

Sidewall Repair

This process describes the safe and proper procedure to repair any unit which experiences a crack at the bottom corner of a slideout at the gooseneck of a 5th wheel, opening the side wall to repair broken tube welds. This technical service bulletin explains how to perform the repair. Please note: A sublet will be required for aluminum welding if you do not have that capability.

This TSB requires a Pre-Authorization & Photographs

- Parts Required per Unit:** Please call into the appropriate Parts Team for assistance with ordering the following parts. The Adhesives noted below are the only acceptable Adhesives for this repair.
- 2ea. KRV # 207257 - Adhesive - Panel Bonding - Automix - 200ml - 2 Part Epoxy - 08115 -3M - 2 application tips included with each tube.
 - 1ea. KRV # 207258 - Tool - Adhesive Applicator Gun - MixPac - 1:1 Ratio - 08117 - 3M
 - 2ea. KRV # 346665 - Adhesive - Sealant - Lavanture - 10oz - High Performance - Manus-Bond 75-GP
- Ground shipment only - Hazardous material Application Gun may be returned for full credit, submit on RGA.
- 1ea. KRV Manual ID - Fiberglass/Filon Skin, noting single or double layer of lauan.
- Local parts:** #14 x 5" Screws, 2" Wood Screws, Pinbox Jack, Sealant, Putty Tape, 2"x4" or 2"x6" Wood
- Tools Required:** Screw Gun, Die-Grinder, Caulk Gun, Flat Bar/Pry Bar, Drill Bit-6" x 3/16", 4" Floor Scraper

When performing warranty or recall service, please make certain that appropriate Personal Protective Equipment (PPE) is used.

VERY IMPORTANT! DO NOT CUT A SQUARE OUT OF THE WALL-SEE REPAIR BELOW

REPAIR INSTRUCTIONS

Step 1

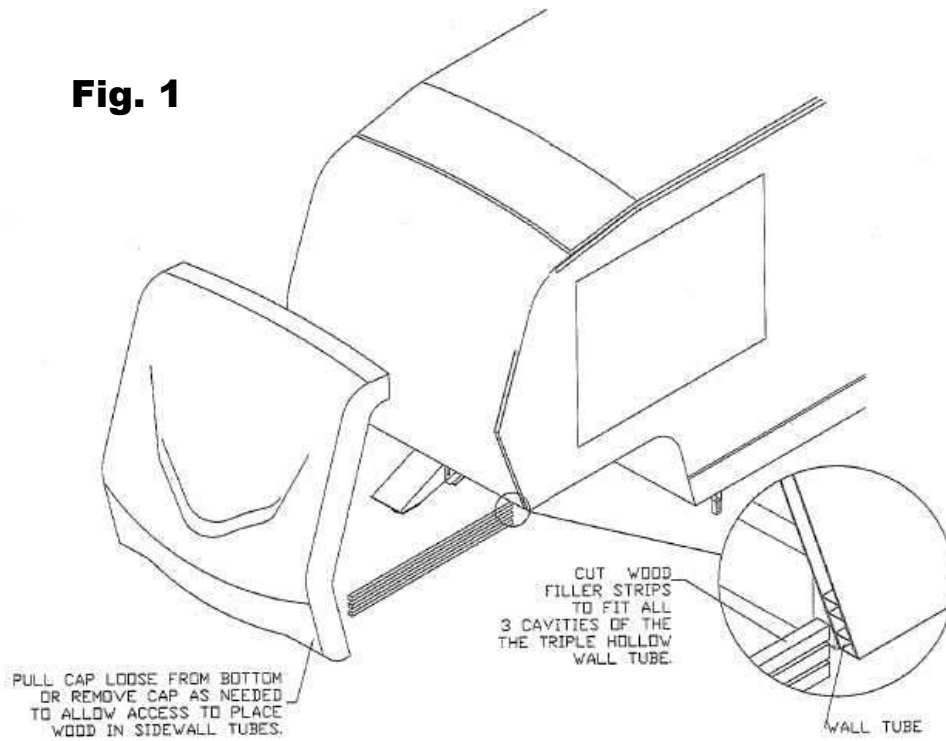
Locate the trailer on a level, flat, hard surface. Chock the wheels.

