



SAFETY RECALL BULLETIN

June, 2014

NHTSA RECALL 14V-133, 14V-198, 14V-199 and 14V-200

AUTOCAR INDUSTRIES LLC SAFETY RECALL M-1401, M-1405, M-1406, M-1407

Attention:

Service Managers / Parts Managers

Subject:

Various fasteners on the Autocar Xpert cab may not maintain required torque.

Safety Recall Information:

Autocar Industries has determined that the fasteners on various components of the cab of Autocar Xpert vehicles may not be torqued to required values or configured to ensure the required torque is maintained, which may affect safety and/or performance of the vehicle. The affected vehicles were manufactured between July 11, 2011 and March 5, 2014. This bulletin describes the procedures to reconfigure and/or re-torque the fasteners. ***This bulletin provides the work instructions for Safety Recall No. M-1401, M-1405, M-1406 and M-1407.***

Vehicles Affected:

There are 207 affected vehicles with serial numbers in the range 213288 through 217702. Refer to the VIN list beginning on Page 38.

Service Responsibility:

Service sites must perform this recall on affected vehicles at no charge to the owner regardless of vehicle mileage, age or ownership. If a vehicle affected by this recall is taken into or is currently in your vehicle inventory, or at your center for service, you must perform this recall before the vehicle is sold or released to the owner.

To Obtain Parts:

Ensure that you have authorization from the customer to perform this work, and send an e-mail to warranty@autocartruck.com and include the following:

- VIN(s) (or last 6 digits of VIN(s))
- 'Attention To' name
- 'Ship To' address

Required Parts:

S5004001K001 Service Kit

- (20) A5200041-001 Spacer
- (1) 8003812 Washer
- (1) S500011-001 Trimmed washer
- (10) GE811637WB01 Washer 1" guide
- (6) S5000012-001 Plastic Plug 1-3/16"
- (20) GM410108AD13 Bolt M8X1.25X25)
- (12) GM410108AD16 Bolt M8X1.25X40
- (2) GM410108AB24 Bolt M8X1.25X80
- (24) GM410108AS15 Bolt M8X1.25X35
- (2) S5000013-001 Bolt 3/8X3-14"
- (2) S5000014-001 Bolt 7/16-20
- (2) S5000015-001 Bolt 7/16-20
- (2) S5000016-001 Bolt 7/16-20
- (2) S5000017-001 Bolt 7/16-20
- (16) S5000018-001 Bolt M8X1.25X30
- (4) GM280708BD01 Nut M8X1.25
- (4) GM280710BD01 Nut M10X1.50
- (2) GE280531BB01 Nut

Super glue (obtain locally)

Torque seal (obtain locally)

S52A4001K001 Service Kit - 3rd man seat

- (4) A5200041-001 Spacer
- (4) GM410108AD13 Bolt M8X1.25X25
- (4) GM410108AD16 Bolt M8X1.25X40
- (2) A5220003-001 Bolt 7/16
- (4) GM280708BD01 Nut
- (1) A52A0005-001 BRKT
- (1) A52A0006-001 BRKT

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Claims for Reimbursement:

Submit a claim for reimbursement in accordance with Autocar's Warranty Administration Manual.

Claim Coding Information:

Labor Operation Code Number	Time Allowance SRT	Description
88401-2-03	9.0 HR	Torque Check/Re-work

Tools Required:

- 1-3/16" Hole saw
- Phillips driver (medium)
- Scale ruler (inch)
- Tape measure
- Dremel tool
- Craft knife
- 8 mm Hex socket tool
- 6 mm Allen socket tool
- 10 mm Wrench
- 12 mm Hex socket tool
- 13 mm Hex socket tool
- 16 mm Hex socket tool
- 5/8" Hex socket tool
- 9.6 ft-lb (13N•m) Torque wrench
- 13 ft-lb (18 N•m) Torque wrench
- 19 ft-lb (26 N•m) Torque wrench
- 38 ft-lb (52 N•m) Torque wrench
- 42 ft-lb (57 N•m) Torque wrench
- Drill
- File
- Marker pen
- Level (or digital protractor)

Safety Notices



WARNING

To prevent eye injury, always wear eye protection when performing vehicle maintenance, service or inspection.



WARNING

Before working on a vehicle, set the parking brake, place the transmission in neutral and block the wheels. Failure to do so can result in unexpected vehicle movement and can cause serious personal injury or death.

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CAUTION

LOCKOUT/TAGOUT PROCEDURES

Before entering the vehicle or vehicle body, read and follow OSHA regulations concerning entry and working in “CONFINED SPACE” OSHA 1910.146 and “LOCKOUT/TAGOUT” OSHA 1910.147. Follow OSHA regulations while performing any work on the vehicle. The vehicle must be disabled by the following steps before performing any work on the vehicle:

1. Place the transmission in NEUTRAL.
2. Set the parking brake.
3. Shut the engine OFF.
4. Lock cab doors, keep the key in your pocket. Block the wheels before entering the body or performing any work on the vehicle.
5. Turn the battery disconnect switch OFF, if equipped.
6. Completely drain the air from the primary/A system and secondary/B system by opening the drain valves on the air tanks themselves or by using the drain manifold if supplied. When draining the air tanks, do not look into the area where air is draining. Dirt or sludge particles may be expelled in the air stream and can cause eye injury.
7. Place magnetic “DANGER” signs on both cab doors before entering the body or performing any work on the vehicle.
8. Take proper precautions before working under the vehicle. Use ramps approved for the weight of your vehicle, or use floor jacks and stands. Never work under a vehicle supported by jacks alone. Always use jack stands to support the vehicle.



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WORK INSTRUCTIONS

Step 1. Replacement of Step Bolts

1. Raise the cab in accordance with the following safety precautions and procedures.



NOTE

Place the front wheels in a straight ahead position before raising or lowering the cab. Failure to do so may result in damage to the cab steps if they contact the tire and wheel assembly.



WARNING

Due to the danger of sustaining personal injury and/or damage to the vehicle, never attempt to raise the cab outdoors under extremely windy conditions. Strong wind conditions could force the cab beyond the normal limits of its travel. Never rely on the hydraulic pressure to hold the cab in an open position. Always use the safety pin in the cab tilt lock tube to prevent serious personal injury or death.



WARNING

Remove or secure all loose articles and close all doors before raising the cab. The area above and ahead of the cab must be clear from obstructions. Place front wheels in a straight ahead position.

Remove the pump handle from its storage on the inside of the cab near the driver or passenger seat.

Place the selector lever on the hydraulic pump in the RAISE position. Insert the pump handle into the pump and operate the handle in an up and down motion. The hydraulic cab latches will open, then the hydraulic cylinders will lift the cab until the midpoint (top) is reached.

Once the cab has reached its midpoint the cab will move forward to the fully open position. The safety pin in the cab tilt lock device must be installed when the holes line up in the sliding bar.

Remove the pump handle when not in use. It may stick out and could cause injury to passersby.

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2. With the cab raised, locate the step on the RH side. One at a time, remove the 6 bolts from the top step and replace with new bolt (GM410108AS15) while discarding the original bolt.
3. Tighten the newly installed bolts (GM410108AS15) to 9.6 ft-lb (13 N•m) (see Figure 1-1).



Figure 1-1

4. One at a time, remove the 6 bolts from the lower step and replace with new bolt (GM410108AS15) while discarding the original bolt.

5. Tighten the newly installed bolts (GM410108AS15) to 9.6 ft-lb (13 N•m) (see Figure 1-2)



Figure 1-2

6. Apply torque seal to all bolts (see Figure 1-3).



Figure 1-3

7. Repeat steps 1-3 through 1-6 for the step on the LH side.

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Step 2. Removal of Seats

Note: *This step involves removal of the LH and RH seats. When working with the seats, depending on the seat configuration, there may or may not be square seat riser tubes. If the tubes are not present on your vehicle, skip the steps indicated in the procedure. The fasteners for the seats are reconfigured and reinstalled beginning in Step 16. If equipped, the bolts for the third seat are reconfigured and replaced in Step 18.*

1. Pull the seat bellows off the base of the seat at each corner to access the mounting bolts in the square seat riser tubes (see Figure 2-1).
2. Remove the 4 bolts mounting the seat to the square seat riser tubes and set aside for reinstallation in step 16 (see note above).
3. Remove the 4 bolts mounting the square seat riser tubes to the cab floor and discard.

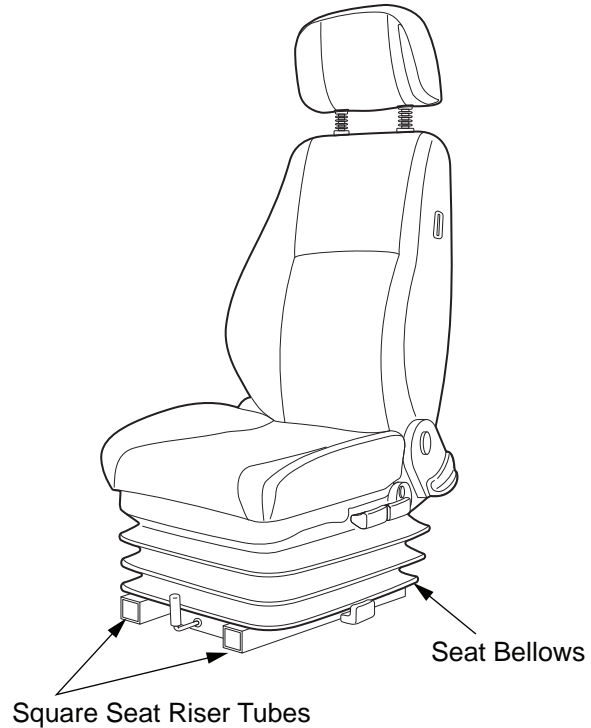


Figure 2-1

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Step 3. Removal of Lower Dashboard Panel

1. Remove 5 screws from the lower dashboard panel and set aside for reinstallation (see *Figure 3-1*).
2. Remove the panel and set aside for reinstallation in step 9-12.
3. Remove 2 screws from the steering column shroud (one on each side of shroud) and set aside for reinstallation (see *Figure 3-2*).
4. Remove the shroud and set aside for reinstallation in step 9-12.

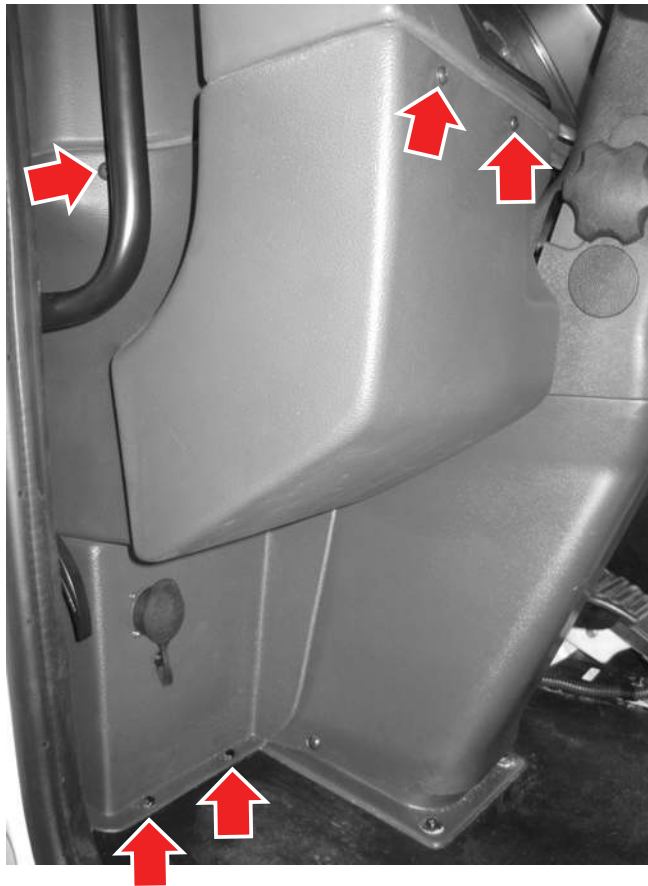


Figure 3-1



Figure 3-2

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Step 4. Extraction of Floor Mat from LH Throttle Pedal Bracket

Note: This step involves making cut-outs in the floor mat to remove soft joint material from the throttle pedal bracket fasteners.

