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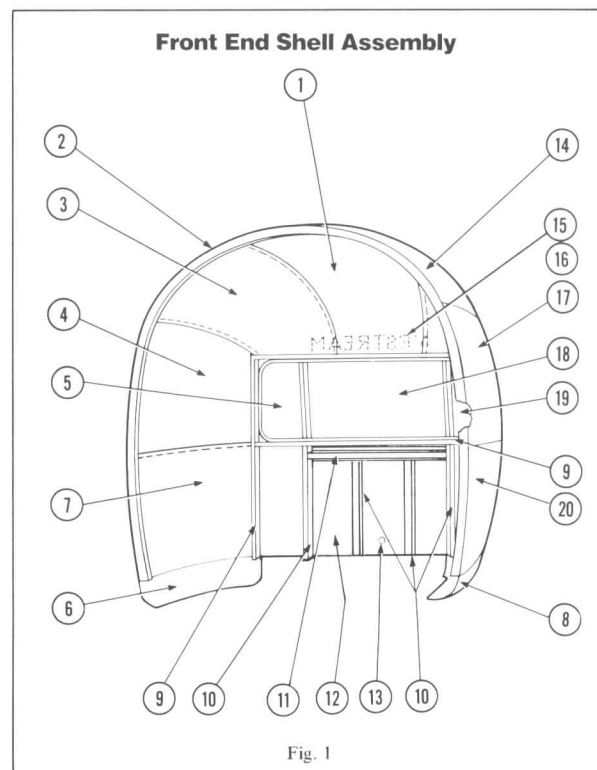


Fig. 1

Front End Shell Assembly

No.	Part No.	Description
1	101136	Skin, end segment — front no. 10
2	101358	Rib, front shell
3	101141	Skin, end segment — front no. 21
4	101137	Skin, end segment — front no. 11
5	371142	Window, corner, front left assembly
6	101308	Wrap, underbelly no. 15 roadside
7	101139	Skin, end segment — front no. 13
8	101309	Wrap, underbelly no. 16 curbside
9	101317	Frame, window, inner
10	101314	Brace, vertical, front
11	101150	Stiffener .032 x 7-7/8" x 42" aluminum
12	101172	Skin, front, lower 31" x 45 1/4" x .050
13	101150	Aluminum plate .032
14	101142	Skin end segment — front no. 22
15	385069	"AIRSTREAM" letters — set
16	350002	Palnut ("Airstream" letters)
17	101138	Skin, end segment — front no. 12
18	370025	Front window
19	371141	Window, corner, front right, assembly
20	101140	Skin, end segment — front no. 14

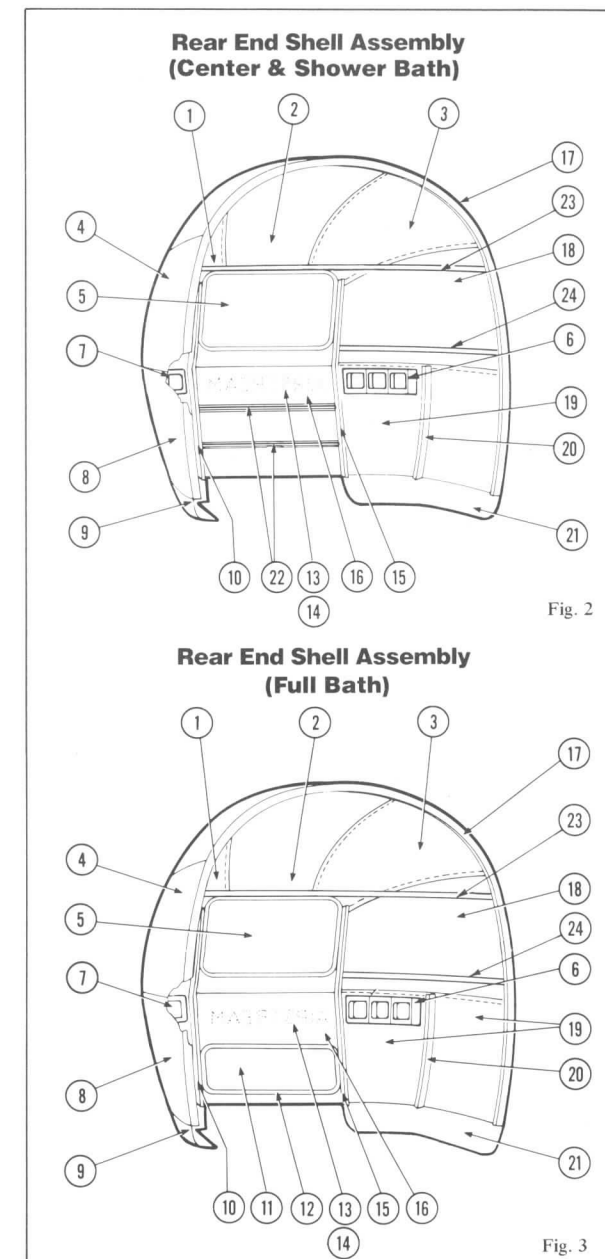


Fig. 2

Rear End Shell Assembly (Full Bath)

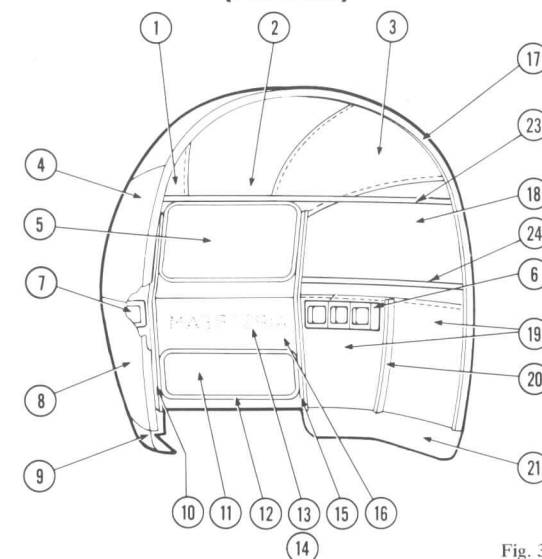


Fig. 3

Rear End Shell Assembly

No.	Part No.	Description
1	101149	Segment — no. 20
2	101144	Segment — no. 1
3	101148	Segment — no. 19
4	101145	Segment — no. 3
5	371186	Rear window assembly
	371137	Rear window assembly (all weather window) (option)
6	101313	Bezel, taillight, roadside
7	101312	Bezel, taillight, curbside
8	101146	Segment — no. 4
9	101307	Wrap, underbelly, no. 7 curbside
10	101311	Brace, vertical curbside
11	922071	Rear service door assembly
12	922070	Rear service door Jamb ass'y
13	385069	'Airstream' letters — set
14	350002	Palnut (Airstream letters)
15	101310	Brace, vertical roadside
16	101156	Skin, rear, lower .032 x 38" x 45¼"
17	101358	Main bow
18	101144	Segment, no. 2
19	101147	Segment, no. 5
20	101315	Vertical brace
21	101306	Wrap, underbelly, no. 6 roadside
22	100034	Member frame horizontal (L.Y. & Int'l Ctr Bath)
23	101161	Rib, horizontal upper
24	101162	Rib, horizontal lower - CS Rib, horizontal lower - RS

End Shell Segment Replacement

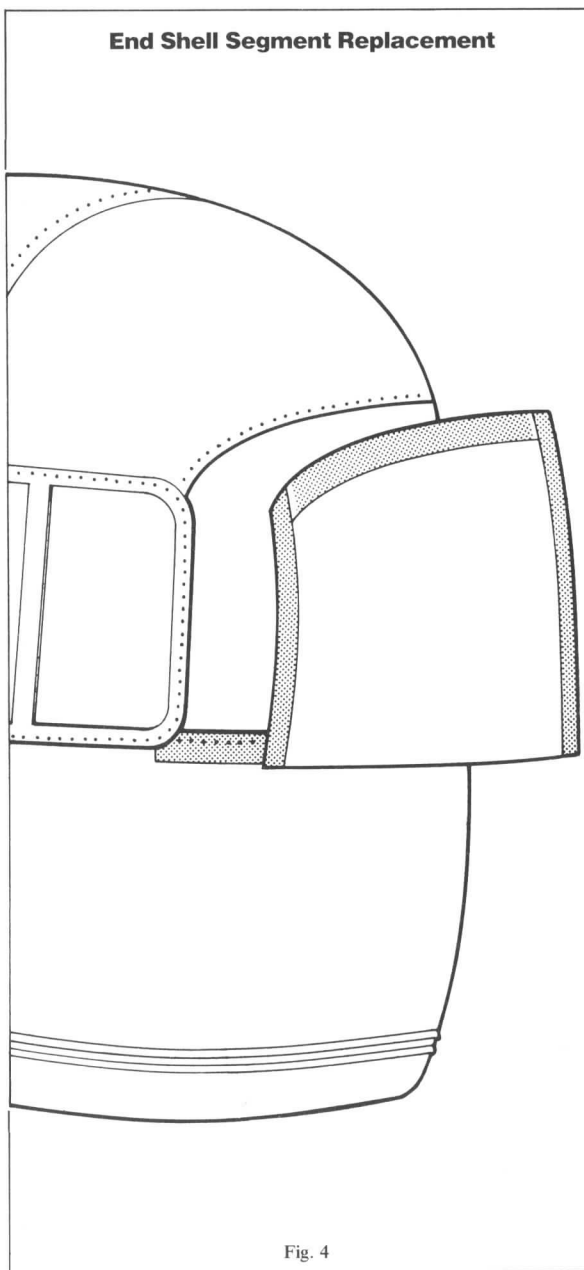


Fig. 4

End Shell Segment Removal and Replacement

1. Using a No. 30 drill (aircraft type 135° split point), remove the rivets from all the seam lines of the damaged segment. (See side and roof panel removal step No. 1, regarding rivet removal).
2. After all rivets have been removed from the damaged segment, it may be necessary to use a putty knife to loosen the seams, due to caulking which is applied at the time of manufacture. This is also necessary at window areas and at seams, where curved segments and side and roof sheets meet. (Be careful not to scratch or damage surrounding segments or panels when prying loose)
3. After all seams are loose, segment can now be removed.
4. After damaged segment is removed from trailer, it will be necessary to use it as a pattern for cut-out or trim areas.
5. If segment is dented, use a hammer to partially straighten. Tape all edges with masking tape to keep damaged segment from scratching new segment when using it as a pattern.
6. Place new segment on a flat surface with the stamped number on exterior facing you.
7. Overlay the damaged panel on the new segment, being very careful not to scratch or damage new segment. Make sure damaged segment is in correct position, with top and bottom corresponding with new segment. Once correct position is obtained, use a grease pencil to mark the ends and cut out areas.
8. After segment is marked, remove damaged pieces. With a pair of metal snips, trim new segment where marked.
9. Segment is now ready for lay-up (see Fig. No. 4). Before laying-up, apply a strip of furnace tape to top edge of new segment. Also place a strip of tape on the top edge of remaining lower segment which the new segment will overlay. This is to prevent scratching.
10. Place segment in position and fit top corner under sheet which will overlay new segment. Very carefully slide new segment under roof or side sheets . . . depending on area in which you are installing.
11. After panel is started under roof or side sheets, work bottom end under window seam or front parts, depending on which segment is being replaced. Once segment is started at both ends and at top, it can now be fitted into proper position.
12. Once segment is fitted to proper position it can be drilled to be held in place with wedge-lock fasteners. Start in middle of top of new segment, use a No. 30 bit and very carefully drill through every fourth existing hole. Use a sharp drill and allow drill to feed itself through the

metal without force. As soon as drill is through new segment, remove and install a wedge-lock (See p. 3-13). Be sure that seams are tight and no gaps are occurring.

13. At lower edge, lay out new holes 1 3/8" on centers with 3/8" edge distance on new segment. These holes should be spaced at least 1/2" from old holes in remaining segments. Starting from middle, drill every fourth hole with No. 30 drill bit and install wedge-lock as in step 12.
14. Fit a piece of seam tape under roof or side sheet to make a waterproof seal on the rib seam. As soon as tape is in place, drill and hold with wedge-lock as in step 12. (See Fig. 4).
15. Should opposite end fit under the window frame, use window seam tape to make the waterproof seal in this area. Install and hold with wedge-locks as in step 12.
16. When all wedge-locks are in place on all four sides, use a No. 21 drill and drill all remaining holes.
17. As soon as all holes are drilled, remove top wedge-locks and clean out drill shavings. Caulk a long segment in line with drill holes using Vulkem seal and replace wedge-locks. Repeat for bottom. Do not use an excessive amount of sealant.
18. Install Olympic rivets in all holes where there are no wedge-locks.

Start from middle and work to edges.

19. As soon as rivets are in place, remove wedge-locks and redrill these holes using a No. 21 drill. Rivet with Olympic rivets.
20. When all rivets are in place, use a sharp knife to trim and remove excess tape and sealer from the edge of the seams.
21. When excess tape is removed, panel is to be plasticcoated. (See p. 3-22)

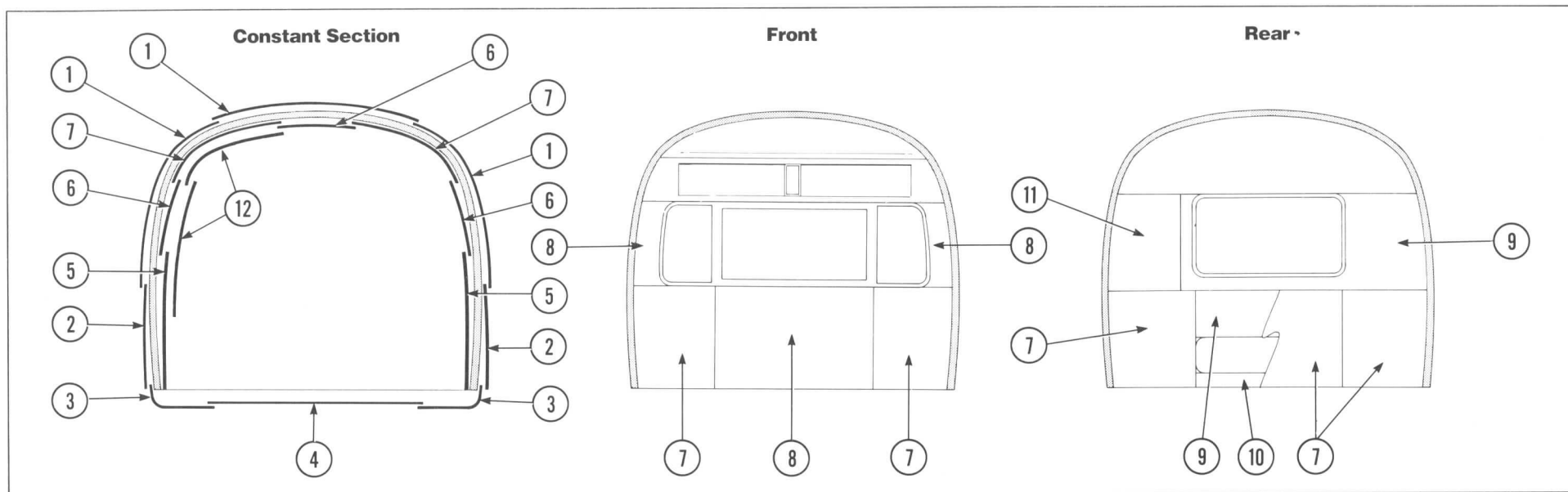
*Note: For front and rear center segments, apply furnace tape to adjacent remaining segments only.

Banana Wrap Replacement

1. Remove rub rail by drilling out pop rivets using a No. 30 drill.
2. Drill out rivets securing lower edge of corner wrap to floor channel.
3. Drill out pop rivets securing banana wrap to floor channel (concealed behind corner wrap).
4. Drill out rivets attaching banana wrap to underbelly.
5. Use the old banana wrap as a pattern, and cut out the new banana wrap.
6. Apply sealant between corner wrap and banana wrap prior to installation.
7. Install new banana wrap securely with AD45BS pop rivets.
8. Reinstall rub rail using pop rivets and seal top edge only

Ceiling Light & Roof Vent Frame Removal and Replacement

1. Remove ceiling light from interior if so equipped (See p.8-24) .
2. Remove fan and disconnect wire if so equipped (See p.8-24) .
3. Drill and pop rivets securing ceiling skin to vent frame flange.
4. Drill out hard rivets securing vent from flange to roof.
5. Remove vent frame by lifting from roof.
6. Reverse above procedures for reinstallation, using caulking liberally under and around roof flange.



