Slide Out Crack Instructions

Bulletin Type:	SRP
Bulletin #(s):	22-043
Job Code(s):	N/A
Flat Rate(s):	• "Pinnacle RU" model not to exceed 48 hours total, • All other models not to exceed 36 hours total • If Structural C-channel and frame tube is needed add 4 hours labor total • If LP gussets needed add 1.5 hours labor per gusset

Publication Date: **Revision Date:**	January 2022 February 2022
Make(s):	Jayco
Model(s):	North point, Pinnacle, Eagle, Eagle HT 5th Wheels
Model Year(s):	Before Model Year 2021

Incident:	**Crack forming at the front bottom corner of the off door side (ODS) or door side (DS) Front Slide Out**
Affected Units:	North point, Pinnacle, Eagle, Eagle HT 5th Wheels , Before Model Year 2021
Parts List:	- 2 – 0326331 Steel Gusset (If needed after inspection, order or source locally) - 1 - 5" x 6.7LB 86" Structural C-channel (If needed after inspection, source locally) - 2 – 2" x 3"-11GA x 120" steel tube (if needed after inspection, source locally) - 1 – 2028834 -16.25" x 1" x1" 14GA LP steel angle(If needed after inspection) - 1 – 2028833 - 7" x 1" x 1" 13GA LP steel angle(If needed after inspection) - 1 – 2028832 - .38-16 x 10" threaded rod (If needed after inspection) - 2-0403922 Strap, LP (If needed after inspection) - 2 - 0501848 – Aluminum Gussets 9.50" x 9.50"(order or source locally) - 1 set– 0403478 1 set = 25 screws

	- 1 – 0160674 Galvanized Steel backer 3” x 96” - 6 – 0087179 #221 Sikaflex adhesive - 1 - Fiberglass , Gelcoat panel or Filon panel (This part is unit specific) - 1 – Front Side wall Decals (These parts are unit specific)
Misc. Tools & Supplies:	- Standard Misc. hand tools - Caulk - Putty tape - Variety of screws - Scrap 3’ x 6’ 1/4" - 3/8" plywood and wood wedges, 2"x4"-8', - Misc electrical connectors (if applicable) - Shingle Scraper - Tig welder for Aluminum and Steel (or sublet to perform the welding) Fiberglass / paint repair (or sublet to perform the fiberglass / paint repair) - Pin box stand
Parts Return Information:	N/A

INSTRUCTIONS FOR REPARING A SLIDE OUT CRACK

Please read the following instructions thoroughly before starting the repair. If you have any questions, contact Jayco customer service department.

Introduction:

This document will guide you through the repairs of a slide out crack that has appeared at the bottom front corner of the front slide out opening.

NOTICE

Indicates a potential situation that,if not avoided, may result in property damage or damage to your RV.

⚠ CAUTION

Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

⚠ DANGER

Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury. This alert information is limited to the most extreme situations.

⚠ WARNING

Indicates a potentially hazardous situation that, if not avoided, may result in death or serious injury.

Note: a "note" is not necessarily safety related, but indicates a recommendation or special point of information that could assist in understanding the use or care of a feature item.

Safety and precaution:

Table of contents

1.0 Measure Upper Deck Flex

A. Reference LCI Upper Deck Flex
   a. Measurement sheet (LIP SHEET 0236) for measuring front flex of unit. Unit should not flex more than ¼", if flex is more than ¼" contact Jayco customer service for further instructions
B. Document the upper deck flex before the repair and **after** the repair is completed, keep for your records.

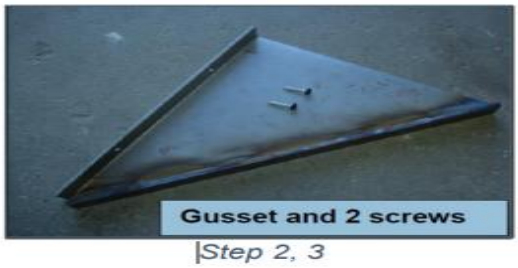
2.0 Inspect unit for steel gussets in LP compartments

A. Inspect ODS and DS LP compartments per Jayco TSB 18-012 for a welded steel gusset shown in top picture of Figure 1A (part number 0326331) on vertical tube.