1. Remove the 4 bolts used to mount the throttle pedal to the floorboard of the cab, and discard. Set aside the throttle pedal for reinstallation (see Figure 4-1).

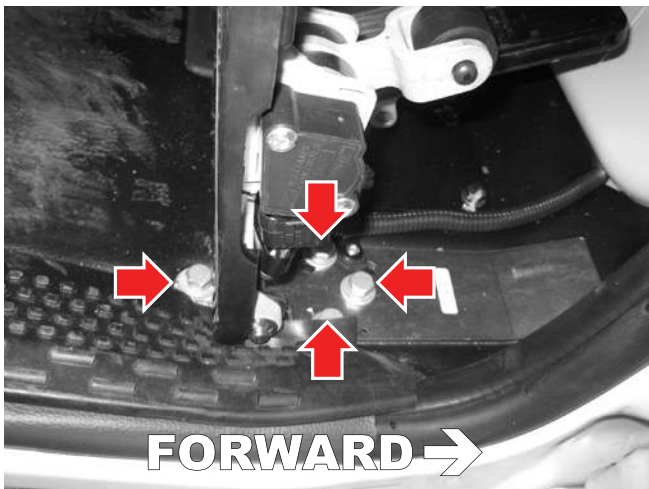


Figure 4-1

2. Place one spacer (A5200041-001) concentric with one of the mounting holes (see Figure 4-2).
3. Place one 1" (guide) washer (GE811637WB01) over the spacer (see Figure 4-2).
4. Clamp the spacer and washer down using one bolt (GM410108AD16) (see Figure 4-2).

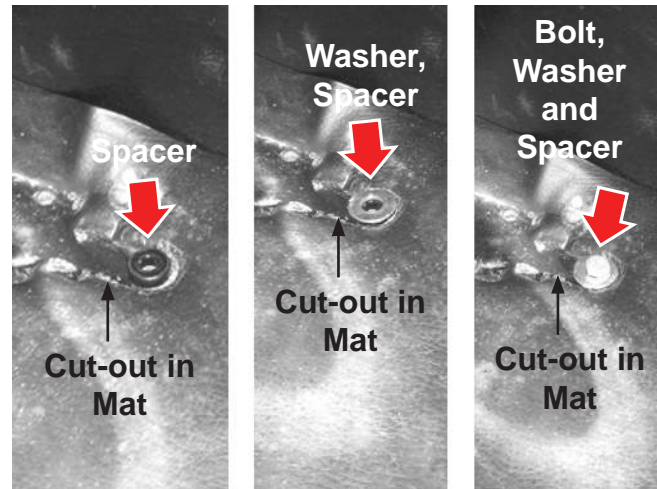


Figure 4-2

5. Using a hole saw, carefully trim away the floor mat around the clamped washer and spacer (see Figure 4-3).

Note: Use very slow speed and gentle pressure when trimming the mat.

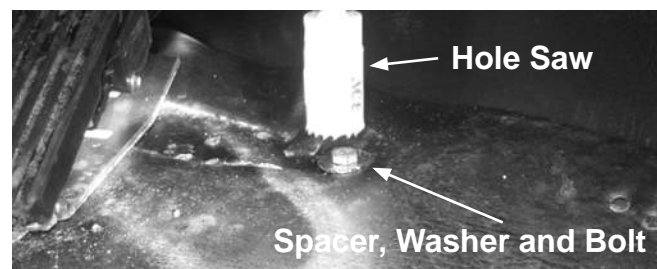


Figure 4-3

6. Remove the 1" (guide) washer (GE811637WB01) and set aside to use on the next mounting hole. Remove the bolt (GM410108AD16) and spacer (A5200041-001) and set aside for reinstallation.

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- Scrape off any insulation glued to the sheet metal of the cab floor (see Figure 4-4).

Note: Repeat steps 4-2 through 4-7 for the other three mounting holes.

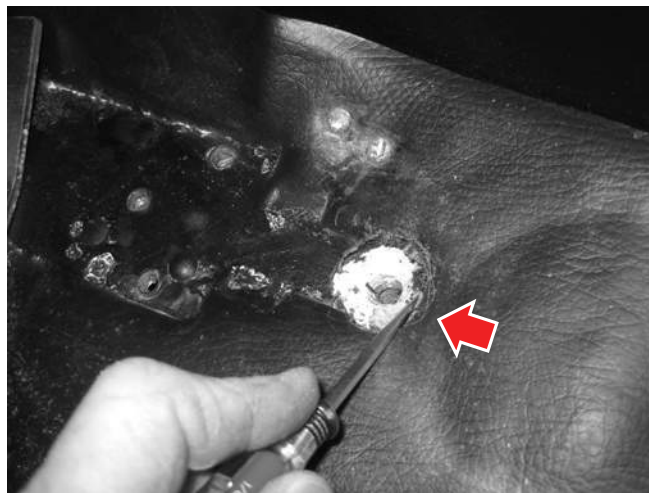


Figure 4-4

- Place the trimmed washer (S5000011-001) concentric with front right hole (see Figure 4-5).

- Align washer (8003812) with the rear mounting hole (see Figure 4-5).

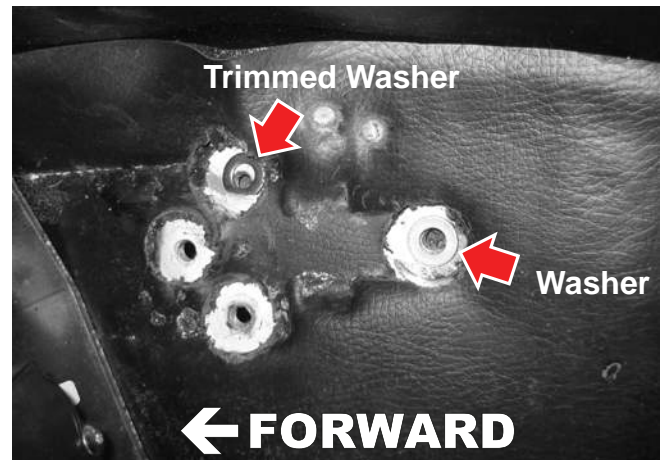


Figure 4-5

- With the washers in place over the front right and rear mounting holes, place spacers (A5200041-001) over all 4 holes (see Figure 4-6).

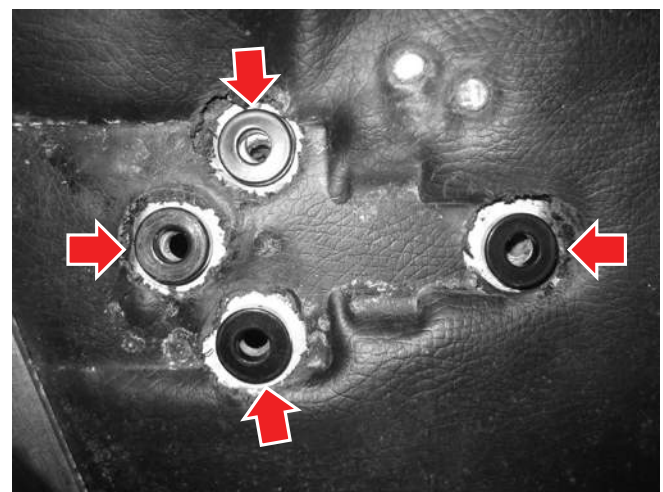


Figure 4-6

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- Reinstall the throttle pedal using the new bolts (GM410108AD16) and tighten to 13 ft-lb (18 N•m) of torque.

Note: Use the appropriate quantity of washers to ensure that the mounting contacts are as level as possible to provide a secure mounting surface for the throttle pedal. If additional washers are necessary please obtain locally.

- Apply torque seal to the bolts (see Figure 4-7).

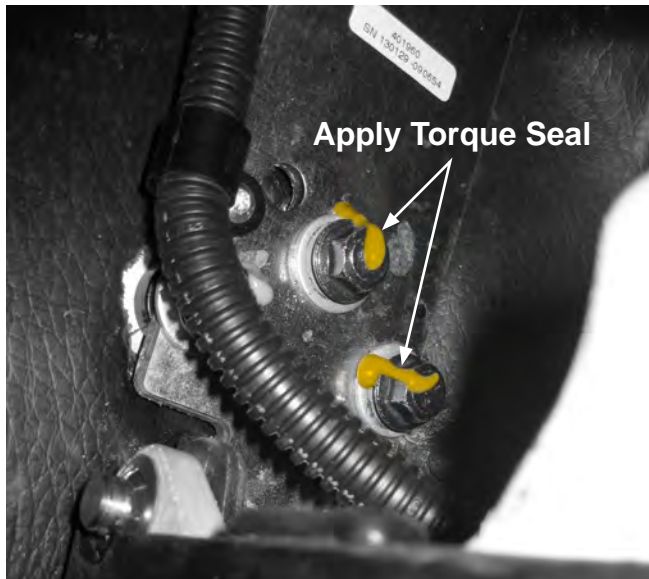


Figure 4-7

Step 5. Extraction of Floor Mat from RH Throttle Pedal Bracket

Note: This step involves making cut-outs in the floor mat to remove soft joint material from the throttle pedal bracket fasteners.

Note: Items 1-8 for the RH throttle pedal are the same as Items 1-8 for the LH throttle pedal. At Item 9 of the procedure, the LH throttle pedal procedure differs in that no washers are required during reinstallation of the throttle pedal.

- Remove the 4 bolts used to mount the throttle pedal to the floorboard of the cab, and discard. Set aside the throttle pedal for reinstallation (see Figure 5-1).

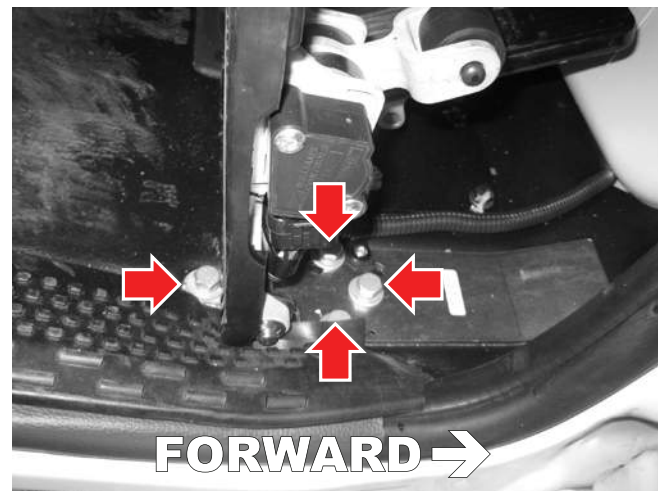


Figure 5-1

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2. Place one spacer (A5200041-001) concentric with one of the mounting holes (see Figure 5-2).
3. Place one 1" (guide) washer (GE811637WB01) over the spacer (see Figure 5-2).
4. Clamp the spacer and washer down using one new bolt (GM410108AD16) (see Figure 5-2).