Step 2

Disconnect RV battery and unplug the shore cord power.

Step 3

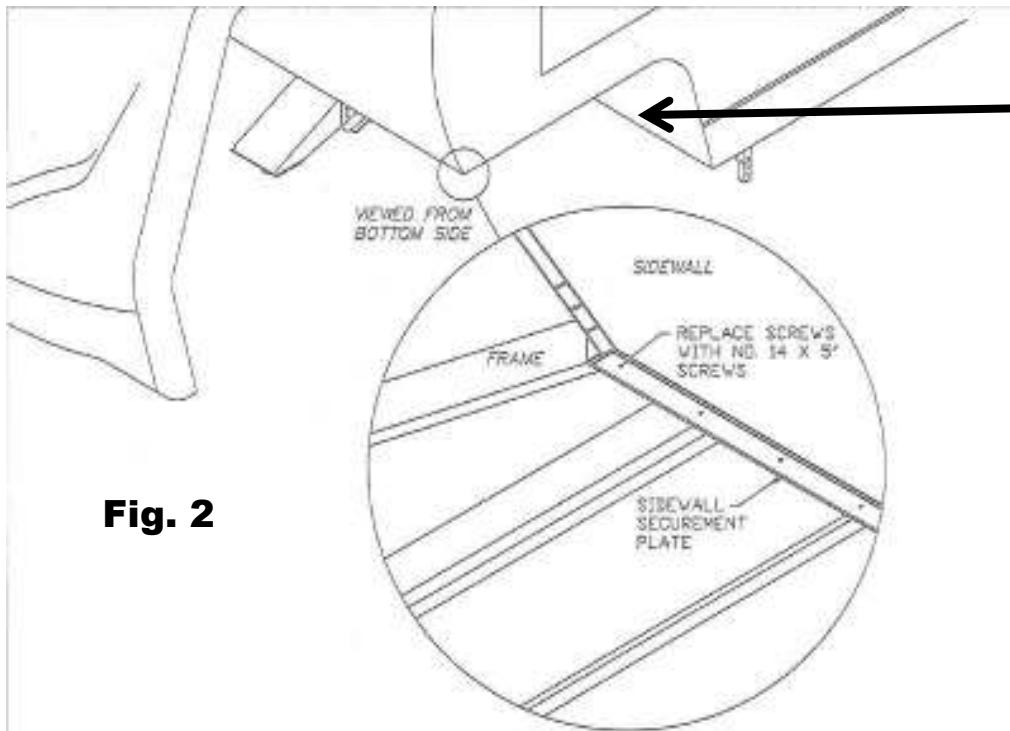
Remove front cap and bed slide box. Remove roof line molding and peel back roof materials. Remove molding around slide opening and gooseneck edge of sidewall. Remove molding used to cover expansion joint/relief cut at bottom of slideout opening. Cut skin within 1" of top slideout corner from slide opening to roof line.

Fig. 1**Step 4**

Inspect bottom sidewall tubes for wood. This will vary product to product. Take photos.

If wood is missing in tubes, see Figures 1 and 2.

If wood is present in all tubes, continue to replace the screws as directed in Figure 2.

**Fig. 2**

In Figure 2 replace screws all the way to this point.

