

Recall Repair Instructions

NHTSA Recall # 24V-669

Transport Canada Recall # 2024-529

Tiffin Motorhomes Recall # TIF-142

Models Involved: 2022 – 2025 Allegro Bay Motorhomes

Purpose: To provide instructions on how to reinforce the subframe of the motorhome house structure.

Tools:

Motorhome Lift
Measuring tape
Jack stands, minimum of 10 tons
Welder
Welding Blankets

Parts:

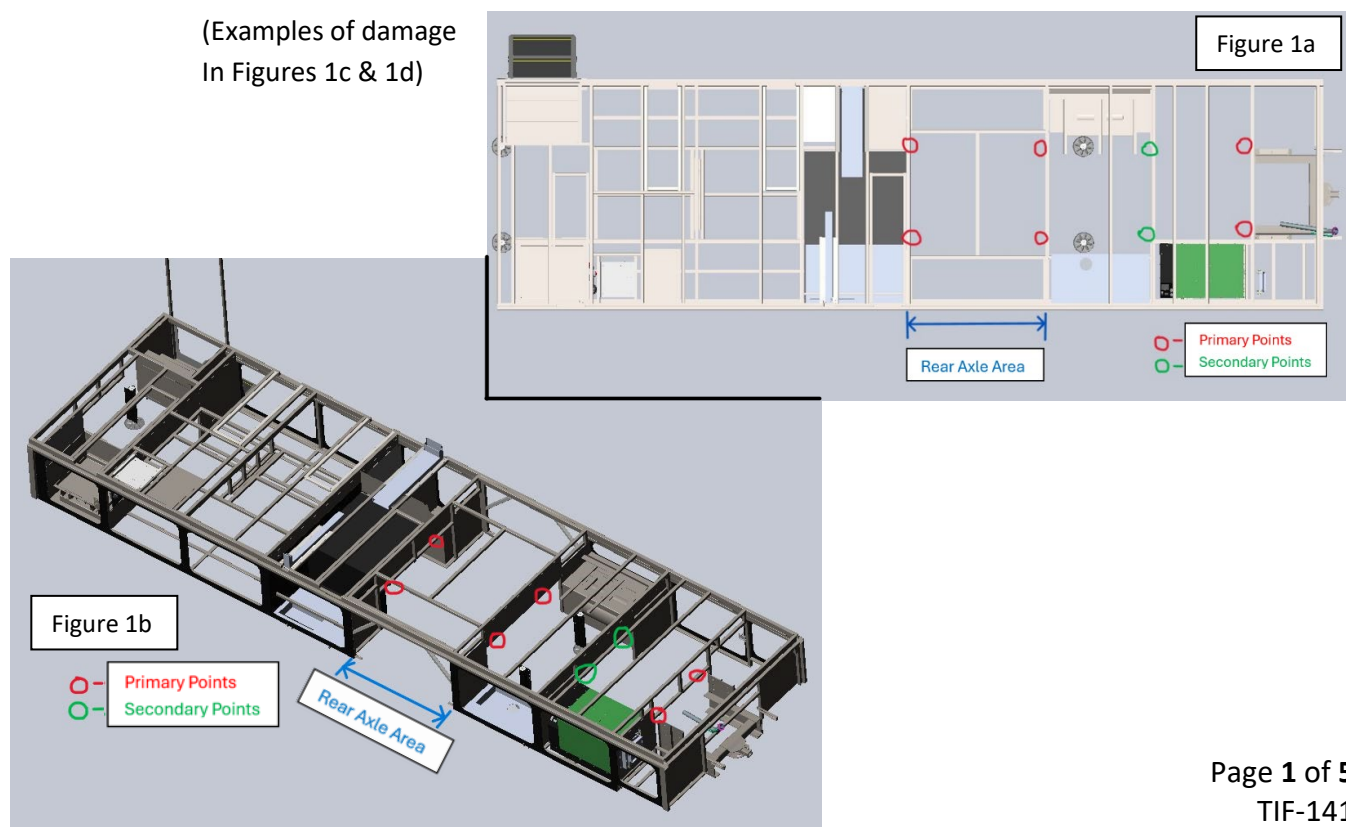
1 ½" x 1 ½" 11 Ga steel tubing
1 ½" x 3" 11 Ga steel tubing
Black spray paint
¼" Flat stock

