



BLUE BIRD

SECOND FINAL NOTICE

DATE: SEPTEMBER 14, 2015
TO: BLUE BIRD OWNERS
SUBJECT: RECALL R14XC
REAR WHEELHOUSE TO BODY GUSSET PANEL JOINT

According to our records, we have not received confirmation that the above referenced recall dated April 24, 2015 has been completed. A copy of Recall R14XC is attached.

Your buses affected by Recall R14XC are identified by Blue Bird body number and VIN under Section 2 on the enclosed cover sheet.

If this is the first time you received notification of Recall R14XC, please read the enclosed notification carefully and follow the instructions provided. Recall R14XC must be completed as soon as possible.

If you have already had R14XC performed on your affected buses, please complete and mail the enclosed pink R14XC recall reply sheet to us in the enclosed postage paid pink reply envelope so we may update our recall records. Be sure the reply sheet is filled out properly.

Questions regarding this recall campaign should be directed to me at (478) 822-2242 or lisa.hancock@blue-bird.com.

Thank you for your prompt attention to this matter.

Sincerely,

Lisa Hancock
Corporate Recall Administrator
Blue Bird Body Company

BLUE BIRD BODY COMPANY
P.O. Box 937 – 402 Blue Bird Blvd – Fort Valley, Georgia – (478) 825-2021



BLUE BIRD

R14XC

**IMPORTANT SAFETY RECALL NOTICE
NHTSA RECALL NO. 14V-110 SCHOOL BUS**

April 24, 2014

Dear Blue Bird Owner:

This important safety recall notice applies to your buses identified by both Blue Bird Body Number and Vehicle Identification Number (VIN) on the enclosed yellow cover sheet.

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

Blue Bird Body Company has decided that certain 2014 model year All American and Vision model school buses manufactured from January 21, 2013 through February 28, 2013 may fail to conform to the joint strength requirements of Federal Motor Vehicle Safety Standard (FMVSS) No. 221, "School Bus Body Joint Strength" at the rear wheelhouse to body gusset panel joints.

On the subject buses, the joint between the rear wheelhousing and body gusset panel may have partially separated during the manufacturing process. Buses with separation at the wheelhouse to body gusset panel joints fail to conform to the joint strength requirements of FMVSS No. 221. Bus passengers may sustain injuries in the event of a vehicle crash. Buses with this noncompliance must be corrected immediately according to the enclosed instructions for Recall R14XC.

If you no longer own the subject bus(es), please complete the appropriate section of the **pink** reply sheet and return to Blue Bird in the enclosed pink postage prepaid envelope.

You should contact your Blue Bird dealer to have this recall performed. Or, if you prefer, you may perform this recall yourself or have a qualified repair facility convenient to you perform this recall. A qualified technician should perform this recall.

Parts and labor required to complete Recall R14XC, according to the attached instructions, will be provided at no cost to you.

Affected buses must be inspected according to Recall R14XC instructions for deformation at both the right and left rear wheelhouse to body gusset panel joints. Your findings must be recorded on the attached Recall R14XC Inspection Sheet and returned to Blue Bird in one of the enclosed pink self-addressed postage paid reply envelopes or the inspection sheet may be faxed to 478-822-2467. You should retain a copy of Recall R14XC Inspection Sheet for your bus records.

BLUE BIRD BODY COMPANY

P.O. Box 937 – 402 Blue Bird Blvd – Fort Valley, Georgia – (478) 825-2021

Labor time to visually inspect the outside of both left and right rear wheelhouse to body gusset panel joints for deformation is 0.1 hours (6 minutes) per bus.

Labor time to complete further inside visual inspection for deformation of any rear wheelhouse to body panel joint identified by the outside visual inspection is 0.2 hours (12 minutes) per wheelhouse to body gusset panel joint.

Labor time to correct any rear wheelhouse to body gusset panel joint deformation found is 2.5 hours per rear wheelhouse to body gusset panel joint.

You may elect to perform this recall yourself, or have a qualified repair facility convenient to you perform this recall. Parts needed to perform Recall R14XC will be provided at "no charge" when a properly completed **Recall R14XC Inspection Sheet** is returned to Blue Bird Recall Administration.

If the modifications directed by this notification were performed on your bus prior to the receipt of this recall notification, complete and sign the recall reply sheet and attached a copy of the work order/invoice. Mail the documents in the **pink** self-addressed postage paid envelope included with the recall notification to Blue Bird for warranty consideration. Reimbursements will be made in accordance with the requirements of the National Highway Transportation Safety Act, Title 49 Code of Federal Regulations, Parts 573 and 577.

