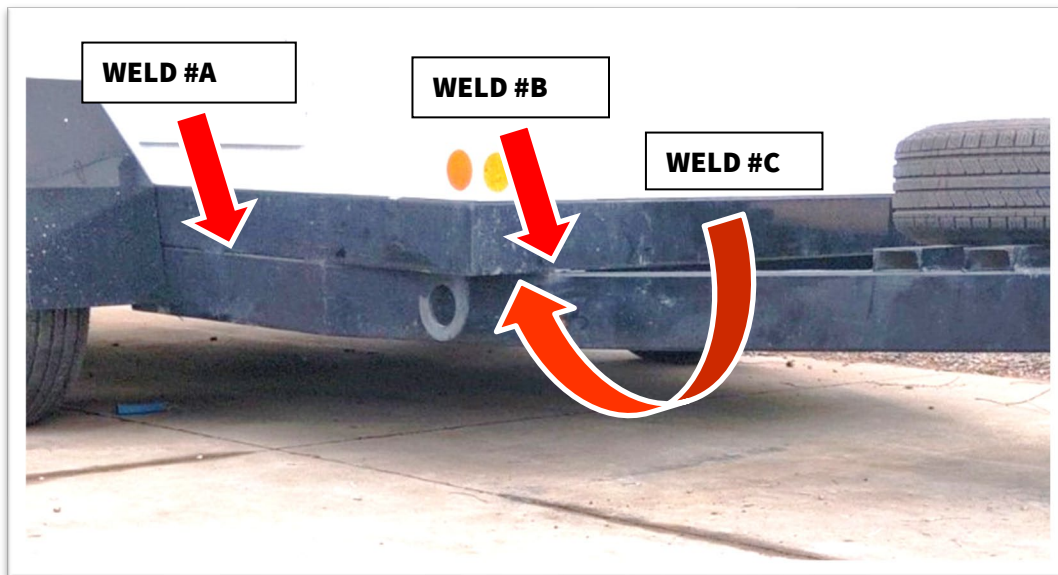
**NOTE:** The welds are located at the following locations:

- **WELD A:** Along the length of the face where the tongue and frame are mated (welded the full length, BOTH on the INSIDE and OUTSIDE of the framerail)
- **WELD B:** On the top of the tongue where it first meets the trailer frame (welded the full width of the frame rail, BOTH on the FRONT and BACK of the framerail)
- **WELD C:** On the side of the tongue rail where it contacts the bottom of the frame rail (welded the full width of the frame rail, BOTH on the INSIDE and OUTSIDE of the framerail)

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**IMPORTANT:** Each of these welds must be removed from both legs of the trailer tongue assembly.

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**IMPORTANT:** When removing the welds, DO NOT HARM THE INTEGRITY OF THE TRAILER FRAME ITSELF. If the frame rails are damaged during the tongue removal process, those weaknesses will need to be corrected as well.

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13. Grind off any remaining weld bead until the bottom of the trailer frame is flush.

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**IMPORTANT:** INSPECT THE TRAILER FRAME FOR ANY WEAKNESSES before proceeding. Any weaknesses will need to be fixed before proceeding.

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14. Position the new trailer tongue assembly under the trailer frame in its approximate location.

15. Using the location shown on the Service Bulletin drawing (see Appendix A), properly position the new tongue assembly under the trailer frame and clamp the tongue assembly in place securely.

**NOTE:** The forward tip of the tongue assembly must be POSITIONED 61.92" FROM THE FRONT FACE of the trailer frame AND the new tongue assembly must CENTERED ON THE MIDDLE AXIS of the trailer centerline.

16. Check that the position of the new tongue assembly corresponds to the photos, notes, and measurements taken of the original tongue assembly before it was removed.

**NOTE:** If there are discrepancies, make the necessary adjustments.

17. Use the MIG or STICK process to WELD the new tongue assembly to the trailer frame using the photograph below and the drawing in Appendix A for details.