No. Part No. Description

1	101384	Aluminum alclad .032 x 56½"
2	101397	Aluminum alclad .040 x 30½"
3	101131	Aluminum 3004 .024 x 22-3/8"
4	101132	Aluminum 3004 .024 x 61½"
5	101488	Aluminum vinyl clad .032 x 41½"
6	101486	Aluminum vinyl clad .032 x 24½"

7	101487	Aluminum vinyl clad .032 x 37½"
8	101487	Aluminum vinyl clad .032 x 30"
9	101009	Aluminum vinyl clad .032 x 16"
10	101011	Aluminum vinyl clad .032 x 3¾"
11	101417	Aluminum vinyl clad (floral) .032 x 35"
12	101218	Aluminum vinyl clad (floral) .032 x 35 (center bath)

Side and Roof Panel Removal and Replacement

1. Determine seam line of damaged area to be replaced. Using a No. 30 drill (aircraft type split point 135°), remove the rivets from the damaged section. Start the drill in the center of the rivet head (to start bit, do one turn by hand) and as soon as the head is drilled off, continue to drill until the shank of the rivet drops from the hole. Start in the center of the damaged area. All vents, windows, trunk doors, etc. must be disconnected from inside skin by drilling out pop rivets in interior. Remove these components completely before removing exterior panel and save them for installation into new panel.
2. After all rivets have been removed from the damaged panel it is now ready for removal. It may be necessary to use a putty knife to pry panel loose. Be very careful when using tools to pry panels loose so as to avoid damage to the surrounding panels.
3. All areas of cut-outs which were located in damaged section should be measured very carefully for transferring to the same locations on the new panel. Areas that are to be cut out can have rough cuts made at this time.
4. At least two people will be required to start lay-up. Seam tape should be used on front and rear ribs before replacing a new panel.
5. Use a grease marking pencil and mark vertical ribs and horizontal bars on remaining panels (see Fig. 5).
6. Tape top edge on new panel with furnace tape and slide it under the top existing sheet. All overlapped seams should have the top sheet overlapping the bottom. (See Fig. 5.)
7. When sliding sheet under top panel, be very careful not to install it past the tape as the new panel is readily scratched.
8. With sheet held in place, check all edges and any cut-out areas for proper alignment.
9. Once panel is fitted to proper position, it can be held in place with wedge-lock fastener. Start in middle of top of new panel (use a No. 30 drill bit) and very carefully drill through every fourth existing hole of the overlying panel. Use a sharp drill and allow drill to feed itself through the metal without force. As soon as drill is through new panel, remove and insert wedge-lock in the hole. Be sure that seams are tight and no gaps are occurring.
10. Use a chalk line to mark off bars and ribs; after lines have been marked off, use a drill marker to show rivet spacing. (Drill marker can either be metal or wood, approximately 3/4 inch wide, 4 feet long and straight on both sides.) On one edge, mark seam rivet spacings 3/8" on center. On other side, mark rib and bar rivet spacings 4" on centers.

11. After sheet is marked off, double-check markings for straight and even spacings. Start in middle and install wedge-lock in every third location.
12. At lower edge, lay out new holes 1 3/8" on center with 3/8" edge distance on new panel. These holes should be spaced at least 1/2" from old holes in remaining panel. Starting from middle, drill every fourth hole with No. 30 drill bit and insert wedge-locks as in step 10.
13. After all wedge-locks are in place, use a No. 21 bit and drill out all remaining rivet locations.
14. As soon as all holes are drilled, remove top wedge-locks and clean out drill shavings. Caulk along panels in line with drill holes using Vulkem seal and replace wedge-locks. Repeat for bottom. Do not use an excessive amount of sealant.
15. Install rivets in all holes where there are no wedge-locks. For Olympic rivet installation (See p. 3-20). Start from middle and work to edges.
16. As soon as rivets are in place, remove wedge-locks and redrill these holes using a No. 21 drill and rivet with Olympic rivets.
17. When all rivets are in place, use a sharp knife to trim and remove excess tape and sealer from the edge of the seams.
18. Reinstall all 4 components removed in Step No. 1 (See p. 3-7 through 3-19 for details on installation.)
19. When excess tape and sealer is removed, panel is to be plastic coated. (See p. 2-20).

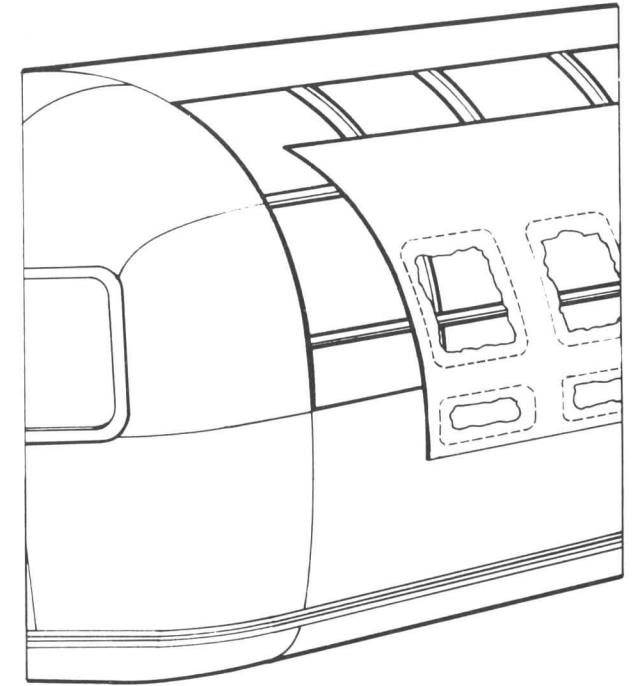


Fig. 5

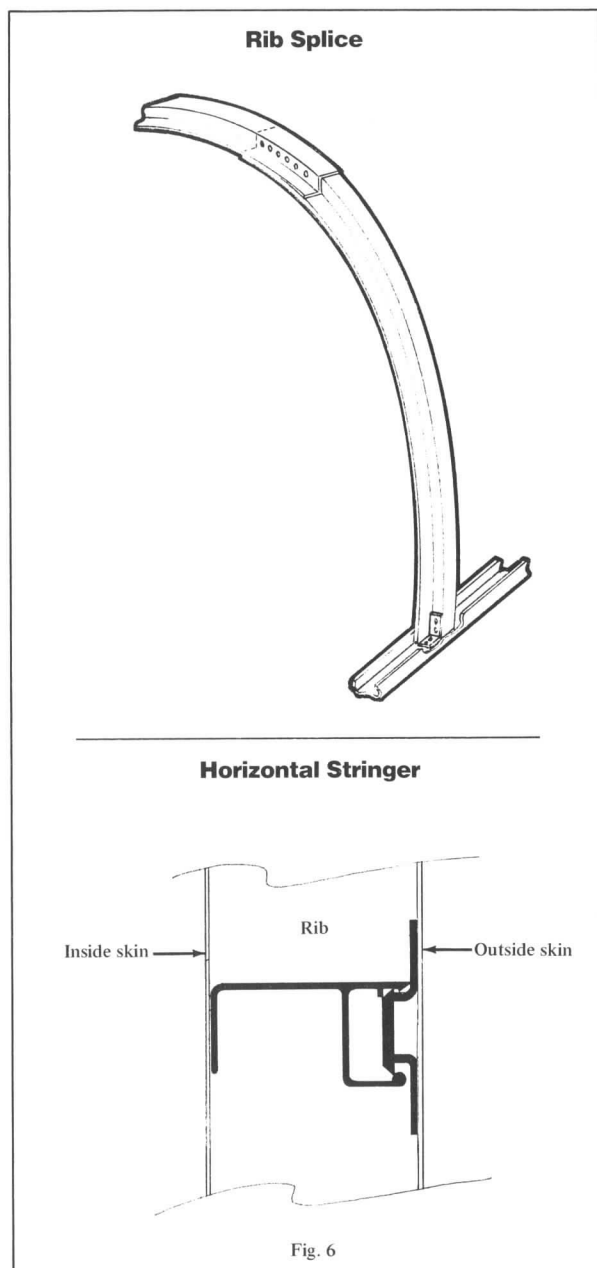
Underbelly Removal and Replacement

Flat Section

1. Cut out damaged portion with metal snips.
2. Add new underbelly piece that exceeds damaged area by 2" on all sides. Pop rivet in place and fillet caulk all edges with Ten-X.

Curved Section

1. Using a No. 30 drill, remove rivets attaching trim, lower side sheets and underbelly.
2. Cut underbelly piece to correct size and push up 1" under side sheet. Attach side sheet and underbelly to floor channel with Olympic rivets. Fold back underneath trailer and pop rivets in place starting in the middle and work to ends. This requires two men — one to hold underbelly in place and one to rivet. If repair is in wheel well area, trim after installation. Fillet caulk all edges with Ten-X.



Rib Splice and Horizontal Stringer

1. Determine height of damage or bent area of rib.
2. Cut out damaged section approximately 10" above damaged area.
3. Measure length of rib needed for replacement, allowing 6" more in length for splice.
4. Fit replacement rib into floor channel and allow the other end to overlap replacement rib.
5. Drill six (6) evenly spaced holes (using a No. 30 drill), through both ribs and rivet together. (Use 1/8" diameter medium length hard bucking rivets.)
6. Using a 1" square angle of 14-GA metal, attach rib to floor channel with (2) 1" No. 8 sheet metal screws. After the screws are secured to the floor channel, drill (2) holes with a No. 30 bit and rivet rib to bracket with (2) 1/8" diameter, medium length bucking rivets. (See Fig. 6).

Rain Leaks

Whenever rain leaks occur, the area in which the leak is originating must be determined.

1. Using a water hose, and starting in the general area in which the leak is appearing, water check the trailer.
2. With someone inside the trailer watching for the leak, start at the bottom of the trailer and work upward with the water test (covering approximately 4 sq. ft. section of trailer at a time). Allow a few minutes between each move for leaks to appear inside. As soon as the person inside detects leaks, they can advise the person checking with the hose. This will help to determine the area in which to concentrate for correcting leaks.
3. After trailer has been dried from water checking, use a Ten-X can to flow a bead of sealer along the seams of the metal, around any loose rivets which may appear, or around the window frames. Recaulk as necessary around exterior lights, Airstream lettering, plumbing, vent pipes, refrigerator vent, exhaust range vent or any other point where an opening has been made through exterior metal sheets. The seams on the roof area around the vent frames and TV antenna may be caulked with Vulkem. (This is purchased in cartridges and applied with a cartridge caulking gun.)
4. Allow sealer to dry at least one hour, then repeat water test as in Step No. 2.

Ten-X may be applied using any good clean pump-type oil can. You can purchase Ten-X sealer in bulk quantities through the Airstream Parts Department. It is also available in many Automotive Parts Stores.

Vents

Part No.	Description
101158	Bath drain line vent casting
380114	Bath drain line vent gasket.
510232	Range exhaust hood cap
101157	Refrigerator vent cap
	Refrigerator vent cap (RM 100 only)

Vent Termination Removal and Replacement

1. Drain line vent casting.
Remove No. 8 sheet metal screws and, using putty knife, carefully pry off of roof skin. When reinstalling use new gasket.
2. Refrigerator vent cap.
Using No. 30 drill, drill out attaching rivets. With putty knife, carefully pry off roof skin. Reinstall using Olympic rivets (for Olympic rivet installation see pg. 3-20/3-21) and a new gasket.

Range Exhaust Vent Removal and Replacement

1. Remove panel on the right side of the Airstream central control panel to gain access to cable.
2. Detach cable from operating arm.
3. Remove cover (lid) by lifting (bending) up the metal tab covering hinge end, and sliding lid laterally.
4. Reverse procedure for reinstallation of lid.
5. To remove cylindrical collar, remove the pop rivets from flange.
6. Lift collar from position.
7. Reverse above procedures for reinstallation using caulking under collar flange.

Front Window Assembly

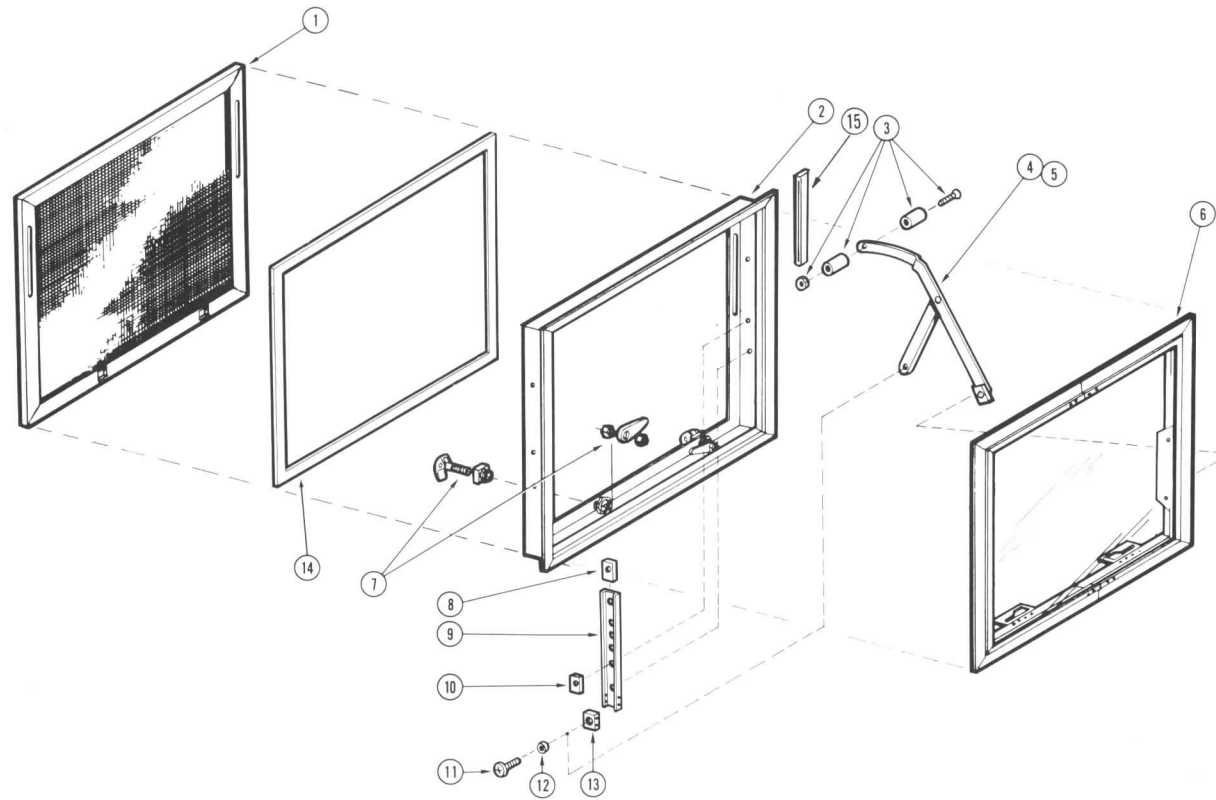


Fig. 7

Front Window

No.	Part No.	Description
	371146	Front window assembly
1	1114-15	Screen assembly
2	1112-01	Frame assembly
3	—	Handle assembly
4	1107-41	Lever arm assembly — right
5	1107-43	Lever arm assembly — left
6	1112-06	Sash assembly
7	1002-01	Latch assembly
8	1107-46	Track — guide
9	1107-36	Track — catch
10	1107-39	Stop — block
11	*	Screw — link arm
12	1107-45	Bushing — link arm
13	1107-38	Pivot — block
14	365001	Gasket, vinyl foam tape
	*	Type F 10-24 x 1/2" pan slot head
15	—	Bug seal

Side and Rear Window Assembly

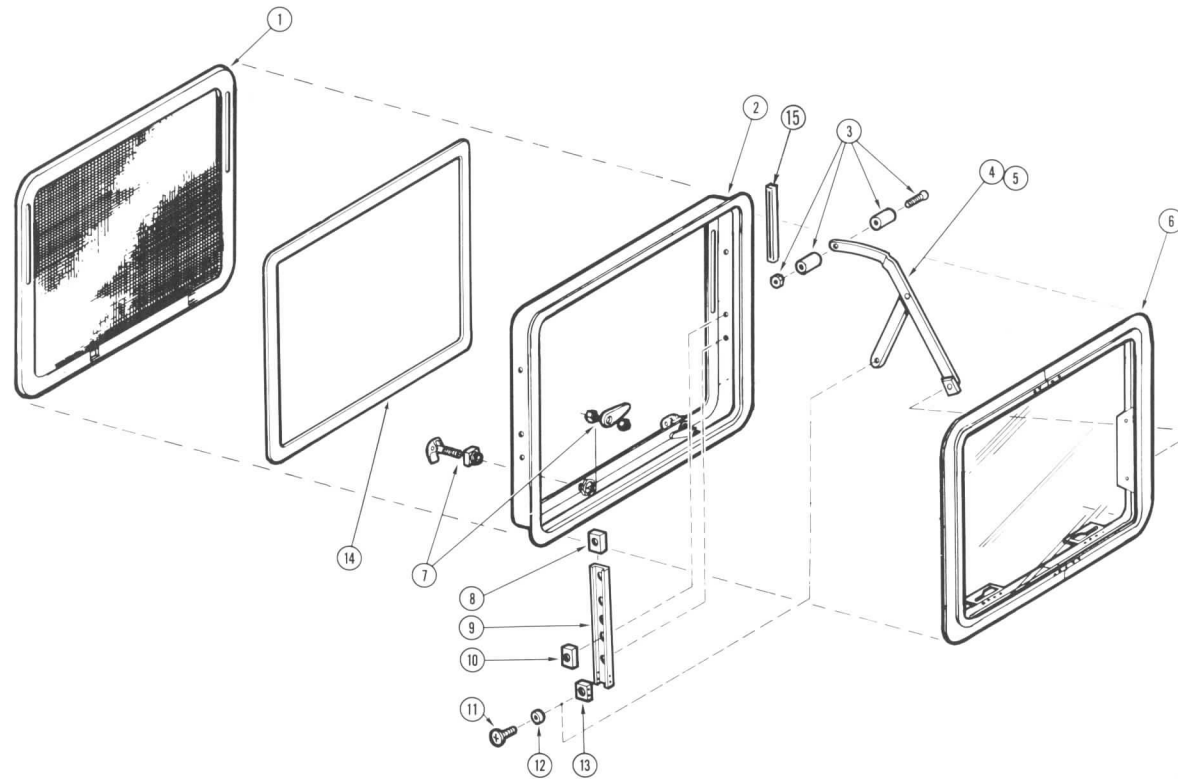


Fig. 8

Rear Window

No.	Part No.	Description
	371186	Rear window assembly – single pane
	371147	Rear window assembly – double pane
1	1114-15	Screen assembly
2	1112-01	Frame assembly
3	–	Handle assembly
4	1107-26	Lever arm assembly – right
5	1107-33	Lever arm assembly – left
6	1113-21	Sash assembly
7	1002-01	Latch assembly
8	1107-46	Track – guide
9	1107-40	Track – catch
10	1107-39	Stop – block
11	*	Screw – link arm
12	1107-45	Bushing – link arm
13	1107-38	Pivot – block
14	365001	Gasket, vinyl foam tape
	*	Type F 10-24 x 1/2" pan slot head
15	–	Bug seal

Side Curved Windows 20 in., 30 in. & 40 in.