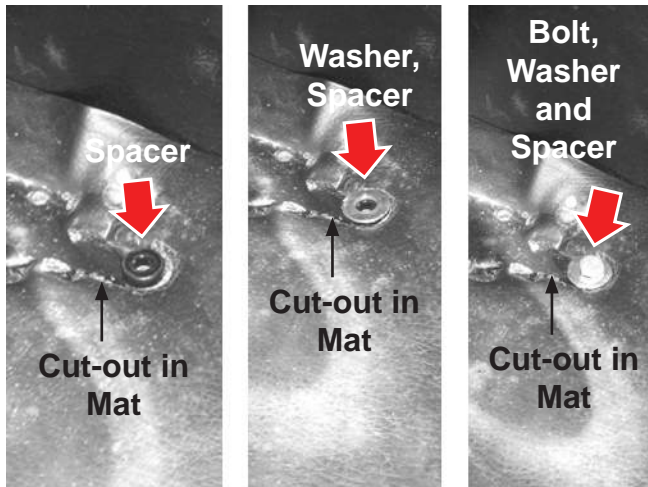


Figure 5-2

5. Using a hole saw, carefully trim away the floor mat around the clamped washer and spacer (see Figure 5-3).

Note: Use very slow speed and gentle pressure when trimming the mat.

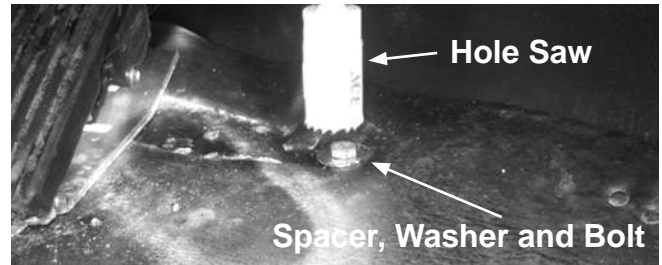


Figure 5-3

6. Remove the 1" (guide) washer (GE811637WB01) and set aside to use on the next mounting hole. Remove the bolt (GM410108AD16) and spacer (A5200041-001) and set aside for reinstallation.
7. Scrape off any insulation glued to the sheet metal of the cab floor (see Figure 5-4).

Note: Repeat steps 5-2 through 5-7 for the other three mounting holes.

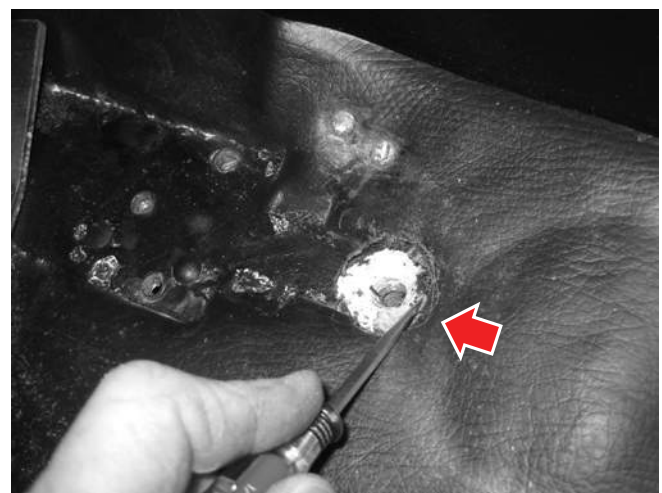


Figure 5-4

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8. Place spacers over all 4 holes (see Figure 5-5).

Note: Unlike the LH throttle pedal, no washers are required during reinstallation.

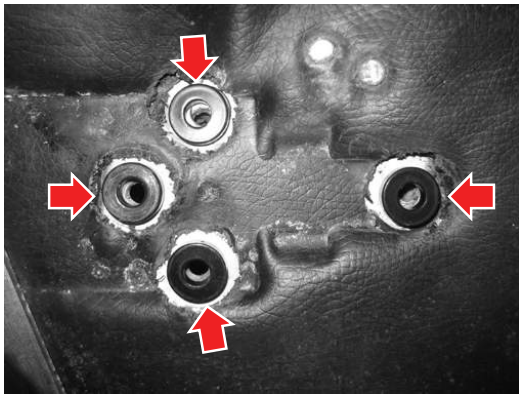


Figure 5-5

9. Reinstall the throttle pedal using the new bolts (GM410108AD16) and tighten to 13 ft-lb (18 N•m) of torque.
10. Apply torque seal to the bolts (see Figure 5-6).

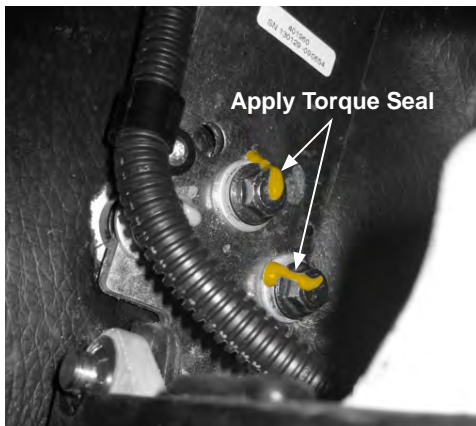


Figure 5-6

Step 6. Replacement of Steering Column Bolts (LH and RH Steering Columns)

1. Remove 2 nuts from the upper steering column and discard. Replace with new nuts (GM280710BD01) and tighten to 38 ft-lb (52 N•m) of torque (see Figure 6-1).
2. Remove the bolt and nut from the intersection of the steering column and discard. Replace with a new bolt (S5000013-001) and a new nut GE280531BB01). Tighten to 19 ft-lb (26 N•m) of torque (see Figure 6-1).
3. Remove 2 nuts from the lower steering column and discard. Replace with new nuts (GE280708BD01) and tighten to 13 ft-lb (18 N•m) of torque (see Figure 6-1).
4. Apply torque seal to the bolts.

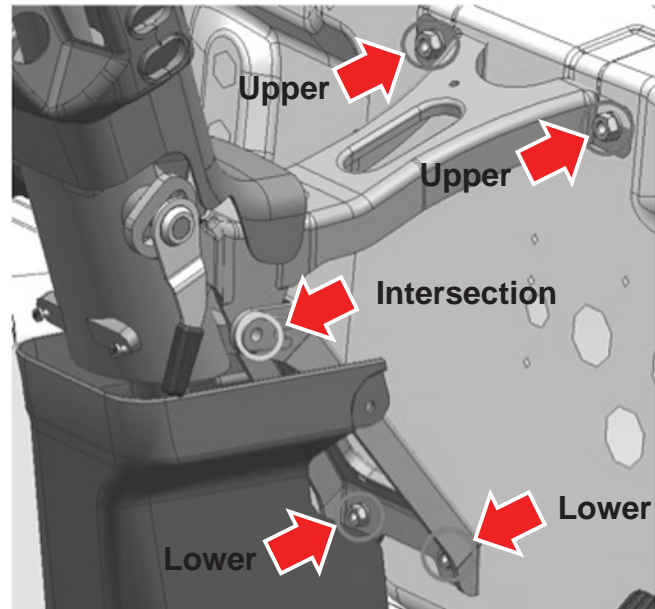


Figure 6-1

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Step 7. Replacement of Brake Valve Bolts

1. Working from inside the cab, locate the brake lamp switch, remove and set aside for reinstallation (see *Figure 7-1*).

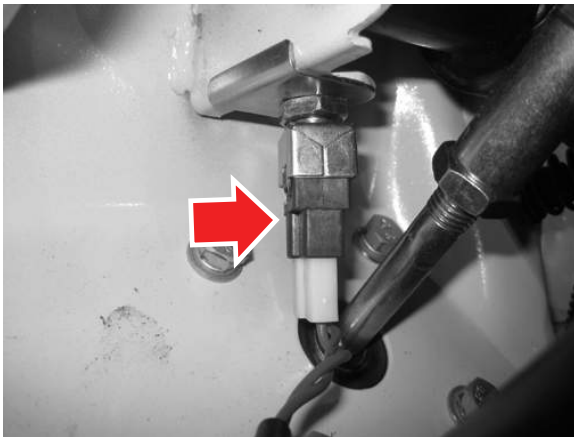


Figure 7-1

2. Remove and discard (one at a time) the 4 bolts securing the brake valve to the brake valve bulkhead. Replace with new bolts (GM410108AD13) and tighten 9.6 ft-lb (13 N•m) of torque (see *Figure 7-2*).

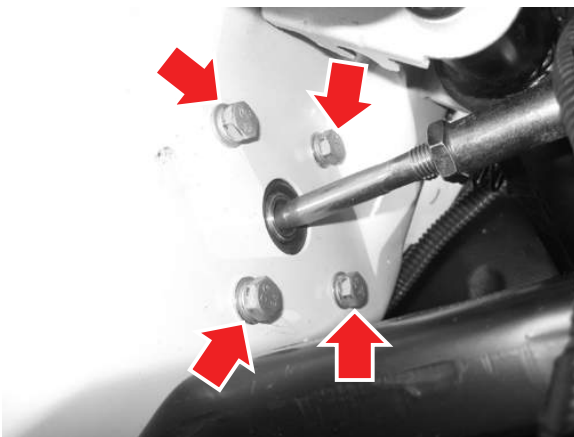


Figure 7-2

3. Apply torque seal to bolts (see *Figure 7-3*).

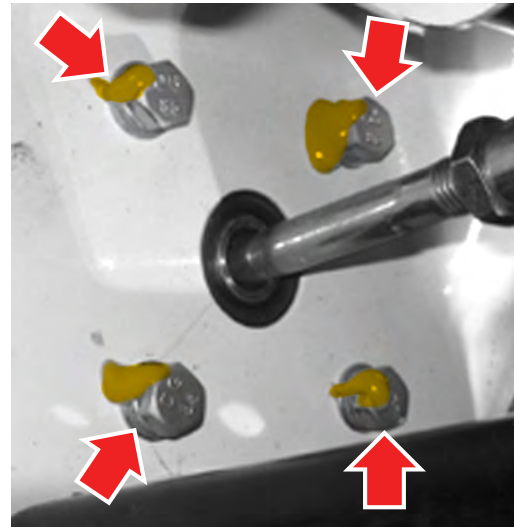


Figure 7-3

4. Reinstall the brake lamp switch removed in step 7-1.

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Step 8. Replacement of Brake Valve Panel Bolts

- Starting with the bolt marked [1], remove the bolt and replace with new bolt (GM410108AD13). Remove and replace the bolts marked [2] through [6] in sequence. Tighten the bolts in rounds, in sequence [1] through [6], until each holds 13 ft-lb (18N·m) of torque (which should require approximately 10 rounds of tightening in sequence [1] through [6]) (see Figure 8-1).

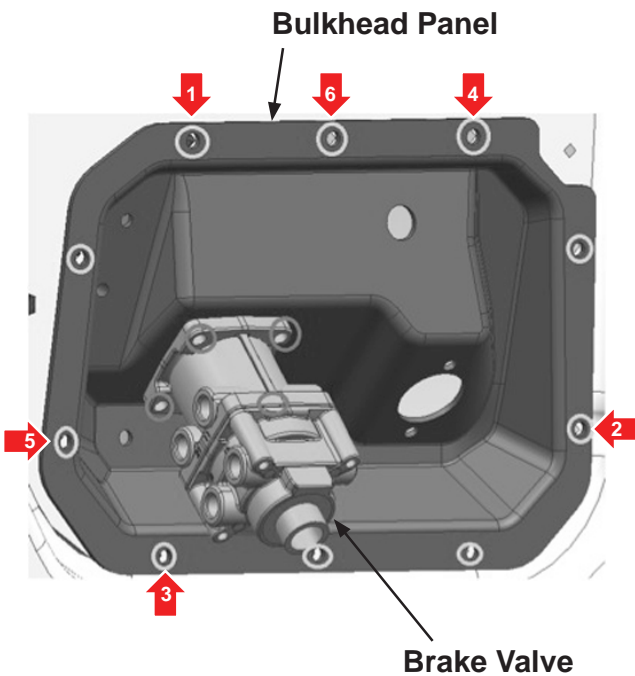


Figure 8-1

- Apply torque seal to the bolts.

Step 9. Removal of Trim from Interior Grab Handle Fasteners (Lower)

- Remove the 3 bolts securing the dashboard support bracket and set aside for reinstallation (see Figure 9-1).
- Remove the dashboard support bracket and set aside for reinstallation.

