



# FOREST RIVER RECALL 17V-611 COACHMEN FREEDOM EXPRESS CHASSIS STIFFENER REPAIR PROCEDURES

**NOTE:** Please see Forest River listed models to make sure trailer is covered under this recall. This notice will cover trailers manufactured from 1/1/2013 to 8/31/2013.

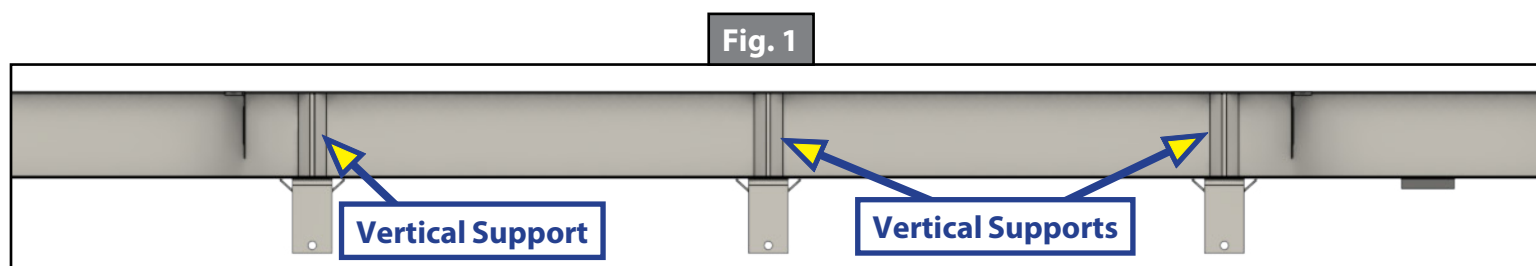
| Coachmen Freedom Express 2013-2014 Models |                               |       |                               |
|-------------------------------------------|-------------------------------|-------|-------------------------------|
| Model                                     | Repair Part #                 | Model | Repair Part #                 |
| 22DSX, 230BH                              | 715114<br>6 Total<br>Required | 21TQX | 715113<br>6 Total<br>Required |
| 233RBS, 242RBS                            |                               |       |                               |
| 246RKS, 269BHS                            |                               |       |                               |

## Purpose

The intent of this document is to describe an inspection of the chassis of the models listed to determine if reinforcement supports are welded to the I-beam above each hanger. If the trailer does not have the vertical supports, instructions are included to add 1" x 2" 14 Ga tubes above the axle hangers.

## Inspect Chassis for Vertical Supports

Inspect the chassis to determine if there are vertical supports above the axle hangers on both sides of the trailer (Fig. 1). If the supports are not present, then tubes will need to be added. See Adding Vertical Supports.



Caution, warning and danger symbols indicate that an installation procedure has a safety risk involved and may cause death, serious injury or property damage if not performed safely and within the parameters set forth in this manual. This repair should only be completed by a qualified service technician.

## Adding Vertical Supports

Vertical supports are added to the I-beam above the axle hangers in instances where the trailer is not equipped with vertical supports.

## Resources Required

- Personal protective equipment
- Fire extinguisher
- Welder
- Black spray paint
- Floor jack
- Jack stands



**Lift the trailer by the chassis. Do not go under the trailer unless it is properly supported. Unsupported trailers can fall and may result in death, serious injury or property damage.**

## Preparation

1. Support front and rear of chassis/frame with a floor jack and stabilize with jack stands. Support framework in accordance with the manufacturer's recommendations.
2. Remove any wires, heat ducts, gas lines, water/holding tanks and underbelly material that is against the I-beams or that might cause a fire hazard.
3. Cover tires with a barrier to protect from welding splatter.

