

RECALL 24V629 / 2024-489 REMEDY INSTRUCTIONS



Make(s): SALEM & WILDWOOD
Model(s): SBF325RL & WBF325RL
Model Year(s): 2024 - 2025

Concern:
The tire(s) may contact chassis components.

Repair Code: RC-005-09-00-004606
Allotted Time: 5.00 HRS.
Inspection Code: RC-005-05-00-004609
Allotted Time: .20 HRS.

Photo(s) Required: NO
Prior Authorization Required: YES
Part(s) Kit Number: F100654759
Part(s) Return: N/A

Turn off LP Gas at LPG Tank(s). Disconnect the vehicles' battery Positive and Negative, disconnect any House battery(s) Positive and Negative, if equipped with a generator ensure it is off and lastly, ensure the vehicle is disconnected from shore power. Block any tires/wheels to prevent the vehicle from rolling. Failure to do so may result in electrocution, fire or other personal injury, property damage and/or death.

PLEASE SEE ATTACHED REMEDY INSTRUCTIONS

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Safety

WARNING

The "WARNING" symbol above is a sign that the installation procedure has a safety risk involved and may cause death, serious personal injury, product or property damage if not performed safely and within the parameters set forth in this manual

WARNING

Always lift trailer by the frame, never the axle or suspension. Do not go under the trailer unless it is properly supported by jack stands. Unsupported trailers can fall causing death or serious injury. This repair should only be completed by an authorized service technician.

CAUTION

Always wear eye protection when performing service or maintenance to the trailer. Other safety equipment to consider would be hearing protection, gloves and possibly a full face shield, depending on the nature of the service.

CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

Resources Required

- 2 pre-cut 11 gauge riser tubes with axle hangers and angle brackets – Part number 862649101 (1 tube per order; 2 tubes needed for procedure)
- Jack stands
- Grease pencil
- Blow torch/plasma cutter
- Grinder
- Wire brush for grinder (cupped or flat)
- Tape measure
- Welder
- Floor jack
- Spray paint
- Safety glasses
- Rubber gloves
- Paint mask
- Clean cloth
- Cleaning solvent

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Instructions

Preparation

NOTE: Note: Dashed RED lines in this service form refer to using a plasma cutter/ blow torch to remove components. SOLID RED lines indicate the necessity of a welder to add frame components per instructions and image references. SOLID WHITE lines refer to making marks on the frame with a grease pencil. DASHED BLUE lines indicate the centerline of an area.

1. Remove any gas lines and/or other items that may be flammable. Remove obstructions that are in the way of tube weld to I-beam.
2. Lift front and rear of chassis/frame with floor jack and stabilize with jack stands.

NOTE: Rear jack stands should be 12"-24" from the rear of the trailer. Front jack stands should be 12" from front landing gear.

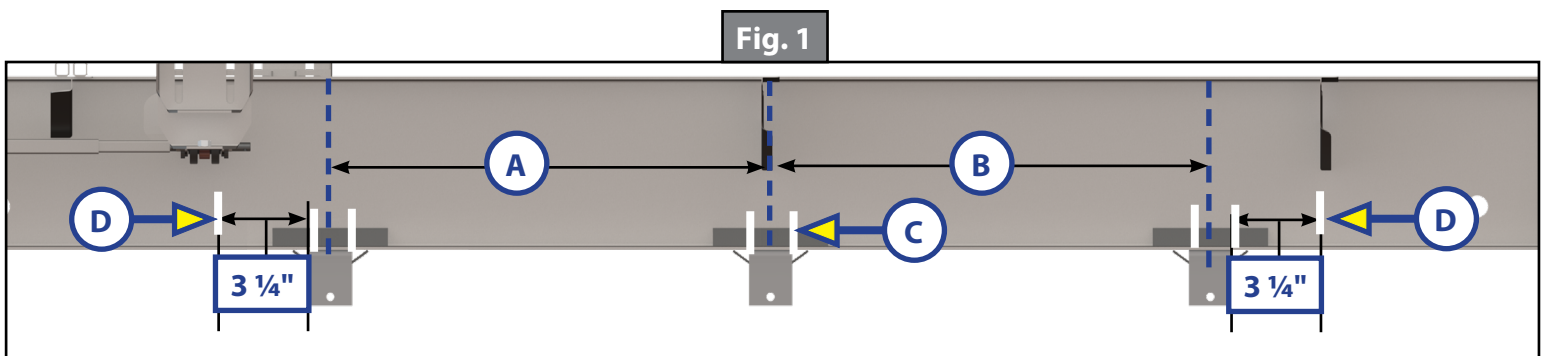
3. Remove tires, axles, and any additional suspension components from the axle hangers.