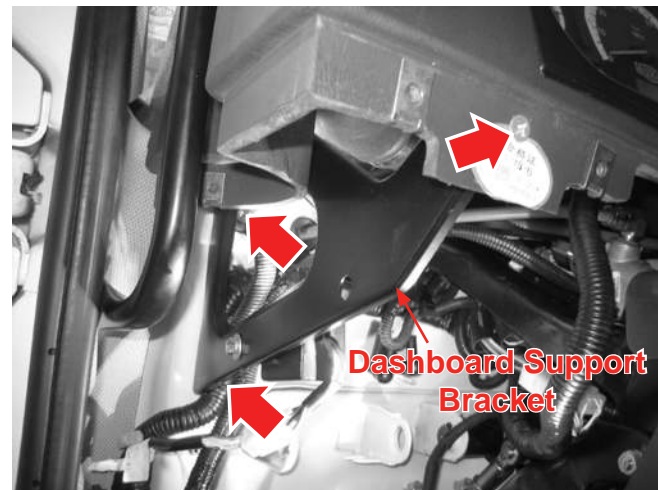


Figure 9-1

- Remove the interior grab handle lower mounting bolts and discard (see Figure 9-2).

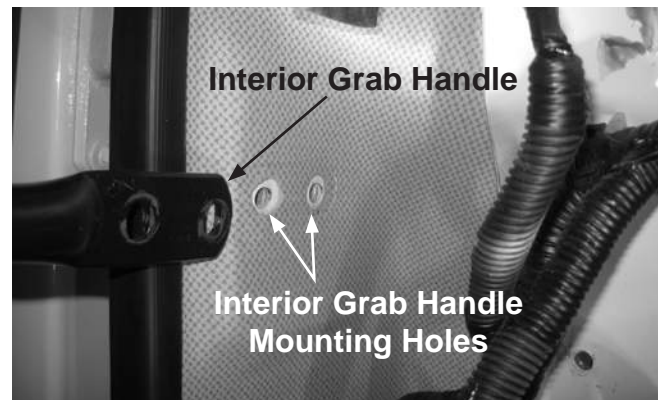


Figure 9-2

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4. Place one spacer (A5200041-001) concentric with each of the mounting holes (see *Figure 9-3*).
5. Place one 1" (guide) washer (GE811637WB01) over each of the spacers (see *Figure 9-3*).
6. Clamp the spacer and washer down using one new bolt (GM410108AD16) (see *Figure 9-3*).
7. Using a hole saw, carefully trim away the trim panel around the clamped washers and spacers (see *Figure 9-3*).

8. Remove each bolt and spacer, setting aside for reinstallation. Place the 1-inch (guide) washers (GE811637WB01) aside for future use (see *Figure 9-4*).



Figure 9-3

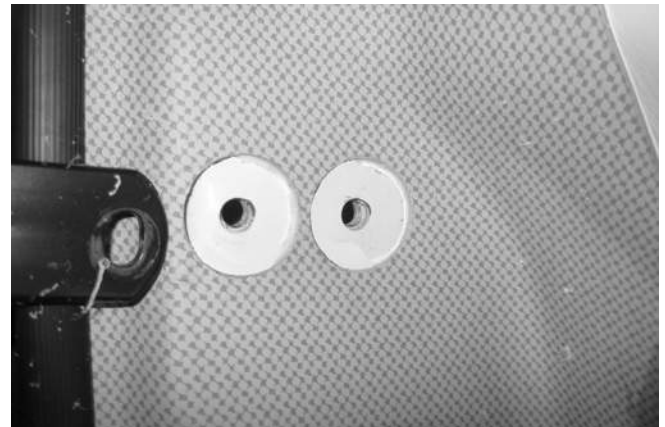


Figure 9-4

9. Place spacers (A5200041-001) for the lower mount flange of the interior grab handle (see *Figure 9-5*).

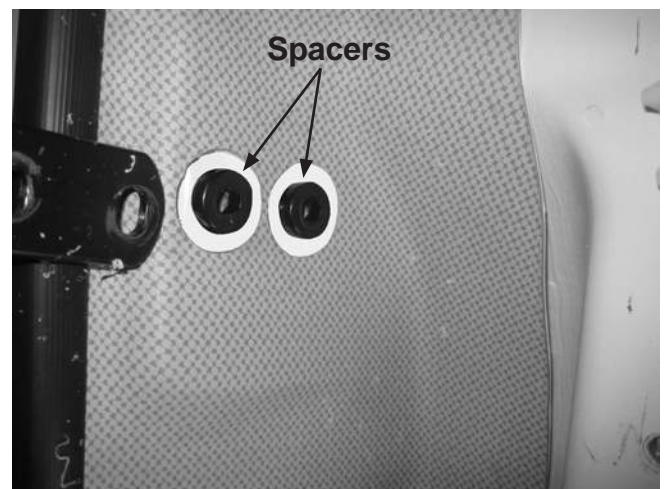


Figure 9-5

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- Using new mounting bolts (GM410108AD16), reinstall the grab handle. Tighten to 13 ft-lb (18 N•m) of torque (see Figure 9-6).

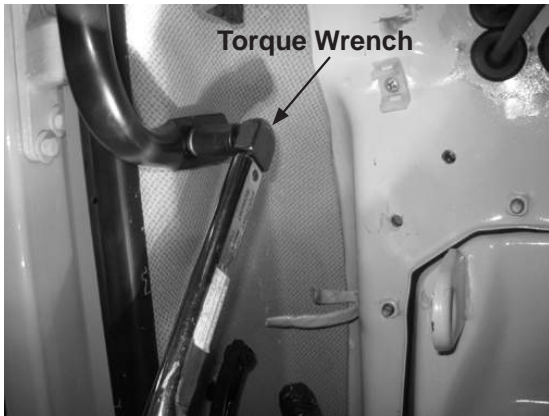


Figure 9-6

- Apply torque seal to the bolts (see Figure 9-7).



Figure 9-7

- Reinstall the dashboard support bracket, tighten support bracket bulkhead mount bolts to 13 ft-lb (18 N•m). Lower dashboard panel trim (ref. step 3-2) and the column shroud (ref. step 3-4).

Step 10. Replacement of Interior Grab Handle Fasteners (Upper)

- In the area of the handle upper mount, separate the door seal from the trim panel (see Figure 10-1).

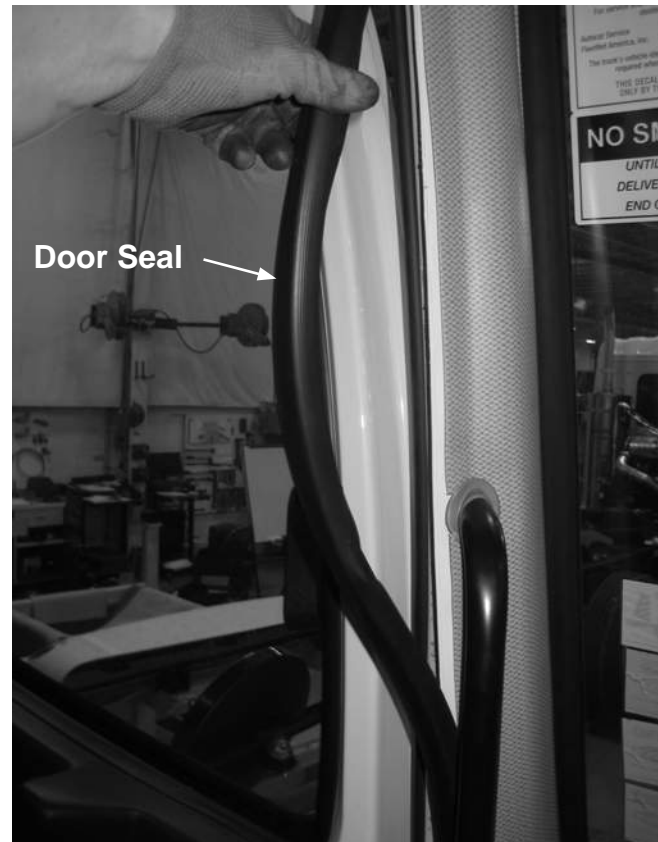


Figure 10-1

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2. Slide the grommet down the handle just far enough to expose the mounting bolt (see Figure 10-2).



Figure 10-2

4. Apply torque seal to the bolt (see Figure 10-4).
5. Reinstall grommet (slid down in 10-2) and door seal (separated in 10-1)

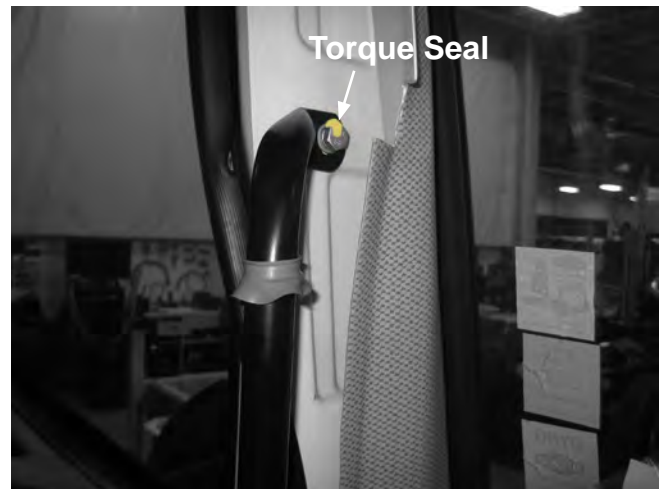


Figure 10-4

3. Remove the bolt and discard. Install the new bolt (GM410108AD13) and tighten to 13 ft-lb (18 N•m) of torque (see Figure 10-3).



Figure 10-3

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Step 11. Printing Templates (for Step 12 Procedure)

Note: This step involves printing of the templates used in Step 12, which involves the LH and RH exterior grab handle bolts located behind the cab side panels. The procedure does not call for removal of the cab side panels. Instead, the procedure calls for cutting holes in the B-pillar interior panels and capping the holes after replacing the bolts. In this Step 11, print the templates used in Step 12, which indicate where to make the holes in the B-Pillar interior side panels.

1. Print the first template sheet following this page.
2. To confirm the scale, measure the 5-inch reference line (see Figure 11-1).
3. If the reference line measures 5 inches, proceed to item 4 below. If the reference line does not measure 5 inches: Divide 5 by the measured length of the line. Multiply the print scale by the result, and reprint using the adjusted print scale. Measure the 5-inch reference line to confirm.

Example: If the 5-inch line measured 4 inches, divide 5 by 4. The result is 1.25. Set the print scale to 125% and reprint.