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

If Blue Bird Body Company should fail to or is unable to remedy this condition without charge to you, you may contact:

**ADMINISTRATOR
NATIONAL HIGHWAY TRAFFIC SAFETY ADMINISTRATION
1200 NEW JERSEY AVENUE, SE
WASHINGTON, D.C. 20590**

Or, you may call The National Highway Traffic Safety Administration toll free at:

1-888-327-4236 TTY 1-800-424-9153 or, go to: [HTTP://WWW.SAFERCAR.GOV](http://WWW.SAFERCAR.GOV)

Questions regarding this recall campaign should be directed to me at (478) 822-2242.

Thank you,



Bill Coleman
Corporate Recall Administrator
BLUE BIRD BODY COMPANY



Rear Wheelhousing Joint

RECALL

Models Affected: 2012-2014 Vision and All American w/standard floor and without optional rubber fenders.

ISSUE

Rear wheelhousing to body gusset panel joint may not comply with FMVSS 221, Joint Strength requirement.

CORRECTIVE ACTION

Inspect for deformed wheelhousing and repair as necessary to comply with FMVSS 221, Joint Strength requirement.

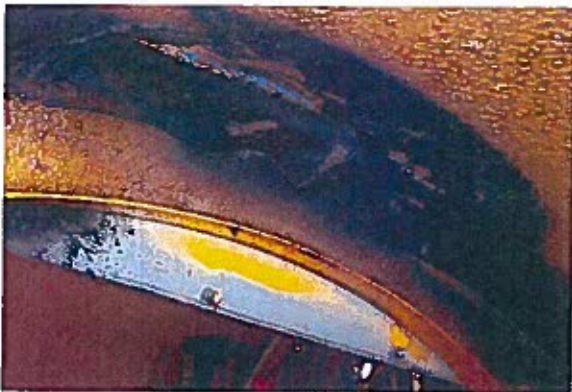
PROCEDURE

WARNING: Always follow all Federal, State, Local and Shop safety standards and use proper safety equipment, and thoroughly read and understand all instructions before performing these procedures.

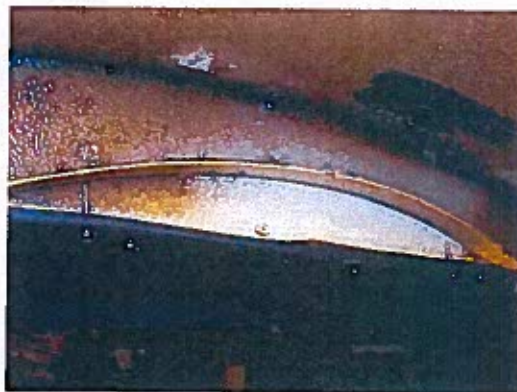
WARNING: Before using Magnobond adhesive, review manufacturer's handling instructions and cautions included with each shipment.

Procedure 1

- Inspect underside of each rear wheelhousing for deformed panel.
- If panel is deformed (pic 1), proceed to Procedure 2.
- If panel is not deformed (pic 2), recall is complete. Return bus to service.



Picture 1



Picture 2



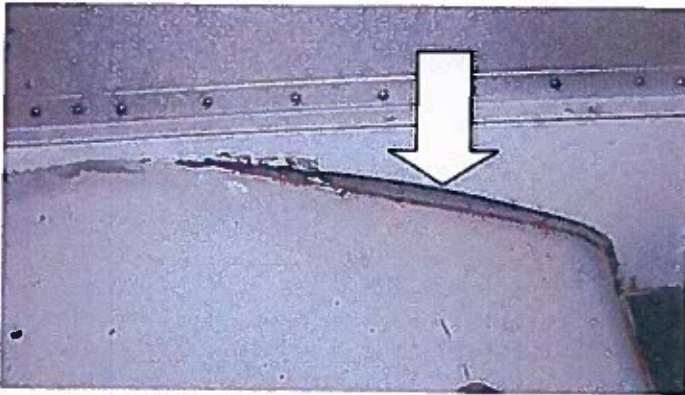
RECALL

Procedure 2

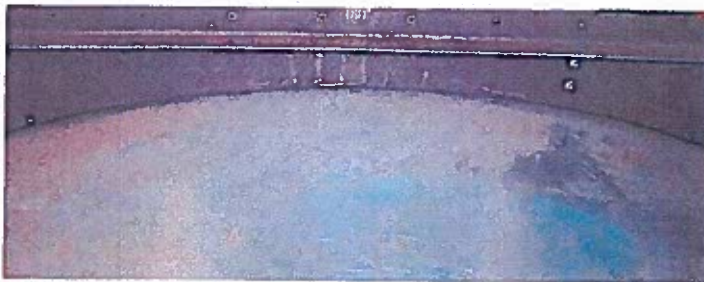
- Remove wheelhousing cover screws and slide the wheelhousing cover towards the center of the bus.