B. If the steel gussets (part number 0326331) **are in place**, continue on to "inspect I-beam for tube" section.

C. IF the unit has the 2 40LBS LP tanks option, you will need to order Jayco part numbers 2028832, 2028833, 0403922, 2028834 for the repair

D. If the steel gusset (part number 0326331) **is not in place**, see Jayco TSB 18-012 to install gusset. Repeat the TSB-012 process for the ODS (off door side) as well.



Step 2, 3


Steel Gusset installed between tanks on ODS

Fig 1A

⚠ CAUTION

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

3.0 Inspect/measure I-beam for tube

Eagle FW & Eagle HT FW DO NOT get tube or c-channel added

Note: Measure the front ODS I-beam, if the I-beam measures 8" you will need to add tube. See section 11.0 for instructions

⚠ WARNING

Always make sure that the slide-out room path is clear of people and objects before and during operation of the slide-out. Always keep away from the gear racks when the slide-out room is being operated. Obstructions in the slide-out room's path can cause serious personal injury, severe product or property damage.

A. Disconnect all 120VAC and 12VDC power to the unit before unhooking any electrical connections.

4.0 Removing Bedroom Slide Out Room

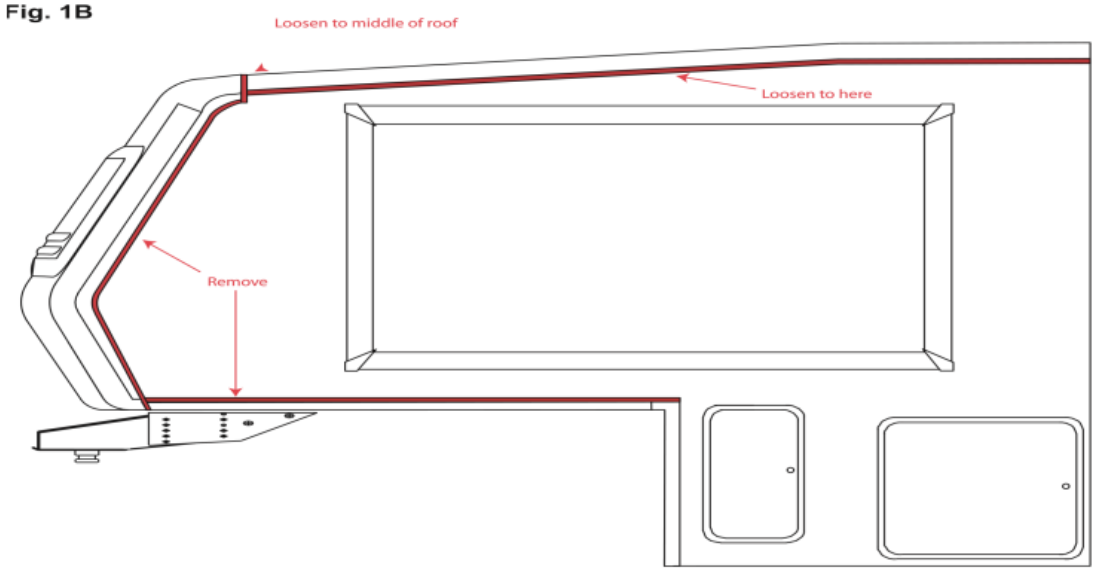
A. Remove/Save all **Interior** slide out attachments for the slide out room to use on reassembly. Attachments will be different for each model.
B. Remove/Save all **Exterior** slide out attachments for the slide out room to use on reassembly. Attachments will be different for each model.
C. Unhook any plumbing connections attached to the slide out room (if applicable).
D. Unhook any 12 VDC and 120VAC electrical connections attached to the slide out room (if applicable).
E. Support the slide out room safely with proper lifts.
F. Remove any bolts/screws that secure the slide-out room to the interior or exterior of the coach.
G. Safely remove slide-out from the coach wall opening with proper lifts.
H. Remove/save bottom slide out pan with seal (replace if damaged).
I. Remove bottom slide out corner pan with seal (replace if damaged).

5.0 Loosening Exterior Wall, Cap and Roof Trims

A. Remove/Save the front vertical cap trim to access cap trim screws. (Figure 1B)
B. Remove all front vertical cap trim screws. (Figure 1B)
C. Loosen the screws from the roof line trim from the front cap to about the rear of the slide. **(Figure 1B) Do not remove this trim**.
D. Remove/Save lower goose neck molding.
E. Remove/Save the slide-out drip rail.
F. Loosen front cap to access full side of wall.