No.	Part No.	Description
	371184	Side curved window ass'y – single pane – 18"
	371143	Side curved window ass'y – double pane – 18"
	371185	Side curved window ass'y – single pane – 30"
	371144	Side curved window ass'y – double pane – 30"
	371179	Side curved window ass'y – single pane – 40"
	371180	Side curved window ass'y – double pane – 40"
1	1114-00	Screen assembly – 18"
	1114-05	Screen assembly – 30"
	1114-10	Screen assembly – 40"
2	1109-01	Frame assembly – 18"
	1110-01	Frame assembly – 30"
	1111-01	Frame assembly – 40"
3	–	Handle assembly
4	1107-26	Lever arm assembly – right
5	1107-33	Lever arm assembly – left
6	1109-21	Sash assembly – 18"
	1110-21	Sash assembly – 30"
	1111-21	Sash assembly – 40"
7	1002-01	Latch assembly
8	1107-46	Track – guide
9	1107-36	Track – catch
10	1107-39	Stop – block
11	*	Screw – link arm
12	1107-45	Bushing – link arm
13	1107-38	Pivot – block
14	365001	Gasket, vinyl foam tape
	*	Type F 10-24 x 1/2" pan slot head
15	–	Bug seal

Wing Window Assembly

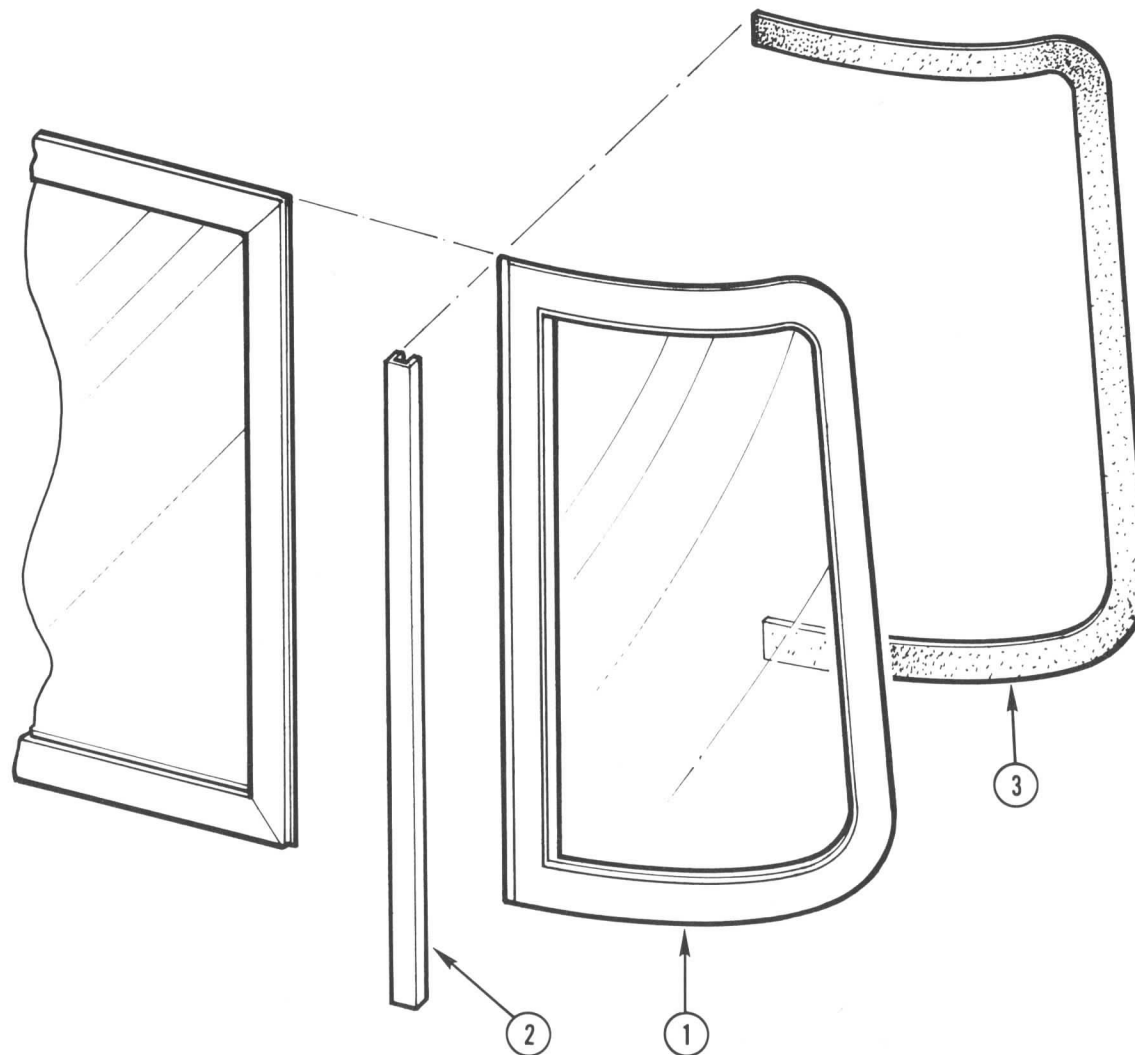


Fig. 9

Wing Window

No.	Part No.	Description
1	370026	Wing window assembly – c.s. single pane
	370027	Wing window assembly – r.s. single pane
	371141	Wing window assembly – c.s. double pane
	371142	Wing window assembly – r.s. double pane
2	1018-00	Splice bar
3	365001	Gasket – vinyl foam tape

Fixed Windows

Part No.	Description
371135	Fixed window assembly – 18" single pane
371136	Fixed window assembly – 30" single pane
371137	Fixed window assembly – 40" single pane
371138	Fixed window assembly – 18" double pane
371177	Fixed window assembly – 30" double pane
371140	Fixed window assembly – 40" double pane
00575	Gasket, vinyl foam tape

Vista View Window

Part No.	Description
371181	18" Vista View window assembly
371182	30" Vista View window assembly
371183	40" Vista View window assembly
365001	Gasket, vinyl foam tape

Main Door Window

Part No.	Description
370036	Fixed window assembly – 18" double pane

Opening Windows

Glass and Sash Replacement and All-Weather Window Installation

1. From inside trailer:

- a. Unlock window latches.
- b. Open window to 3rd position.

2. From outside trailer:

- a. Remove (1) #10-24 x ½" type "F" screw from each link arm (be careful not to lose the bushing).
- b. Lower window to closed position, allowing lever arm guide block to drop out of sash track.
- c. Rotate window upward past horizontal and it will drop out of stationary hinge (see fig.10).
- d. Replace being sure hinge on window is inside locators on stationary hinge.
- e. Re-install lever arm guide block into window sash track one side only. Re-install (1) #10-24 X ½" type "Z" screw at link arm (make sure bushing is on screw) and tighten to jam bushing against pivot block. Note: These screws must be extremely tight.
- f. Repeat Item e for remaining lever arm.

Lifting Arm Replacement

1. From inside trailer:

- a. Unlock window latches.
- b. Open window to 3rd position.
- c. Remove handle assemblies from L.H. and R.H. lever arm using screw driver to loosen.

2. From outside trailer:

- a. Remove (1) #10-24 x ½" type "F" screw from (1) link arm (be careful not to lose bushing).
- b. Lower window to closed position allowing lever arm guide block to drop out of sash track.
- c. Raise and position window. Remove lever arm assembly from

frame track guide block by twisting out of block. Pull lever arm through slot in window frame.

- d. Slide new lever arm assembly into window frame slot and assemble stud into guide block. Lower window, assemble guide block on end of lever arm to sash track.
- e. Re-install (1) #10-24 x ½" type "F" screw at link arm (make sure bushing is on screw) and tighten to jam bushing against pivot block. Note: These screws must be extremely tight.
- f. Repeat Items a. through e. for remaining arm assembly.

3. Return to inside of Trailer:

- a. Re-assemble handles.

Window Lock Replacement

1. From outside of trailer

- a. Remove locking pawl and retainer nuts from shaft.
- b. Remove large nut from threaded housing.

2. From inside of trailer

- a. Pull old lock inside trailer.
- b. Replace new lock through window frame.

3. From outside trailer

- a. Replace large nut on threaded housing.
- b. Replace locking pawl and retainer nuts on shaft
- c. Adjust pawl on shaft to give proper tension on window.

Screen Replacement

1. Remove inside lifting grip (Item No. 3) by removing Allen screw.
2. Remove No. 8 sheet metal screws attaching screen to window frame.
3. Turn window locking arms to horizontal position and slide screen off.
4. To replace, reverse the above.

Window Frame Removal (All)

Front, Rear, Side (Movable), Vista View and Fixed

1. Remove glass and sash.
2. Remove screen.
3. Using No. 30 drill remove pop rivets attaching interior skin to window frame.
4. On outside, using No. 30 drill, remove rivets attaching window frame to exterior skin. (Note: On front window, vertical tie bar between front window and wing window must be removed. (See Fig. 9.)
5. With putty knife, gently pry window frame loose from shell.

Window Frame Installation

1. Apply foam type gasket under window flange.

2. Insert window in opening.

3. Rivet window flange to side of trailer using Olympic rivets (see page 3-20 for installation instructions).

Note: On front window, install new vertical tie bar mating center window to wing window (see Fig. 9).

4. Inside vinyl metal is to be trimmed to window frame (cut out for lift arm movement – movable only) and fastened with colored pop rivets if inside skin has been replaced.

5. Using rawhide or plastic mallet, tap down any high areas between exterior rivets. Remove excess ribbon caulking and Ten-X the perimeter.

Fixed Window Removal and Replacement

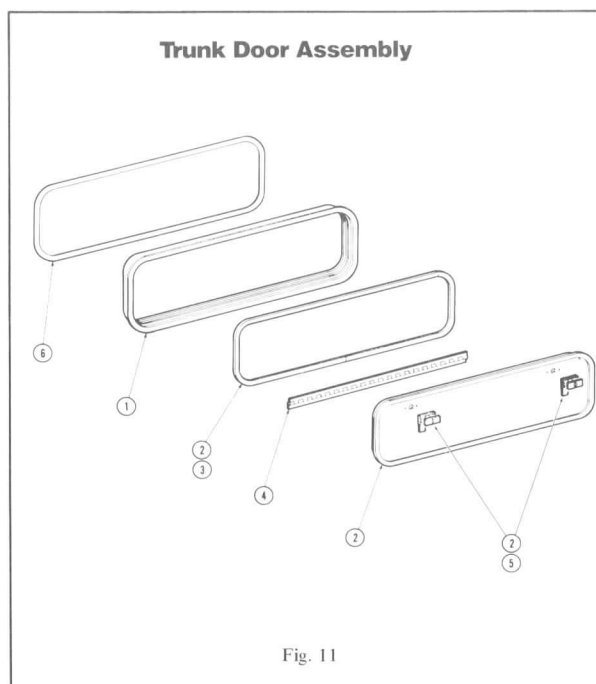
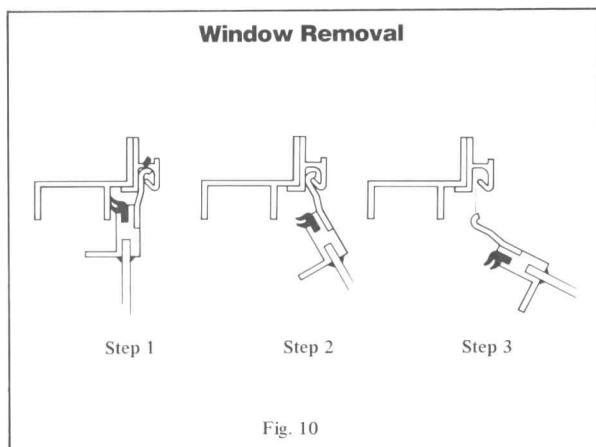
1. Remove lower curtain track.
2. Remove interior window trim by drilling out pop rivets.
3. Remove rivets from exterior window frame by drilling out with number 30 drill.
4. Reverse procedure for reinstallation.

NOTE: (1) You may use solid rivets when installing new window since back side is open for bucking. (2) Caulk liberally between exterior window flange and side of trailer to prevent rain leakage.

Wing Window Removal and Replacement

1. Remove exterior vertical tie bar between ctr. window and wing window (Fig. 9).
2. Using No. 30 drill, drill out rivets around periphery of wing window.
Note: Use stop on drill to prevent drilling inside close out.
3. Using putty knife, gently pry window loose from shell.
4. To install, apply foam tape gasket under window flange.
5. Place window onto trailer and install vertical tie bar, mating the wing window and center window (new tie bar will be required).
6. Rivet window flange to side of trailer using Olympic rivets (See p. 3-20 for installation instructions). Note: Use stop on drill to prevent drilling inside close out.

Note: If exterior wing glass and sash is all right, it can be used again.
(See exterior wing window removal and installation.)



No..	Part No.	Description
1	922070	Rear service door Jamb ass'y.
2	922071	Rear service door ass'y (less jamb)
3	201023	Extrusion seal
4	380201	Piano hinge
5	380192	Lock ass'y
6	365001	Gasket, vinyl foam tape

For part number on license plate light see page 8-3

Trunk Door

1. Trunk Door Removal and Installation

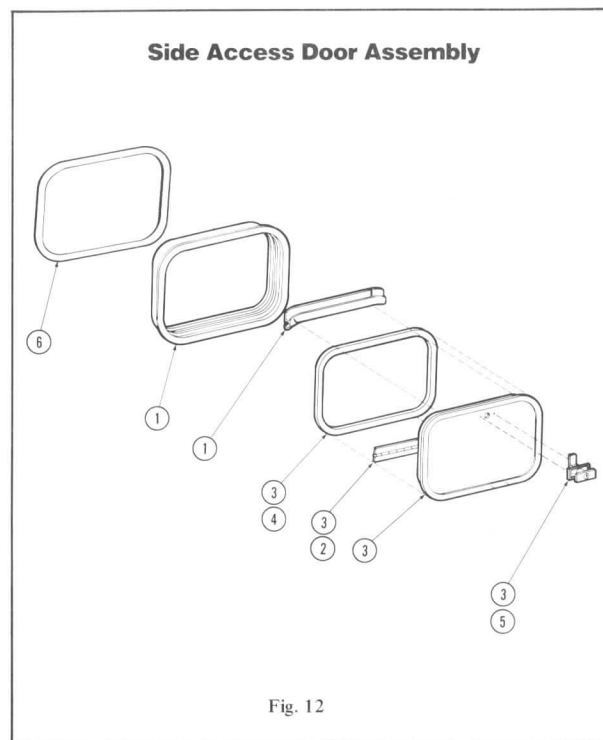
- a. Using No. 30 drill bit, drill out rivets attaching piano hinge to door frame.
- b. To install, rivet hinge to door frame using Olympic rivets. (See p. 3-20 for installation.)