4. Print the other templates at the scale determined above, as applicable. Confirm the scale of each as set forth above.

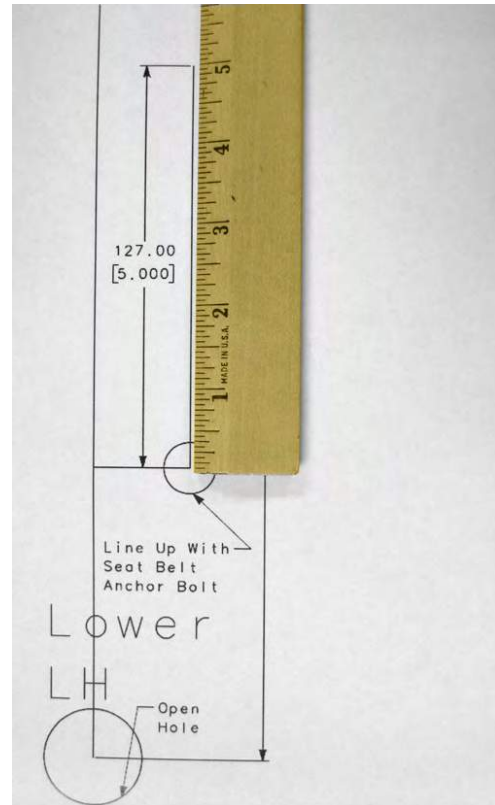


Figure 11-1

**B Pillar Trim Panel Cut-Out Template:
Exterior Grab Handle Middle Mount**

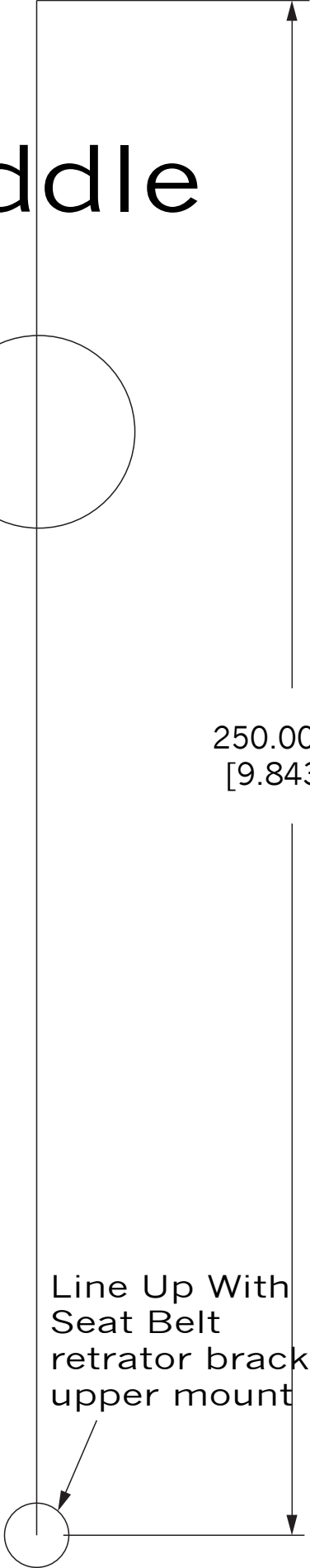
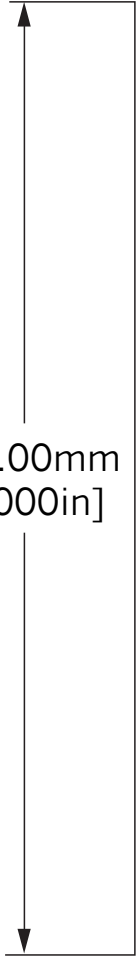
Middle

Open
Hole

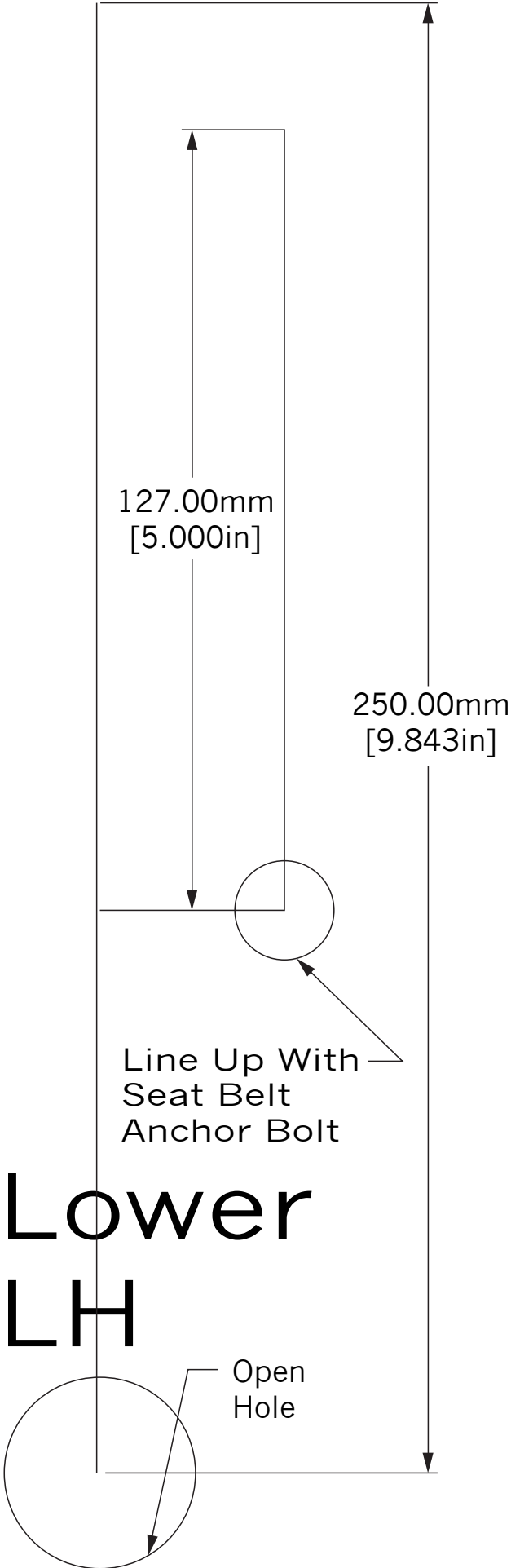
127.00mm
[5.000in]

250.00mm
[9.843in]

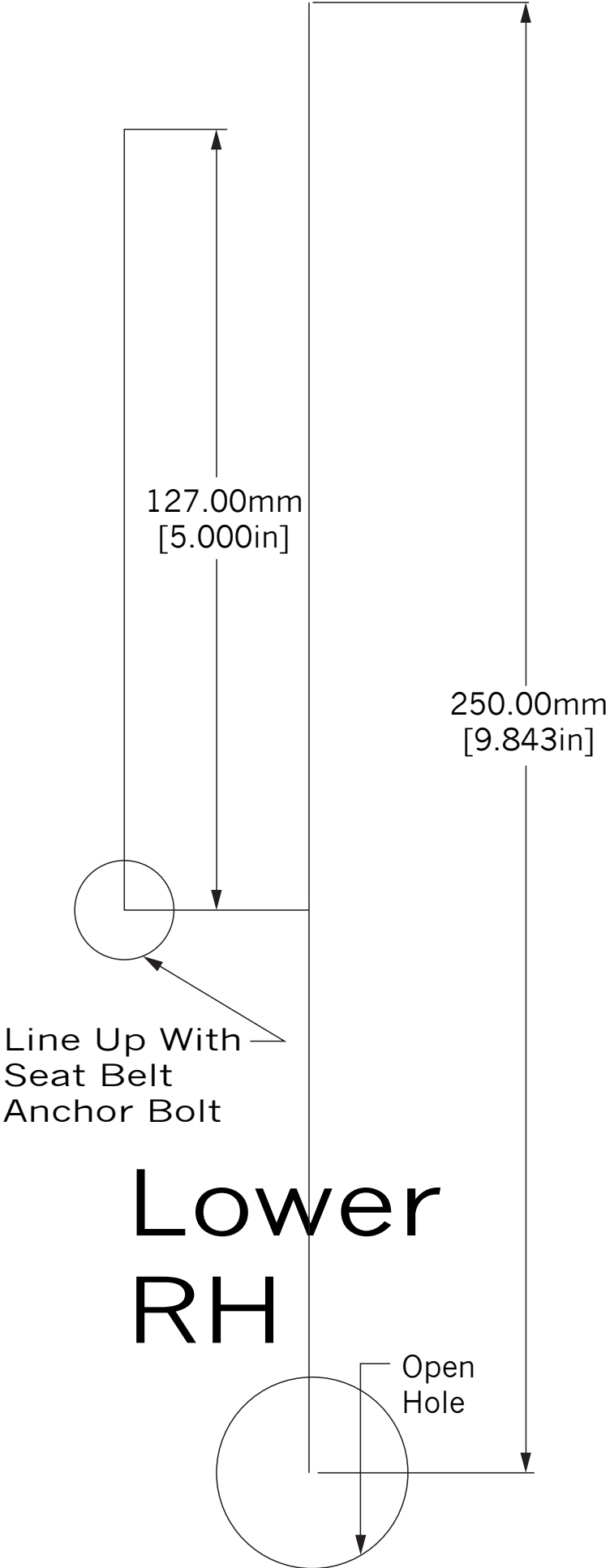
Line Up With
Seat Belt
retrator bracket
upper mount



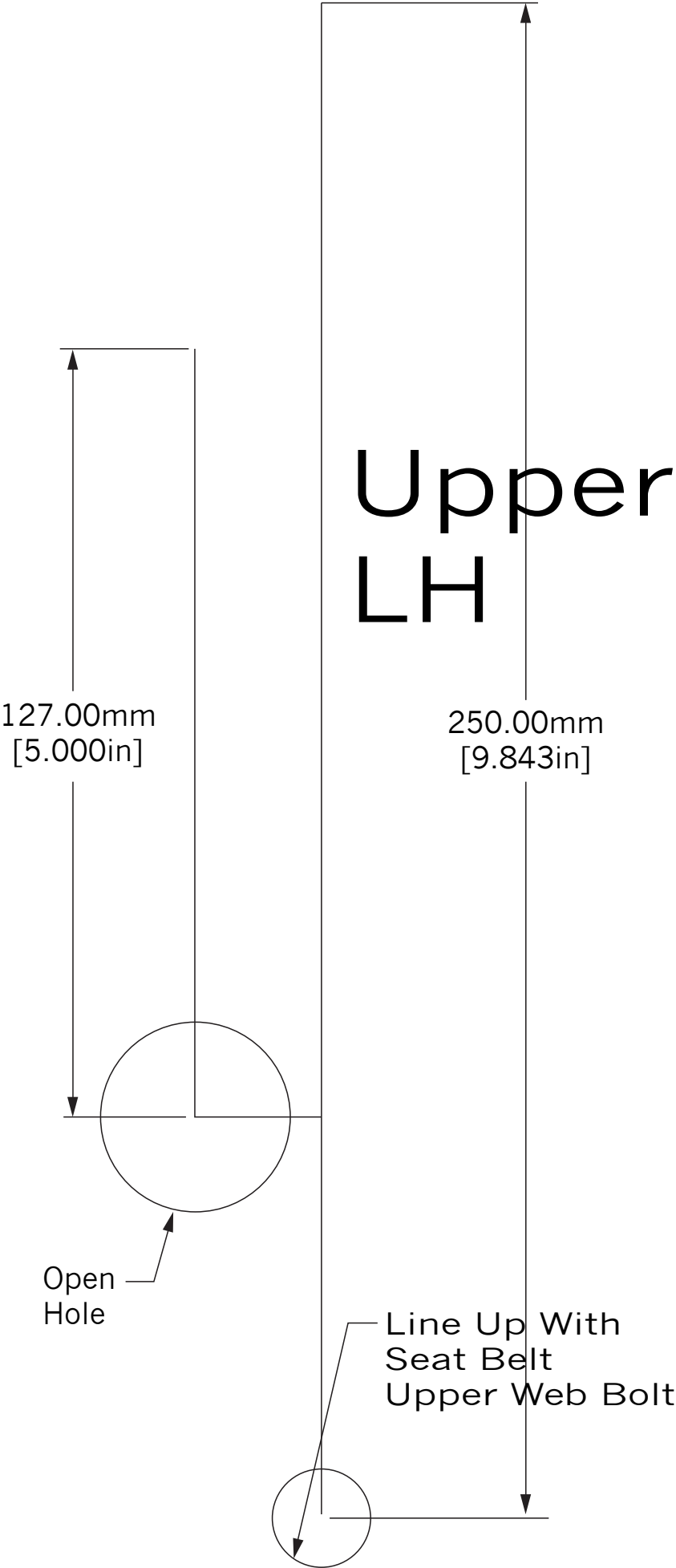
**B Pillar Trim Panel Cut-Out Template:
Exterior Grab Handle LH Lower Mount**