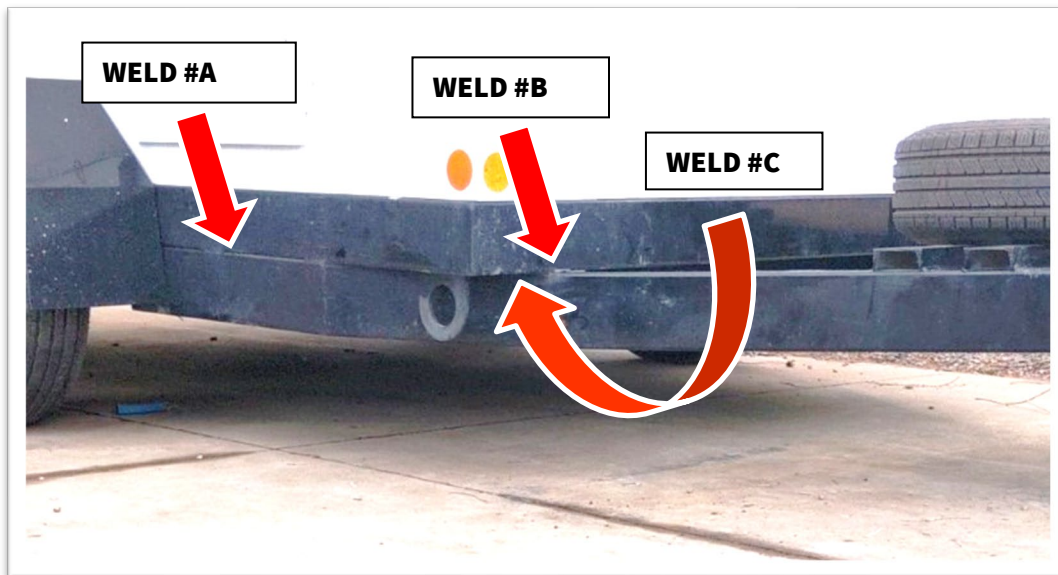
**NOTE:** New welds must be completed at the following locations:

- **WELD A:** Along the length of the face where the tongue and frame are mated (welded the full length, BOTH on the INSIDE and OUTSIDE of the framerail)
- **WELD B:** On the top of the tongue where it first meets the trailer frame (welded the full width of the frame rail, BOTH on the FRONT and BACK of the framerail)
- **WELD C:** On the side of the tongue rail where it contacts the bottom of the frame rail (welded the full width of the frame rail, BOTH on the INSIDE and OUTSIDE of the framerail)

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**IMPORTANT:** Each of these welds must be done on both legs of the trailer tongue assembly.

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18. After welding is complete, WIRE BRUSH/SAND the welded areas to remove any flaking paint or powder coat. Touch up those areas with a quality GLOSS BLACK PAINT.

19. Reinstall the following components:

- A. 7-pin lighting wiring and electrical junction box
- B. Breakaway wiring, battery box, and cable box  
**NOTE:** When splicing the wires back together, use waterproof connectors AND shrink-wrap on the connections.
- C. Hitch coupler