> **NOTE:**
>
> The front cap DOES NOT need to be removed from the coach to perform this repair. (see Figure 1B)

Fig. 1B

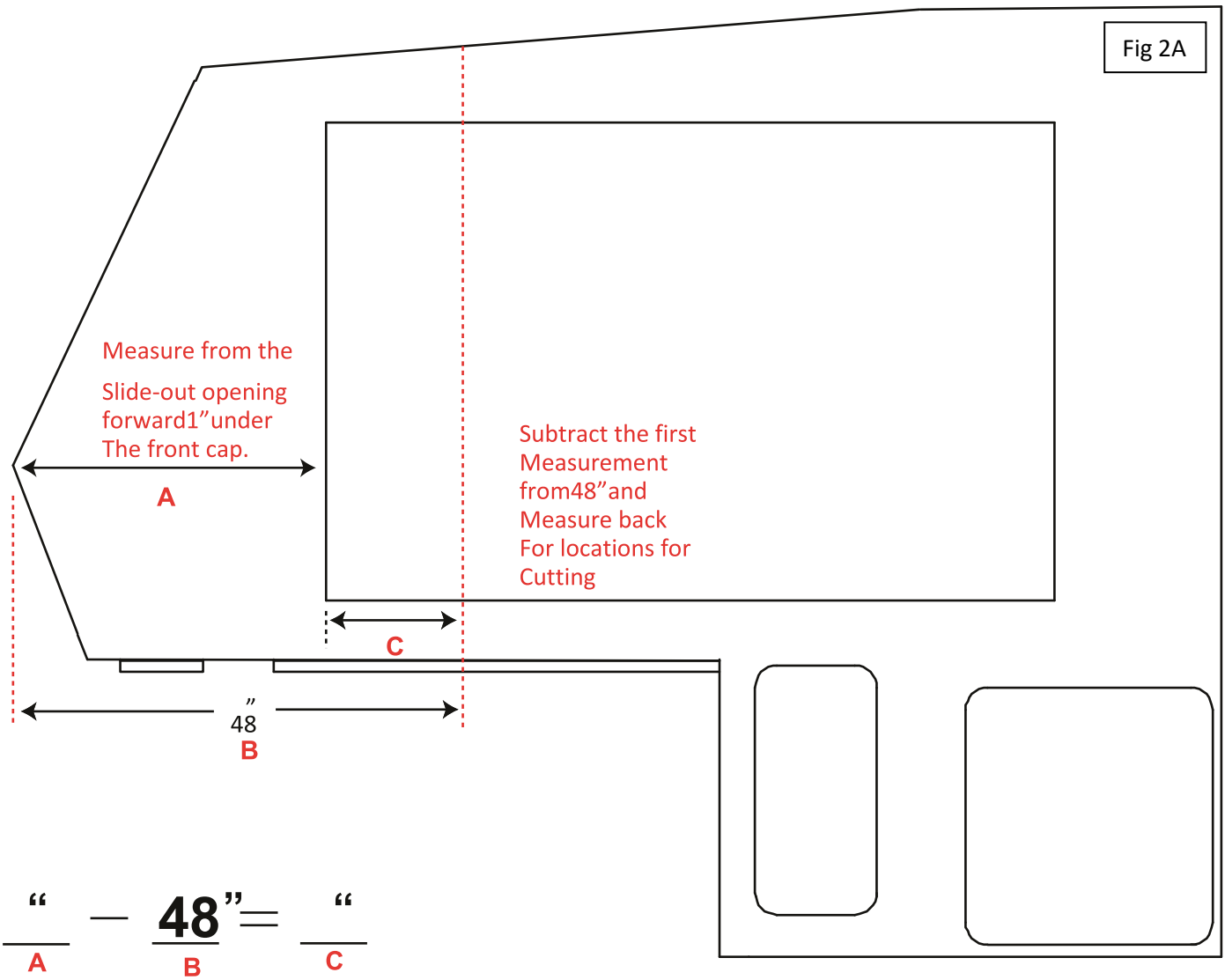


6.0 Removing Fiberglass/Filon Panel from coach wall

A. Measure from the front point of the sidewall to the slide-out opening. (Figure 2A)
B. Subtract this measurement from 48" and measure from slide-out opening back for cutting location. (See the table on Figure 2A for help)
C. Make a cut through the fiberglass/filon siding at the markings both top and bottom of the slide-out. Multiple shallow cuts will be needed to ensure you do not cut the aluminum tube below the glass.
D. Remove the fiberglass and luan from the aluminum framework by using a scrapper or a chisel.

