



Recall Bulletin

Recall Number:

National Highway Traffic Safety (NHTSA) Number 04V-425.

Subject:

SAFETY DEFECT - Walking Beam Mounting Bolts, Flat Washers, Nuts and Spacers

Vehicles Affected:

SPECIFIC ORION BUS INDUSTRIES INC. CITY TRANSIT BUSES of the Orion VII model year with the "old style" walking beam bolts, flat washers, nuts and spacers.

NOTE

Federal regulation requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.

General Information:

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act.

Orion Bus Industries Inc. has decided that a defect, which relates to the motor vehicle safety, exists in some of its transit buses equipped with old style walking beam bolts, flat washers, nuts and spacers.

Failure to replace all walking beam bolts, flat washers and nuts with a Porteus Fastener Company grade 9 style and a thicker spacer, can result in the nut and bolt loosening and causing the deterioration of vehicle control which could result in a crash without warning. Orion Bus Industries Inc. has identified your company as a potential owner of one of the vehicles affected by this recall.

The corrective action is outlined below:

Recall Procedure

Installing New Spacers, Bolts, Flat Washers and Nuts

1. Drive the vehicle over a pit or raise the vehicle and support with safety stands.
2. Thoroughly clean the area around all 8 spacers. Refer to **Figure 1-1**.

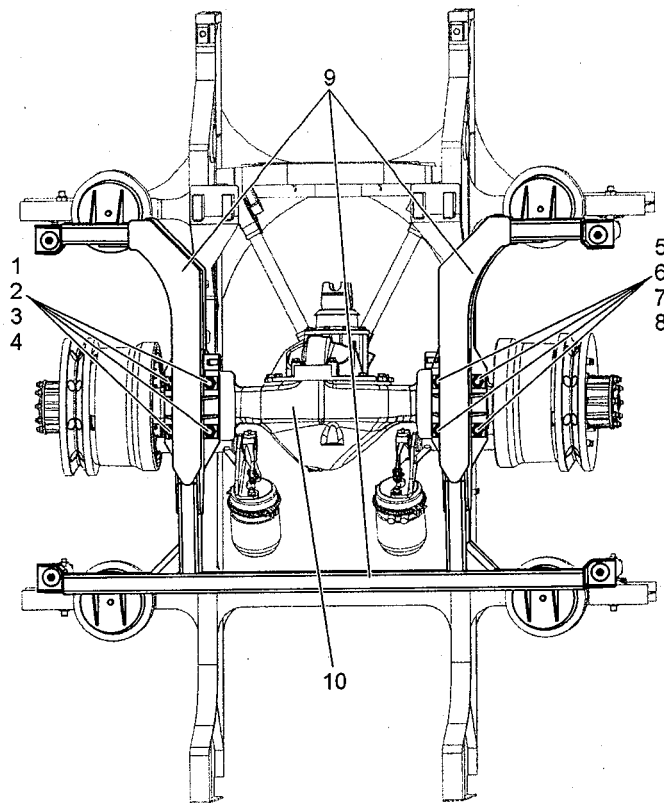


Figure 1-1 Spacer Location (Underside View)

LEGEND

- | | |
|-------------------------|-------------------------|
| 1. Bolt(s) (roadside) | 6. Washer(s) (curbside) |
| 2. Washer(s) (roadside) | 7. Spacer(s) (curbside) |
| 3. Spacer(s) (roadside) | 8. Nut(s) (curbside) |
| 4. Nut(s) (roadside) | 9. Walking Beam |
| 5. Bolt(s) (curbside) | 10. Axle |

 NOTE

To retain the integrity of the rear axle alignment, remove and replacen one bolt at a time.

3. Remove and discard the nut (4), bolt (1) and flat washer (2). Refer to **Figure 1-2**.

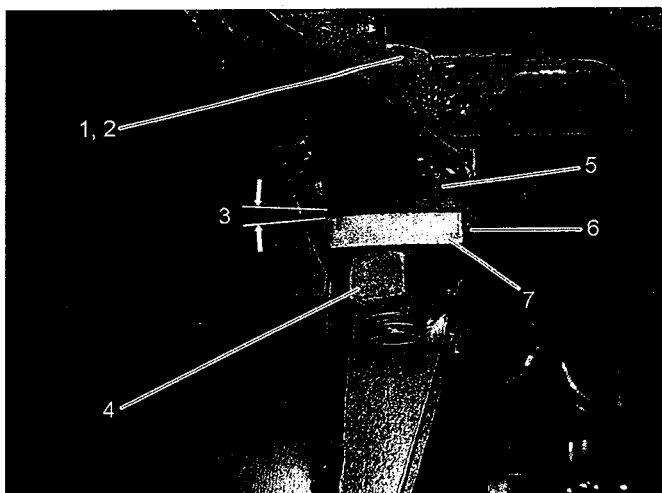


Figure 1-2 "Old-Style" Bolt, Nut and Spacer

LEGEND

- | | |
|----------------|-------------------|
| 1. Bolt | 5. Walking Beam |
| 2. Flat Washer | 6. Retaining Weld |
| 3. Gap | 7. Spacer |
| 4. Nut | |

