



# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

# RECALL

**Models Affected: Certain 2015 through 2018 Model Year Vision Buses with Chassis Mounted Battery Box**

## ISSUE

The chassis mounted battery box support brackets may develop cracks or fracture and could allow the battery box to separate from the chassis and fall.

## CORRECTIVE ACTION

Inspect for loose front brace and cracked support brackets. From matrix in instructions, select the correct repair for your bus which includes removing braces, and may include adding reinforcements or replacing front or front and rear support brackets.

## 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.

### INSPECTION

1. Park bus on level surface, apply parking brake, turn off ignition key, and chock wheels.
2. Disconnect batteries.
3. Inspect front brace for loose or missing fasteners on the front battery box-to-floor brace. See Illustration on Page 2.
4. Inspect for cracks on the front battery box-to-body floor brace, front battery box frame mounting bracket, and rear battery box frame mounting brackets for cracks at bolt holes and in the bend.
5. Per the Battery Configuration in the bus and the inspection results, perform the appropriate repair per the matrix on Page 3.

### BATTERY IDENTIFICATION



THREE GROUP 31 BATTERIES



THREE ODYSSEY BATTERIES

**NOTE:** Two 8D and Four Group Three 31 Battery Configurations are not shown.

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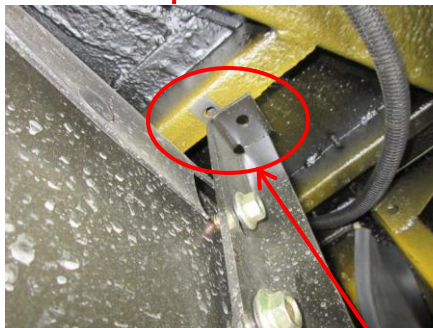
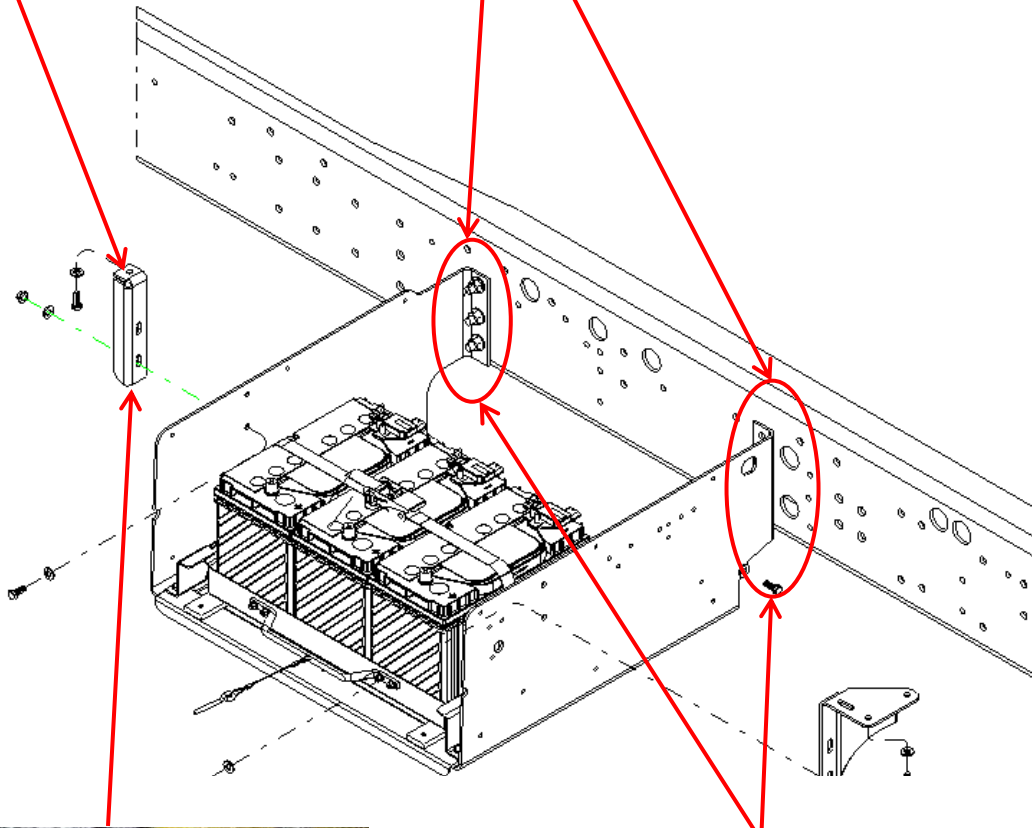
# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## INSPECTION

Inspect front brace for loose or missing fasteners and/or cracks.

Inspect front and rear frame battery box brackets for cracks around the fasteners and in the vertical bend.



Example shown of front brace missing fasteners at floor and loose at battery box attachment.



Crack may be in vertical bend.

Example shown of vertical crack at lower hole. Cracks may be vertical or horizontal to one or more holes.