Note: DO NOT damage the aluminum frame.

Fig 2A



NOTE: Save removed fiberglass/filon panel to use as a template in later steps if possible.

E. For re-installation on new fiberglass/filon panel. If backers are damaged upon removing from fiberglass/filon panel, you will need to make your own from 3"X 96" galvanized 28 gauge steel.
F. Remove all glue and wood pieces from aluminum frame work with a scrapper and a hammer.
G. Clean all surfaces of the aluminum frame work with a wire wheel. All glue and wood pieces must be removed.

7.0 Installing Aluminum Gussets on Coach Wall

A. Block all coach wheels.
B. Place a support under the pin box.
C. Using the landing gear, lower the coach so that all the weight is on the pin box.

Note: All weight must be on the pin box.

D. Do not lift the front landing jacks more than ½" off the ground when the full weight is on the pin box.
E. Remove the styrofoam from bottom of the triangle portion of the coach wall structure for gusset placement (if applicable).
F. Cut down one aluminum gusset (part number 0501848) to fit inside of the bottom of the triangle portion of the coach wall frame.
G. Weld aluminum gusset (part number 0501848) into bottom of the triangle portion of the coach wall frame.

Note: Figure 2B below shows Aluminum Gussets installed

H. Cut 2" off the tip of the aluminum gusset (part number 0501848) and drill three 7/8" holes in middle of gusset.

I. Weld aluminum gusset (part number 0501848) areas (drill hole area as stated in step H also) across the bottom of the wall frame. Inspect all existing exposed wall frame welds for cracking. Re-weld as needed (see figure 2B).

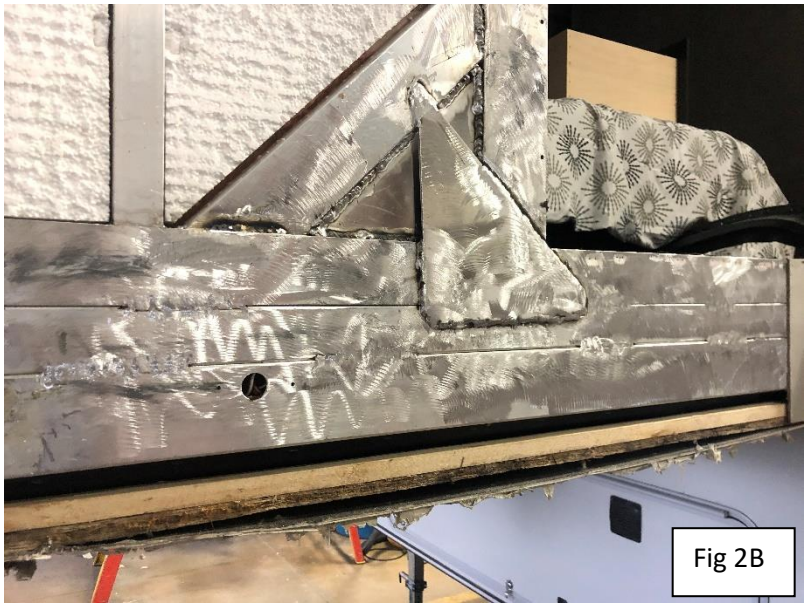


Fig 2B

J. With a ball peen hammer indent all areas where welding is to be done on frame. Indent enough for welds to hold and to be ground flat. (Shown in Fig 3).

K. Weld all tube seams together with 3” long beads spacing to making sure you have at least 3 welds. (Shown in Fig 4)
L. Grind all the welds on side wall tubes and gussets for a flush surface.


Fig 3


Fig 4

⚠ CAUTION

Use caution while drilling and screwing into the main frame rail steel tube. There is a wire harness that is routed through the frame rail. Do not damage the harness.