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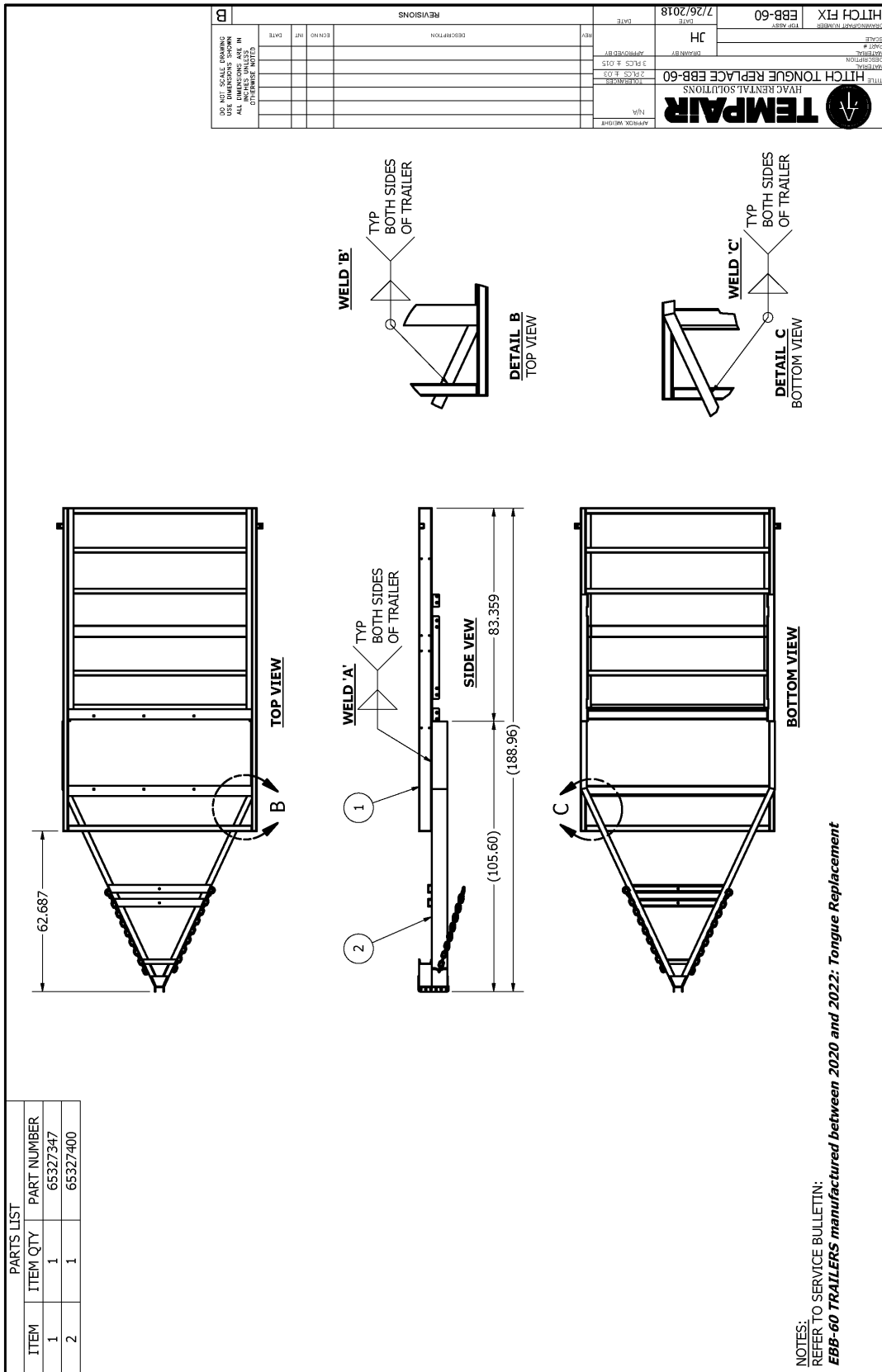
**IMPORTANT:** Remember that one bolt was threaded on the right side and the other bolt should be threaded on the left side.