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		<u>Choose Bus Battery Option</u>	
		Three Group 31	Two 8D, Three Odyssey, or Four Group 31
<u>Inspection Results</u>	NO cracks or missing or loose fasteners or history of loose fasteners	Repair A	Repair B
	<b>Front battery box-to-body floor brace-</b> History of loose fasteners or inspection shows missing or loose fasteners or any cracks	Repair B	Repair B
	<b>Front battery box frame mounting bracket CRACKS-</b> at <u>one</u> bolt hole or in the bends of bracket	Repair C	Repair C
	<b>Front and Rear battery box frame mounting bracket CRACKS-</b> at <u>more than one</u> bolt hole or bend of either bracket	Repair D	Repair D

**Repair A:**

Remove and discard the front and rear battery box-to-body floor braces

**Repair B:**

Install Kit 1 (reinforcement braces), remove and discard the front and rear battery box- to-body floor braces

**Repair C:**

Install Kit 2 (reinforcement braces, new high strength steel front battery box frame mounting bracket) , remove and discard the front and rear battery box-to-body floor braces

**Repair D:**

Install Kit 3 (new high strength steel front and rear battery box frame mounting brackets), remove and discard the front and rear battery box-to-body floor braces

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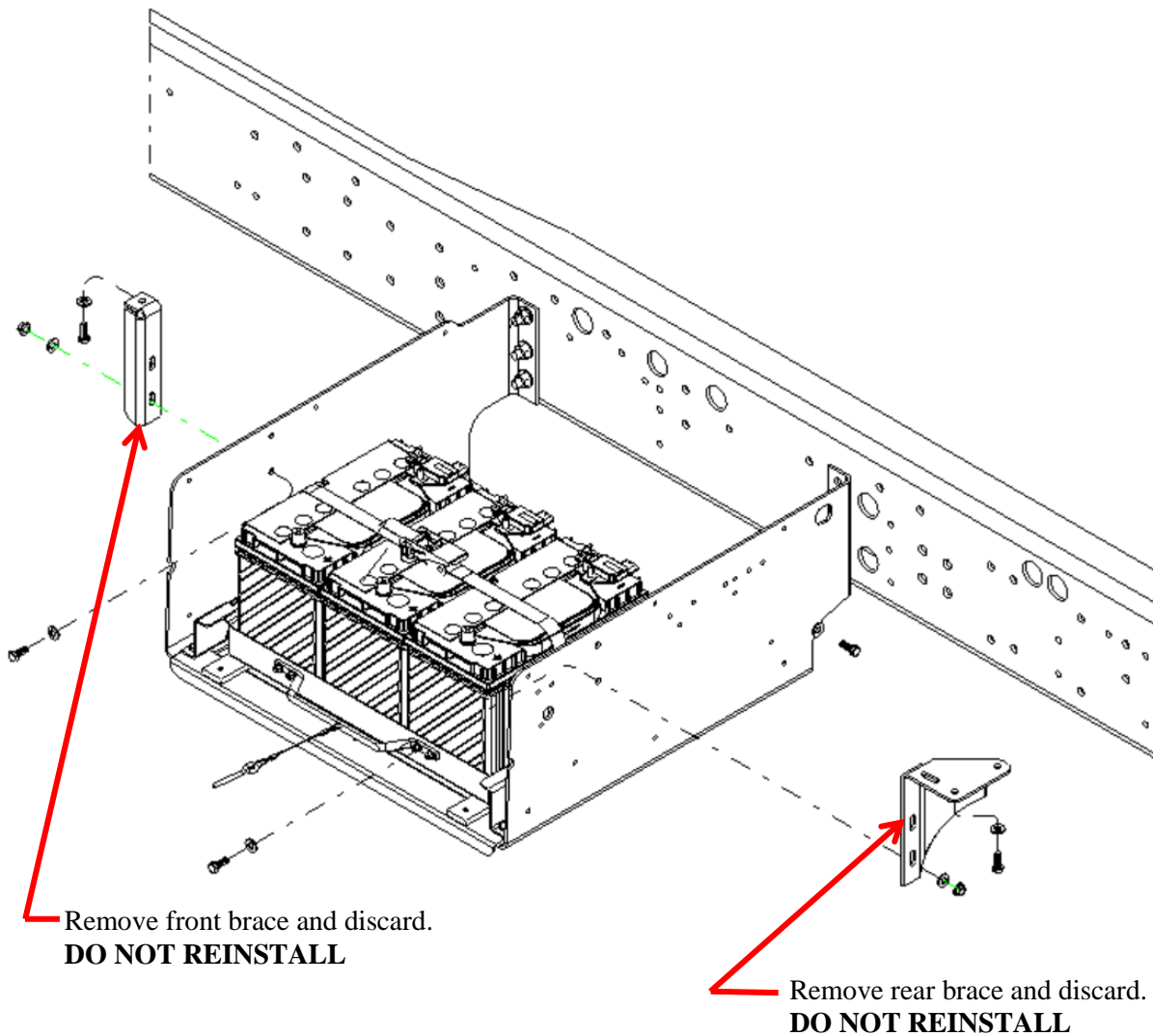


# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR A

1. Park bus on level surface, apply parking brake, turn off ignition key, and chock wheels.
2. Disconnect Batteries.
3. Remove the front and rear braces and discard. **DO NOT REINSTALL.**
4. No further action required. Reconnect batteries and place back in service.