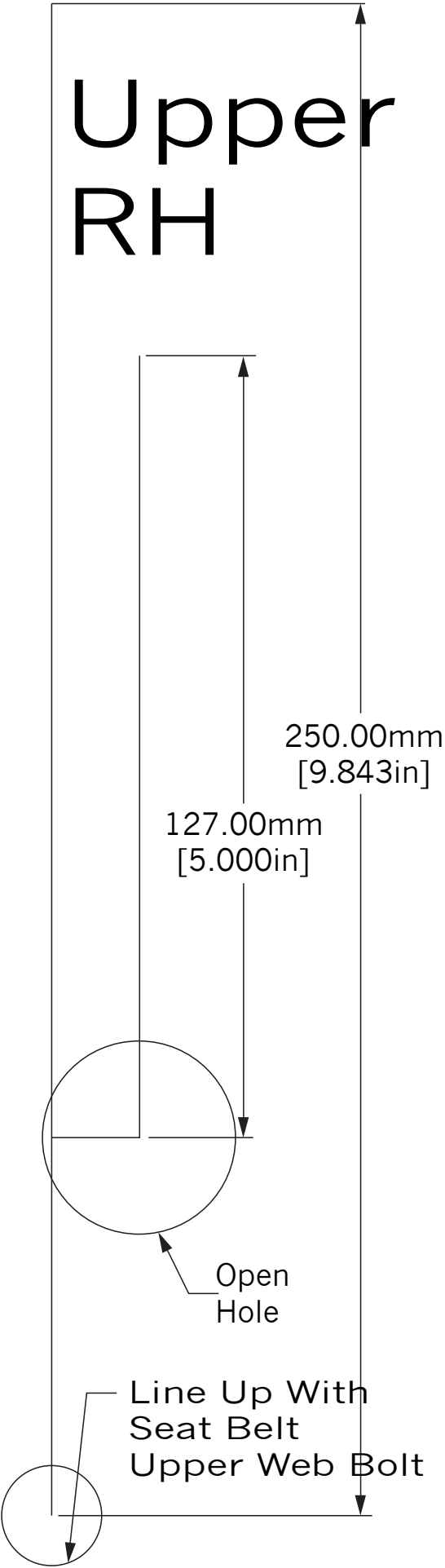
B Pillar Trim Panel Cut-Out Template: Exterior Grab Handle RH Lower Mount



B Pillar Trim Panel Cut-Out Template: Exterior Grab Handle LH Upper Mount



**B Pillar Trim Panel Cut-Out Template:
Exterior Grab Handle RH Upper Mount**



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Step 12. Replacement of LH and RH Exterior Grab Handle Bolts

Note: This step involves the LH and RH exterior grab handle bolts, which are located behind the cab side panel. The procedure does not call for removal of the cab side panels. Instead, the procedure calls for cutting holes in the B-pillar interior panels and capping the holes after replacing the bolts. In this Step 12, use the templates printed in Step 11, which indicate where to make the holes in the B-pillar interior side panels.



Figure 12-1

1. Line up the three templates using the reference bolts specified on each template. Ensure that the reference lines are vertical using a leveling device (see Figure 12-2).

Note: See Step 11 for information and printing of the templates.



Figure 12-2

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2. Pierce a hole through each template so that a mark is left on the side panel in the center of the location in which each hole will be drilled (see Figure 12-3).

Note: Before marking off middle exterior grab handle mount bolt access cutout in trim panel remove the grey plastic retractor cover (A5220018-001) and set aside for reinstallation.

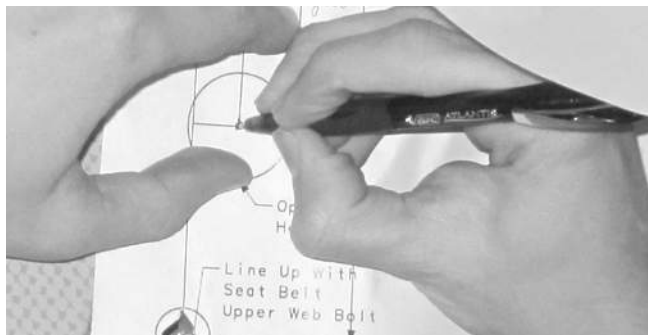


Figure 13-3

3. For each of the three holes, apply super glue to the non polished surface of the 1" (guide) washer (GE811637WB01) (see Figure 12-4).

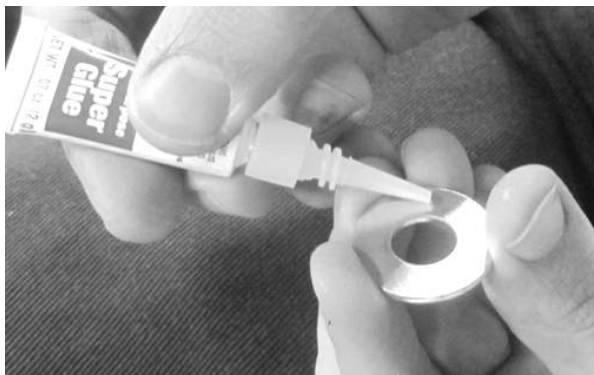


Figure 12-4

4. For each of the three holes, use the mark on the side panel made in Step 11-2 to position the 1" washer and adhere to the side panel. Apply pressure for 20 seconds to ensure the washer sticks (see Figure 12-5).

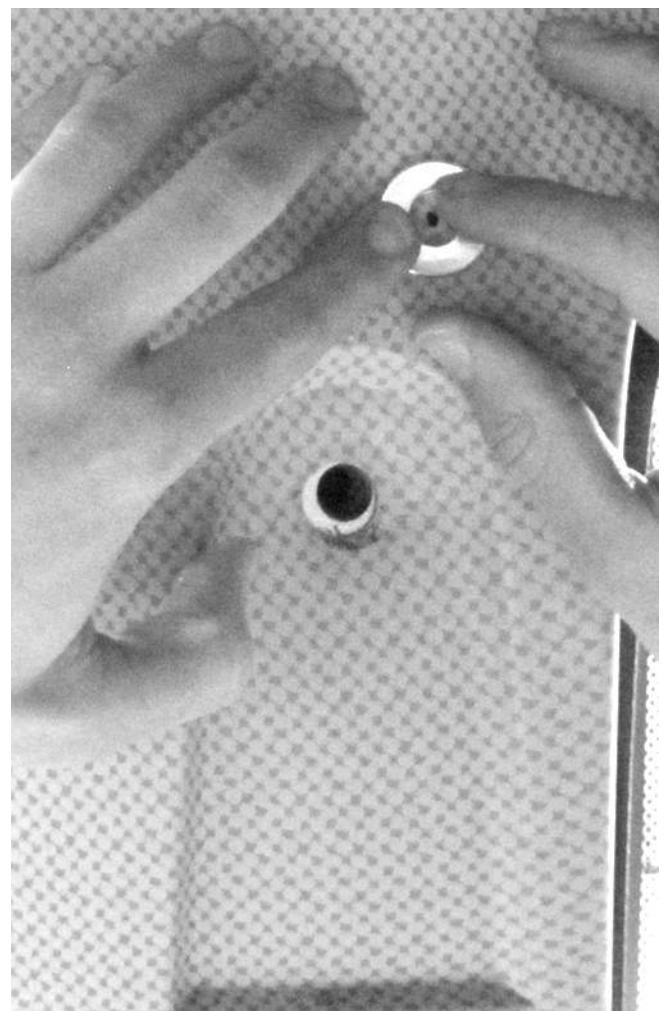


Figure 12-5

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Note: Wait a minimum of 15 minutes for the super glued washer to set in place.

5. Ensure that door lamp switch wires are not routed behind side panel in a manner that would result in the hole saw cutting through them (see Figure 12-6).



Figure 12-6

6. For each of the three holes, after the super glue has dried (minimum 15 minutes) use the washer to align the hole saw (see Figure 12-7).



Figure 12-7

7. For each of the three holes, start the drill at a very low speed (less than 1 rps), applying minimal pressure on the side panel, but keep the drill firmly located to prevent the teeth from breaking the washer free. Allow the teeth to slowly shave layers off of the side panel until the saw penetrates through.
8. For each of the three holes, using a hand file, smooth the rough edges left by the hole saw (see Figure 12-8).

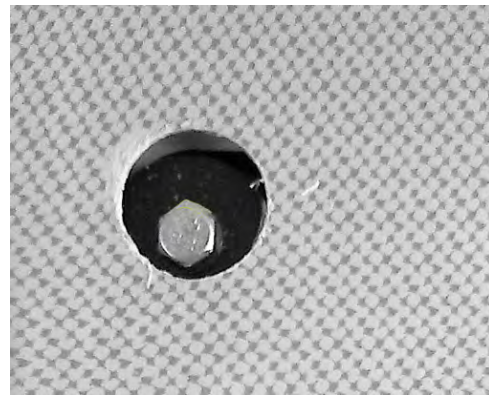


Figure 12-8

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9. Replace the upper bolt with new bolt (GM410108AB24). Tighten bolt to 19 ft-lb (26 N•m) of torque (see Figure 12-9).
10. Replace the middle bolt with new bolt (GM410108AD13). Tighten bolt to 13 ft-lb (18 N•m) of torque (see Figure 12-9).
11. Replace the lower bolt with new bolt (GM410108AD13). Tighten bolt to 13 ft-lb (18 N•m) of torque (see Figure 12-9).
12. Apply torque seal to the middle and lower bolts.
13. Install a plastic plug (S5000012-001) into the middle and lower holes (see Figure 12-10).

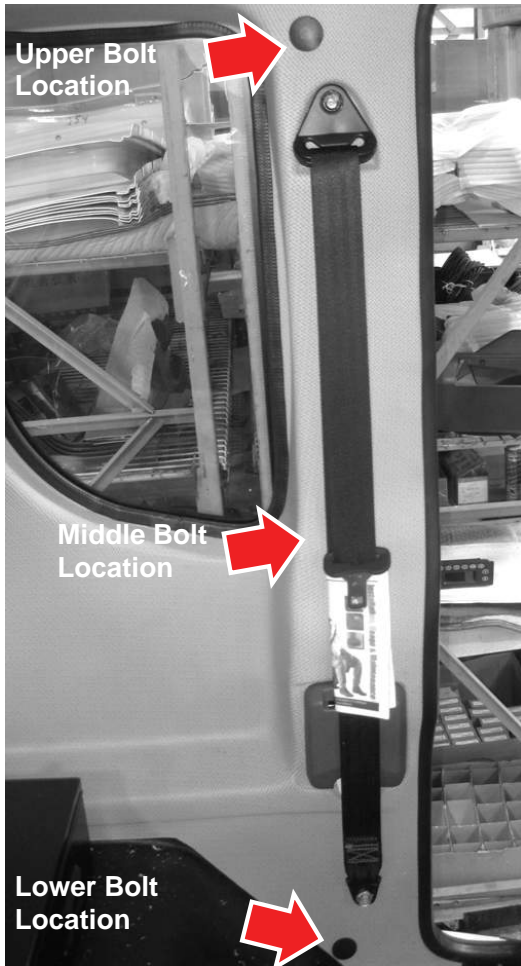


Figure 12-9

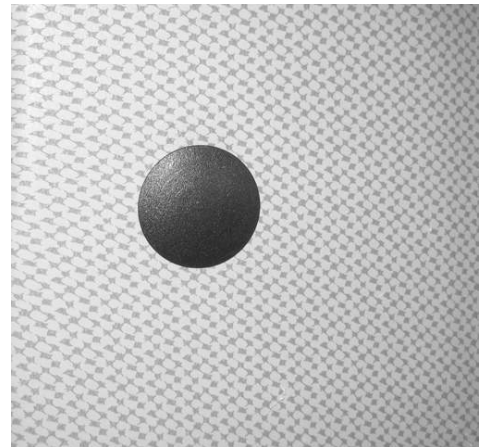


Figure 12-10

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Step 13. Replacement of Seat Belt Bolts (B Pillar)

1. Remove the seat belt web/anchor and replace with one 1" (guide) washer (GE811637WB01). Set the seat belt web/anchor aside for reinstallation (see Figure 13-1).