NOTE: Passenger seat(s) do not need to be removed for this step.

- Inspect the joint where the wheelhousing meets the gusset.
- If there is a gap present or the spot welds visibly appear to be compromised (pic 3), proceed to procedure 3.
- If there is no gap present (pic 4), replace the wheelhousing cover.
- Place the wheelhousing cover into position, seal under the lip of the cover using black sealant (Manus Bond).
- Install perimeter screws.
- Recall is complete. Return bus to service.



Picture 3



Picture 4

RECALL CAMPAIGN R14XC



RECALL

Procedure 3

WARNING: Secure the bus with jack stands and chock the wheels accordingly to prevent the bus from moving.

- Remove the tire(s) on the side of the affected wheelhousing.
- Remove the seat(s) over the affected wheelhousing. Discard the mounting bolts and nuts.
- Remove any loose sealant or debris from the gapped area.
- Using a wire brush, wire wheel or die grinder, remove any paint from between the wheelhousing and gusset ledge.
- Using the appropriate body hammers and/or slide hammers form the wheelhousing as required so there is little to no gap between it and the gusset edge. (pic 5)



Picture 5



Picture 6

- Beginning at the radius where the gap is, measure 1 1/4" from the side panel and drill a hole (17/64") to install a self-threading fastener (02000198) to pull the wheel housing up to the gusset and close the gap. (pic 6)
- Continue to drill and install a fastener every 7 inches the entire radius of the wheel housing.
- Once all fasteners are installed, verify there is no gap in the joint.

NOTE: Continue working the material with the body hammers and installing fastener until there is no gap present.

RECALL CAMPAIGN R14XC



RECALL

Prepare the surface for Magnobond adhesive.

WARNING: Before using Magnobond adhesive, review manufacturer's handling instructions and cautions included with each shipment.

NOTE: Be sure there is no paint, dirt or silicone within the area the adhesive is to be applied

- Remove all self-threading fasteners that were previously installed.

- Apply a ¼" bead of Magnobond adhesive between the wheelhousing and gusset edge. (pic 7)

NOTE: It may be necessary to use a pry bar and block of wood to apply downward pressure to the top of the wheelhousing to allow access to apply the adhesive.

- Re-Install the self-threading fasteners working towards the center of the wheelhousing.
- Centered between each fastener, drill a 17/64" hole and install a ¼" repair rivet (01854397).



Picture 7



Picture 8

- There should be a fastener at least every 3.5 inches. (pic 8)
- Spray undercoating on the exposed rivets and fastener heads.
- Allow ample time for the Magnobond to dry to the touch, normally 1-6 hours.
- Install wheelhousing cover; Place the wheelhousing cover into position, seal under the lip of the cover using black sealant (Manus Bond).

RECALL CAMPAIGN R14XC



RECALL

- Install seat using new bolts and nuts. Reference Seat Parts List for torque specifications.
- Recall is complete. Place bus back into service.

Repair Parts List Contact Blue Bird Recall Administration at 478-822-2242 to obtain repair parts if needed.

Quantity	Part Number	Description
14	01854397	Rivet, Blind, .25 Dia, .38 grip
14	02000198	SCREW, 5-16-18 X 1, F, HEX HD, YEL ZN DICH
AS NEEDED	NPN	17/64 DRILL BIT, OBTAIN LOCALLY
AS NEEDED	NPN	Undercoating, OBTAIN LOCALLY
1	10016413	Nozzle, Joint, Mixing, Static 1
1	10016411	Adhesive, Joint, Magnobond 200ML/200ML ***
1	10016412	Gun, Dispensing, 2 Barrel 1
1	10028090	Sealant, Black, Manus Bond

One tube set will do multiple buses

Seat Parts List Contact Blue Bird Recall Administration at 478-822-2242 to obtain repair parts if needed.

Seat Ledge Mounting Fasteners			
Part Number	Description	Quantity	Torque ft-lb
00854406	Capscrew, 5/16-18 x 1, GR8	3	
00829390	Nut, 5/16-18, SER Washer	3	12-13
10021595	Capscrew, 3/8-16 x 2, GR8	1	
00543934	Nut, 3/8-16, SER Washer	1	13-15

Floor Mounting Fasteners			
Part Number	Description	Quantity	Torque ft-lb
10021595	Capscrew, 3/8-16 x 2, GR8	6	
00543934	Nut, 3/8-16, SER Washer	6	18-20

NOTE: Re-torque the seat bolts after one month or 1,000 miles of service.

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