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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

# RECALL

## REPAIR B

### REINFORCEMENTS INSTALLATION

**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.

1. It is highly recommended that this repair be performed on a lift. If not on a lift, park bus on level surface, apply parking brake, turn off ignition key, and chock wheels.
2. Disconnect batteries.
3. Support the batteries and battery tray by placing jack(s) and required supports underneath the battery tray before and during the procedure.
4. Loosen the fasteners for the front and rear braces, but **DO NOT REMOVE** at this time. See Illustration on Page 7.
5. Remove and discard the front three 1/2 inch capscrews, flat washers, and locknuts that attach the front frame battery bracket to the frame rail.
6. Using a pry bar, move the front frame battery bracket toward the outside of the body approximately 1/4 inch.
7. Slide the front (LH) reinforcement bracket 10054519 between the outside of the frame rail and the front frame battery bracket. Align holes and install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of front frame battery bracket, and new 1/2 inch locknuts 00850800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
8. Using the new reinforcement bracket as a guide, drill six (6) 3/8 inch diameter holes. Use a drill set stop collar or shield on the inside next to the batteries and cables to prevent damages to batteries and/or cables. **DO NOT DRILL** through batteries and/or battery cables.
9. Install six (6) 3/8 inch capscrews 00559195, flat washers 01107085, and flange locknuts 00543934. Install one (1) 1/4 inch capscrew 00870477, flat washer 01991108, and locknut 02001345. Torque 3/8 inch to 29 to 33 Ft. Lbs. and the 1/4 inch to 96 to 108 In. Lbs.

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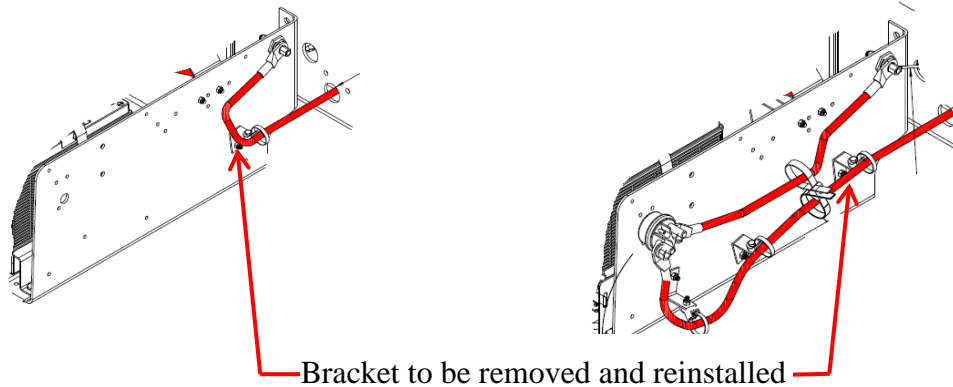
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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR B



Rear Frame Battery without  
Battery Disconnect Switch

Rear Frame Battery with Battery  
Disconnect Switch

10. On rear frame battery bracket, remove the bracket that supports the battery cable and discard fasteners.
11. Remove and discard the rear three 1/2 inch capscrews, flat washers, and locknuts that attach the rear frame battery bracket to the frame rail.
12. Using a pry bar, move the rear frame battery bracket toward the outside of the body approximately 1/4 inch.
13. Slide the rear (RH) reinforcement bracket 10054518 between the outside of the frame rail and the rear frame battery bracket. Align holes and install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of rear frame battery bracket, and new 1/2 inch locknuts 00850800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
14. Using the new reinforcement bracket as a guide, drill five (5) 3/8 inch diameter holes. Use a drill set stop collar or shield on the inside next to the batteries and cables to prevent damages to batteries and/or cables. **DO NOT DRILL** through batteries and/or battery cables.
15. Install five (5) 3/8 inch capscrews 00559195, flat washers 01107085 and flange locknuts 00543934. Install two (2) 1/4 inch capscrews 00870477, flat washers 01991108, and locknuts 02001345. Torque 3/8 inch to 29 to 33 Ft. Lbs. and the 1/4 inch to 96 to 108 In. Lbs.
16. Reinstall the rear battery cable support bracket that was removed in Step 10; use new 1/2 inch fasteners for attaching the battery cable bracket to the rear of the box.
17. **IMPORTANT:** After the front and rear reinforcements have been installed and all the fasteners torqued, remove and discard both front and rear braces that were loosened in Step 4. **DO NOT REINSTALL** front and rear braces.
18. Remove battery tray supports, reconnect batteries, and place bus back in service.