FLAT RATE CODE & TIME ALLOWED When filing the warranty claim for payment, please use the following flat rate code. **9886RC01, 8.00 hours.** For additional repair time, please contact service@tiffinmotorhomes.com. **No authorization is required for work completed at the flat rate times stated on the work instructions.** Use "TIF142" as the authorization on claim for payment.

Inspection Procedure:

1. Put motorhome on a motorhome lift and raise the lift to a comfortable height to visually inspect the trusses, Figure 1c, on each side of the rear axle and next to the last truss as indicated on Figure 1a & 1b.

(Examples of damage
In Figures 1c & 1d)



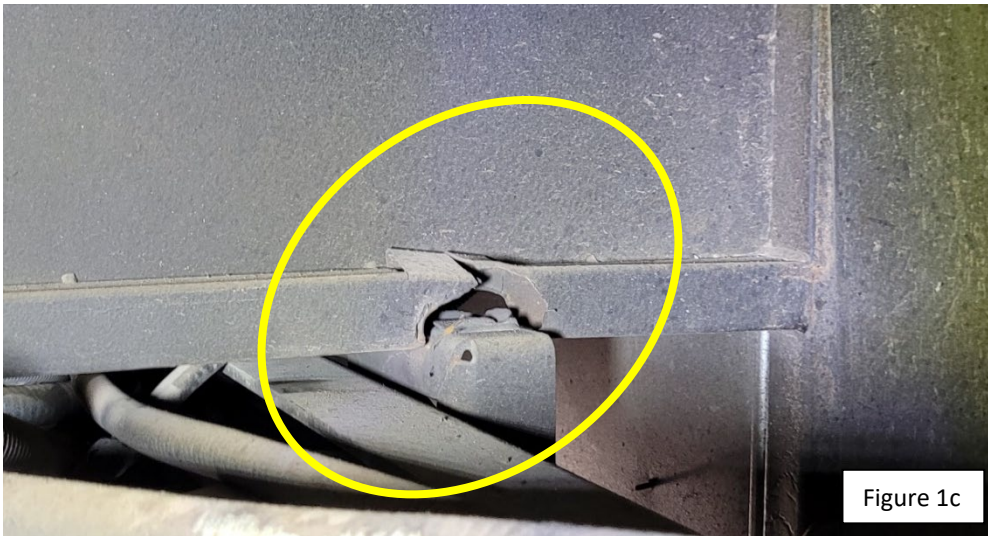


Figure 1c

Example of Damage to Truss

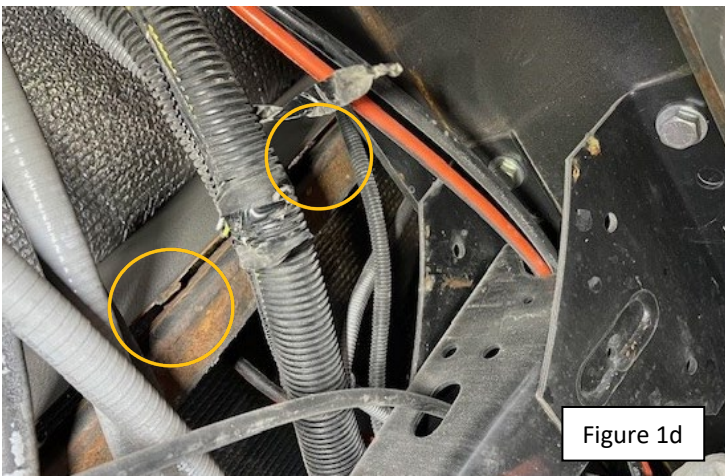


Figure 1d

Broken Welds between sheet metal face and tube truss.