⚠ WARNING

Failure to remove flammable objects, obstructions, tires, axles or additional suspension components may result in death, serious injury or property damage.

Procedure

1. Measure the center-to-center distance of the current axle hangers from the center hanger out to each side (Fig. 1A and 1B). Record the measurements, which should be 29 1/2".
2. Verify the tube length, which is 3 1/4" beyond the hangers at each end (Fig. 1C).
3. Mark the location (WHITE lines) of each of the hangers on the I-beam with a grease pencil (Fig. 1C).
4. Mark the end locations (WHITE lines) for the tube placement (Fig. 1D).

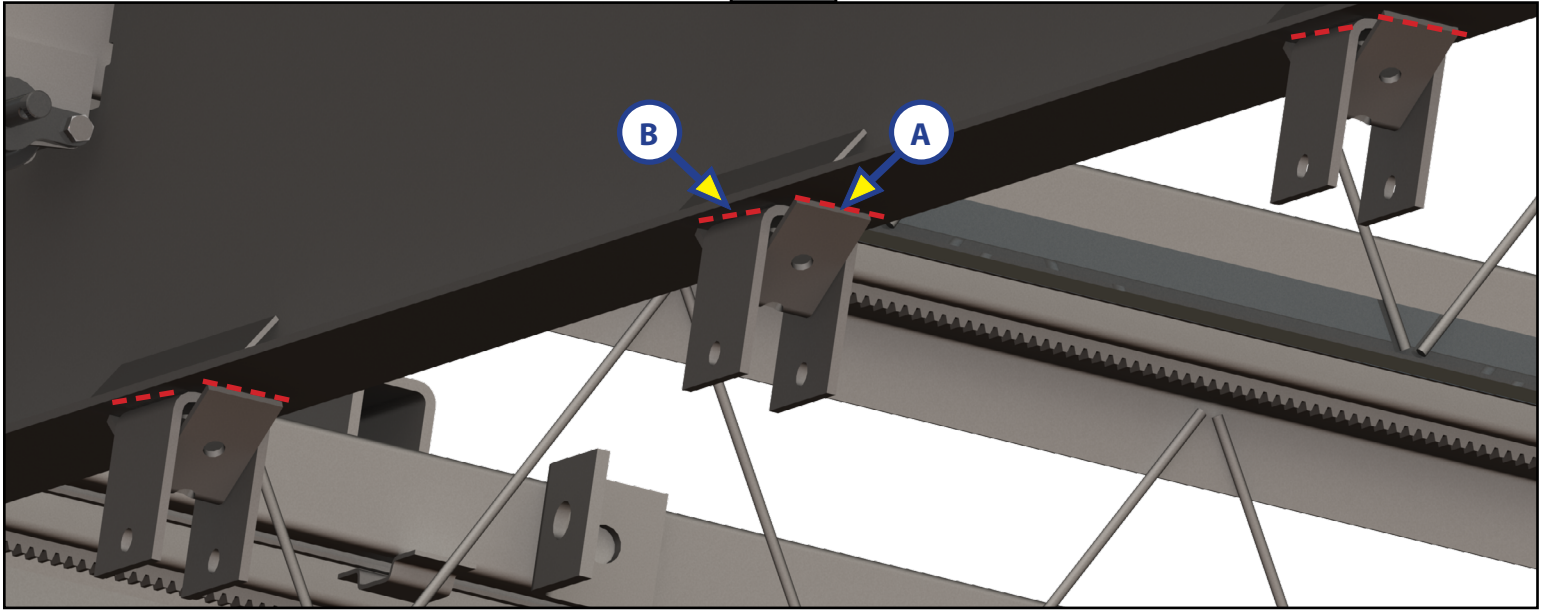


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NOTE: Old hangers and angle brackets may NOT be reused. Re-using hangers and axle brackets will result in compromised product quality.

5. Cut off the angle brackets around the hangers (Fig. 2A) (RED lines).
6. Cut the old hangers off of the I-beam (Fig. 2B) (red lines), then grind the affected I-beam areas until smooth. After grinding areas, wire brush the bottom of the I-beam to remove loose or flaking paint and/or rust.