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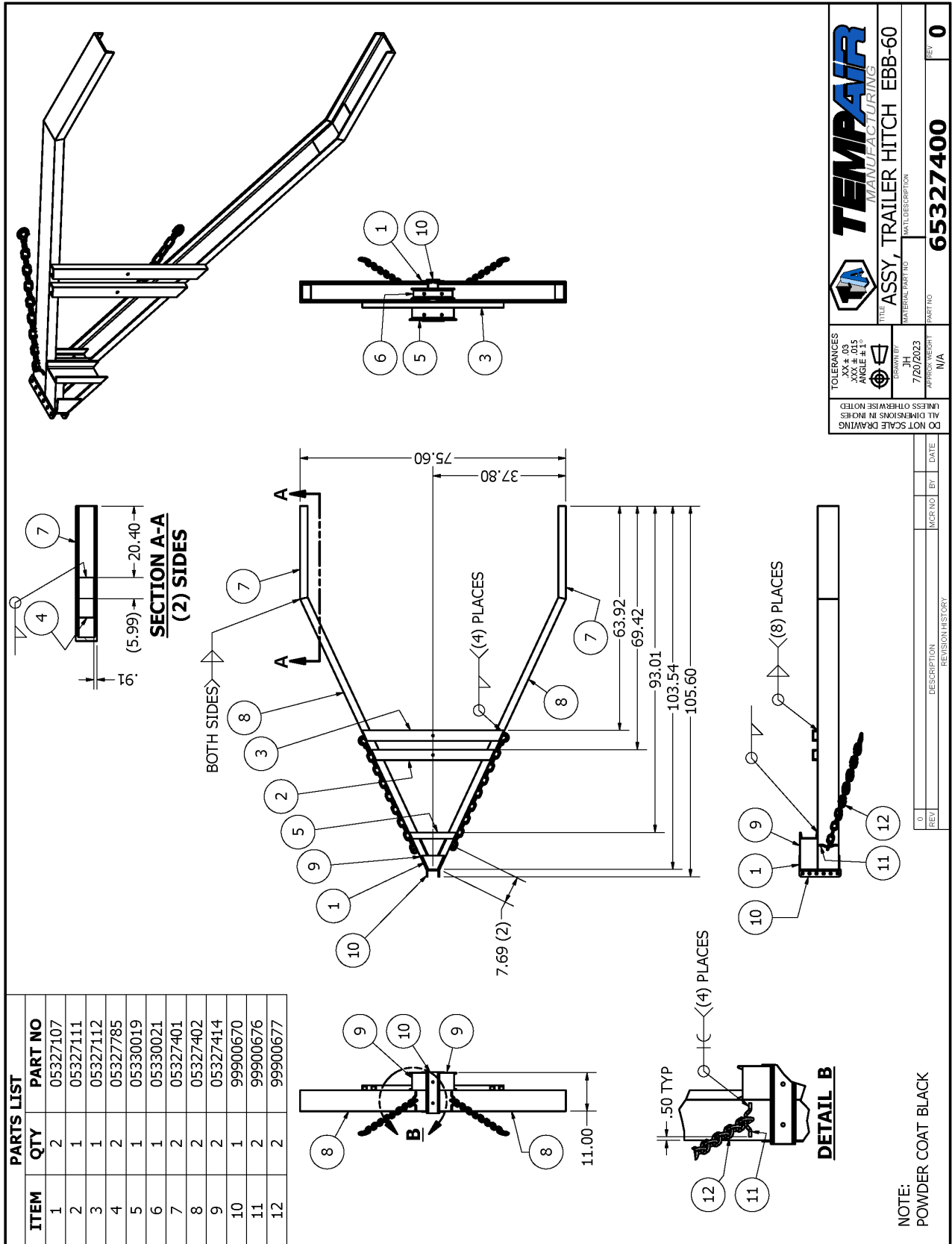
- D. Tongue jack
- E. Spare tire mounting bolts and spare tire

20. Have the trailer reinspected at a designated DOT Inspection Station.

**APPENDIX A: EBB-60 REPLACEMENT TONGUE TO TRAILER, WELDMENTS**



**APPENDIX B: EBB-60 REPLACEMENT TONGUE, ASSEMBLY**



**TEMPAIR**  
MANUFACTURING

ASSY, TRAILER HITCH EBB-60

DATE: 7/20/2023

PART NO: 65327400

REV: 0

TOLERANCES: .XX ± .03, .XXX ± .015, ANGLE ± 1°

APPROVED BY: N/A

NOT SCALE DRAWING

ALL DIMENSIONS IN INCHES

UNLESS OTHERWISE NOTED

DATE: 7/20/2023

FILE: C:\Inventor\Plant Remediation\EBB TIER 4\EBB-60\_MODEL\2018\REPLACEMENT HITCH Ebb-60-60\65327400.dwg