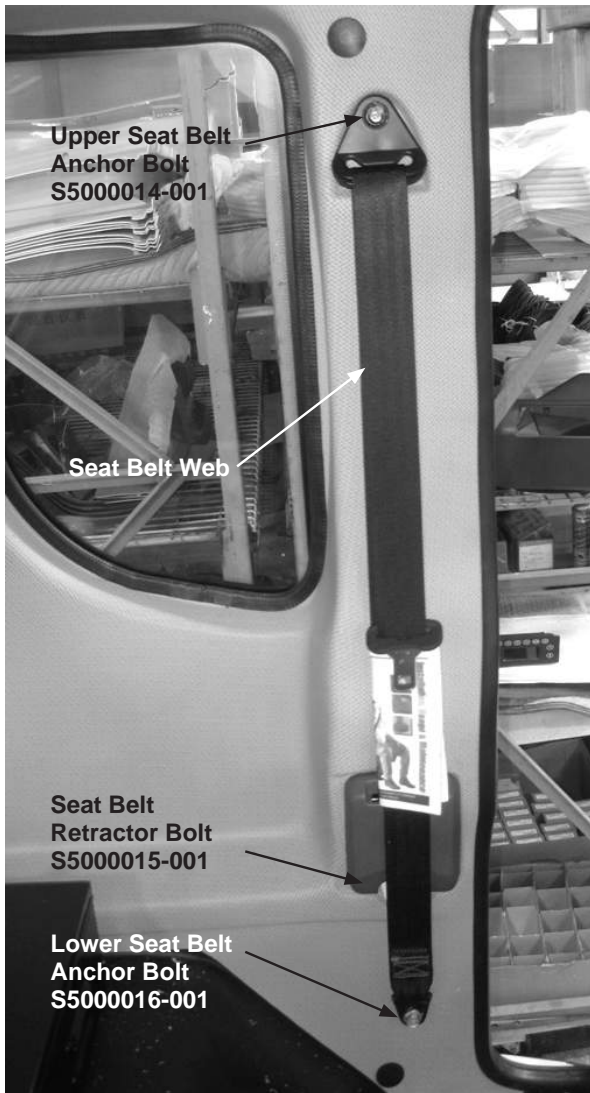


Figure 13-1

2. Use the (guide) washer to align the hole saw (see Figure 13-2).



Figure 13-2

3. Start drill at very low speed (less than 1 rps), applying minimal pressure on the side panel, but keep the drill firmly located to prevent the teeth from breaking the washer free. Allow the teeth to slowly shave layers off of the side panel until the saw penetrates through (see Figure 13-3).



Figure 13-3

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4. Smooth the burrs away with a file; remove the washer and discard. Reinstall the seat belt web/anchor using the new bolt (S5000014-001).
5. Alternate tightening between the previously-reinstalled exterior grab handle upper bolt and the newly reinstalled seat belt anchor bolt until each holds the torque indicated below.
6. Tighten the external grab handle bolt (GM410108AD13) to 19 ft-lb (26 N•m) of torque (see Figure 13-4).
7. Tighten the seat belt web anchor bolt (S5000014-001) to 42 ft-lb (57 N•m) of torque (see Figure 13-4).
8. Apply torque seal to the bolts (see Figure 13-5).

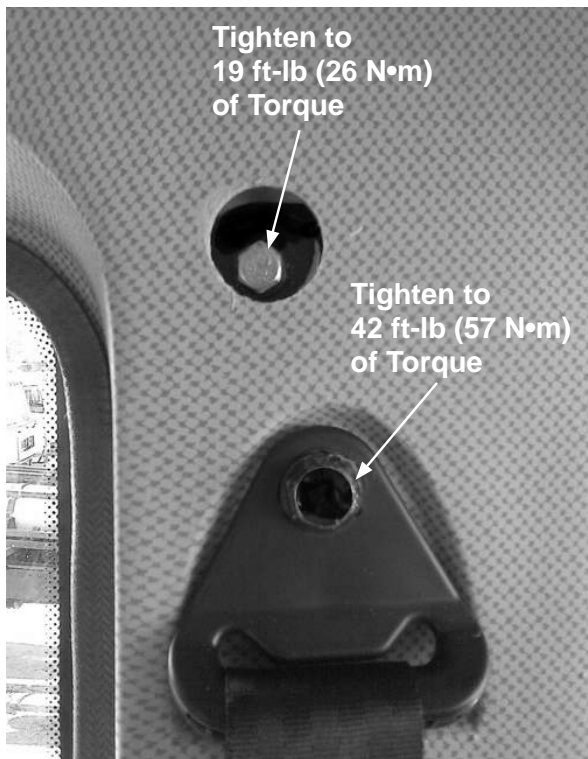


Figure 13-4

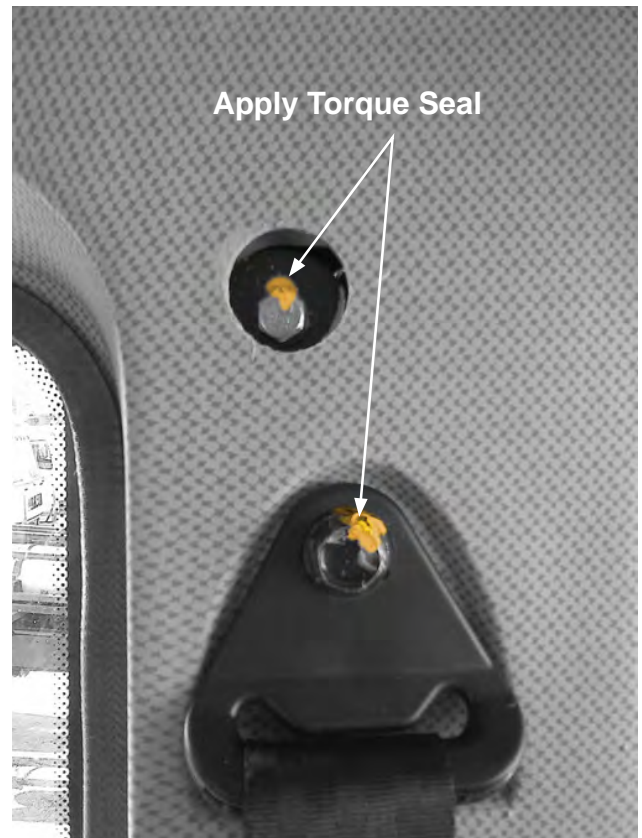


Figure 13-5

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9. Install the plastic plug (S5000012-001) and reinstall the anchor cap (see Figure 13-6).

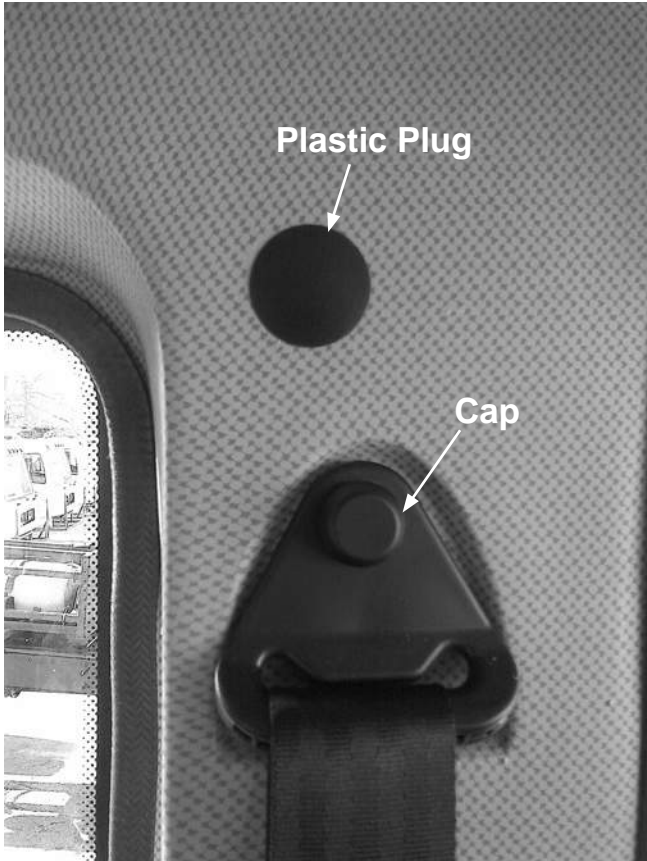


Figure 13-6

10. With the retractor cover removed, use the retractor bracket as a template to draw a cutting guide on the side panel around the bolts (see Figure 13-7).



Figure 13-7

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- 11. Remove the retractor and cut along the lines drawn in the previous step using a Dremel (or equivalent tool) (see Figure 13-8).



Figure 13-8

- 12. Smooth the edges where the panel was cut (see Figure 13-9).



Figure 13-9

- 13. Using new bolt (S5000015-001), reinstall the retractor and tighten to 42 ft-lb (57 N•m) of torque (see Figure 13-10).
- 14. Apply torque seal to the bolts (see Figure 13-10).

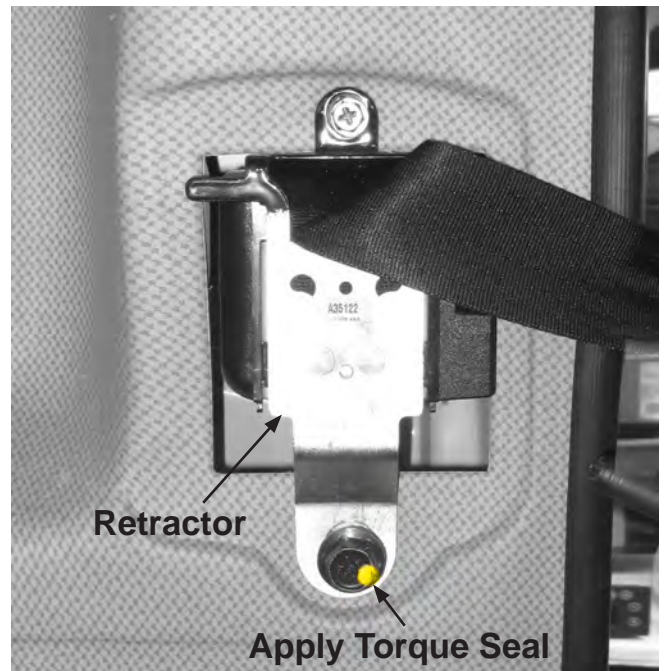


Figure 13-10

- 15. Reinstall the retractor cover (see Figure 13-11).

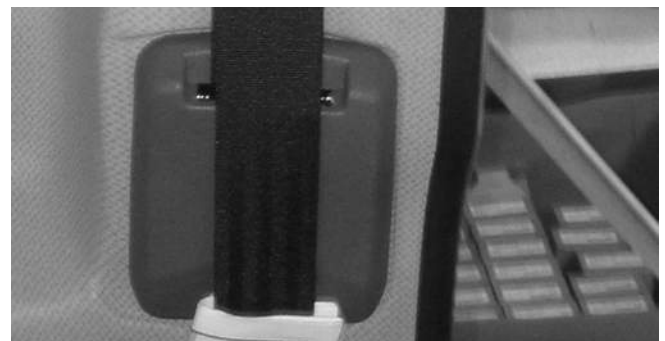


Figure 13-11

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Step 14. Extraction of Mat from Seat Belt Buckle Bolt

1. Remove the seat belt buckle bolt and discard. Set the seat belt buckle aside for reinstallation (see *Figure 14-1*).



Figure 14-1

2. Cut out the mat so that no part of the mat is between the seat belt buckle mounting bracket and the sheet metal floor (see *Figure 14-2*).

