

## Pre 1980 Main Frame Reinforcement

A main frame rail reinforcing plate (illustration attached) has been developed by Airstream to be used on broken or bent frames.

The reinforcement plates are designed with sufficient strength to become the main supporting structure in the area of the axle mounting plate. The general design has been used on production units since 1982. The plates are pre-notched and drilled to clear the axles, axle mounting bolts and shock mounting studs. Each plate is pre-drilled for the bolts to be used to attach the reinforcing plate to the axle mounting plate and main frame. Always reinforce both frame rails. The proper bolts are 3/8 inch, grade five or better, with flanged-serrated heads and nuts. Or, in lieu of flanged heads, star washers may be used on both sides. Proper torque for the bolts is 34 ft. lbs.

### PROCEDURES

1. Support trailer on jack stands at each end so the main frame is level or slightly below level in the center.
2. Remove strip of underbelly next to frame for access.
3. Remove axles.
4. Straighten any part of the frame or axle mounting plate that would prohibit the reinforcing plate from laying flat.
5. Locate reinforcing plate over axle mounting bolt holes and shock mounting brackets.
6. Recheck levelness of frame. Drill holes for the 3/8 attaching bolts and torque to 34 ft. lbs. **Note:** Do not drill holes oversize. They should be as snug as possible around bolts.
7. Repair underbelly and replace axles.

On some trailers it will be necessary to remove water tanks and/or bleed the disc brake systems.

Part number 451120 is the roadside frame rail reinforcing plate, and part number 451121 is the curbside frame rail reinforcing plate.