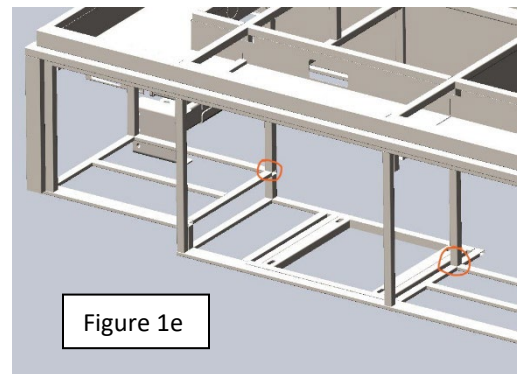


Figure 1e

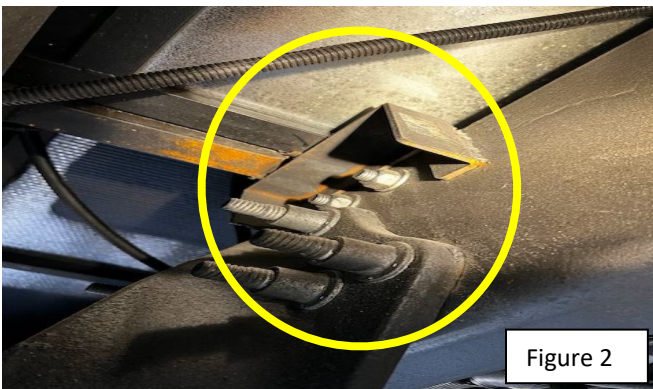


Figure 2

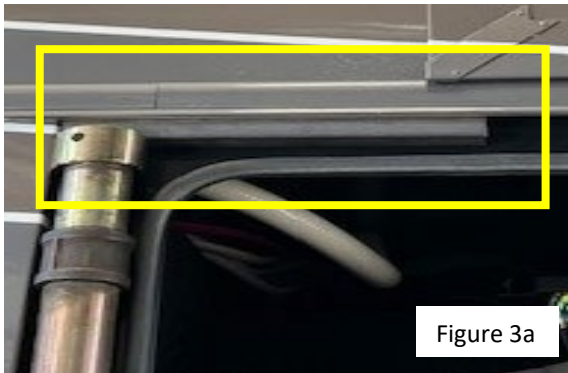
2. Check the horseshoe (Figure 2 above) for damage. The picture above shows one example of a horseshoe, depending on the location, it can look different from the picture below.
3. Check the welds on the generator rack down tubes to the trusses. (Figure 1e)
4. If damage is found, proceed with step 1 of the repair procedure.

- If no damage is found, skip steps 1, 2 and proceed with step 3 of the repair procedure.

Repair Procedure:

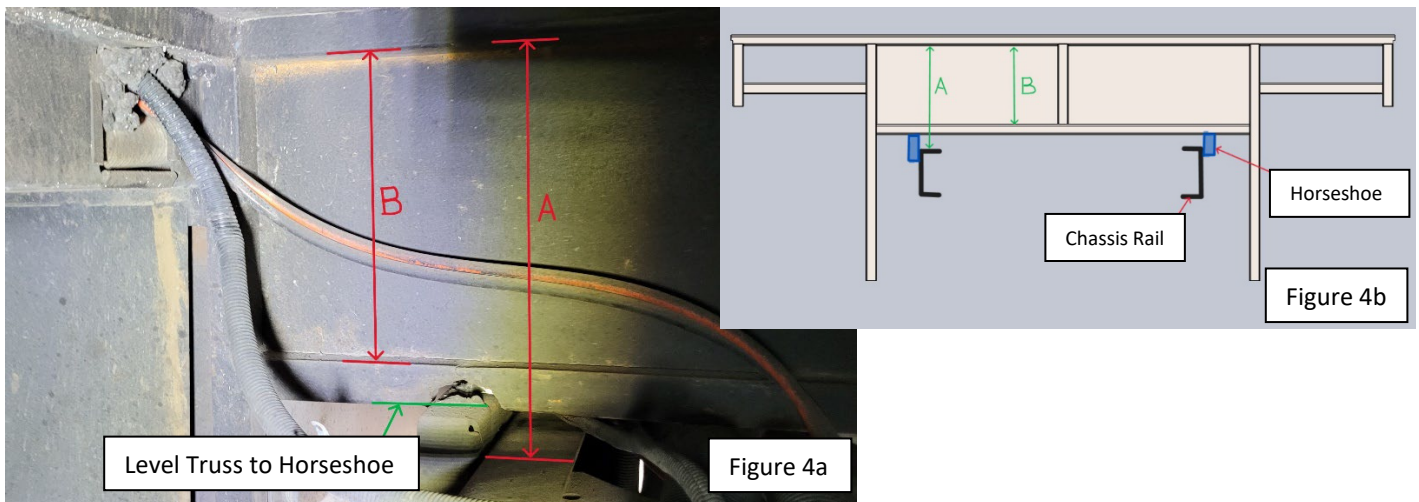
Note: Prior to performing any welding, disconnect the House and Chassis batteries completely, inside the first compartment on Driver's Side.