8. Install 4” Long Screws (part number 0403478) into Goose Neck Steel Angle

A. See Standard Repair procedure (SRP 19-010) for further detailed instructions.
B. The plywood strips covering the screws that need to be replaced. (See Figure 5)
C. Remove the screws and or nails holding the plywood in place.
D. Remove all the screws from the black angle under the plywood strip.
E. Drill out all the screw holes using a 1/4" bit.
F. Install new 4" long lag screws (part number0403478) in the holes just drilled, using a screw gun with a #3 Philips head Bit shown in Figure 5.
G. Inspect wall angle to ensure welds are there and not cracked.


Fig 5

⚠ CAUTION

DO NOT DRILL THE HOLES THROUGH THE ALUMINUM TUBE. Drill only deep enough to penetrate the steel angle.

9.0 Installing the New Fiberglass/Filon Panel on Coach Wall

A. If the original fiberglass/filon came off the coach wall in one piece, use this as a template to trace on the new piece of fiberglass/filon.

B. If original fiberglass/filon piece is not useable as a template, measure the coach wall carefully and cut new piece to fit on the wall.
Figure 6 shows New "C" shaped fiberglass

C. Place the metal backers (part number 0160674) in the same location on the new fiberglass /filon panel, as they were located on the original fiberglass/filon panel. Use masking tape to hold the metal backers (part number 0160674) in place while installing new fiberglass/filon panel.

D. Test fit fiberglass/filon panel in place. Check to ensure front cap covers new panel and seams are even. Make adjustments to the fiberglass/filon panel as needed. Retest fit as needed.

E. Remove fiberglass/filon panel.

F. Gather all the plywood (a piece of 3' x 6' 3/8" plywood), wood wedges (12 needed) and clamps needed to secure fiberglass/filon panel to the coach wall. You will secure the panel as shown below. (Figure 7)

G. Figure 7 shows bracing of new fiberglass to side wall.

Fig 6

Fig 7

Note: You must maintain an even bead and a maximum of 2”-3” “S” pattern on the adhesive for proper adhesion of frame/styrofoam to sidewall.

H. Cut the nozzle of your tube of adhesive to 3/8”– ½”. Apply the adhesive to the side wall working from the top down.
I. Apply adhesive to all areas until you get an estimated 6” from the gussets welded in the triangle wall area.
J. Starting at the gusset apply a heavy bead that is about 1/8” – ¼” taller than the gussets.

Figure 8 shows the glue pattern, thicker around aluminum triangle.

Fig 8

NOTE: DO NOT put any adhesive on the face of the gusset. This will make the fiberglass not lay flat and create a bulge in this area.

K. Slowly apply the adhesive in the “S” (No more than 2”- 3” spacing) pattern away from the gusset and feather the bead size back to 3/8” close to the fiberglass seam. (See Figure 8)
L. Repeat as needed around the rest of the gusset.

M. Carefully align the new fiberglass/filon panel on the sidewall.

NOTE: If fiberglass/filon is loose at the cut edge of the coach wall seam, apply some Sikiflex under the seam.

N. Clamp the sidewall fiberglass in place, install screws in any locations that trim will cover. (See Figure 7)
O. Make sure you place 3” – 4” masking tape over the seam.

NOTE: Not using masking tape will allow the adhesive to contact the plywood and you will not be able to remove after it has dried.

P. Apply pressure to the upper and lower seams by using small pieces of 1/2” plywood. (See Figure 7)
Q. Screw the plywood at the top and bottom edges making sure they are in areas that trim will cover. (See Figure 7)

R. Wedge the cap to the sidewall with the use of wood wedges. (See Figure 7)

S. Place a piece of 3’ x 6’ 3/8” plywood against the sidewall. Place a 2” x 4” board over the plywood and screw the 2” x 4” to the top and bottom of the sidewall to hold the fiberglass section in place. (See Figure 7)

> **NOTE:** This is to apply even pressure to the sidewall for equal adhesion.

T. Follow the recommended adhesive dry time normally 24 hours.

> **NOTE:** Do not take weight off of the pin box till the 24 hours is up.

U. After 24 hours, remove all wedges, boards, and plywood.
V. Remove all screws that were used to hold the new fiberglass sidewall in place.

10.0 Preform Fiberglass/Filon Repair on Wall Seams

> **NOTE:** Follow Jayco repair Instructions for smooth and gelcoat fiberglass to repair the seams on the new sidewall joints. Use a sublet to perform fiberglass and paint repairs.

