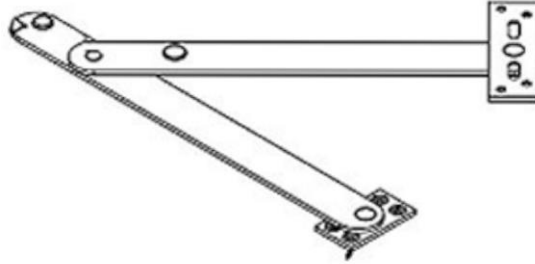


Monaco Coach Entrance Door Gas Strut Conversion

Stock Swing Arm / Locking Arm.

Over time, the entrance door swing arm on many Monaco Family coaches will loosen at the rivets, causing the arm to droop. This results in its failure to keep the door open in even light winds. It will also contact the screen door whenever it is opened.



Some owners have had success in tightening the rivets, or bending the outer end to result in a tighter contact. However, this will not usually correct contact with the screen door. It may still be possible to obtain a replacement swing arm. Try <https://shop.findmyrvparts.com/monaco-rv-pos-a-lock-swing-arm-1091-p/190414.htm> ..OR.. <https://shop.findmyrvparts.com/swing-arm-assembly-08408401-entry-door-hinge-p/190060.htm>

Many owners have switched to a gas strut to replace the swing arm. The advantage of this option is:

- Lower cost than replacement of stock swing arm.
- Readily available from Amazon, eBay and many other vendors.
- Years of trouble free service. Easy and economical replacement.
- Continues to open door fully as soon as someone starts to open it.
- Resists normal wind velocities. Absorbs strong gusts and automatically returns the door to fully open. No more slamming door in wind gusts.

Procedure to install gas strut.

Materials Needed.

- 1 – Gas Strut, 20 inch, 15 lb. closing force. [Click Here for Google Search.](#)



- 1 – Bracket, Inside 10mm Ball. Normally available in sets of 2. Black is available, but most are silver which can be painted black. This will be installed on the coach door frame.
- 1 – Bracket, **Outside** 10mm Ball. Normally available in sets of 2. Black is available, but most are silver which can be painted black. This will be installed on the door.



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- 5 – 3/16" Aluminum Rivets. Aluminum rivets are recommended because the door frames are aluminum. Matching the rivet material to the frame where it will be installed will prevent galvanic corrosion from dissimilar metals. ALTERNATIVE: 5 - #10 x 3/4" self-tapping hex head screws can also be used instead of rivets.
- 1 - #10 x 3/4" self-tapping hex head screw for center hole on Inside bracket. There is no room to use a rivet gun for this attachment.
- Black paint for brackets if required and/or to touch up screw heads and rivets after installation.
- Black Sealant for swing arm mounting point on top of door frame.
- Optional: 1 – 1/8" x 2" x 4" flat aluminum bar to seal the hole in the top of the door frame after the swing arm has been removed. Cut to match hole.

Tools Required.

- Phillips screw driver.
- Electric Drill.
- Pop Rivet Gun.
- 3/16" drill bit.
- 3/32" drill bit - pilot hole(s) for self-taping screw.
- Small combination wrench to fit self-tapping screws.
- Tape measure.
- 3/4" masking tape.
- Step Ladder. Must be tall enough to work on top of door when open.

Preparation

- 1) Paint gas strut brackets black if desired. Should be allowed to dry for a minimum of 24 hours.
- 2) Due to variability between different manufacturers of gas struts, it is strongly recommended to lay out the bracket positions to confirm correct fitment before installing the brackets on your coach. Check to ensure that the gas strut will allow the door to shut completely and that when open the door will be 90° to the coach.
 - Use a bar clamp to compress the gas strut to verify the closed distance between mounting points. Should be no more than 12 3/8" to use the suggested measurements.
 - Lay out the dimensions on a piece of art card available at most dollar stores. Then test fit gas strut in door open and closed position.

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Remove swing arm

Caution: When swing arm has been removed, door is free to swing fully open potentially causing damage to the door or the coach.

- 3) Remove 4 Philips head screws securing swing arm to door frame.
- 4) Drill out 4 rivets securing swing arm to top of door.

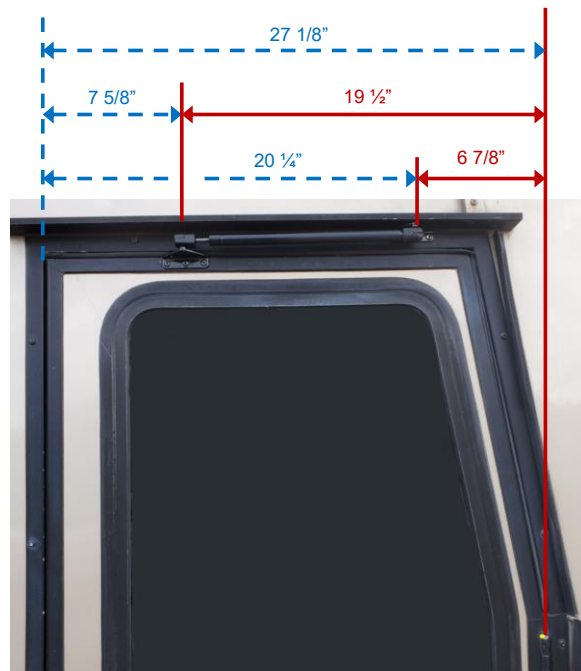


- 5) It is strongly recommended to seal the hole in the top of the door frame where the swing arm was secured. One option is to drill out the rivet holding the mounting plate to the swing arm and reinstall to partially fill the hole. Use the black sealant to completely seal the plate and block any water intrusion. A better option is to use a piece of aluminum flat bar and cut square to fill the hole.



Install Gas Strut

- ❑ Using masking tape, mark door where center hole of brackets will be located. The measurements provided in the illustration are provided for reference, but may vary dependent on actual size of gas strut (closed vs. open). Ensure the door mounted bracket is just high enough to allow the gas strut to clear the top of the door when installed.



- ❑ Drill center holes for both brackets.
 - The hole for the door bracket will be 3/16" if using rivets.
 - The pilot hole for the door frame bracket will be smaller and is only a guide for the self-tapping screw.
- ❑ Remove masking tape.
- ❑ Using a 3/16" rivet, mount the "outside" bracket on the door frame.
- ❑ Drill the remaining mounting holes and install rivets.
- ❑ Install a self-tapping screw into the predrilled hole in the door frame, then remove.
- ❑ Mount the "inside" bracket on the door frame using the self-tapping screw and a wrench.
- ❑ Drill the remaining mounting holes and install rivets.
- ❑ Install gas strut. The main body should be installed forward.
- ❑ Using black paint, touch up rivets and screw heads if desired.