VERY IMPORTANT! PLACE HITCH WEIGHT ON PIN, THEN LOWER FRONT LANDING LEGS TILL THEY TOUCH THE GROUND BUT DO NOT RAISE THE UNIT. LEAVE WEIGHT ON PIN FRAME THROUGHOUT REPAIR. SEE FIGURE 3

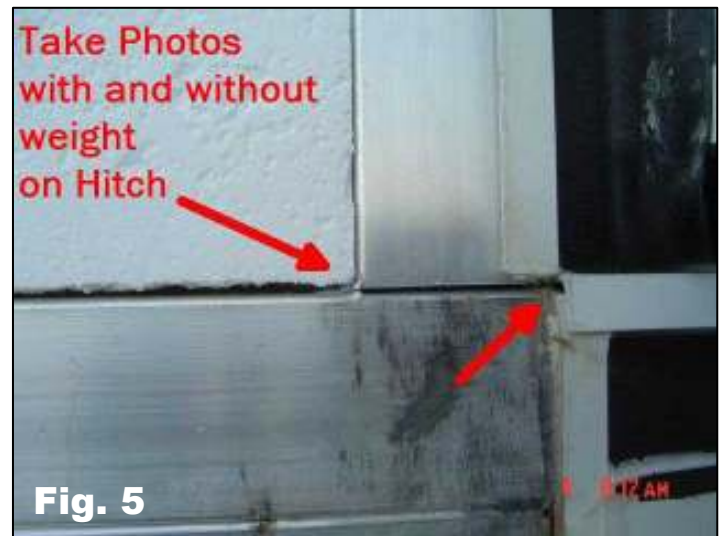
Step 5

Peel back forward portion of skin to corner of slideout top and bottom using a flat scraper to release the lauan from the aluminum frame and foam. Try your best to remove in one piece to use as template for new piece. Order new piece through Keystone RV Parts Dept. Submit a manual ID order and make sure you provide square dimensions and photos to determine color. Please note if the skin is backed with a single or double layer of lauan.



Step 6

Inspect lower and upper welds for cracks. Take photos of all cracked/broken welds with weight on the hitch, see Figure 4.



Step 7

Take photos with weight off the hitch, see Figure 5.