11.0 Inspect I-beam for tube and c-channel

> **Note:** DO NOT add tube or c-channel for Eagle FW & Eagle HT FW

A. Measure the front ODS I-beam from top of beam to bottom.

B. If the I-beam measures 10”, no further repairs needed. Continue to “installing bedroom” section.
C. If the I-beam measures 8”, follow steps below for repairs.
    a. **Standard labor time for this addition repair is 2 hours**

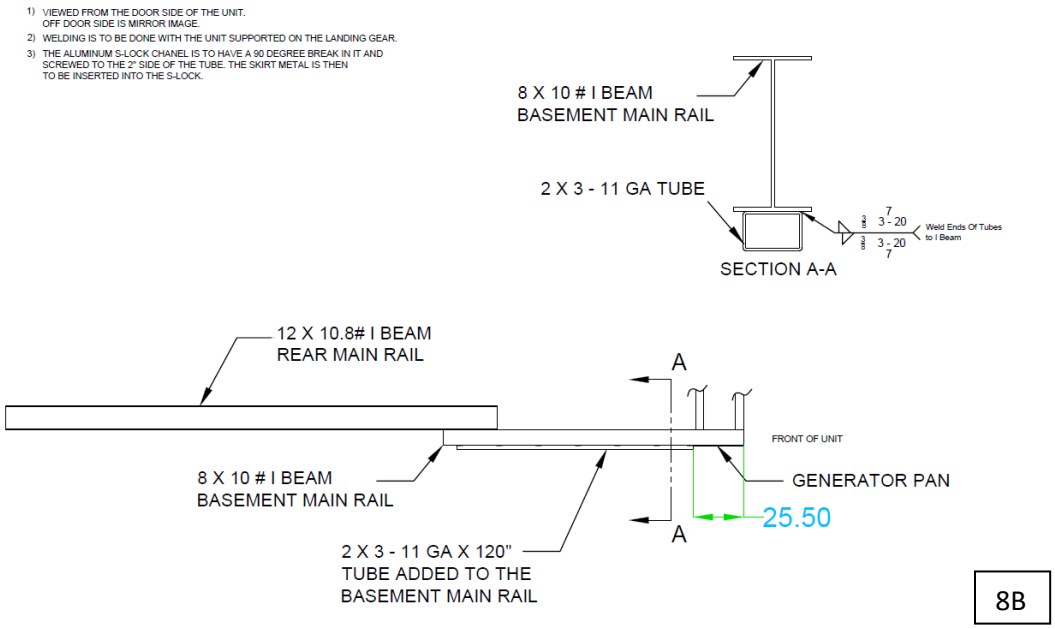
D. Loosen screws on bottom of ODS and DS skirt metal from front of unit to rear of basement main rail.
E. Loosen LP hose clamps on ODS bottom of I-beam.
F. Support the tank brace in the middle
G. Remove the two screws securing the tank bracket into the bottom of the I-beam
H. Cut off the angled bracket off the end of the tank bracket assembly. See Figure 8A
I. Locate and weld 2” x 3” x 120” long tube on bottom of I-beam. Use sublet if needed for the welding.

Fig 8A

J. Weld the angled bracket
   a. one leg of the angle in on the bottom of the tank tube
   b. the other angle is screwed against the new 2" x 3" tube (See Figure 8AB)
K. Screw two screws into the angle bracket

Fig 8AB

Diagram Figure 8B shows 2 x 3 tube on bottom of I-beam



8B

12.0 Installing structural C-channel on front header cross tube of frame

A. If the I-beam measures 8" in step 11.0C, you need to install the c-channel. Use the following steps below.
    a. **Standard labor time for this additional repair is 2 hours**.