2. Lock Removal

- a. Remove pawl by taking off nut.
- b. Using No. 20 drill, remove two rivets on exterior of lock. Lock can now be removed.
- c. To install, reverse procedure using 5/32 pop rivet.

3. Jamb Removal and Instruction

- a. Using No. 30 drill, remove rivets around periphery on the inside and outside.
- b. Gently pry away from ext. skin with putty knife.
- c. To install, apply foam tape gasket under flange and place in opening. Pop rivet inside skin to frame with 1/8 rivets in existing holes. Attach to exterior skin using Olympic rivets (see page 3-20) for installation instructions.



No.	Part No.	Description
1	922059	Access door jamb assembly
2	380203	Hinge
3	922057	Access door assembly (less jamb)
4	200054	Extrusion seal 50''
5	380192	Lock assembly
6	365004	Gasket, vinyl foam tape

1. Access door removal

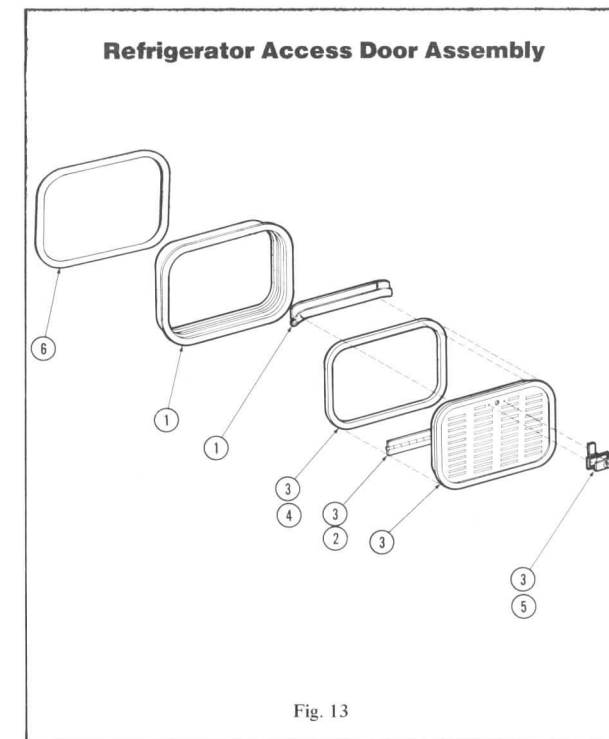
- Using No. 30 drill bit, drill out rivets attaching piano hinge to door frame.
- To install, rivet hinge to door frame using Olympic rivets. (See page 3-20 for installation instructions)

2. Lock Removal

- Remove pawl by taking off nut.
- Using No. 20 drill, remove two rivets on exterior of lock. Lock can now be removed.
- To install, reverse the procedure using 5/32 pop rivet.

3. Jamb Removal and Instruction

- Using No. 30 drill, remove rivets around periphery on the inside and outside.
- Gently pry away from ext. skin with putty knife.
- To install, apply foam tape gasket under flange and place in opening. Pop rivet inside skin to frame with 1/8 rivets in existing holes. Attach to exterior skin using Olympic rivets (see page 3-20 for installation instructions).



No.	Part No.	Description
1	922056	Access door jamb assembly
2	380203	Hinge
3	922057	Access door assembly (less jamb)
4	200054	Extrusion seal 50''
5	380192	Lock assembly
6	365004	Gasket vinyl foam tape

Main Door and Screen Door Assembly

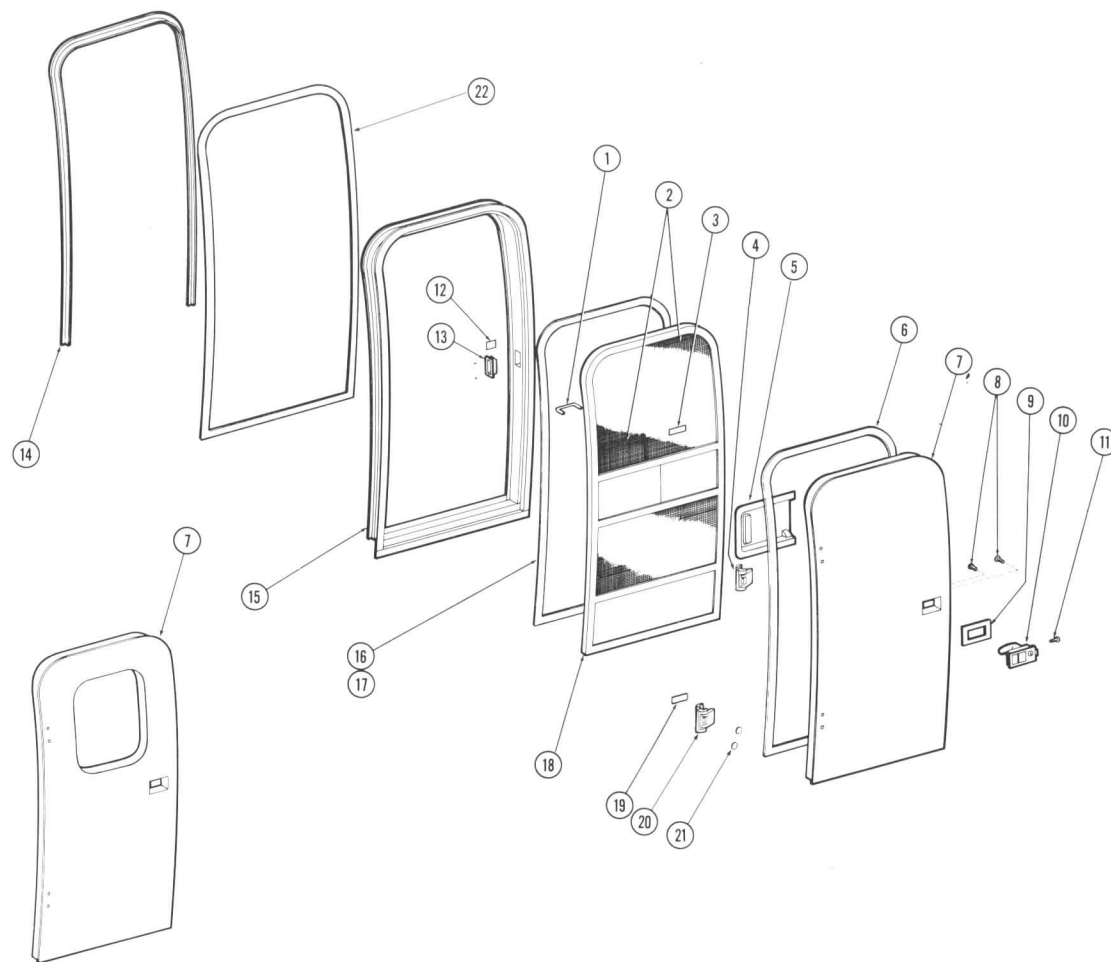


Fig. 14

No.	Part No.	Description
1	380004	Handle, screen door
2	372010	Screen 28" x 52"
3	201055	Door latch — screen door to main door
4	380235	Upper main door and screen hinge
5	201275	A B S cover — main door handle
6	200054	Seal, neoprene
7	922061	Maindoor assembly — less window (less jamb)
	994368	Main door assembly with window (less jamb)
8	345000	Screw, machine
9	380223	Seal, main door latch
10	380193	Latch assembly
11	345001	Screw, machine
12	380329	Screen door roller catch with strike
13	380557	Strike pocket
14	101077	Main door trim, interior
15	101076	Main door jamb (formed)
16	365000	Foam tape 13'
17	200007	Spline, gray
18	922168	Screen door assembly
19	380291	Door latch — hold back (3 pc.)
20	380234	Lower main door and screen hinge
21	365005	Tape — hinge screw cover
22	365001	Gasket — vinyl foam tape

Main Door Removal and Replacement

1. Remove inside metal from door by using a No. 30 drill.
2. Remove nuts from hinges.
3. Door can now be removed.
4. To install main door, reverse above procedure.

Main Door Adjustment

1. Recontouring door for proper mating with jamb.
 - a. To adjust top half of door, drill rivets from inside skin of door face. Start approximately 6 inches above center of door on lock side. Use a No. 30 drill and remove the rivets up the side of the door, across the top of the door, and down the hinge side, to within 6 inches of center.
 - b. After rivets are removed, door will now be able to flex. Close door to determine how much door must be formed. With one person holding door, and the second person forming it, the adjustment can be made.
 - c. After adjustment is made with one person holding door frame in

correct position, the second person will drill new holes in door skin and place a rivet (AD45BS — paint match for vinyl skin) in each top corner and close door to make sure position has not changed.

- d. If it is found to be correct, open door and continue to pop rivet skin in place, installing new rivets, equally spaced between original holes.

2. To adjust bottom half of door, start drilling rivets out 6 inches below center of door, down and across bottom, then up the lock side. Follow same adjustment procedure as used in top half.

3. Striker Pocket Adjustment.

- a. Using grease pencil, mark bevel of strike bolt of lock and close door to determine vertical misadjustment of pocket.
- b. Drill rivets from strike pocket and adjust pocket to proper height.
- c. Rerivet pocket in new position with a rivet at top and bottom of pocket. Double check latching and ease of door closing.
- d. Lateral adjustment may be necessary to gain ease of latching.
- e. When correct, install remaining rivets (never file lock bolt).
- f. After relocating pocket, be sure to mark outer surface of bolt with the grease pencil once again. Double check to make sure bolt is entering pocket deep enough (at least $\frac{1}{4}$ ") to prevent door from opening in transit.

4. Door Seal.

- a. Using a drill with a No. 30 bit, and starting at the bottom of the door, pull rubber loose and start drill under edge of rubber.
- b. Carefully pull on rubber with one hand, and run drill around edge of door (between rubber and door). This will peel rubber from door very easily. (See Fig. 14.)
- c. Make sure the old rubber is completely removed from door. Then, using any good rubber adhesive, apply a thin coat to edge of door.
- d. Lay out replacement rubber on a flat surface with side to be applied against door facing upward.
- e. Apply a coat of glue to this side of rubber.
- f. Pick up rubber, keeping edges separated. Starting at bottom corner of door, feed rubber up the side and across top and down opposite side and bottom.

- g. When starting rubber, be sure proper edge of rubber is facing outward on door for correct seal. Keep rubber tight but do not stretch. (See Fig. 14)

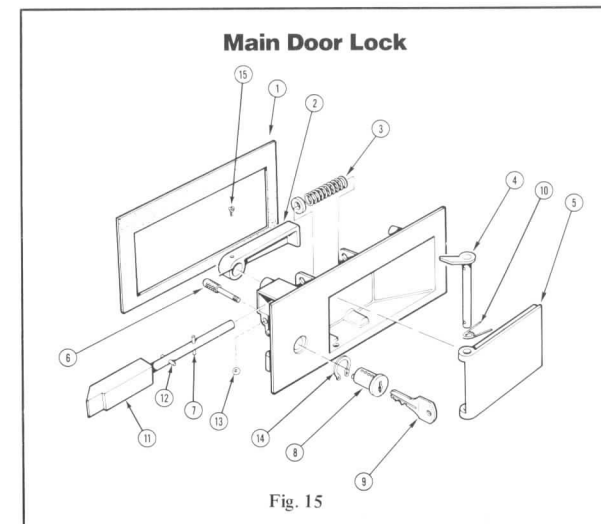
Apply a coating of silicone spray to door rubber and door jamb frame. This will ease closing of door.

Replacement of Lock

1. Remove inside door lock handle by loosening set screw and pulling handle from shaft.
2. Remove screw from door frame, securing lock to the frame. This is located just above the bolt.
3. Remove three mounting screws that attach inside skin to lock body. (See Fig. 15.)
4. Use a drill (No. 30) and remove rivets from center seam of inside door skin; also from edge of door approximately 12" in each direction.
5. Pull inside skin slightly to clear inside lock handle shaft.
6. Lock can now be removed.
7. Replace by reversing above steps.

To Replace Lock Cylinders

1. To remove lock cylinder with lock installed in trailer, drill center of lock cylinder with a No. 20 drill bit as a pilot hole, to a depth of approximately $\frac{1}{2}$ an inch. After reaching this depth, change drill size to $\frac{3}{8}$ of an inch and very carefully redrill same hole to same depth. Lock cylinder is held in place by a spring-loaded horseshoe keeper on back side of cylinder. By drilling a hole in the cylinder, this will allow keeper to drop out and lock cylinder can be pulled from lock.
2. To replace, press horseshoe keeper flush with cylinder, and insert into hole. With key in upright position, press cylinder into hole until it is fully in place. Spring will allow keeper to snap into place, locking cylinder into position. Lock should now operate.



No.	Part No.	Description
	380010	Main door lock assembly
1	380223	Gasket seal
2	380345	Handle — inside
3	380344	Spring — slide bolt
4	380348	Vertical shaft (outside handle)
5	380346	Handle — outside
6	380347	Knurled locking pin
7	380343	Roll pin
8	380341	Tumbler cylinder and keys
9	380342	Key blank
10	380632	Lever spring
11	380633	Slide bolt
12	380634	Roll pin
13	380635	Locking ball and spring
14	380636	Cylinder retainer ring
15	380637	Set screw - inside handle

Door Lock Outside Handle Replacement

1. Remove lock from door. (See p. 3-15)
2. Place lock in bench vise holding bolt in retracted position.
3. Using drift pin, remove drive pin from arm assembly.
4. Remove arm assembly.
5. Install new arm assembly inserting through exterior handle pivot lugs.
6. Align holes in handle pivot lugs with holes in arm assembly, inserting 3/32 x 1/2" drive pin.
7. Install lock in main door. (See p. 3-15)

Screen Door Adjustment

1. Door not square in opening.
 - a. Using a No. 20 drill, remove rivets attaching screen door to hinge.
 - b. Properly locate screen door into door jamb.
 - c. Hold in this position and have second person drill two new holes from hinge through door.
 - d. Install 5/32 pop rivet in these holes.
 - e. Check if properly located and then install balance of pop rivets.
2. Recontouring door for proper mating with jamb (two people required).
 - a. If too much curvature is in screen door, hold center firmly against jamb from the outside and pull on top or bottom till proper contour is achieved.
 - b. If not enough curvature is in screen door, place a 6" 2 x 4 wood spacer at center in latch area. Close screen door and push on top or bottom until proper contour is achieved. Increase spacer if necessary.
3. Replacing foam tape
 - a. Starting at bottom of door, peel gasket seal from frame. This is a self-adhesive gasket, and should be able to be removed very easily.
 - b. Clean frame surface with lacquer thinner and wipe clean.

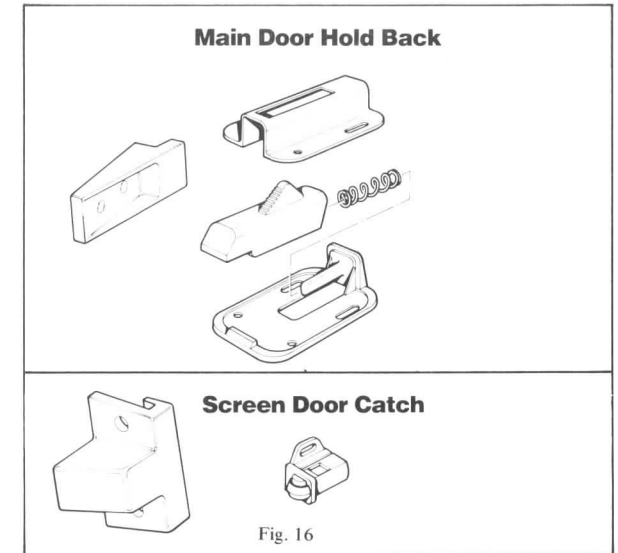
- c. To replace, peel paper backing from new gasket. Starting at the bottom, form around door.

Plastic Screen Door Insert Removal and Replacement

1. Push upward on panel as far as it will go, and pull out on bottom.
2. To reinstall, reverse above.

Main Door Jamb Removal and Replacement

1. Remove main door. (See p. 3-14, 3-15) Remove striker by drilling out pop rivets with No. 30 drill.
2. Remove pop rivets from inside door trim.
3. Gently pry out inside door trim.
4. Using a No. 30 drill, remove pop rivets attaching inside skin to door jamb.
5. Using No. 30 drill, remove rivets attaching exterior skin to door jamb.
6. Remove screws attaching door jamb to floor.
7. Remove screws attaching galley and galley top to sidewall.
8. Remove screws attaching galley to floor.
9. Slide galley approximately 6" away from wall.
10. Remove pop rivets attaching inner skin approximately 12" to the rear of the door jamb.
11. Hold inner skin away from door jamb in hinge area and remove nuts attaching hinge to jamb.
12. Remove door jamb.
13. Before installing new jamb, apply foam tape gasket under door jamb flange.
14. For installing, reverse procedures 1 - 11 using AD45 pop rivets for attaching inner skin and Olympic rivets for attaching exterior skin. (See page 3-20 for installation instructions.)