- For units with damage, jack stands will need to be set up. A section of 1 ½" x 1 ½" 11-gauge tubing will need to be placed between the outside edge of the subfloor structure, just below the beltline extrusion and the top of the jack stand as shown in figures 3a and figure 3b. There will need to be one jack stand on each side of the coach beside the truss to be worked on at that time. Start on the next to the last truss as shown in Figure 1a & 1b above.



- With the jackstands in place on each side of the motorhome, begin to very slowly lower the lift. The weight of the house structure will be held in place while the weight of the chassis pulls away. This should only be from ½ inch to 2 inches. The bottom surface of the truss frame should be even with the top surface of the horseshoe. See Figure 4a.

Note: Do not lower lifts completely away from tires.



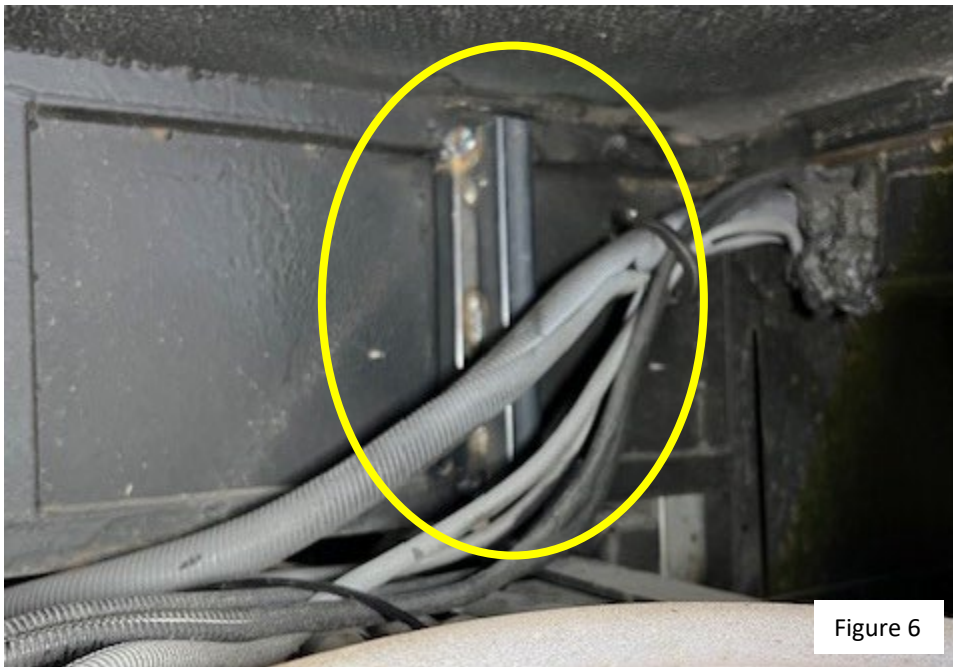
- Take measurements from the top of the chassis rail to the bottom of the upper tube of the truss and add 1 ¼" for the length of the 1 ½" x 1 ½" tube. See Figure 4a & 4b, measurement "A". For the 1 ½" x 3" tube, measure the distance between the bottom of the upper truss tube and the top of the lower tube and subtract 1/8". See Figure 4a & 4b, measurement "B".