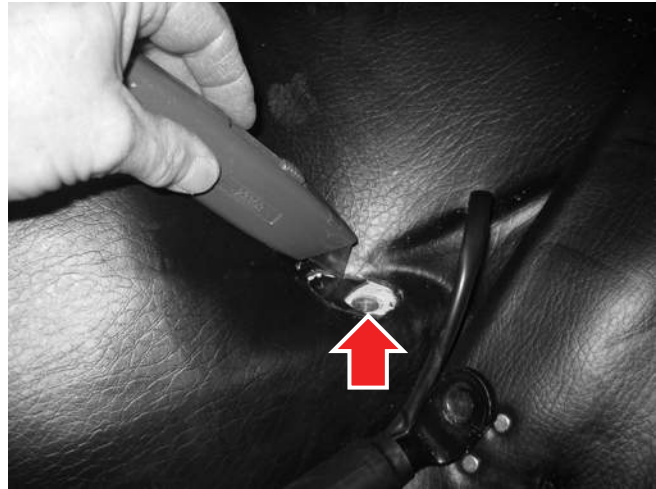


Figure 14-2

3. Using the new seat belt buckle bolt (S5000017-001), reinstall the seat buckle.
4. Tighten the seat belt buckle bolt to 42 ft-lb (57 N•m) of torque.
5. Apply torque seal to the bolt (see *Figure 14-3*).



Figure 14-3

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Step 15. Extraction of Mat from Third Seat Belt Buckle Bolt

Note: *The third seat is optional and may not be present on every vehicle.*

1. Remove the bolts to the seat belt buckle and the retractor, and discard. Set the seat belt buckle and retractor aside for reinstallation (see Figure 15-1).

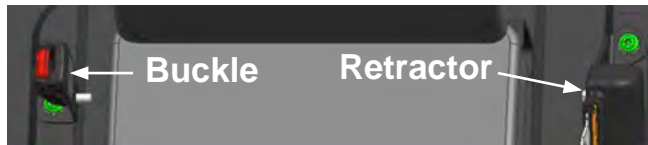


Figure 15-1

2. Cut out the mat so that no part of the mat is between the seat belt buckle mounting bracket and the sheet metal floor (see Figure 15-2).

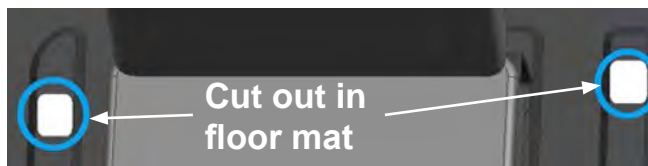


Figure 15-2

3. Install the new bolt (A5220003-001) to the seat belt buckle and also to the retractor, tighten bolts to 42 ft-lb (57 N•m) of torque.
4. Apply torque seal to the bolts.

Step 16. Preparation for Reinstallation of LH and RH Seats

1. Prepare each of the mounting holes as set forth below in items 2-7 (see Figure 16-1).

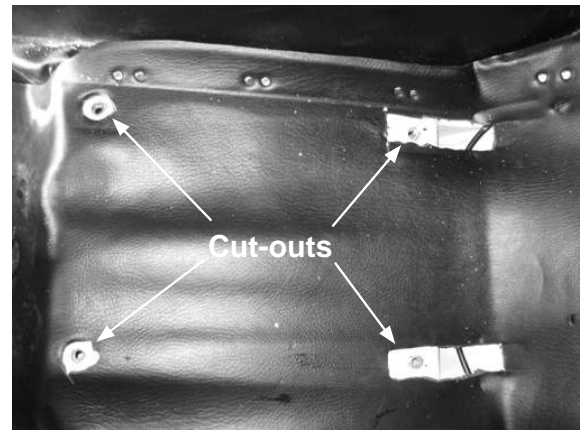


Figure 16-1

2. Place one spacer (A5200041-001) concentric with the mounting hole.
3. Place one 1" (guide) washer (GE811637WB01) over the spacer.
4. Clamp the spacer and washer down using one new bolt (GM410108AD16).
5. Using a hole saw, carefully trim away the floor mat around the clamped washer and spacer.

Note: *Use very slow speed and gentle pressure when trimming the mat.*

6. Remove the bolt and discard. Remove the washer and spacer and set aside for use on the other mounting holes.
7. Scrape off any insulation glued to the sheet metal of the cab floor.

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8. Place round spacers (A5200041-001) and the rectangular spacers (A5200042-001) concentric with the mounting holes (see Figure 16-2).

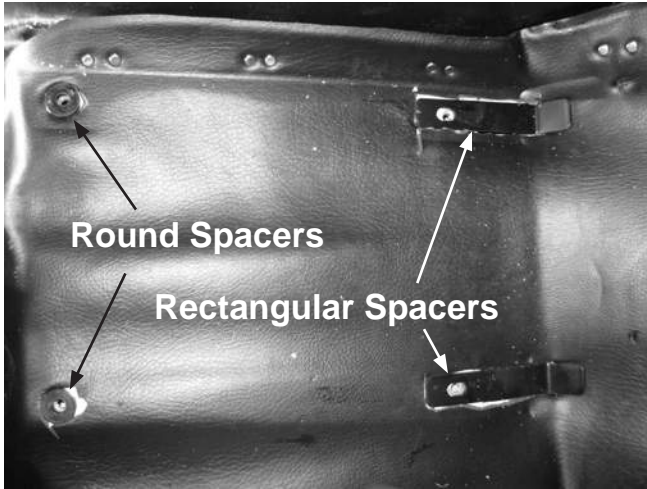


Figure 16-2

Note: Depending on the seat configuration, square seat riser tubes may or may not be present; if square seat riser tubes are not present, skip to Step 17.

9. If equipped (see note above), reinstall the square seat riser tubes removed in Step 2-3. Ensure that the tubes are parallel and 216 mm (8.5") apart. Check both front and back of the tubes to ensure that they are parallel. Install 2 new bolts (A5220003-001) to the front (see Figure 16-3).

Note: Slide the seat backward/forward a few times to ensure the square seat riser tubes are aligned. Install but do not torque the 2 new bolts to the front until step 17-3. Install and torque the 2 new bolts to the rear as set forth below in the next step.



Figure 16-3

10. Install 2 new bolts (A5220003-001) to the rear and tighten to 19 ft-lb (26 N•m) of torque.
11. Apply torque seal to the bolts.

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Step 17. Reinstallation of LH and RH Seats

Note: Depending on the seat configuration, square seat riser tubes may or may not be present.

1. Place the seat on top of the square seat riser tubes, if equipped, or on top of the seat rails, if square seat riser tubes are not equipped. The front hole in the seat must line up with the front mounting hole in the riser or rail, as applicable. There may be multiple mounting holes in the seat rails, so ensure the front holes are used (see Figure 17-1).
2. Install and hand tighten the seat bolts until fully seated, starting with the front two bolts, if equipped. Slide the seat backward/forward a few times to ensure the square seat riser tubes are aligned, if equipped (see Figure 17-1).



Figure 17-1

3. Tighten the seat bolts to 19 ft-lb (26 N•m). Tighten the front two bolts, mounting the risers, if equipped, to the floor, to 19 ft-lb (26 N•m) of torque (see Figure 17-2).



Figure 17-2

4. Apply torque seal to the bolts (see Figure 17-3).



Figure 17-3

5. Reattach the seat bellows.

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Step 18. Reinstallation of Third Seat

Note: *The third seat is optional and may not be present on every vehicle.*

1. Remove the 4 bolts and nuts securing the seat to the mounting brackets and discard (set the washers aside for reinstallation). Remove the 4 bolts securing the seat mounting brackets to the cab floor and discard the bolts and the brackets (see Figure 18-1).

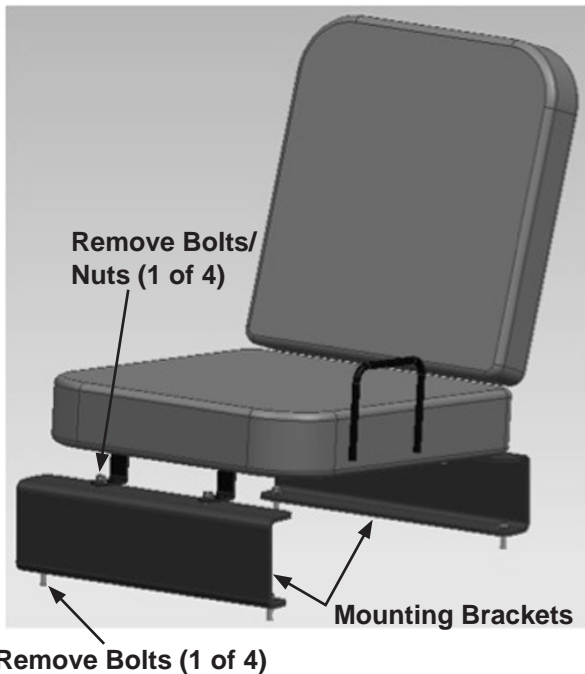


Figure 18-1

2. Prepare each of the bracket mounting holes in the floor as set forth below in items 3-8 (see Figure 18-3).

3. Place one spacer (A5200041-001) concentric with the mounting hole.
4. Place one 1" (guide) washer (GE811637WB01) over the spacer.
5. Clamp the spacer and washer down using one bolt (GM410108AD16).

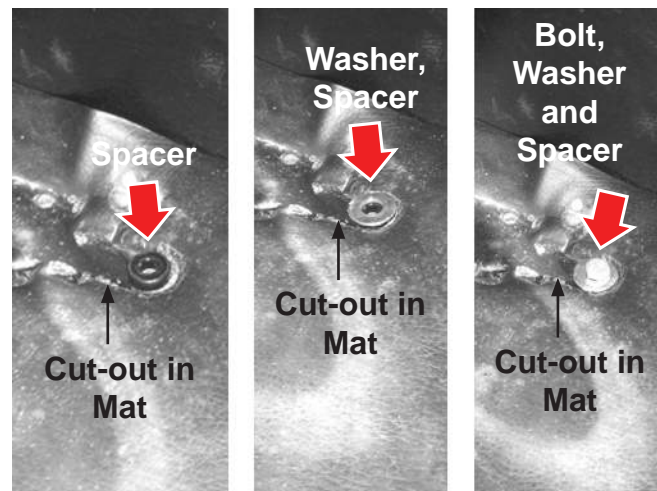


Figure 18-2

6. Using a hole saw, carefully trim away the floor mat around the clamped washer and spacer (see Figure 18-3).

Note: *Use very slow speed and gentle pressure when trimming the mat.*

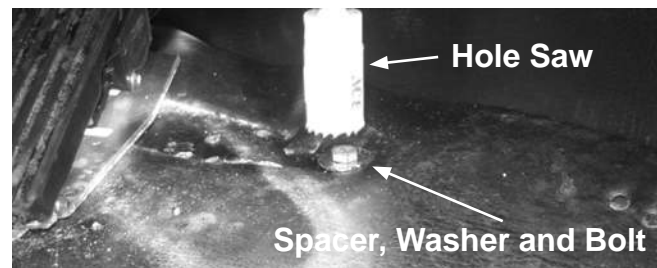


Figure 18-3

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7. Remove the bolt, washer and spacer. Discard the washer. Set the bolt and spacer aside for reinstallation.
8. Scrape off any insulation glued to the sheet metal of the cab floor (see Figure 18-4).



Figure 18-4

9. Place spacers (A5200041-001) over all 4 holes on the floor of the cab.
10. Using 4 new bolts (GM410108AD16), install the new seat mounting brackets (A52A0005-001) and (A52A0006-001), aligned with the spacers (see Figure 18-5).

11. Using 4 new bolts (GM410108AD13) and 4 new nuts (GM280708BD01) and original washers, install the seat to the seat mounting brackets (see Figure 18-5).



Figure 18-5

12. Tighten all bolts to 19 ft-lb (26 N•m) of torque.
13. Apply torque seal to the bolts.
14. End of work instructions.

