

Subject	Solitude ST390RK Rear Upper Deck Securement				Number	22-003
					Date	9/12/2022
					Model	Solitude ST390RK
					Build Date	Units offline prior to June 2022
Circulate To:	Service Manager	x	Parts Manager		Technician	x
	Warranty Admin	x	Sales Manager		Part Number (s)	961113, 960736 &

Concern:	The rear upper deck on Solitude ST390RK models produced prior to June 6, 2022 may not be properly supported. As a result, the rear upper deck floor may sag slightly at the sidewalls.
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Remedy:	The remedy includes the use of additional fasteners (961113 - Screw 14X1 Hex Washer Type A Zinc, 960736 - #625 Tri-fold LG FLG Alum .39-.354 Grip Rivet) and support bracing. (512064 - 1X2 Stuffed AL Tube, 512065 - 2X3 Stuffed AL Tube)
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Flat Rate:	920004 - 2.5 Labor TOTAL
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1. Visually inspect the chassis from the rear axle to the bumper. Ensure there are no bent outriggers and verify the unit has not been modified for towing.
2. Using the hydraulic system, level the unit. Inspect the floor of the rear upper deck for signs of "sag" or dropping.

Photo example 1. Inspecting the floor for sag.



22-003 - Solitude ST390RK continued

3. Open the rear compartment doors on both sides of the unit.
4. Place a jack inside the compartment, using a small board to protect the linoleum covered subfloor. Align the jack with the P-tubing along the outside edge of the upper deck against the interior of the sidewall. Support the deck with the jack. You may need another small board to help support.

Photo example 2. Using jack to support rear upper deck.



Photo example 3. Alignment of 2x4 supporting upper deck.



22-003 - Solitude ST390RK continued

5. With the upper deck supported, remove the existing screws from the P-tube. Using the jack, carefully raise upper deck until level.
6. Install non-selftapping screw 14x1 Hex - *GDRV part number 961113* - every 12" to 14" apart. You may be able to use existing screw holes. This process may require you to relocate the jack several times, checking for level as you go.
7. Using a 7/32" drill, start a pilot hole equal distance between each screw and install an expandable rivet - *GDRV part number 960736*

Photo example 4. Repaired P-tube with screws and rivets installed.



8. Remove the strut rod between the two compartment doors. Measure vertically, the distance between the floor of the cargo area and the bottom of the aluminum P-tube, between the compartment doors.
9. Cut two 1x2, aluminum (wood stuffed) tubes to the measured length and place on either side of the LP hose. Where no LP line is present, use a single 2x3 stuffed aluminum tube. Apply Sika-Flex to the wall side of the tubing and secure with 2.5" screws. Be sure to secure at the top of the support through the lip of the P-tube and at the bottom of the support into the bottom rail of the exterior wall. Add two additional screws, equal distance between the two. Reattach cargo door strut.

22-003 - Solitude ST390RK continued

Photo example 5. 1x2 support framing between the cargo doors.

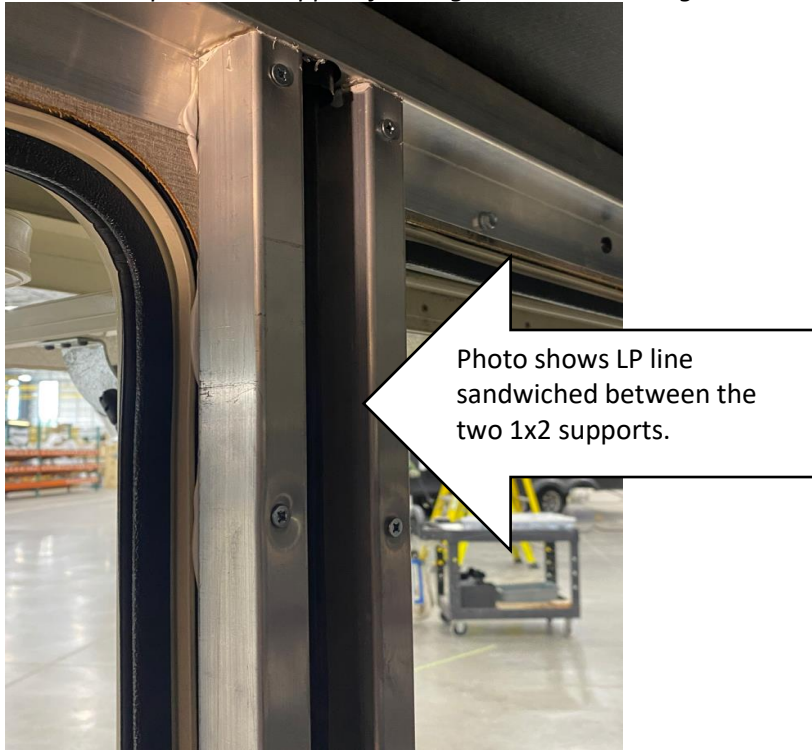


Photo example 6. Cargo door struts reattached.



10. Repeat process for opposite side.

11. Repair complete.