B. Prop out cap. (see figure 9)
C. Locate and weld 5" structural c-channel along front header cross tube of chassis. (see Figure 9B)

Fig 9

Diagram Figure 9B shows Structural C-Channel Installation

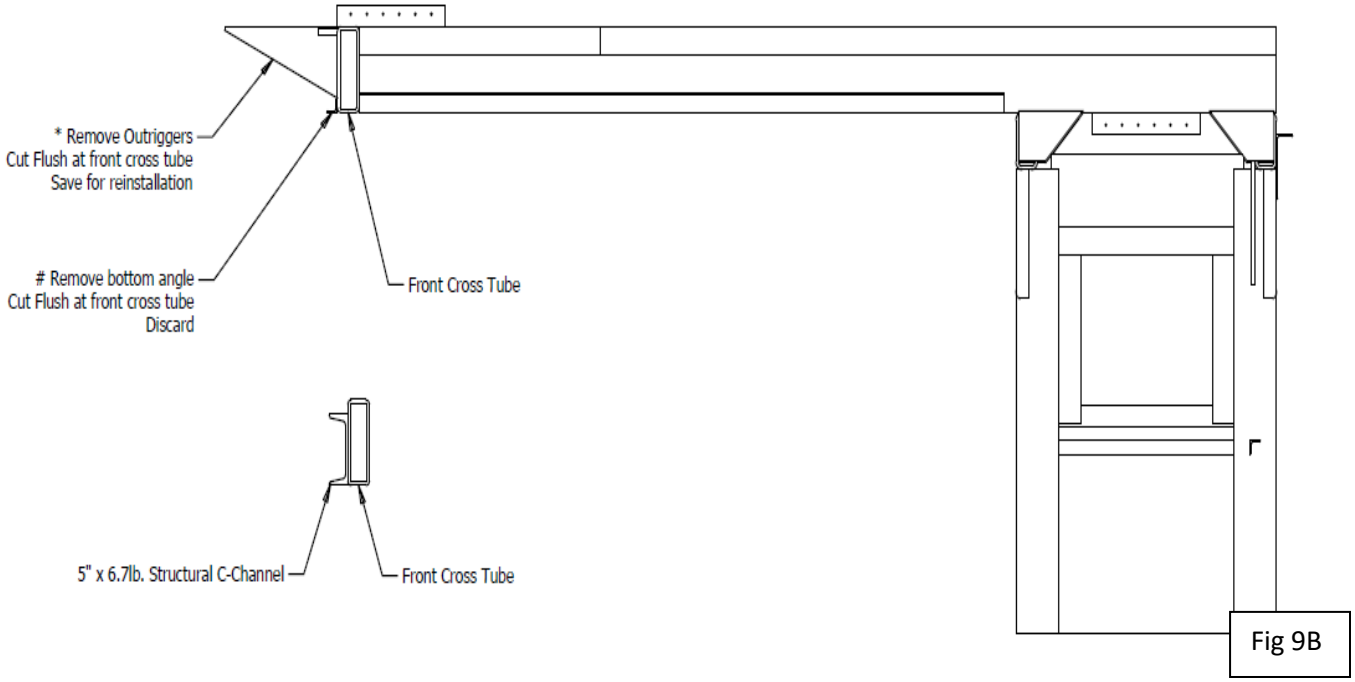


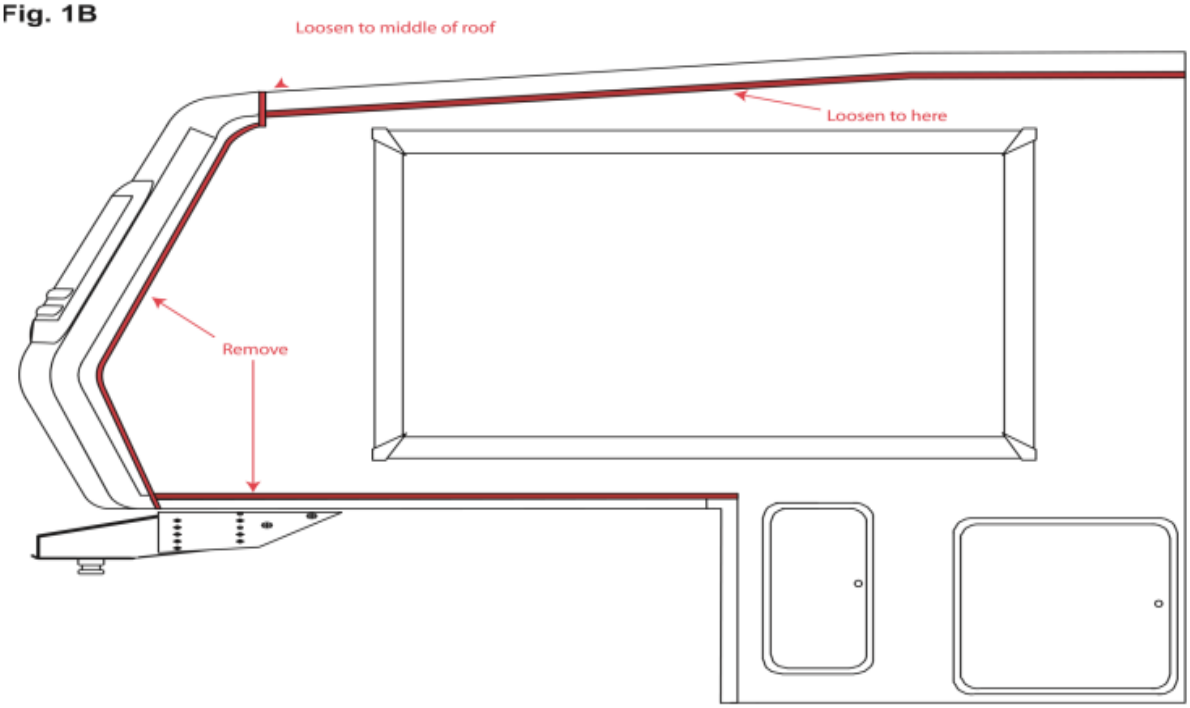
Fig 9B

Figure 10 shows the structural C-channel welded

Fig 10

D. Lower front cap to secure side of wall (See Figure 1B) Install the front vertical cap.
E. Install the front vertical cap trim to access cap trim screws. (See Figure 1B)
F. Install all front vertical cap trim screws. (See Figure 1B)
G. Install the screws from the roof line trim from the front cap to about the rear of the slide. (See Figure 1B)
H. Install lower goose neck molding.
I. Install the slide-out drip rail.

Fig. 1B



13.0 Adding 40LBS LP Tanks Option Repair

A. In the ODS LP compartment, Weld Part number 2028834 -16.25” x 1” x1” 14GA LP steel angle at 14” from the Lp tray to the top of the angle. Ensure the angle is at the top and back before welding in place. See Figure 11
B. Weld part number 2028833 - 7” x 1” x 1” 13GA LP steel angle in the center of the 2”x 3” vertical tube at the 14” from the LP tray. see Figure 11
C. Screw the front LP strap part number 0403922 to the welded angle brackets welded in steps A and B. (see figure 11)
D. Use bolts and washer with locking nuts to secure the rear LP strap through the existing galvanized wall. See figure 11

Fig 11

14.0 Securing Exterior Wall, Cap and Roof Trims

A. Secure the front vertical cap trim to access cap trim screws. (Figure 1B)
B. Secure all front vertical cap trim screws. (Figure 1B)
C. Secure all the screws from the roof line trim from the front cap to about the rear of the slide. (Figure 1B)
D. Secure lower goose neck molding.