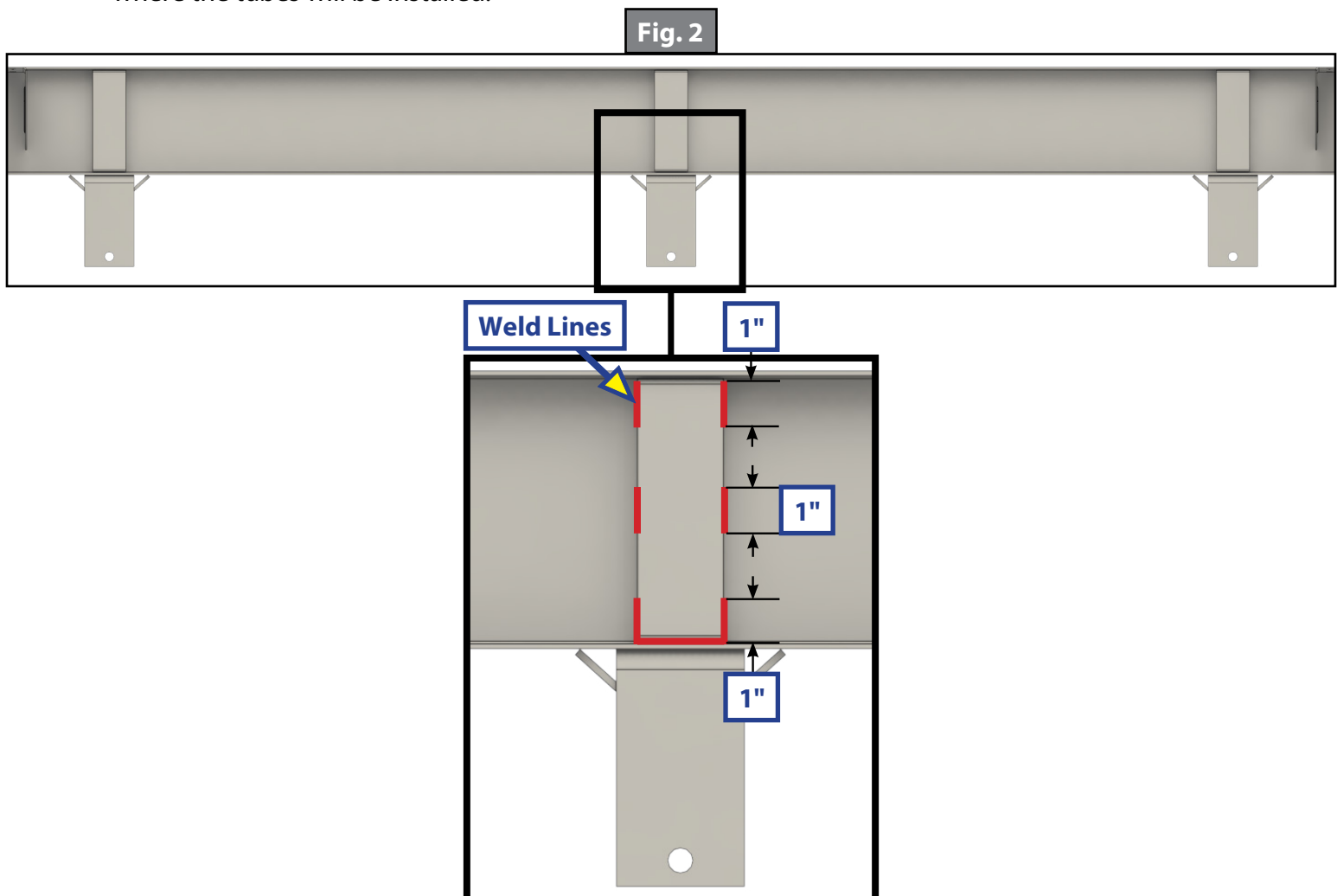
### **⚠ WARNING**

**Failure to remove flammable objects or obstructions may result in death, serious injury or property damage.**

**NOTE:** Model 21TQX has a smaller I-beam size, and tubes for this model (PN 715113) are 4.875" in length. All other models will use the 6.125" tube (PN 715114).

## Procedure

1. Place tube on the exterior of the I-beam centered above the axle hanger and against the I-beam web.
2. Weld tube completely at the base and 1" up each side (Fig. 2).
3. Place 1" welds in the center of the support (Fig. 2).
4. Weld 1" down each side of the tube from the top of the flange (Fig. 2).
5. Add tubes above the remaining hangers on both sides of the trailer. There are a total of six locations where the tubes will be installed.



## After Installation

Touch up the welded areas with black spray paint once the material has cooled down.

---



---

# This manual is provided courtesy of **RV Tech Cheat Sheet**



**Professional resources for the whole RV industry — free.**

We put manuals, wiring diagrams and hard-won tech knowledge in every technician's hands, so repairs get done right the first time, techs work faster, and RV owners everywhere get better service.

---



---

**[rvtechcheatsheet.com/manuals](https://rvtechcheatsheet.com/manuals)**

**Find thousands more RV manuals, wiring diagrams and parts lists**

**RV techs:** share fixes, ask questions and learn from each other.

**Join our free Facebook group →**

---



---

Follow proper safety practices. If in doubt, consult a professional RV technician.