



## A-Frame Additional Support

<b>Bulletin Type:</b>	Technical Service Bulletin TSB	<b>Publication Date:</b>	April 23, 2021
<b>Bulletin #:</b>	20-025	<b>Make(s):</b>	Starcraft
<b>Job Code:</b>	9802517	<b>Model(s):</b>	GPS
<b>Flat Rate:</b>	1.5 Hours	<b>Model Year(s):</b>	2018

<b>Incident:</b>	Missing floor supports in the trailer frame could allow frame flexing that may cause cracks in the corner radius of the fiberglass.
<b>Affected Units:</b>	<b>2018 GPS Travel Trailer</b> J24A5050-5098 J24B5050-5116 J24L5050-5122 J24S5050 J24T5050-5113
<b>Parts:</b>	<b>Kit #: 20-025SC</b> <b>Contents:</b> 2 - CROSSMEMBER,C-CHN 3.00X1.50X1.50X.09XL14.00 16 GA Floor Support Channels
<b>Misc. Tools &amp; Supplies:</b>	C-Clamps & Tape Measure Grinder or Sander Steel Welder Wire Brush & Spray Paint (Black Rustoleum or Equivalent)

## INSPECTION

- Verify the VIN is in the TSB scope. All affected units require this remedy. #1
- Inspect unit for missing floor supports in frame and any signs of stress cracks at corner radius of fiberglass. #2





Step 1: Review instructions in their entirety, and ensure required tools and PPE are available before starting this repair.

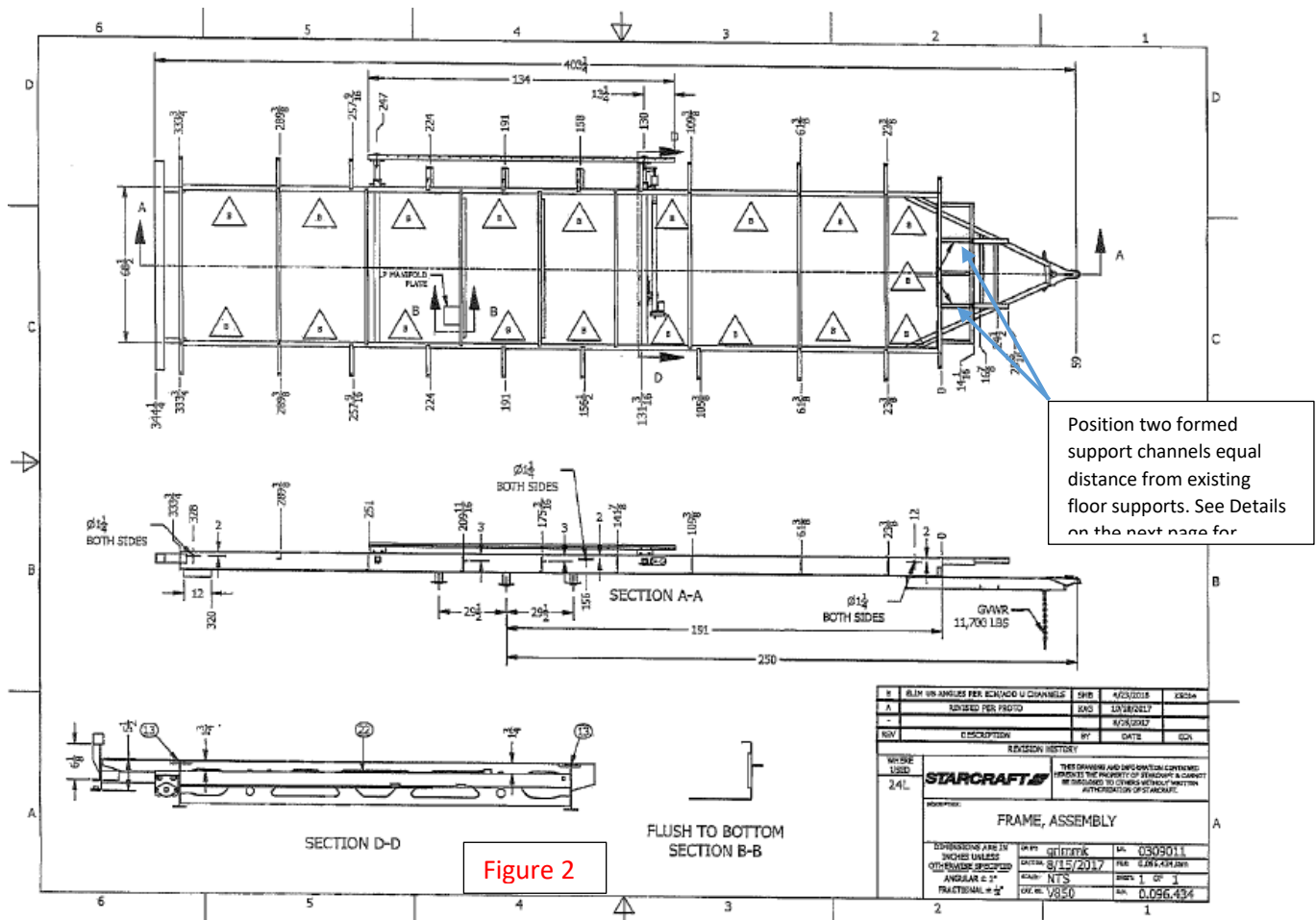
Step 2: Obtain parts kit containing instructions and two floor support channels shown in picture #4.