E. Secure the slide-out drip rail.

15.0 Installing Bedroom Slide Out Room

A. Install bottom slide out corner pan with seal.
B. Install bottom slide out pan with seal.
C. Install slide-out into the coach opening.
D. Install any bolts / screws that secure the slide-out room to the coach.
E. Hook any 12 VDC and 120VAC electrical connections attached to the slide out room.
F. Install all **Interior** slide out trims and attachments that are attached to the slide out room.
G. Install all **Exterior** Slide out trims and attachments that are attached to the slide out room.
H. Install all front ODS decals.
I. Seal all exterior trims and moldings as originally designed.

Jayco's sole obligation under our limited warranty is to repair or replace defective materials and/or workmanship deemed our responsibility as determined by Jayco in our sole discretion. Jayco reserves the right to use new and/or remanufactured parts or materials of similar quality to complete any work, and to make parts and/or design changes as appropriate without notice to anyone. Jayco designs and/or materials changes are done without obligation to incorporate such changes in previously manufactured product. Jayco makes every reasonable effort to ensure field remedies will not adversely affect performance and/or safety of the unit. This field remedy is not intended to extend to future performance of this RV, or any of its materials, components or parts beyond the standard warranty period. The RV owner's obligation to notify Jayco, or one of its independent, authorized dealers, of a claimed defect does not modify any obligation placed on the RV owner to contact Jayco directly when attempting to pursue remedies under state or federal law. Jan. 2019.

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