Screen Door Latch Removal and Replacement

1. Slide latch completely open.
2. At rear of latch, with a screwdriver or similar instrument, lift or pry the two sections apart. Note the spring position for reassembly.
3. Reverse procedure for reinstallation. Firmly pressing the two parts together (in completely open position) until they snap together.

Assist Handle Removal and Replacement

1. Remove pop rivets from inside door trim.
2. Gently pry out inside door trim.
3. Detach lower curtain track.
4. Remove lower window garnish by drilling out pop rivets.
5. Remove rivets from inside skin in general area of assist handle.
6. Pull inside skin away to gain access to back side of assist handle.
7. Remove rivets.
8. Remove assist handle.
9. Reverse above steps to reinstall.

Univolt Compartment Assembly

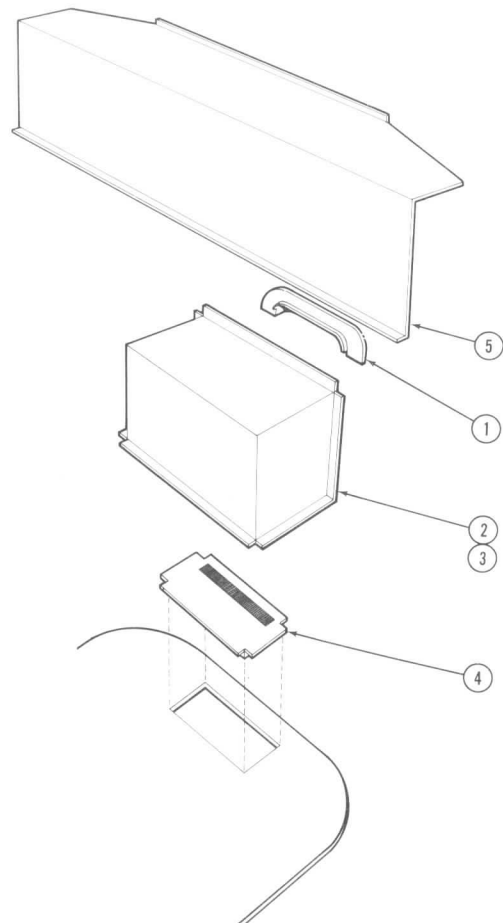


Fig. 17

No.	Part No.	Description
1	100307	Vent, univolt casting
2	100308	Cover, univolt
3	200295	1/2" insulation on inside walls
4	600682	Floor vent
5	100422	Univolt and battery cover

Battery Compartment Assembly

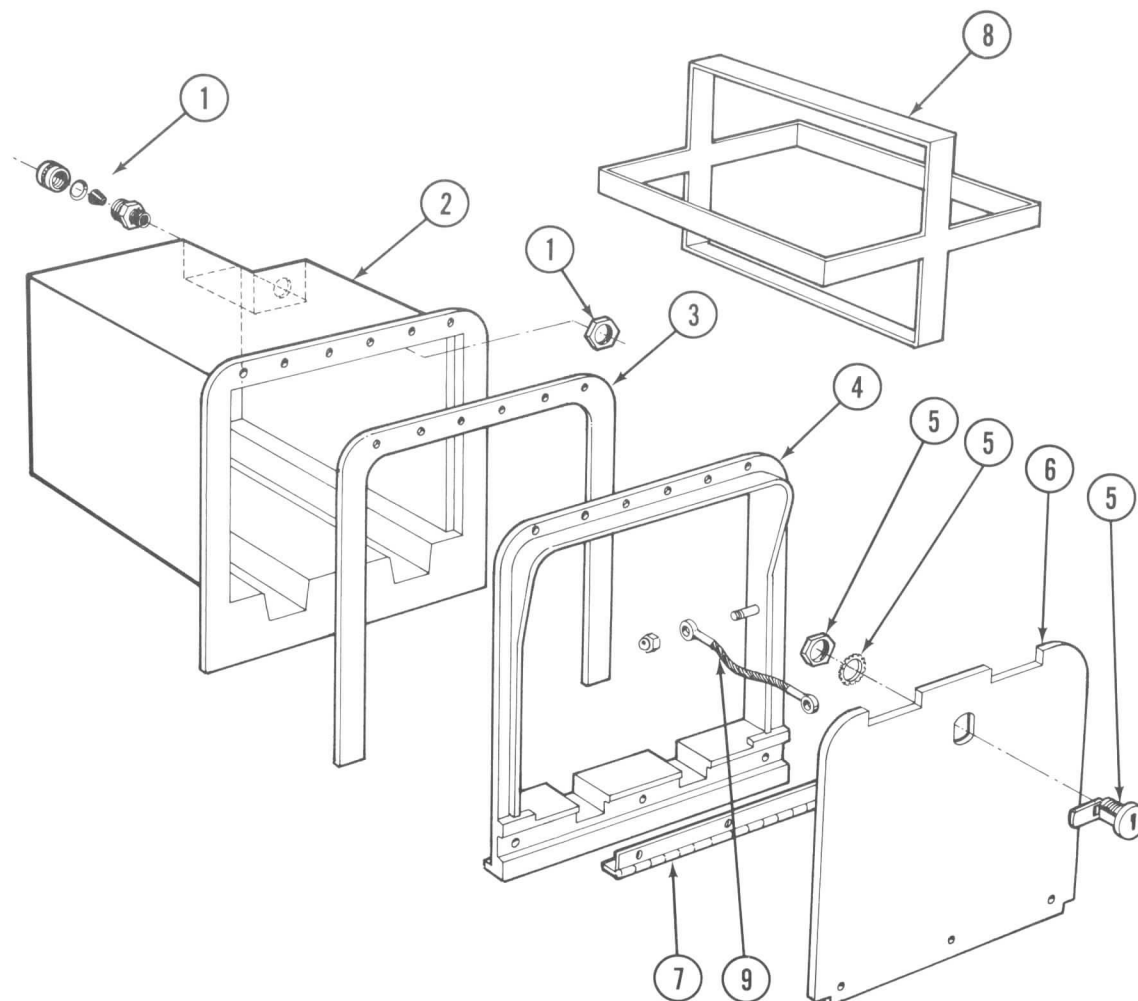


Fig. 18

No.	Part No.	Description
1	380612	Cable strain relief
2	200276	Battery box
3	365004	Gasket, vinyl foam tape
4	100286	Frame, polished casting
5	380093	Lock
6	100287	Door, polished casting
7	380175	Hinge
8	510140	Battery strap
9	380238	Cable support

Removal and Replacement

1. Door Removal

- Disconnect and remove battery
- Using No. 30 drill, drill out rivets and remove piano hinge from door.
- Remove nut securing cable eye to mounting stud. Remove door.
- To install, reverse removal procedure. Use Olympic rivets.

2. Lock Removal

- Remove nut and washer (Item 5).
- Remove lock assembly.

3. Frame and Compartment Removal

- Remove door as per Step 1.
- Drill out rivets holding frame to trailer wall, remove frame (Item 4), and gasket (Item 3).
- Loosen nut (Item 1), pull battery box out to extent of Univolt cable.
- Disconnect cable from Univolt.
- To install, reverse procedure.

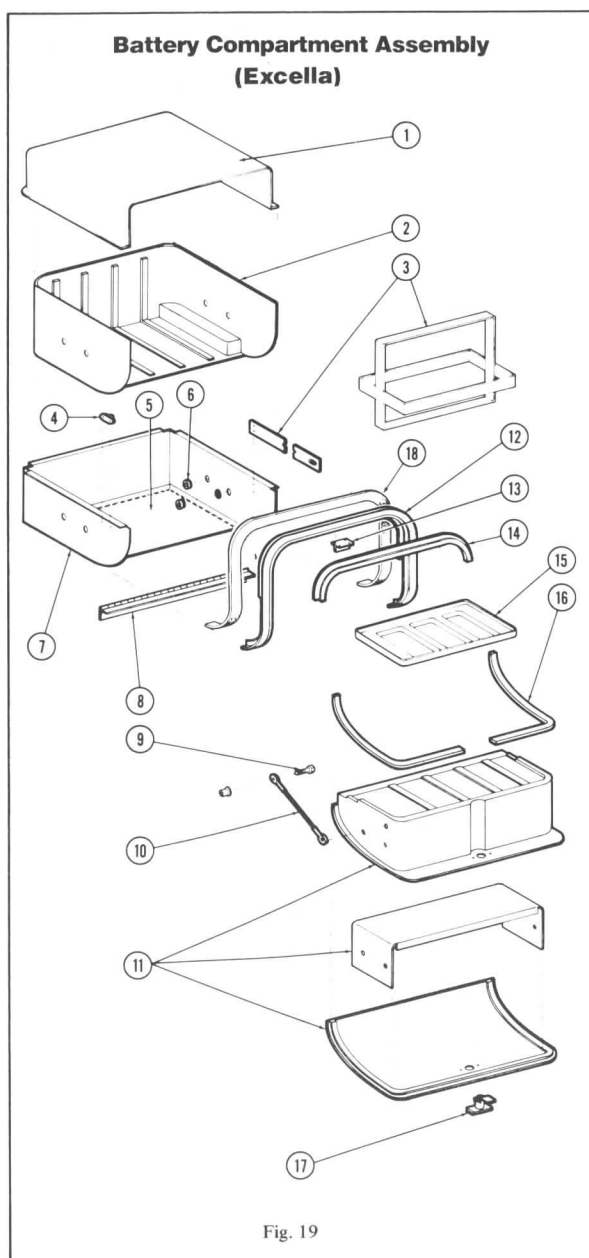


Fig. 19

No.	Part No.	Description
	922062	Battery compartment ass'y
1	201087	Liner ABS, battery cover
2	201087-6	Liner, ABS, battery support
3	410140	Battery strap
4	380245	Stud, single (common sense)
5	101224	Aluminum .050
6	380268	Grommet
7	101224	Aluminum pan
8	380189	Piano hinge
9	345016	Screw machine hex head 1/4 - 20 x 1
10	380238	Cable with eyelets
11	101414	Battery door assembly
12	101126	Extrusion trunk door frame formed
13	380204	Catch access door
14	-	Drip rail
15	201108	Tray, battery
16	201023	Extrusion weather seal 18"
17	380192	Lock access door
18	365001	Gasket, vinyl foam tape

Battery Compartment (Excella)

1. Door Removal

- Disconnect and remove battery.
- Using No. 30 drill, remove piano hinge from door.
- Remove bolt (Item No. 9) holding support cable.
- To install, reverse procedure using Olympic rivets. (See p. 3-20 for rivet installation instructions.)

2. Lock Removal

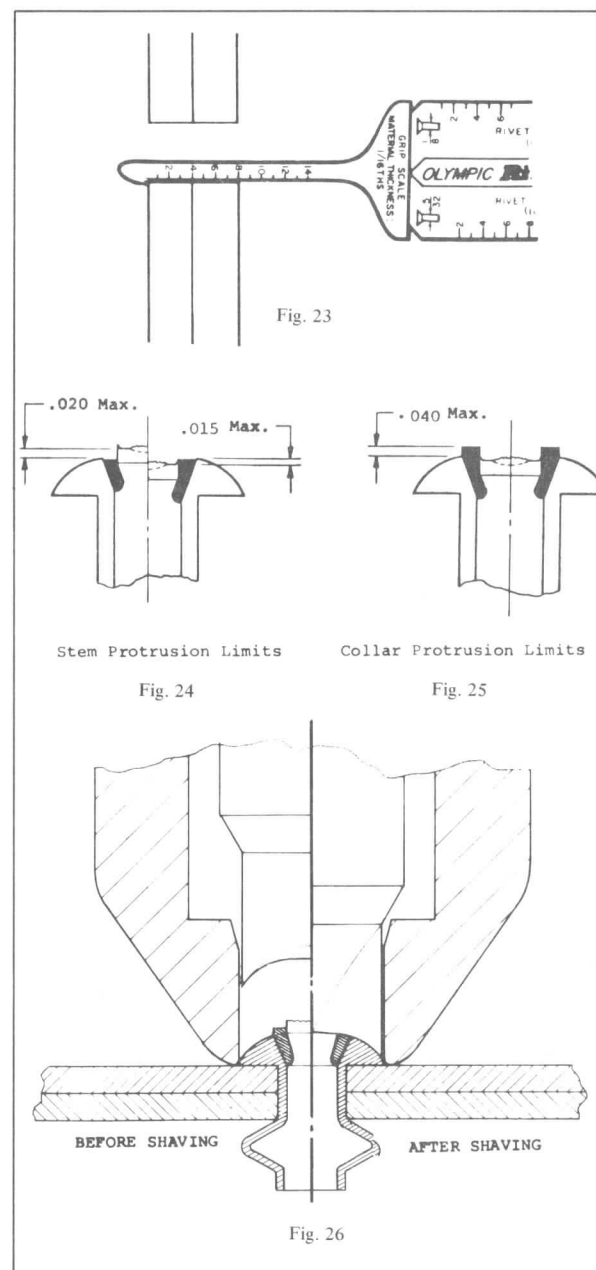
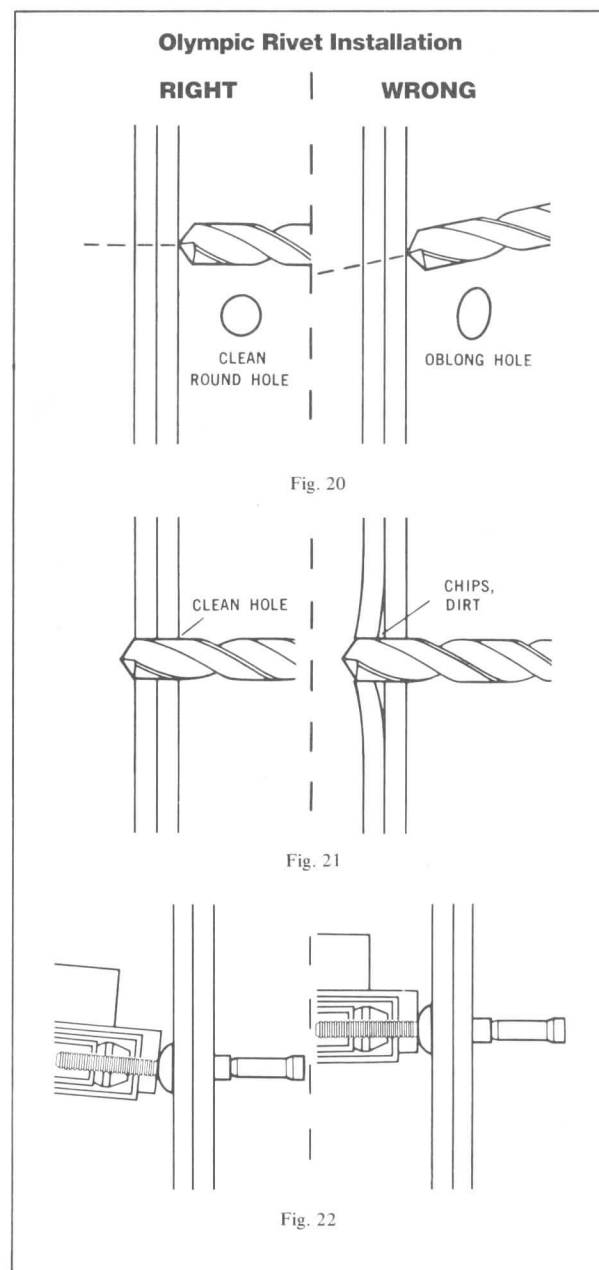
- Remove pawl by taking off nut.
- Remove two screws on exterior of lock. Lock can now be removed.

3. Frame & Compartment Removal

- Remove door per Step 1.
- Remove ABS liners on inside (Items No. 1 and 2) by drilling out pop rivets and taking out screws attaching liner to floor.
- Using No. 30 drill, remove rivets attaching frame to exterior shell.
- On inside, remove screws attaching aluminum pan to floor (Item No. 7).
- Disconnect battery cable from univolt and remove.
- Using putty knife, gently pry from exterior skin.
- To install new compartment, feed battery cable through compartment and floor to Univolt. Connect to Univolt. (Be sure connections are proper - Pos. to Pos. and Neg. to Neg.). Apply foam tape gasket under flange of frame. Place compartment in opening. Rivet to exterior with Olympic rivets and on inside, add screws to floor. (See page 3-20 for rivet installation instructions.)

NOTE - CAUTION:

The weatherseal (item No. 16) is not a continuous strip across top of door. This gap provides venting of oxygen and hydrogen gases that are emitted from battery.



Drilling of Holes for Installation

1. Hole diameter recommended for blind rivets (CV-2100-5 is .160/.164, No. 21 drill).
2. Hold drill at right angle to structure to obtain a round hole. (See Figure No.20)
3. Avoid excessive pressure on drill to prevent distortion to the structure. (See Figure No.21)
4. Correct rivet grip length.