4. Build the tube assembly with the 1 ½"x 1 ½" and 1 ½" x 3" tubing. Use measurements from step 3 to fabricate the brace as shown in figure 5.
Note: Offset the 1 ½" x 1 ½" tube by 1 ¼" above the top of the 1 ½" x 3" tube.



Figure 5

5. Set the fabricated brace in place on top of the chassis rail with the body of the 1 ½" x 3" tube going between the upper and lower tubes of the truss as shown in figure 6.
Note: It is recommended to begin the reinforcement at the rear most position and work your way forward on the motorhome.

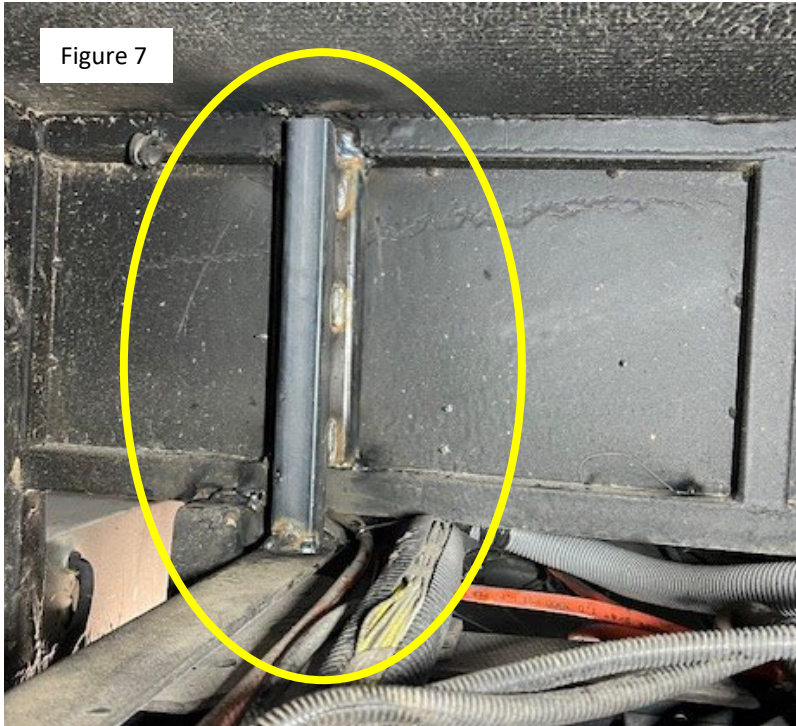


Note: Be very cautious of hydraulic lines while welding.

Figure 6

6. Before welding the fabricated brace in place, cover all surrounding wire harnesses, air lines, or hydraulic lines in this area with welding blankets to prevent damage to these components.

7. Weld the fabricated braces into place by welding the body of the 1 ½ x 1 ½ tube where it contacts the side of the upper and lower tube of the truss, the top of the chassis rail, and the 1 ½" x 3" tube where it contacts the upper and lower tube of the truss. See figure 7.



Note: Be very cautious of hydraulic lines while welding.

8. Any damage to the horseshoe bracket can be repaired by welding a piece of the ¼" flat stock to the horizontal face inside horseshoe. Also, weld the inside formed corners of the bracket. Ensure welds connecting the bracket to the chassis rail are intact.
9. Repeat this process in the other 5 – 7 locations as shown in Figure 1a and 1b regardless of damage, as well as any truss that shows damage.
10. Use black spray paint on all added tubing to protect against rust.
11. Remove Welding Blankets and inspect all areas of repair to ensure quality of hydraulic lines, air lines, and electrical wiring.
12. Raise the motorhome lift to fully support the weight of the coach to free the jack stands and remove.
13. Lower motorhome to the ground and reconnect both sets of batteries, House and Chassis.