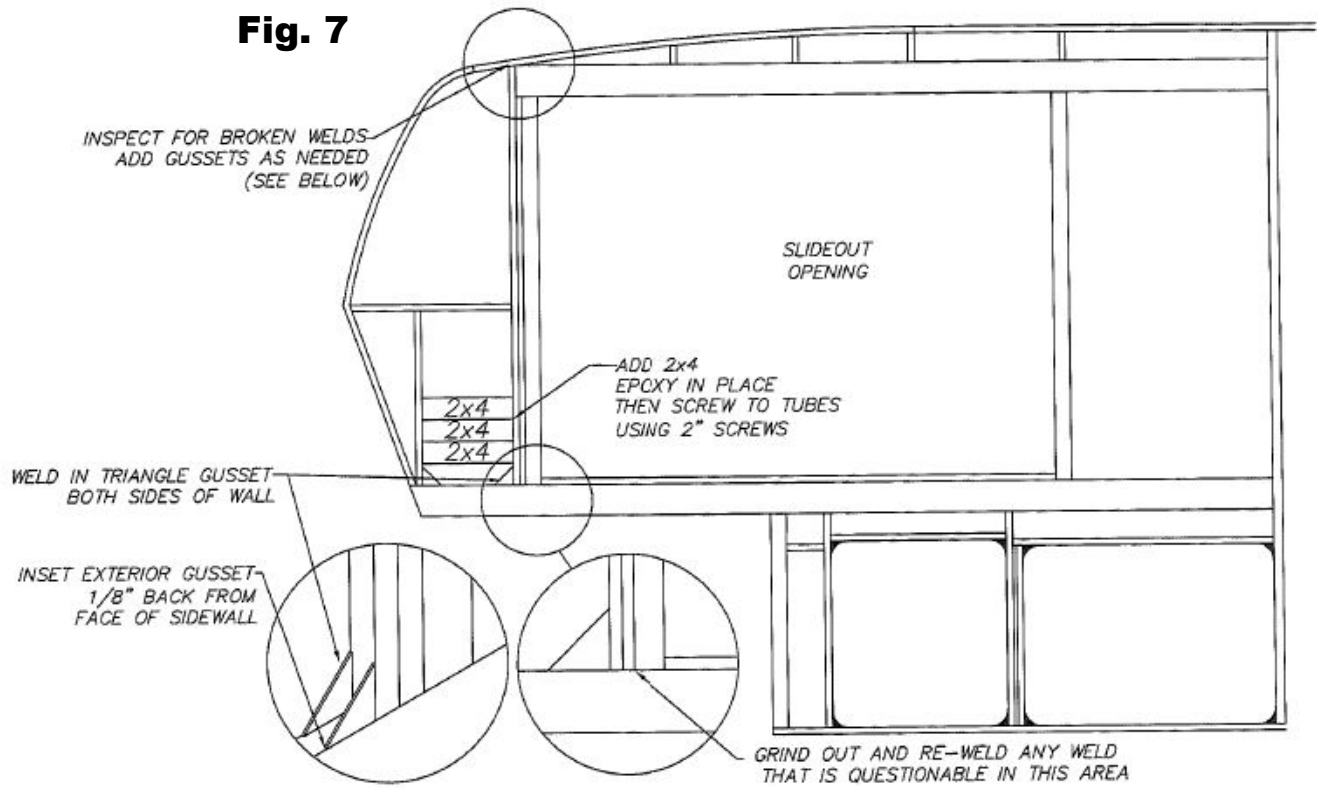
Step 8

Repair all broken/cracked joints as needed and add gussets, if you don't have anyone that does aluminum welding contact a local welder and sublet to repair tubes, see Figure 6 and 7.

Step 9

Dig out the foam between the aluminum studs, clean area to accept adhesive and reinforcement wood. Cut 2x4's or 2x6's to fill area between 2 aluminum studs. Using the adhesive KRV # 207257 install the studs to the interior paneling, use 2" screws to secure aluminum studs as shown in Figures 7 and 8.



Fig. 7

Step 10

Clean surface of tubes with scraper and grinder, and then prep tubes with alcohol or similar. Scuff tubes with sandpaper to accept adhesive, see Figure 8.

Step 11

Following the directions of the Adhesive, apply KRV # 207257 Panel Bonding Adhesive liberally onto tubes in exposed areas where fiberglass was removed. Use tool/squeegee to cover all exposed tubes, see Figure 9.

Step 12

Following the directions of the Adhesive, apply KRV# 346665 Adhesive - Sealant liberally to the exposed foam and wood, squeegee to evenly distribute, see Figure 9.