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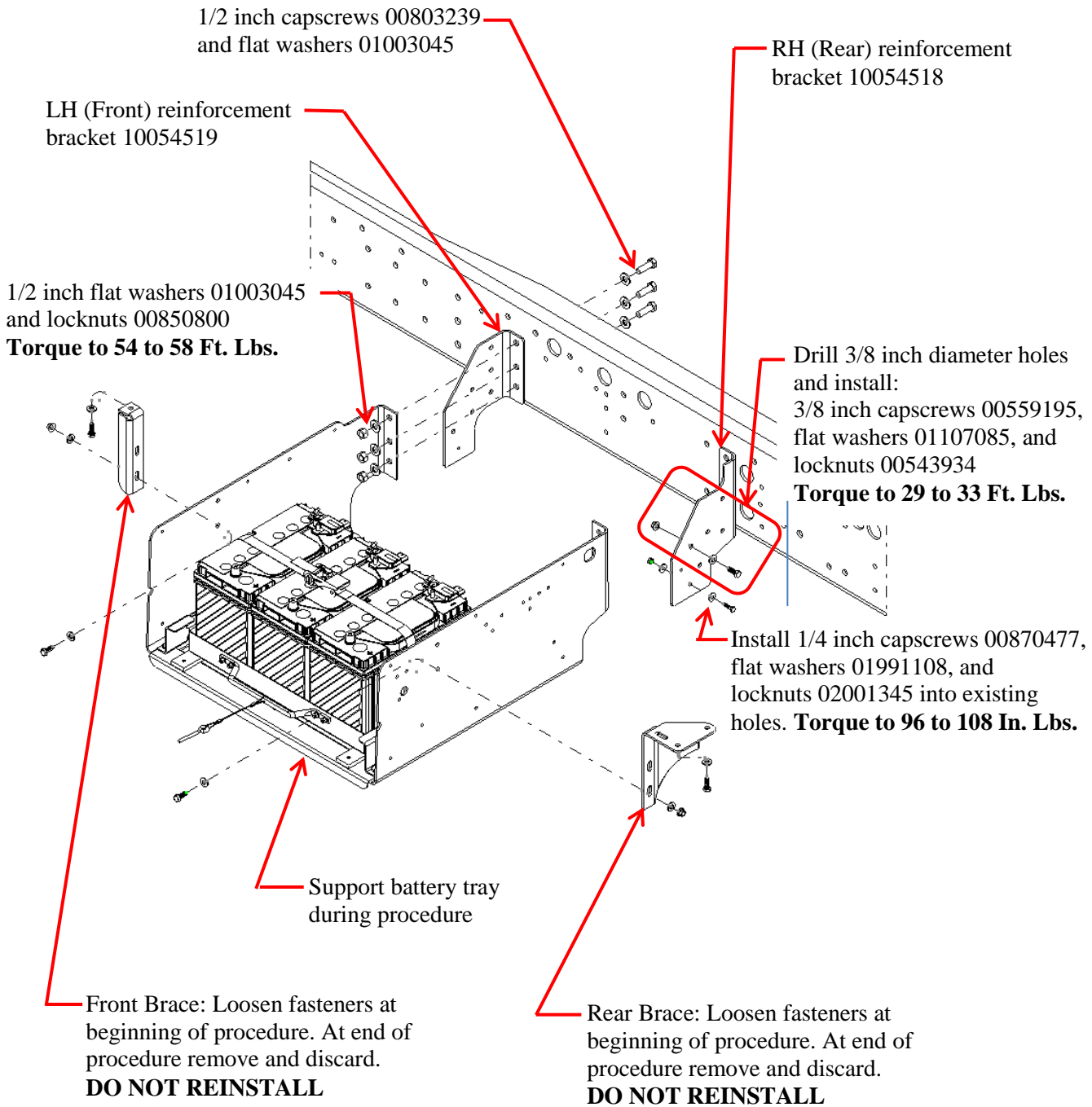


# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

# RECALL

## REPAIR B

### REINFORCEMENTS INSTALLATION



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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

# RECALL

## REPAIR C

### INSTALL REINFORCEMENTS AND FRONT BATTERY BOX FRAME MOUNTING BRACKET

**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.

1. It is highly recommended that this repair be performed on a lift. If not on a lift, park bus on level surface, apply parking brake, turn off ignition key, and chock wheels.
2. On the bench, assembly install new high strength steel front frame battery bracket 10049663 and front (LH) reinforcement bracket 10054519 together with two (2) 1/2 inch capscrews 00803239 and standard nuts (not included in kit) and tighten nuts.
3. Using the front (LH) reinforcement bracket 10054519 as a guide, drill six (6) 3/8 inch diameter holes.
4. Install six (6) 3/8 inch capscrews 00559195, flat washers 01107085, and flange locknuts 00543934. Install one (1) 1/4 inch capscrew 00870477, flat washer 01991108, and locknut 02001345. Leave all fasteners loose; do not torque until assembly has been installed on the chassis.
5. Remove two (2) 1/2 inch capscrews 00803239 and standard nuts (not included in kit) nuts. Reuse two (2) 1/2 inch capscrews 00803239 to install assembly to frame rail.