Use of the Olympic "Hook" gauge allows a direct reading on the correct rivet grip length. Figure 3 shows a stack which is on the borderline between a-4 and a-5 rivet. Either grip length will satisfy this particular stack.

Material Thickness	Correct Olympic Rivet
.050 to .150	XA 4167-2
.151 to .250	XA 4167-5

The thickness of metal on the exterior shell is .032 gauge. Keep this in mind while determining the grip range needed.

5. Rivet Installation:

Use either Olympic RV 506 pulling gun with Olympic RV812-5 pulling head, or Olympic RV862-5 hand gun which includes its own pulling head. Hold the gun in line with the axis of the hole to prevent cocking of the rivet in the hole. Exert firm pressure against the structure to obtain proper seating of the rivet head.

Avoid excessive pressure which could distort the structure. (See Figure No.22)

6. Protrusion Limits:

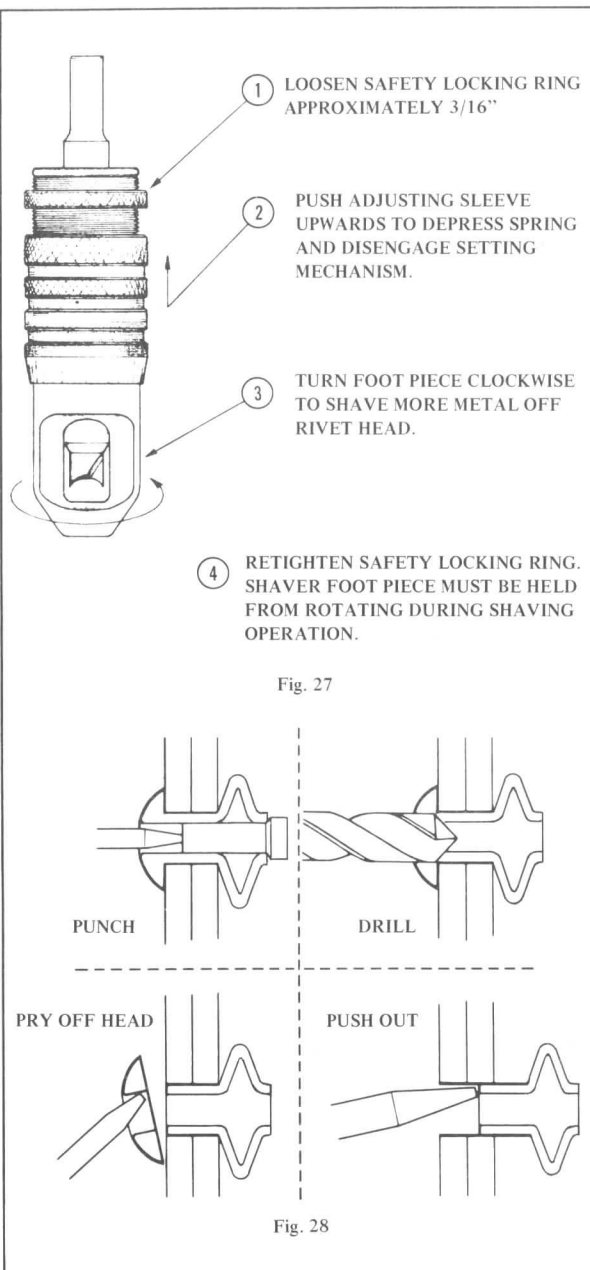
The installed rivets should conform to the stem and collar protrusion limits in Figures No.24 and No.25

7. Shaving of Rivet Head.

After rivet is installed the head can be shaved to give the appearance of a bucked rivet.

Figure No.26 shows a section through the rivet head before and after shaving, as well as the correct adjustment of the shaving tool.

Adjust the shaving tool to remove the minimum amount of metal necessary to clean up the rivet head. (See Figure No.26)



Removal of Olympic Rivets

1. Should it be necessary to remove an improperly installed blind rivet, the following procedure is recommended:
 - a. Punch a drill start into center of head.
 - b. Drill (No. 21) through the head of the rivet only. The drill should be the same size as the rivet shank.
 - c. Pry the head of the rivet with a punch.
 - d. Push or drill out the remainder of the rivet. Be careful not to enlarge the hole in the structure. (See Fig. 28.)

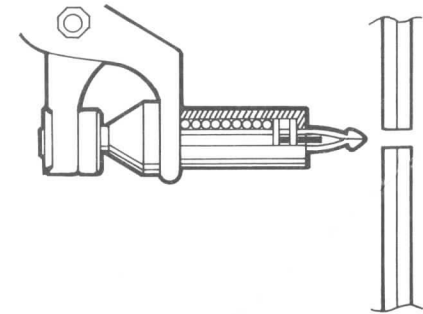
Wedge Locks

Use wedge-locks when pinning up replacement metal panels. Wedge-locks hold the sheet in place and, when properly spaced, hold the sheet flat. This prevents cans or pockets from forming in the metal due to excess metal.

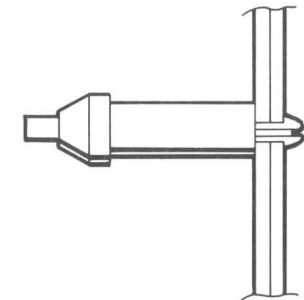
The wedge-lock is a spring-loaded type fastener, which is installed by means of special pliers. (These tools are available from Factory Parts Department.)

1. Using a No. 30 drill, drill hole in replacement sheet where fastener is to be placed.
2. After hole is drilled, place fastener in pliers and apply pressure to pliers. This compresses fastener spring, allowing fastener tip to retract for inserting in hole on panel. (See Fig. 29.)
3. After inserting fastener into hole, release pressure on pliers. Fastener is now locked into position to hold replacement panel. (See Fig. 29.)
4. All sheets should be pinned up with fasteners approximately every fourth hole across top, bottom and sides, and every third hole on center of sheet seams.
5. When pinning up segments, space wedge-lock fasteners every third hole to be sure of a tight seam.
6. To remove fasteners, place pliers in position on fasteners and apply pressure. Then remove from hole.

Wedge Locks



Pushing the plunger compresses the spring, extending the wires over tee. In this position wires converge at the tip, making insertion or extraction an easy operation.



After insertion, release plunger. Automatic spring action retracts wires back over tee. Wedgelock action of tee forces wires apart, locking fastener securely into hole, while pulling sheets firmly together.

Fig. 29

Exterior Maintenance

Any aluminum product, without a protective coating applied to it will oxidize or tarnish when exposed to the weather. The Airstream Alclad aluminum exterior has been covered with an acrylic lacquer finish to provide years of environmental protection. The exterior surface should be washed periodically, and washing procedures are similar to those for washing an automobile. Both have high quality finishes, so certain precautions should be taken to protect them; for example:

1. Always wash in the shade or cool of the day, using a mild non-abrasive soap or detergent. Apply with a sponge or very soft cloth, and always wash with the grain of the metal (horizontal). Rinse with clear water and dry with a chamois or soft cloth. Automatic dishwasher detergents and acid etch cleaners are too strong and should never be used.
2. In the winter, when driving under ice and snow conditions, the trailer must be washed as soon as possible after use, as any highway salt spray can eat through the plasticcoat and oxidize the panel in a very short period of time.
3. Tar, sap, gum, resin, etc. should be removed with mineral of spirits as soon as possible. NEVER USE LACQUER THINNER OR PAINT REMOVER as they will remove the plasticcoat. It is important to remove contaminating materials as soon as possible after they appear by washing and rewaxing. Sunlight and time will tend to bake-harden them, making them almost impossible to remove without heavy buffing. If asphalt remains on the trailer after washing, use a small amount of kerosene on a rag and wipe the spots individually, being careful not to scratch the aluminum.

After cleaning and drying, a good grade of nonabrasive automotive paste or liquid wax will increase the life of the finish. This is especially true in coastal areas where the finish is exposed to salt air, or in polluted industrial areas. Waxing will also protect the shell from minor scratches and make subsequent cleaning easier. Wax should normally be applied every three to six months.

NOTE: On new trailers, or newly refinished trailers, wax should not be applied during the first 90 days. This is to enable the lacquer finish to take a permanent set.

For small areas of damage to the acrylic protective coating, or where oxidation is beginning to occur, remove all traces of the acrylic coating with a good grade of lacquer solvent and then thoroughly clean the aluminum with an aluminum cleaner. Respray the area with clear acrylic lacquer. Paint the "A Frame", L.P.G. tanks, and rear frame periodically by brushing or spraying with aluminum lacquer.

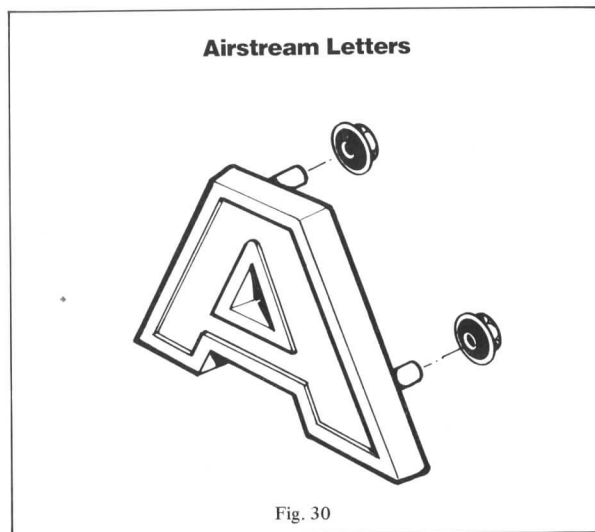
Each time the 7-way electrical connector is connected it should be checked for dirt and corrosion. Keep the contacts clean with "Spray-Kleen".

Plasticcoat Removal

1. Mask all painted areas, such as name plates and body trim.
2. Remove clearance light lens and tail light lens.
3. Shut off gas bottles and extinguish all fires.
4. Brush a paint or varnish remover onto trailer surface. We suggest formula A, Strip Eze, which is an aircraft paint remover.
5. Allow to stand a few minutes, until finish is loose, then flush with clear water.
6. Steps 4 and 5 may need to be repeated in some areas where finish is difficult to remove.
7. After the water flushing, wash the trailer with lacquer thinner and a soft cloth, wiping with the grain of the metal, until surface is completely clean.

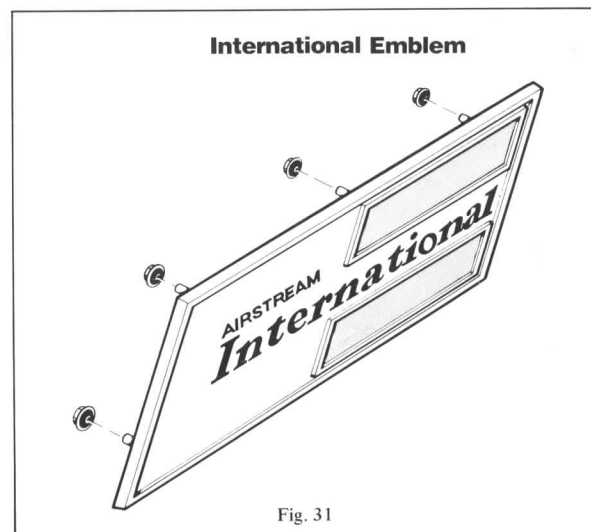
Plasticcoat Application

1. Mask window surfaces. Trailer is now ready for spraying.
2. Do not thin material, as it is ready for application when furnished to you by Airstream. Apply with a Bink's No. 7 spray gun, with No. 36 needles, for best results. Use a line pressure of approximately 45 psi.
3. Spray in vertical sections about 3 feet wide from center of top all the way to bottom of trailer. It is best to start at front of trailer working towards the rear, then going completely around trailer.



Airstream Letter Installation

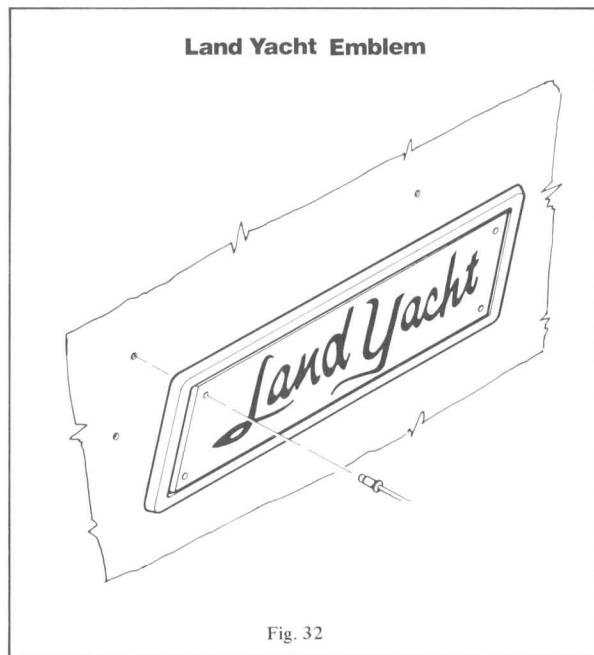
1. Where access to rear of cast lettering is not possible break off the anchoring pin and attach the letter with blue No. 30 pop rivets.
2. Seal perimeter of letters to prevent leaks.



International Emblem – Roadside and Curbside Removal and Replacement

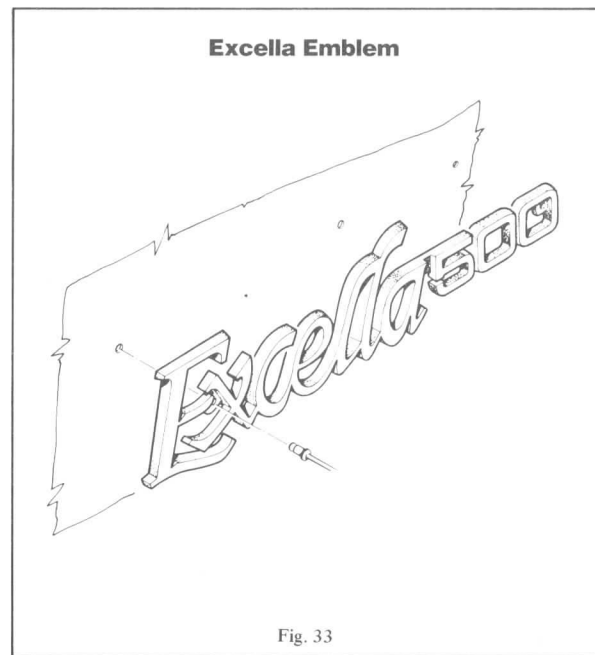
This emblem is held in place by nuts on the inside of the exterior aluminum sheet. Should it be necessary to replace the emblem we suggest:

1. Accurately measure to determine emblem location on inside wall of trailer.
2. Cut a hole through the inside wall of trailer to gain access to the rivets securing emblem in place.
3. Remove nuts.
4. Remove emblem.
5. When reinstalling caulk nuts liberally to prevent leakage.
6. Cut a piece of metal, matching interior wall, approximately 1" larger on all four sides to cover the opening previously cut in step 2.
7. Make certain area between inner and outer wall is covered with insulation.
8. Install plate using proper colored pop rivets.



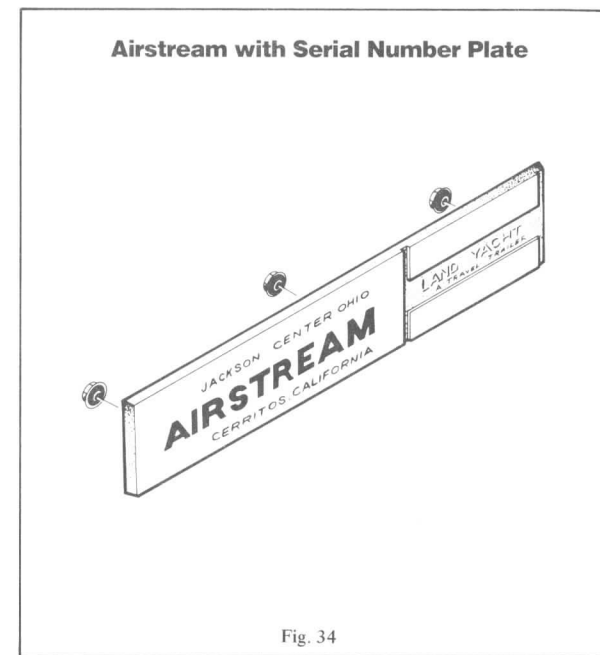
Land Yacht Emblem Removal and Replacement

1. Remove pop rivets securing emblem to side of trailer.
2. Before installing new emblem install pop rivets in trailer skin filling holes from original installation and seal to prevent rain leaks.
3. After installation of new emblem, seal around perimeter for further leak protection.