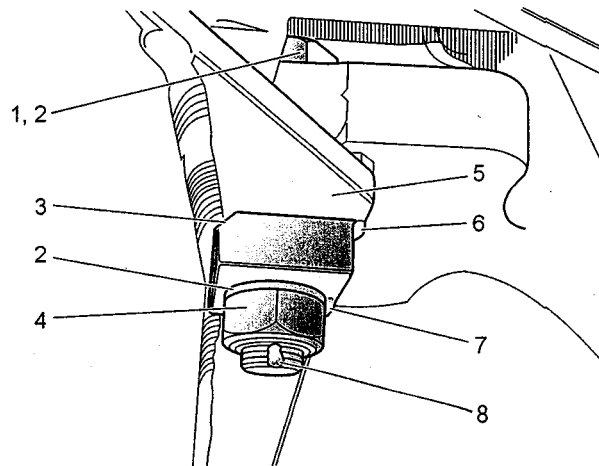


Figure 1-3 New Bolt, Nut and Spacer

LEGEND

- | | |
|---|----------------------|
| 1. Bolt | 5. Walking Beam |
| 2. Flat Washers | 6. Retaining Weld |
| 3. New Chamfered Spacer (<i>facing weld bead on walking beam</i>) | 7. 1/4" Weld Bead |
| 4. Nut | 8. Green Torque-Seal |

4. With a die grinder, grind off the retaining weld (6) and discard the spacer (7). Refer to **Figure 1-2**.
5. Clean the mounting surface of the walking beam. Ensure that the area is free of any burrs or debris.
6. Install the new chamfered spacer (3), bolt (1), nut (4) and flat washers (2). Refer to **Figure 1-3**.

 NOTE

Ensure the chamfered side of the spacer is facing the weld bead on the walking beam.

 NOTE

Ensure that the spacer does not rotate during tightening and remains parallel with the face of the walking beam.

7. Repeat steps 5 to 8 for every walking beam bolt, flat washer, nut and spacer location.
8. Torque all four nuts to 600 - 625 ft. lb. Follow the criss-cross pattern when torquing the nuts. Repeat for both the curbside and roadside of the walking beam.
9. Weld a bead (7) of approximately 1/4 inch on one seam only of each walking beam spacer replaced. Refer to **Figure 1-3**.

 NOTE

It is not required to "debrain" the bus as long as a good ground is established on the walking beam.

10. Apply paint primer to all weld beads after they have cooled.
11. Spray paint all welded seams black.
12. Apply green torque-seal (8) to all fasteners. Refer to **Figure 1-3**.
13. Lower the vehicle. Bus is now ready for service.

Safety Defect - Orion VII Walking Beam Bolts, Nuts and Spacers

Materials

Item	Part Number	Quantity
New chamfered spacer	070231109	8
New grade 9 bolts	BS-4127905	8
New grade 9 flat washers	BS-4500217	16
New grade 9 nuts	BS-4200617	8
Cleaner and rags		As required
1 1/2 inch combination wrench		1
1 1/2 inch impact socket (<i>universal swivel and extensions may be required</i>)		1
Black spray paint		As required
Primer		As required
3/4 inch drive impact wrench		1
Torque wrench (capable of 625 ft. lbs)		1
Welder		1
Green torque-seal		1

Labor Allowance:

If the steps under the Recall Procedure sections of this recall bulletin are required, the cost of labor will be reimbursed.

Procedure	Time Allowed (hours)
Removal of bolt, flat washer, nut and spacer.	
Installation of new bolt, flat washers, nuts, spacers.	

Record of Completion:

Report the completion of this work for each vehicle and deliver to:

ORION BUS INDUSTRIES LTD.
Recall Orion Emergency Exit Pull Handle
Mississauga, Ontario L5J 4T8
Fax: (905) 403-8800
mcaissy@orionbus.com

Claims for Credit:

Reimbursements will be issued only after the record of completion report has been submitted to Orion. Include the campaign number and the date the work was performed on the copy of the work order along with the standard warranty claim form. For warranty claim form completion instructions, see Section 5 - 5 of the Warranty & Policy Manual and mail to either:

**ORION BUS INDUSTRIES LTD.
c/o WARRANTY DEPARTMENT
350 Hazelhurst Road
Mississauga, Ontario L5J 4T8
Tel: (905) 403-1111
Fax: (905) 403-8800**

**ORION BUS INDUSTRIES INC.
c/o WARRANTY DEPARTMENT
165 Base Road, Box 748
Oriskany, NY 13424-0748
Tel: 1-800-71-ORION
Fax: (315) 768-8414**

We are sorry to cause you this inconvenience, however, we have taken this action in the interest of your continued satisfaction with our products.

If you have had this repair performed before you received this letter, you may be eligible to receive a reimbursement for the cost. Notify Orion to obtain a pre-notification remedy to the problem associated with this recall.

If, after contacting Orion Bus Industries Agent at **1-800-492-2116**, you are still unable to have the safety defect remedied, US residents may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street, S.W., Washington, DC 20590 or call the toll free Auto Safety Hotline at 1-888-327-4236.

Service Information

Inquiries for materials and any additional instructions pertaining to these instructions can be made by calling:

1-800-71-ORION (All Service Inquiries)

1-800-786-8099 (Parts Inquiries/Orders)

Orion Bus Industries Inc. Vehicle Regulations and Compliance Department