Step 3: Confirm two floor support channels - 3" tall x 1 1/2" flange x 1/16" thick x 14" Length

Step 4: Measure placement of c-channels and prep area for welding by grinding or sanding paint from frame member.  
Picture #5



Step 5: Position c-channels equal distance between existing supports as shown in Figure 2. Raise the 3" c-channels upward and position flush to top of frames, bottom of floors as shown in section view Z-Z page 6. Clamp c-channels into position.



Step 6: Weld the two 3" c-channels into position as shown in figure 3 and section View Z-Z shown below.

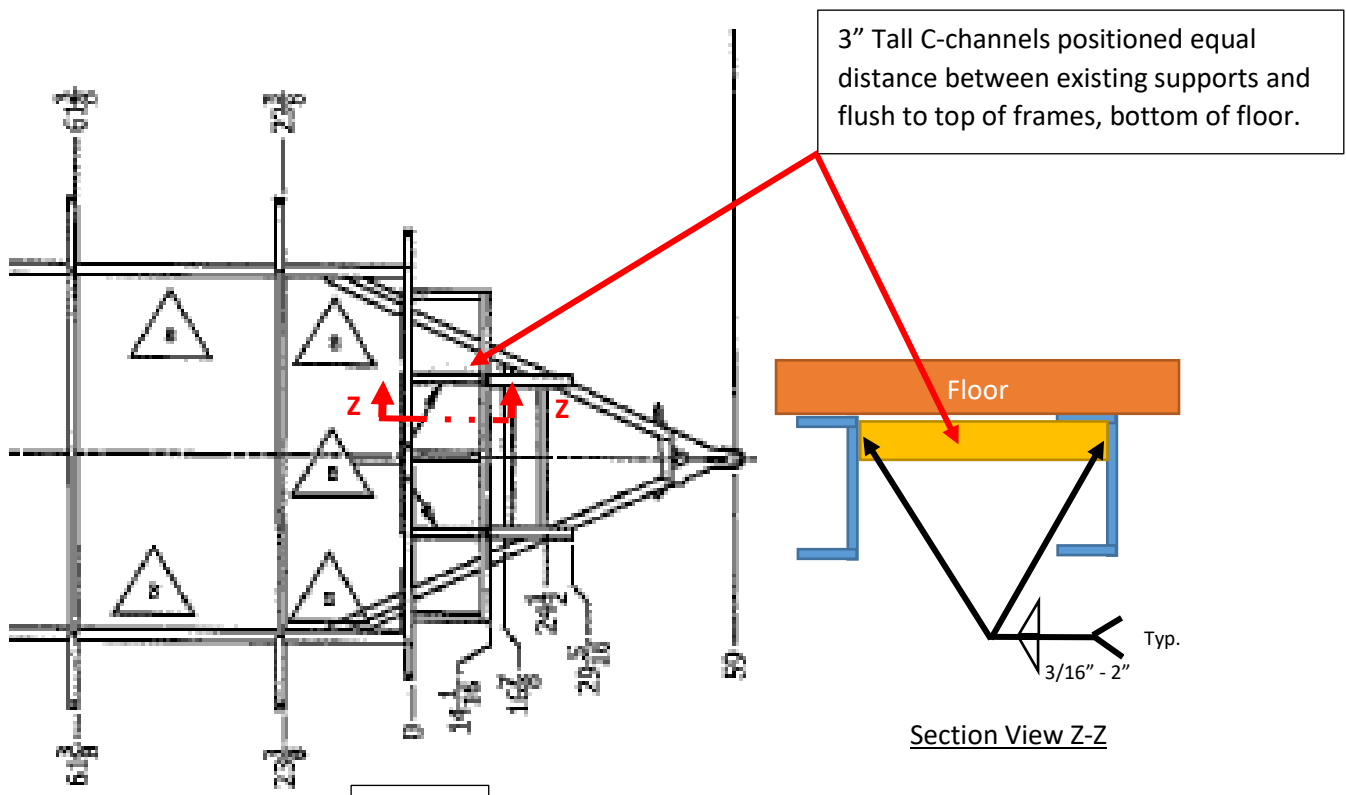


Figure 3



Step 7: After welding is complete, wire brush weld area (both channels) to remove all weld slag #6, #7.

Step 8: Touch up bare metal with a Rustoleum spray paint or equivalent. Allow to dry and apply two coats.  
#8



Step 9: If fiberglass is stress cracked submit a pre authorization request to perform a fiberglass repair.

Step 10: Prepare and submit your claim showing TSB as completed.

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