Excella Emblem Removal and Replacement

1. Remove pop rivets securing emblem to side of trailer.
2. Before installing new emblem install pop rivets in trailer skin filling holes from original installation and seal to prevent rain leaks.
3. After installation of new emblem, seal around perimeter for further leak protection.



Serial Number and Nameplate Removal and Replacement

1. Remove door jamb trim (See p. 3-16).
2. Remove credenza cabinet and table if so equipped.
3. Remove stationary window trim. (See p. 3-11)
4. Remove all rivets from interior panel below stationary window except those rivets on front bow.
5. Pull inside skin back to gain access to nuts securing serial number and nameplate.
6. Remove sealer around nuts.
7. Remove nuts.
8. Remove serial number and nameplate.
9. Reverse procedure for reinstallation.

NOTE: Caulk around nuts liberally to prevent rain leaks.

Tailight Bezel Assembly

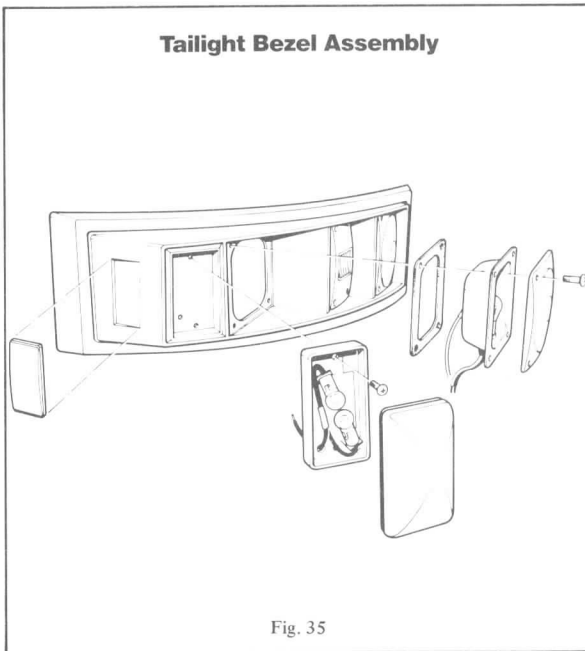


Fig. 35

Tailight Bezel* Removal and Replacement

Tailight bezel requires removal and replacement of the #4 or #5 segment as described on page 3-3 in the Shell Section. Great care should be taken in drilling rivets as detailed in Olympic Rivet Section under drilling of holes. Tape panels of joints for protection against scratches.

Bezel is removed from segment by removal of all attaching screws and inserting a putty knife between bezel and segment to break caulking. Reseal new part with putty tape and reinstall.

*NOTE: For part numbers of electrical components refer to Electrical Section.

Clearance and Side Marker Light and Bezel

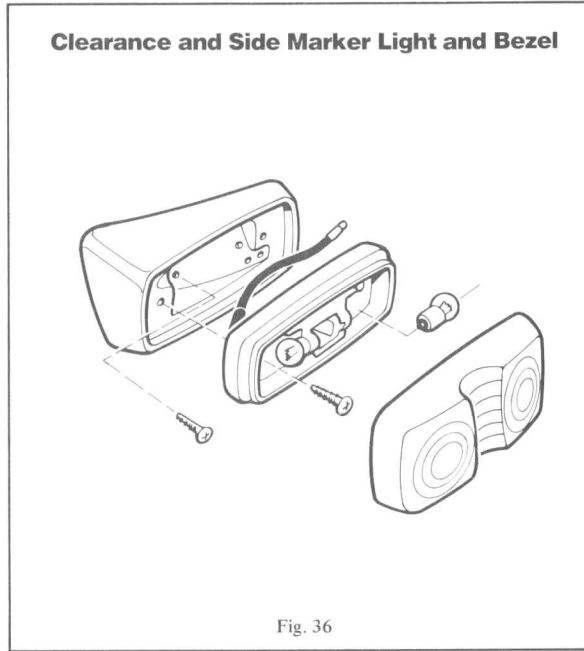


Fig. 36

Clearance Light, Side Marker Light, Cast Bezel* Removal and Replacement

1. Remove light lens and base.
2. Remove two screws securing casting to trailer skin.
3. When replacing casting, seal around perimeter to prevent rain leaks.

Clearance, Side Marker Light, Front & Rear Identification Light* Removal and Replacement

1. Remove lens with screwdriver by prying from light base.
2. Remove two screws securing base to trailer (one serves as electrical ground contact).
3. Unplug wire.
4. Reverse above procedure for reinstallation.

License Plate Bracket and Light

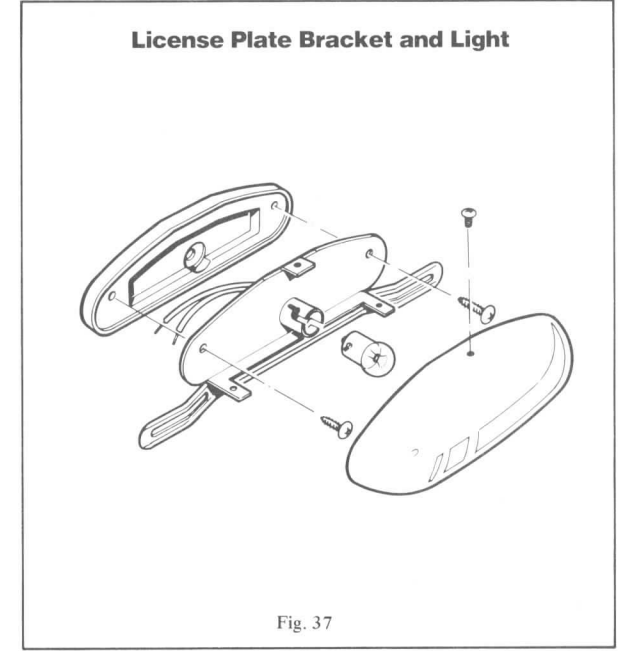
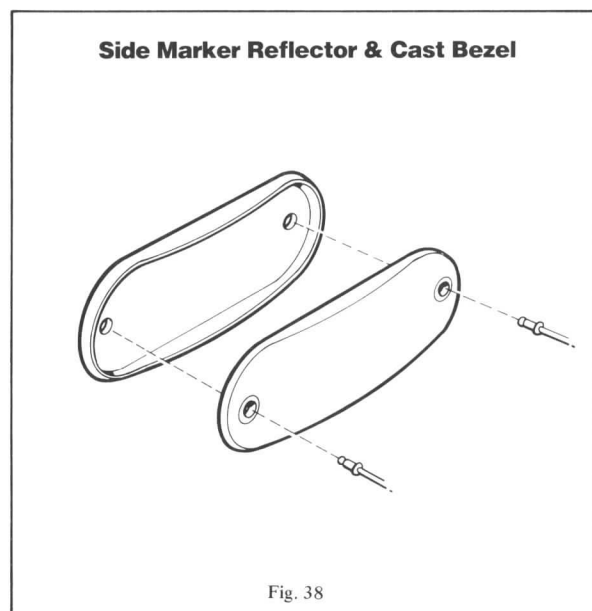


Fig. 37

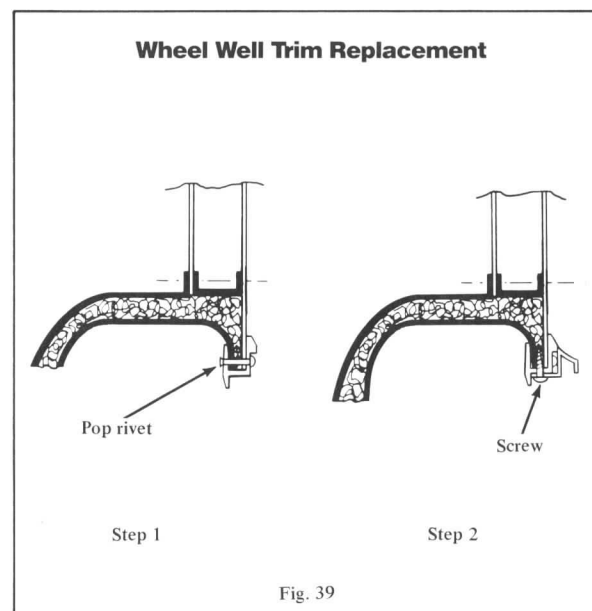
License Plate and Light* Removal and Replacement

1. Remove three screws securing light cover.
2. Remove two screws securing light base and license holder to trailer.
3. Unplug wire.
4. Reverse above procedure for reinstallation.



Side Marker Reflector Cast Bezel* Removal and Replacement

1. Remove reflector by drilling out two pop rivets.
2. Remove casting by drilling out two pop rivets.
3. When replacing casting, seal around perimeter to prevent rain leaks.



Wheel Well Trim Removal and Replacement

1. Remove approximately 24" of rub rail vinyl away from wheel well by removing cleat and pop rivet. Then pull vinyl from rub rail.
2. Remove pop rivets from rub rail for a distance of approximately 24" from wheel well.
3. Remove screws and pop rivets securing outer trim.
4. Remove pop rivets securing inner trim.
5. Reverse procedure for installation.

NOTE: Caulk liberally between exterior metal and wheel well.

Belt Line Trim End Castings (Int'l. & Excella) Removal and Replacement

1. Remove three pop rivets.
2. Remove casting.
3. When reinstalling caulk the top and end perimeters

Belt Line and Rub Rail Trim (Int'l. & Excella) Removal and Replacement

1. Remove pop rivet and cleat at end of vinyl insert.
2. Remove vinyl insert by grasping one end and pulling from the metal trim.
3. Remove the metal trim by drilling out the pop rivets with a No. 30 bit.
4. Reverse procedure for reinstallation.
 - a. Fill old holes with pop rivets and caulk to prevent rain leakage.
 - b. Vinyl insert is installed by placing one edge into metal trim; then pushing other edge in with thumb.
 - c. Caulk top of metal trim to prevent rain leakage.

Exterior Trim and Name Plates

Part No.	Description
385120	Excella 500
385044	International Flag (Roadside)
385041	International Flag (Curbside)
385045	Land Yacht Flag
—	Nameplates:
385034	Airstream with serial number
385035	Globe Trotter (21 Ft.)
385036	Safari (23 Ft.)
385037	Tradewind (25 Ft.)
385139	Caravanner (25 ft.)
385038	Overlander (27 Ft.)
385039	Ambassador (29 Ft.)
385040	Sovereign (31 Ft.)
101198	Belt line trim casting (set)
101197	Rub rail trim casting
380237	Clip, rub rail trim casting
101192	Belt line extrusion
101189	Rub rail extrusion
201089	Vinyl insert, belt line
201090	Vinyl insert, rub rail
330016	Rivet, AD45H (leak tight)
101195	Wheel well trim — inner
101196	Wheel well trim — outer
380012	Rivet, blind No. 48 royal blue (rub rail)
101171	Grab handle (main door)
380002	R.V.I. tag
385062	Plate, 110-125 voltage A.C.

Rear End Liner (Shower Bath, Center Bath & Excella Center Bath)

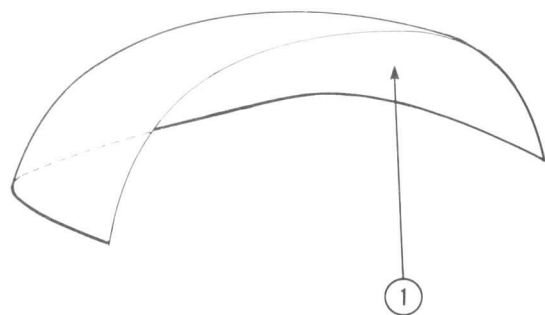


Fig. 40

Rear End Liner (Full Bath & Excella Full Bath)

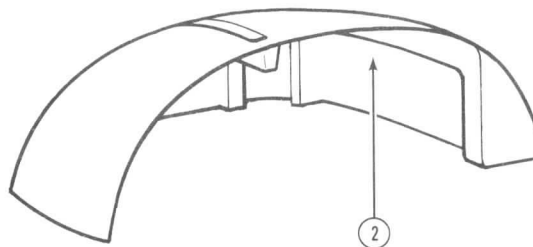
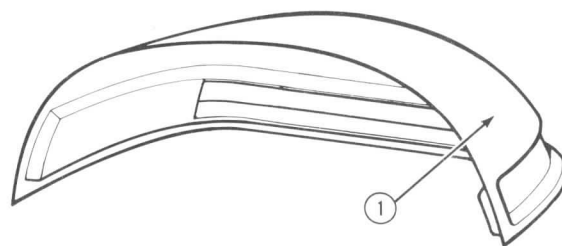


Fig. 41



Front End Liner

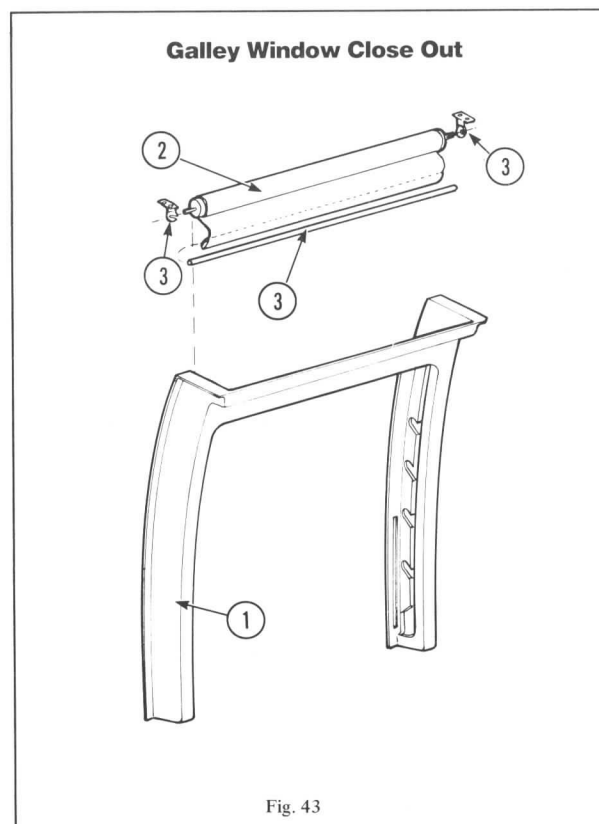
Fig. 42

Rear End Liner

No.	Part No.	Description
1	200101	End liner assembly (shower bath, center bath & Excella center bath)
2	200087	End liner assembly (full bath & Excella full bath)

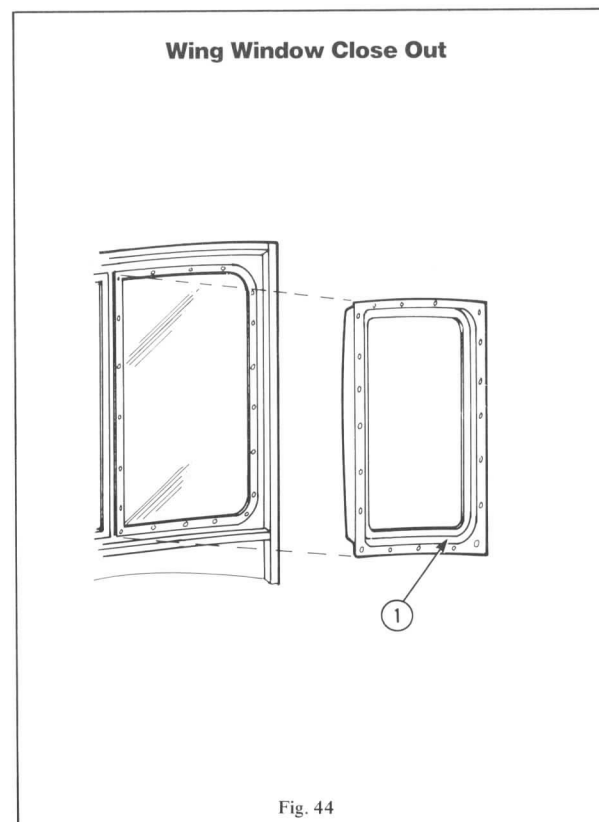
Front End Liner

No.	Part No.	Description
1	200261	End liner assembly



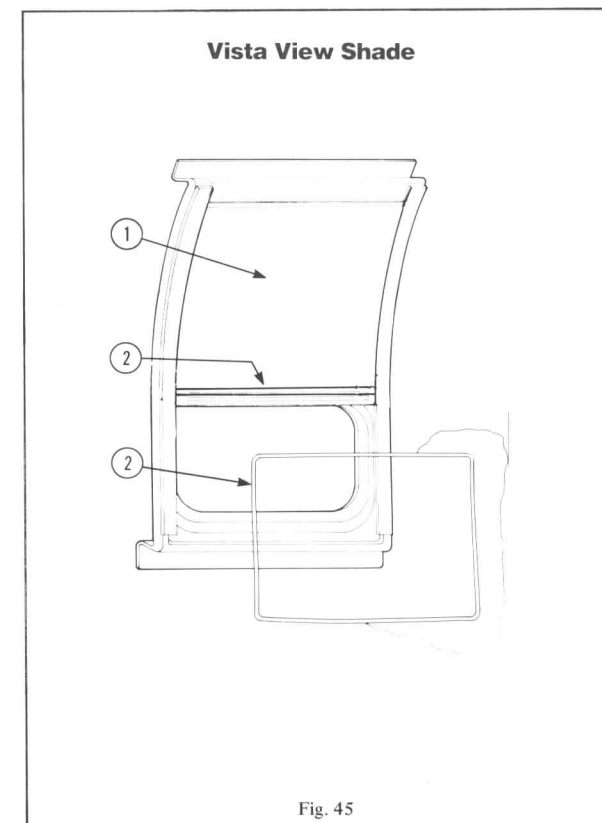
Galley Close Out

No.	Part No.	Description
1	201329	Galley window close out
2	700086	Shade and brackets
3	380247	Rod



Wing Window Close Out

No.	Part No.	Description
1	200287	Wing window close out (curbside)
	200288	Wing window close out (roadside)



Vista View Window Shade

No.	Part No.	Description
	700139	Vista view shade assembly 18"
	700134	Vista view shade assembly 30"
	700135	Vista view shade assembly 40"
1	101203	Aluminum, vinyl clad
2	201196	Plastic trim, extrusion

Front End Liner Removal and Replacement

1. Remove front lounge.
2. Remove top drapery track and drapes.
3. Remove front and side window screens. (See p. 3-11 for detailed removal instructions.)
4. Remove wing window closeout. (See p. 3-12 for detailed removal instruction.)
5. Remove trim extrusion, side window valance, top drapery track, and drapes.
6. Remove all receptacles, switches, speakers, etc. in front liner.
7. Remove all pop rivets where front liner and interior skin mate.
8. Remove approximately 24" of rivets from seam between ceiling and side sheets.
9. Remove pop rivets from top of front window frame. (These rivets go through frame into front liner.)
10. Remove clock (See p. 4-3)
11. Remove reading lights.
12. Remove pop rivets from front wraps. Remove wraps.
13. With interior skin held back, remove all pop rivets attaching front liner to rib.
14. Go over entire front liner to be sure all attachments have been removed.
15. With interior skin held out of way, rotate end liner down and out.
16. For installation, reverse procedures.