### BENCH ASSEMBLY



Temporary install two 1/2 inch capscrews with standard nuts and tighten. Drill six 3/8 inch diameter holes using the reinforcement as guide.



Install all the fasteners attaching the reinforcement to the front frame battery bracket and leave loose until installed onto chassis frame.

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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR C (Front)

### INSTALL REINFORCEMENTS AND FRONT BATTERY BOX FRAME MOUNTING BRACKET

6. Disconnect batteries.
7. Support the batteries and battery tray by placing jack(s) and required supports underneath the battery tray before and during the procedure.
8. Loosen the fasteners for the front and rear braces. Remove and discard front brace, **DO NOT REINSTALL**. See Illustration on Page 10. Do Not Remove rear brace at this time. See Illustration on Page 12.
9. Remove and discard the front three 1/2 inch capscrews, flat washers, and locknuts that attach the front frame battery bracket to the frame rail.
10. Remove and discard the 3/8 inch nuts that attach battery tray to the front frame battery bracket.
11. Remove the rubber pins that attach the top to the front frame battery bracket.
12. If the bus has an optional closeout, remove and retain fasteners for the close out to front frame battery bracket.
13. Remove the existing front frame battery bracket and install new high strength steel front frame battery bracket assembly from Steps 2, 3, and 4 above. Install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of front frame battery bracket, and new 1/2 inch locknuts 00850800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
14. Torque 3/8 inch to 29 to 33 Ft. Lbs. and the 1/4 inch to 96 to 108 In. Lbs.
15. Attach battery tray to front frame battery bracket and install new 3/8 inch locknuts 00543934. Torque 3/8 inch to 29 to 33 Ft. Lbs.
16. If the bus has an optional closeout, reinstall retained fasteners for the close out to front frame battery bracket.
17. Attach top to front frame battery bracket with rubber pin 01160399.

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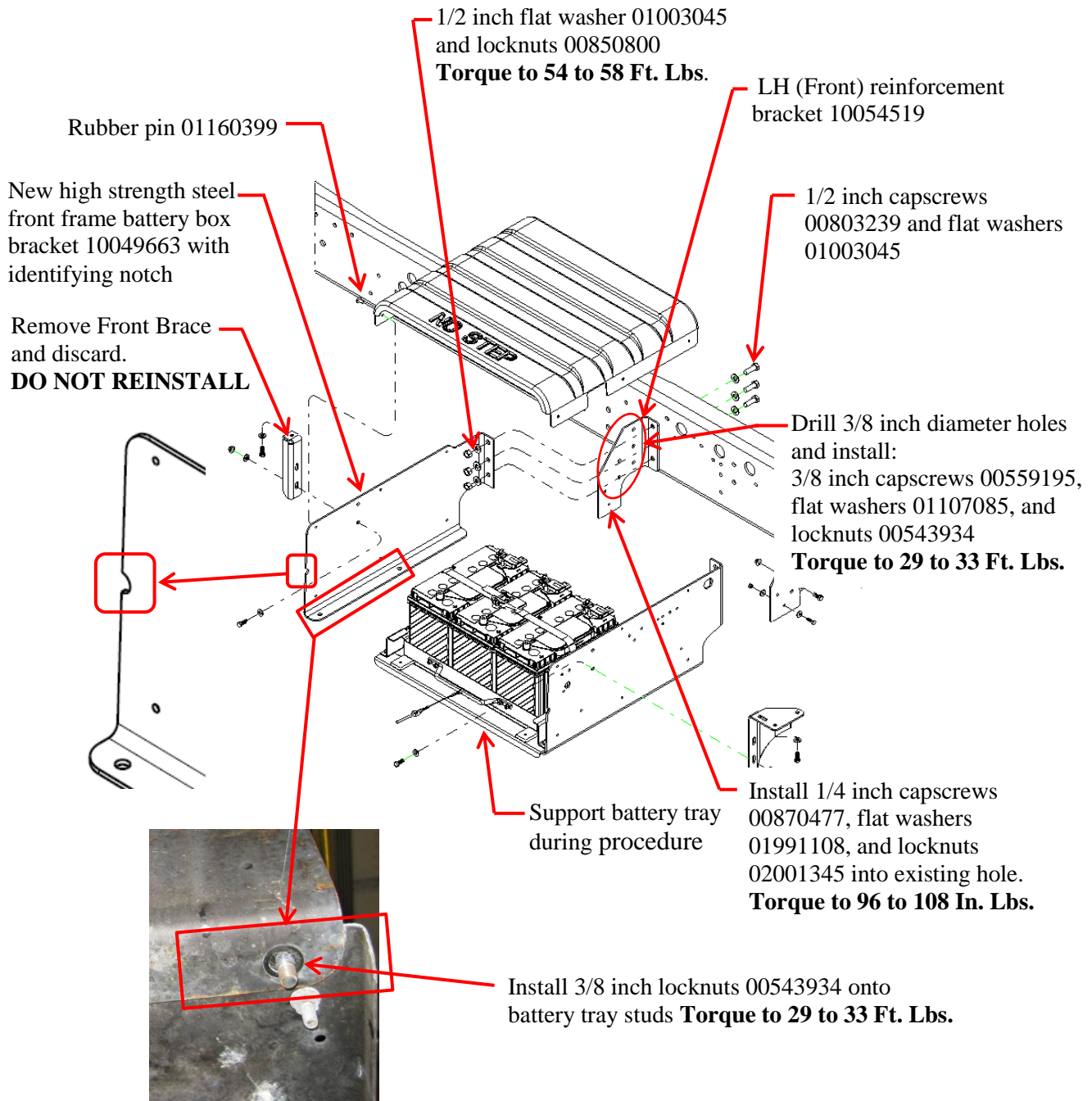


# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR C (Front)

### INSTALL FRONT REINFORCEMENT AND FRONT BATTERY BOX FRAME MOUNTING BRACKET



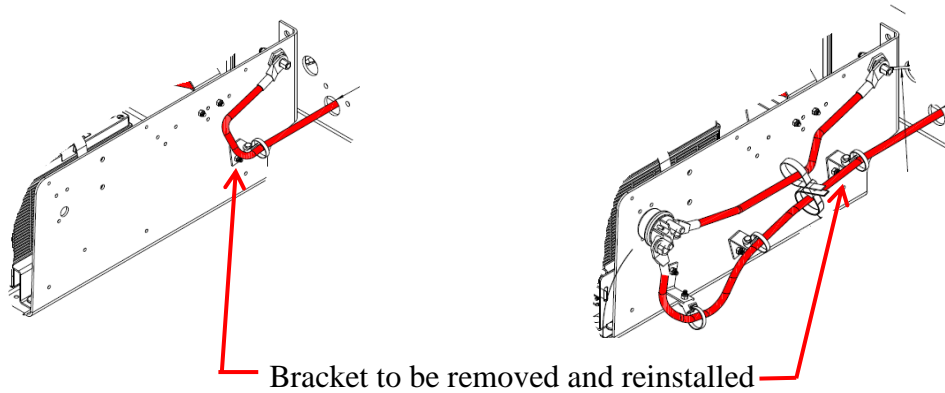
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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR C (Rear)



Rear Frame Battery without  
Battery Disconnect Switch

Rear Frame Battery with  
Battery Disconnect Switch

18. On rear frame battery bracket, remove the bracket that supports the battery cable and discard fasteners.
19. Remove and discard the rear three 1/2 inch capscrews, flat washers, and locknuts that attach the rear frame battery bracket to the frame rail. See Illustration on Page 12.
20. Using a pry bar, move the rear frame battery bracket toward the outside of the body approximately 1/4 inch.
21. Slide the rear (RH) reinforcement bracket 10054518 between the outside of the frame rail and the rear frame battery bracket. Align holes and install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of rear frame battery bracket, and new 1/2 inch locknuts 00850800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
22. Using the new reinforcement bracket as a guide, drill five (5) 3/8 inch diameter holes. Use a drill set stop collar or shield on the inside next to the batteries and cables to prevent damages to batteries and/or cables. **DO NOT DRILL** through batteries and/or battery cables.
23. Install five (5) 3/8 inch capscrews 00559195, flat washers 01107085, and flange locknuts 00543934. Install two (2) 1/4 inch capscrews 00870477, flat washers 01991108, and locknuts 02001345. Torque 3/8 inch to 29 to 33 Ft. Lbs. and the 1/4 inch to 96 to 108 In. Lbs.
24. Reinstall the rear battery cable support bracket that was removed in Step 15; use new 1/4 inch fasteners for attaching the battery cable bracket to the rear of the box.
25. After the front and rear reinforcements have been installed and all the fasteners torqued, remove and discard rear brace that was loosened in Step 8. **DO NOT REINSTALL** front and rear braces.
26. Remove battery tray supports, reconnect batteries and place bus back in service.