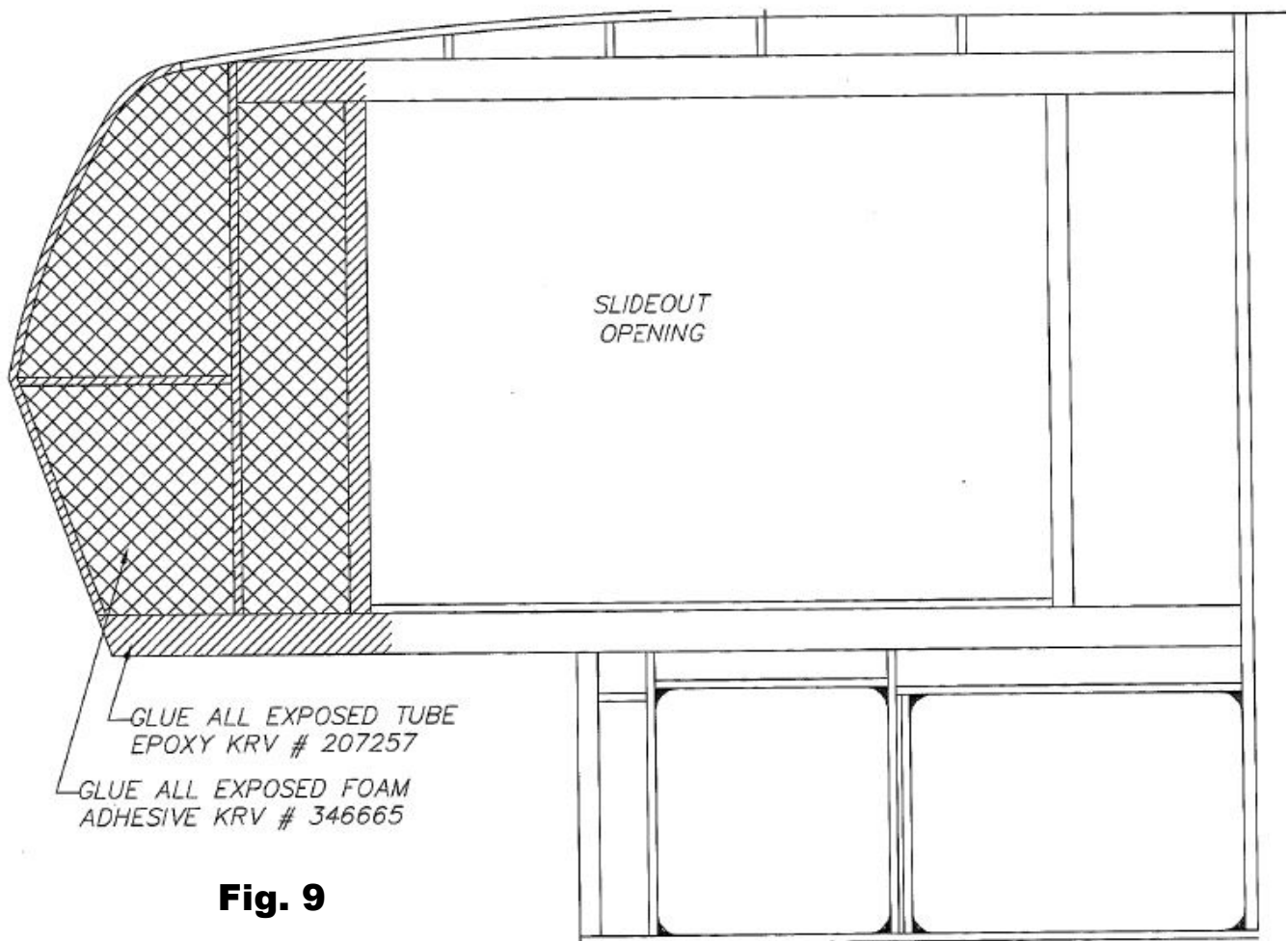


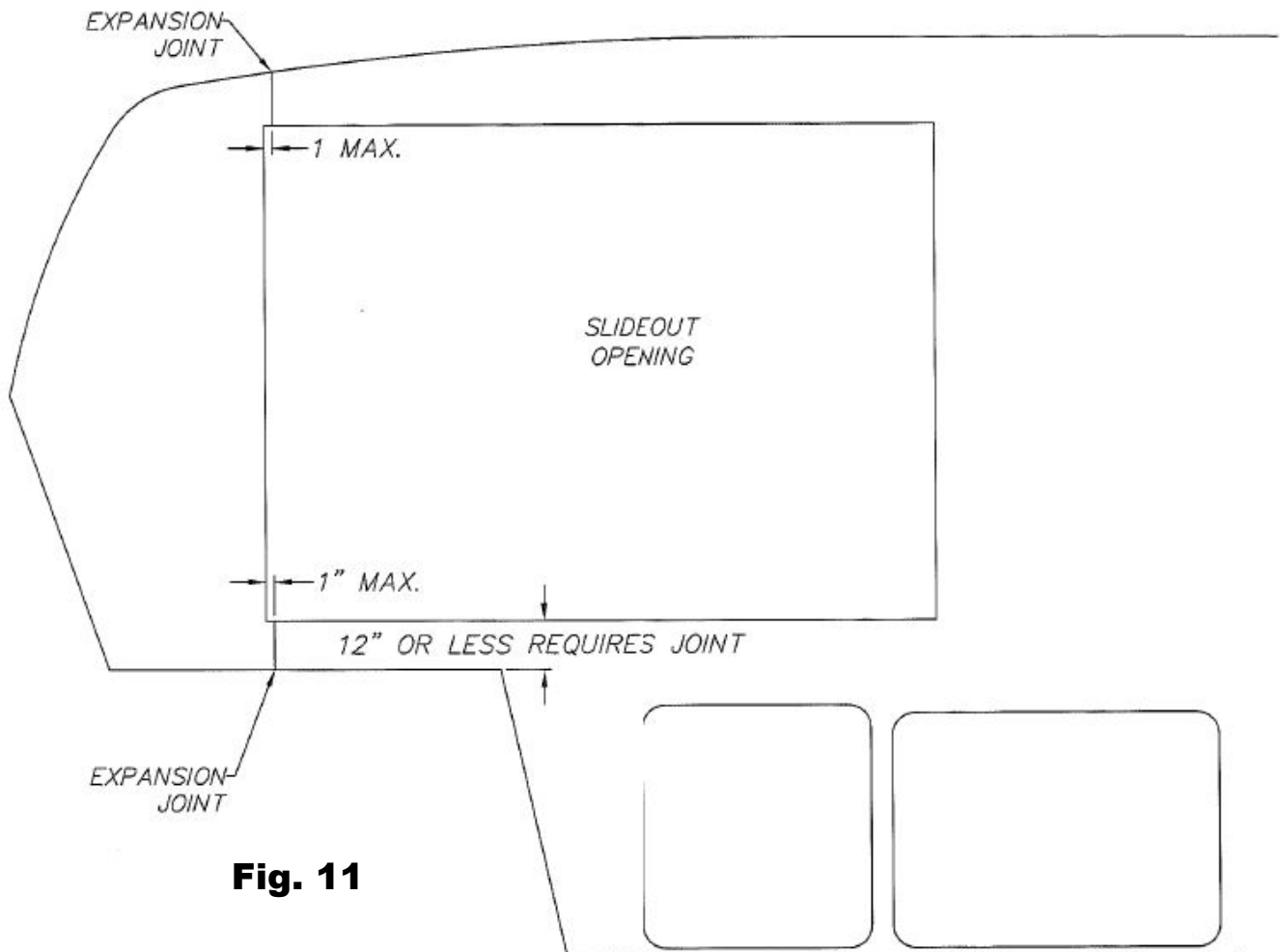
Fig. 9

Step 12

Clamp new skin to surface with clamps and a board and let set for 8 hours, see Figure 10.

Step 13

If expansion joint/relief cut is not within 1" of slideout opening, perform fiberglass repair to existing cut, then cut-in new expansion joint/relief cut. Refer to diagram below for proper placement of expansion joint/relief cut. Another expansion joint will need to be added at the top, see Figure 11.

**Fig. 10****Fig. 11**

Step 14

After 8 hours remove clamps, inspect for cure and adhesion.

Step 15

Test repair by alternating hitch weight between pin and landing jacks and verify skin is unaffected by weight transfer.

Step 16

Trim any excess sidewall skin if necessary.

Step 17

Reinstall cap, moldings, and slide. Caulk components.

Step 18

Take for a test drive if possible.

Step 19

Repair complete. Contact the advisor you have been working with and notify that repair is complete.

REIMBURSEMENT

This TSB is for repair purposes only. If this is a warranty repair, the flat rate code is 7300642A.

No part return required.

If you have questions, please contact the appropriate Service Team:

Luxury (LX) 866-273-1450

Toy Haulers (TH) 866-273-1452

Premium (PR) 866-273-1454

Crossroads (CR) 844-361-8455