NOTE: Minimum of two men will be required. Use No. 30 drill to remove pop rivets.

Rear End Liner Removal and Replacement (Full & Center Bath)

(See Furniture Section for Detailed Removal Instructions of Furniture)

1. Remove galley top and galley. (It is not necessary to remove heater or plumbing.)
2. Remove curbside roof locker (see page 4-7)
3. Remove galley roof locker

4. Remove bathroom door and header track.
5. Remove bedroom partition panel (curbside only).
6. Remove bedroom roof locker (curbside only).
7. Remove bed (curbside only).
8. Remove bathroom sliding door and header track.
9. Remove rear bedroom partition divider panel.
10. Remove both sides of wardrobe.
11. Remove wardrobe wall extrusions.
12. Remove rear window screen.
13. Remove tub seat and medicine cabinet.
14. Remove above tub skirt and top. (It is necessary to disconnect tub faucet to do this, Excella only).
15. Remove lavatory and skirt assembly across rear.
16. Remove bathtub.
17. Remove toilet.
18. Remove clothes hamper top and skirt.
19. Remove light and mirror assemblies.
20. Remove locker assemblies and above window mirror and light assembly (Excella only).
21. Remove window shade.
22. Remove trim above lavatory.
23. Remove rear inside wraps.
24. Remove rivets from side and roof end liner seam.
25. Remove rivets located through window frame into end liner flange around the window.
26. Very carefully pull outward on liner until window flange will clear window frame.
27. After window frame is cleared, slide end liner down at rear to allow it to clear the roof sheets. As soon as it clears the roof sheets, it must be

turned sideways to be removed from trailer.

28. Turn so inside of liner faces curbside of trailer in order to pass through the door opening.
29. When taking in and out of trailer, the liner must be turned slightly to clear door opening. Also, great care must be taken not to damage or scratch furniture remaining in trailer.
30. Install by reversing above steps. It may be necessary to place several strips of metal, 6" x 8" wide and approximately 12" long, under edge of roof sheets to allow end liner to slide past the rib.
31. Usually 3 men are required to remove and replace an end liner.

NOTE: Use No. 30 drill for removal of pop rivets.

Rear End Liner Removal and Replacement (Shower Bath)

(See Furniture Section for Detailed Removal Instructions of Furniture)

1. Remove refrigerator end panel.
2. Remove refrigerator. (See Appliance Section for removal instructions.)
3. Remove refrigerator top and cabinet.
4. Remove folding door and header.
5. Remove bedroom partition panel (curb side only). (Remove galley assembly on 21 foot Globetrotter only.)
6. Remove bed. (curb side)
7. Remove curbside roof locker.
8. Remove rear wardrobe (curbside).
9. Remove bathroom partition panel and sliding bath door with header.
10. Remove shower curtain and track.
11. Remove bathroom wardrobe face and door.
12. Remove clothes hamper assembly.
13. Remove lavatory top and base.
14. Remove rear roadside wardrobe.
15. Remove light over window.
16. Remove rear inside wraps.
17. Remove rivets from side and roof end liner seams.

18. Remove rivets located through window frame into end liner flange around the window.
19. Very carefully pull outward on liner until window flange will clear window frame.
20. After window frame is cleared, slide end liner down at rear to allow it to clear the roof sheets. As soon as it clears, turn liner sideways to be removed from trailer.
21. Turn so inside of liner faces curbside of trailer in order to pass through the door opening.
22. When taking in and out of trailer, the liner must be turned slightly to clear door opening. Also, great care must be taken as to not damage or scratch furniture.
23. Install by reversing the above steps. It may be necessary to place strips of metal 6" x 8" wide and approximately 12" long, under edge of roof sheets to allow end liner to slide past the rib easier.
24. Usually 3 men are required to remove and replace an end liner.

NOTE: Use No. 30 drill for removal of pop rivets.

Front Wing Window Closeout Removal and Replacement

1. Remove lower drapery track.
2. Remove front window screen. (See page 2-11 for detailed removal instructions.)
3. Remove pop rivets from sides and bottom.
4. Remove screws from top. Closeout can now be lifted out.
5. For installation reverse procedure.

NOTE: Use No. 30 drill to remove pop rivets

Galley Window Closeout Removal

1. Remove window screen. (See page 3-11 for detailed removal instructions.)
2. Remove shade; lift out of slot in right hand bracket, pull right end of shade toward you and rotate it down and out.
3. Remove pop rivets from shade bracket (along top) and from side flanges.
4. Remove screws attaching top to roof locker.

5. Remove rivets securing sides.
6. Rotate top of closeout forward and lift out from behind galley top.
7. To install reverse procedure.

NOTE: Use No. 30 drill to remove pop rivets.

Vista View Closeout and Shade Removal and Replacement

1. Remove drape.
2. Remove roof lockers and/or panels to permit inside skin to be loosened approximately six (6) feet aft of Vista View window. (Care must be taken to prevent metal from buckling.)
3. Vista View closeout frame is held in place at the top and bottom by several hard rivets through the roof. Remove these rivets from the outside.
4. Hold out ceiling skin panel and slide vista view frame out. (Shade will come out with frame.)
5. For installation, reverse procedure using Olympic rivets. (For Olympic rivets instructions, see page 2-20)

NOTE: Use No. 30 drill bit for rivet removal.

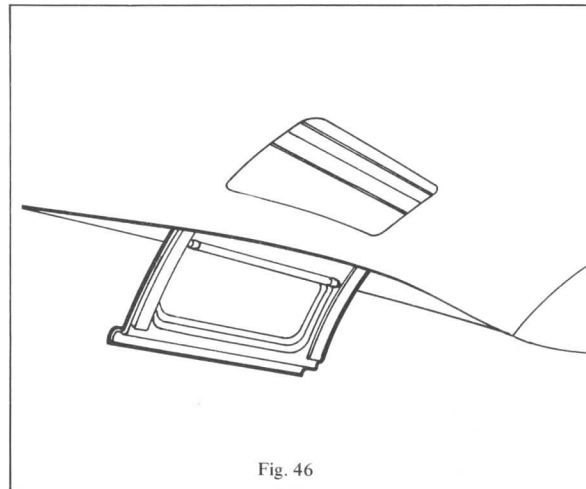


Fig. 46

Fixed Window Interior Trim Removal

1. Remove drapery and track where applicable. (Use No. 30 drill.)
2. Remove pop rivets from trim.
3. Remove trim.

Multi Dome Assembly

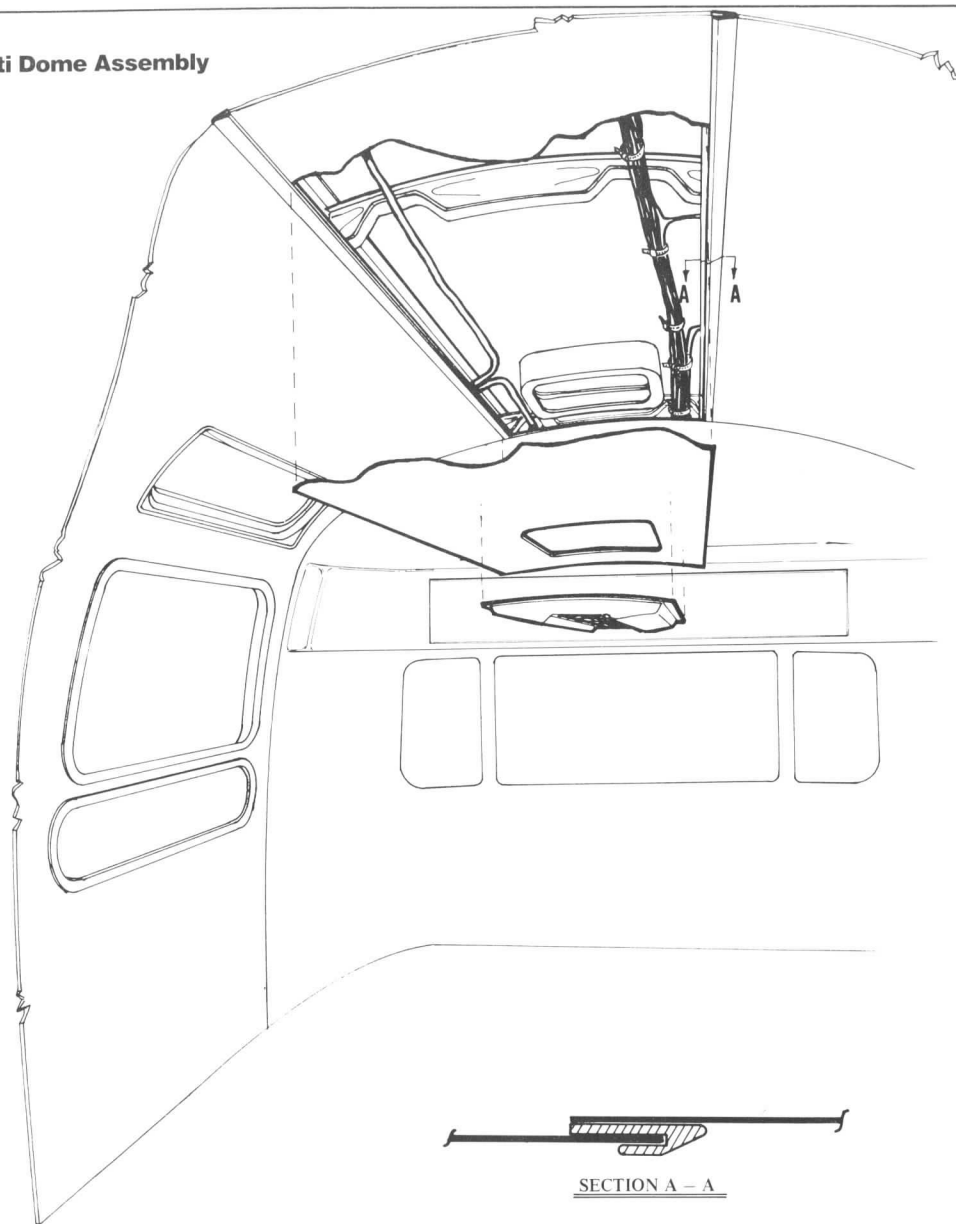


Fig. 47

Multi-Dome Removal & Installation

1. Remove ceiling lights.
2. Remove vent screens.
3. Remove TV antenna handle. (Loosen Allen screw and remove from shaft.)
4. Remove rivets from vent frame flanges, using a No. 30 drill.
5. Remove rivets from ribs in multi-dome area.
6. Remove foldette door header at galley area.
7. Remove inside unit of air conditioner, if so equipped.
8. Remove sliding bath door header. (See page 4-47 for removal.)
9. Remove rivets from bedroom panel wall extrusion which attaches to the multi-dome.
10. Remove rivets at each end of dome.
11. By pulling down on center of multi-dome, it can now be removed. Multi-dome must be slid forward to clear the bedroom panel.
12. Install multi-dome by reversing above procedure using AD43BS colored pop rivets.
13. In some cases a rubber beading is installed under the trim strip to allow the multi-dome to fit tight without a wavy effect. It may be necessary to reinstall this material when making the replacement installation.

NOTE: Use No. 30 drill for removal of pop rivets.

Multi-Dome Removal and Replacement (Center Bath)

1. Remove ceiling lights (See electrical section).
2. Remove vent screens.
3. Remove TV antenna handle (loosen Allen screw and remove from shaft).
4. Remove foldette door and header at galley and bedroom.
5. Remove inside shroud of air-conditioner if so equipped.
6. Because of bath room panels and vent pipe interference, it is not recommended that the multi-dome be removed completely.
7. Using a No. 30 drill, drill out enough rivets from the multi-dome area to allow the curbside to drop down.
8. By pulling down on center of multi-dome it can be removed from trim strip.
9. Install by reversing above procedure using AD43BS colored pop rivets.

NOTE: Use No. 30 drill for removal of pop rivets.

Multi-Dome Removal and Replacement

1. Remove ceiling lights (See electrical section).
2. Remove vent screens.
3. Remove TV antenna handle (loosen Allen screw and remove from shaft).
4. Remove foldette door and header at galley and bedroom.
5. Remove inside shroud of air-conditioner if so equipped.
6. Because of back room panels and vent pipe interference, it is not recommended that the multi-dome be removed completely.
7. Using a No. 30 drill, drill out enough rivets from the multi-dome area to allow the curbside to drop down.
8. By pulling down on center of multi-dome it can be removed from trim strip.
9. Install by reversing above procedure using AD43BS colored pop rivets.
10. Remove rivets at each end of dome.
11. By pulling down on center of multi-dome, it can now be removed.
12. Install multi-dome by reversing above procedure. Use AD43BS colored pop rivets.
13. In some cases a rubber beading is installed under the trim strip to allow the multi-dome to fit tight without a wavy effect. It may be necessary to reinstall this material when making the replacement installation.

NOTE: Use No. 30 drill for removal of pop rivets.

Interior Skin Removal and Replacement

1. Remove necessary furniture to permit access to damaged interior skin.
2. Splices are permitted at ribs only.
3. Splices, where permitted, should always lap to the rear.
4. Splices are usually made where the seam will be concealed by some piece of furniture.

NOTE: Use No. 30 drill to remove rivet. Use No. 30 properly colored rivets for installation of new metal. Install rivets at 4" centers on seams and 6" centers in all other areas.

Refrigerator Vent Scoop Removal and Replacement

1. Remove refrigerator panel. (See p. 13-9, 13-13)
2. Remove shelf above refrigerator. (See p. 13-9, 13-13)
3. Remove roof locker above refrigerator.
4. Remove rivets securing vent scoop.
5. Remove vent scoop.
6. To install, reverse procedure.
7. Be sure that ventilation area behind refrigerator is sealed from interior of trailer.

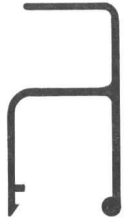
Refrigerator Vent Scoop (23 Ft. & 25 Ft.) Removal and Replacement

1. Remove refrigerator panel. (See p. 13-9)
2. Remove towel cabinet.
3. Remove roof locker.
4. Remove vent scoop.
5. For installation, reverse procedure.

Refrigerator Vent Scoop (21 Ft.) Removal and Replacement

1. Remove central control panel. (See p. 13-5)
2. Remove roof locker.
3. Remove vent scoop.

Extrusions – Shell



100114 Mill 1975-1977



100115 Mill 1976-1977



101191 Mill 1974-1977



101195 Polished and lacquered 1975-1977



101196 Polished and lacquered 1975-1977



101388 Mill 1974-1977



101455 Clear anodize 1976-1977



200035 White plastic 1974-1977



200127 White plastic 1976-1977



201089 Mill 1974-1977



201090 Mill 1974-1977