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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR C (Rear)

### INSTALL REINFORCEMENTS AND FRONT BATTERY BOX FRAME MOUNTING BRACKET

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1/2 inch flat washers 01003045 and locknuts 00850800  
**Torque to 54 to 58 Ft. Lbs.**

1/2 inch capscrews 00803239 and flat washers 01003045  
(Note: Same fasteners for both front and rear)

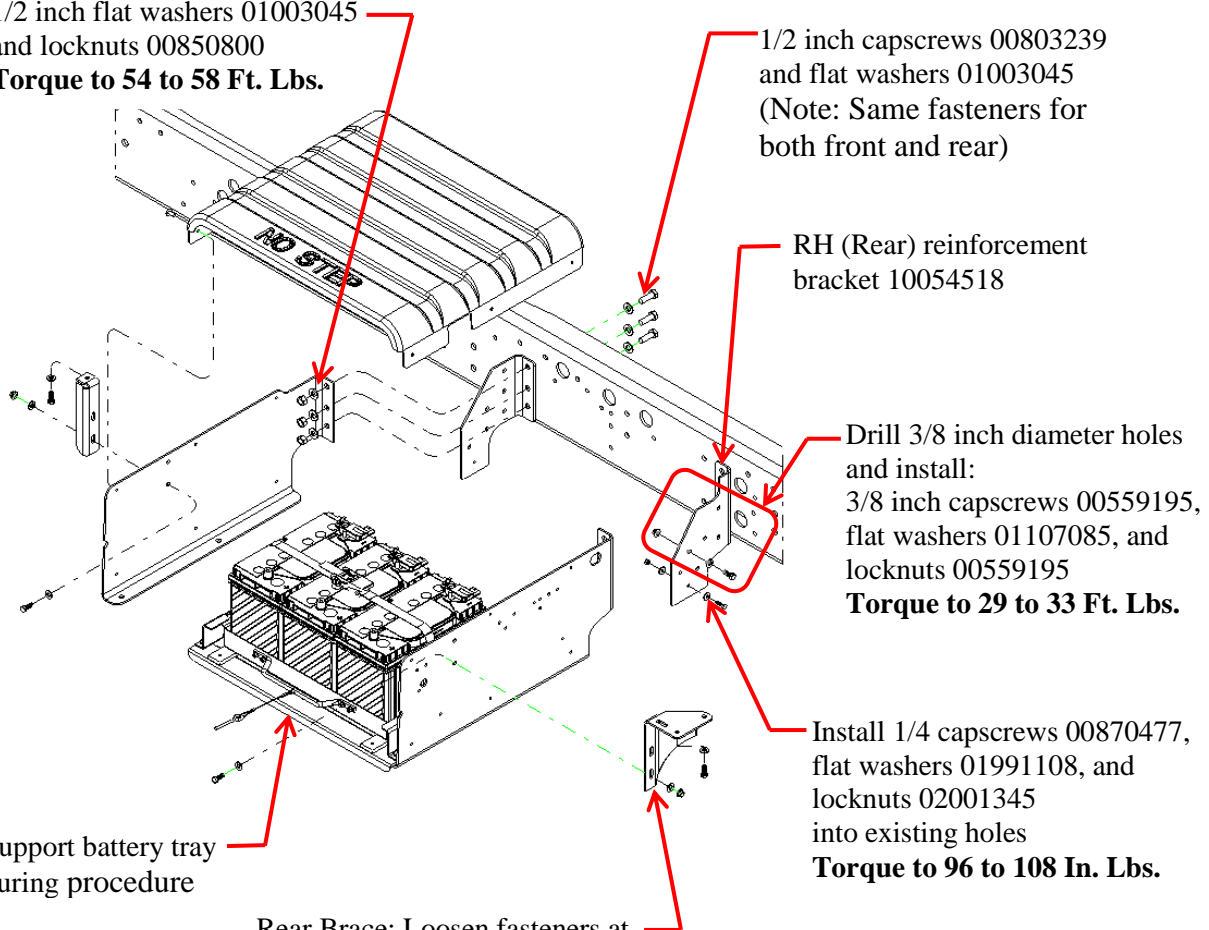
RH (Rear) reinforcement bracket 10054518

Drill 3/8 inch diameter holes and install: 3/8 inch capscrews 00559195, flat washers 01107085, and locknuts 00559195  
**Torque to 29 to 33 Ft. Lbs.**

Install 1/4 capscrews 00870477, flat washers 01991108, and locknuts 02001345 into existing holes  
**Torque to 96 to 108 In. Lbs.**

Support battery tray during procedure

Rear Brace: Loosen fasteners at beginning of procedure. At end of procedure remove and discard.  
**DO NOT REINSTALL**





# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR D (Front)