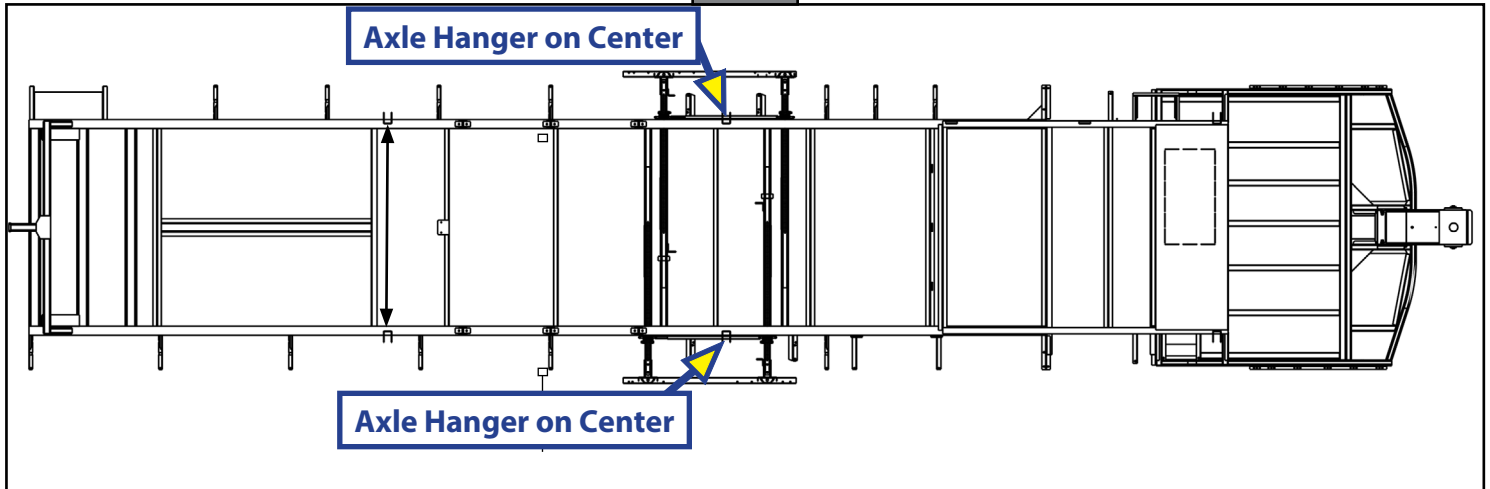
Fig. 2



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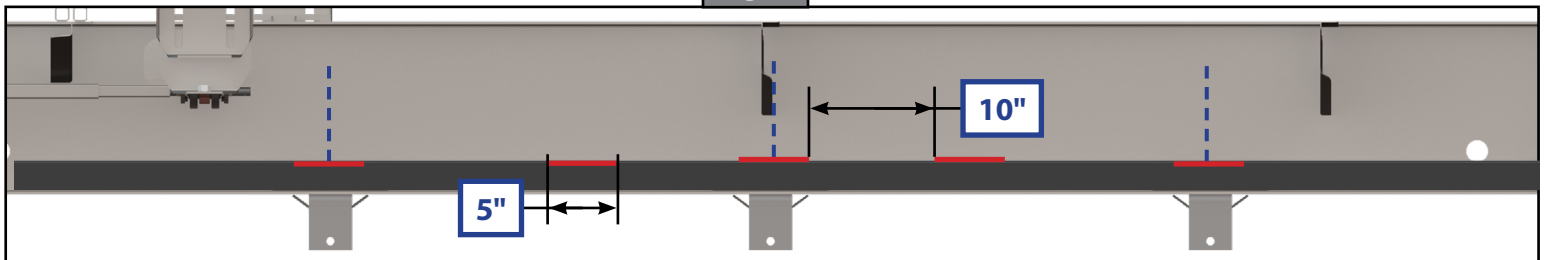
7. Tack weld the tube with hangers/angle brackets on both sides of the I-beam with hangers in the correct location as marked in Steps 3 and 4. Repeat on the opposite side of the trailer. Check the alignment to make sure tube/hanger assemblies are square (Fig. 3), and adjust, if necessary. Make sure that the new hangers are lined up with the marks on the I-beam where the old hangers were located.

Fig. 3



8. Stitch weld the tube 5" every 10", both inside and outside the I-beam (Fig. 4). Weld tubes to specifications as moving down inside then outside.

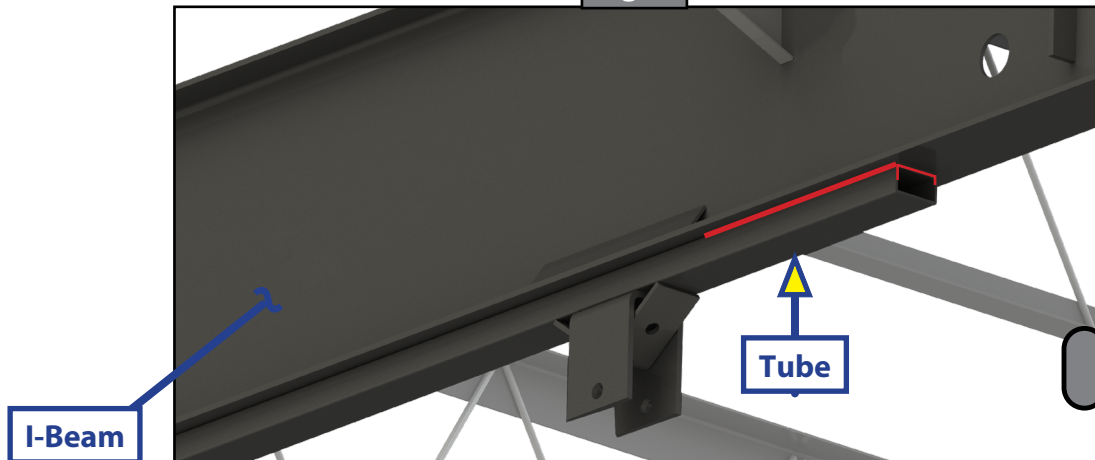
Fig. 4



9. Tube must be welded fully on both ends. Wrap 5" weld around all four corners (Fig. 5).

NOTE: Tube **MUST** also be fully welded above hangers on both sides.

Fig. 5



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⚠ WARNING

Always use rubber gloves and paint mask when using cleaning solvent.

10. After the welds have cooled wire brush welds. Clean with a clean cloth and cleaning solvent.
11. Apply paint to any discolored spots on the frame and the welds.
12. Reinstall all items that were removed prior to removal of axles.
13. Reinstall axles, tires and other suspension components previously removed in the Preparation section.
14. Lower the trailer to the ground.

Modifying Actuator Bracket

1. Cut a 3/8" section out of the bottom of the front actuator bracket (PN 134707) (Fig. 6).

Fig. 6