### INSTALL FRONT AND REAR BATTERY BOX FRAME MOUNTING BRACKETS

**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.

1. It is highly recommended that this repair be performed on a lift. If not on a lift, park bus on level surface, apply parking brake, turn off ignition key, and chock wheels.
2. Disconnect batteries.
3. Support the batteries and battery tray by placing jack(s) and required supports underneath the battery tray before and during the procedure.
4. Loosen the fasteners for the front and rear braces but **DO NOT REMOVE** at this time. See Illustration on Page 15.
5. Remove and discard the front three 1/2 inch capscrews, flat washers, and locknuts that attach the rear frame battery bracket to the frame rail.
6. Remove and discard the two nuts that attach the front frame battery bracket to the battery tray.
7. Remove the rubber pins that attach the top to the front frame battery bracket.
8. Remove the front brace and discard. **DO NOT REINSTALL** front brace.
9. If the bus has an optional closeout, remove fasteners for the closeout that attach to the front bracket.
10. Remove the existing front frame battery bracket and replace with new high strength steel frame battery bracket 10049663. NOTE: New front high strength steel frame battery bracket 10049663 has a **notch** on the outer edge to identify the new high strength bracket and the old bracket does not. Align holes and install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of new high strength front frame battery bracket, and new 1/2 inch locknuts 00580800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
11. Install new 3/8 inch locknuts 0054934 on the studs that attach the tray to the new bracket. Torque 3/8 to 29 to 33 Ft. Lbs.
12. Install the rubber pins 01160399 that attach the top front bracket.
13. If the bus has an optional closeout, install the fasteners for the closeout that attach to the front bracket.

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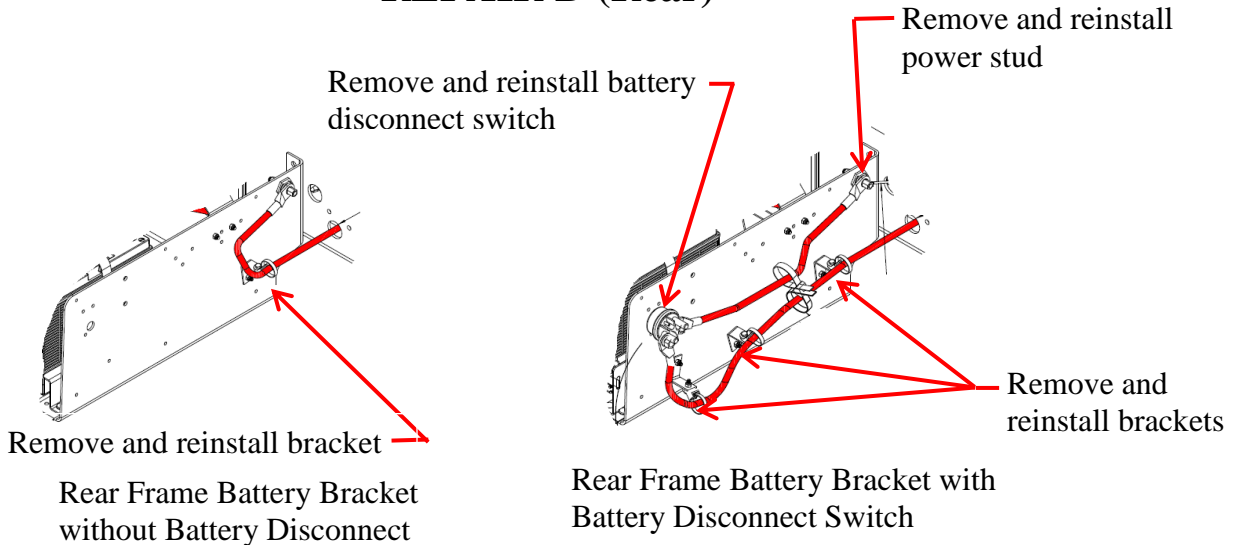
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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR D (Rear)



14. On rear frame battery bracket, remove the all the brackets that supports the battery cables. Remove all additional electrical components such as battery disconnect switch and power stud.
15. Remove and discard the rear three 1/2 inch capscrews, flat washers, and locknuts that attach the rear frame battery bracket to the frame rail. See Illustration on Page 15.
16. Remove and discard the two nuts that attach the rear frame battery bracket to the battery tray.
17. Remove the rubber pins that attach the top to the rear frame battery bracket.
18. Remove the rear brace and discard. **DO NOT REINSTALL** rear brace.
19. If the bus has an optional closeout, remove fasteners for the closeout that attach to the front bracket.
20. Remove the existing rear frame battery bracket and replace with new rear high strength frame battery bracket 10049664. NOTE: New rear high strength frame battery bracket 10049664 has a notch on the outer edge to identify the new high strength bracket and the old bracket does not. Align holes and install new 1/2 inch capscrews 00803239, new hardened flat washers 01003045 on the inside of frame rail and inside of rear high strength frame battery bracket, and new 1/2 inch locknuts 00850800. Torque 1/2 inch to 54 to 58 Ft. Lbs.
21. Install new 3/8 inch locknuts 00543934 on the studs that attach the tray to the new bracket. Torque 3/8 to 29 to 33 Ft. Lbs.
22. Install the rubber pins 0116039 that attach the top front bracket.
23. If the bus has an optional closeout, install the fasteners for the closeout that attach to the front bracket.
24. Reinstall after new frame battery bracket has been installed. Recoat any battery cable that has been removed with protective electrical coating. Remove battery tray supports, reconnect batteries and place bus back in service.

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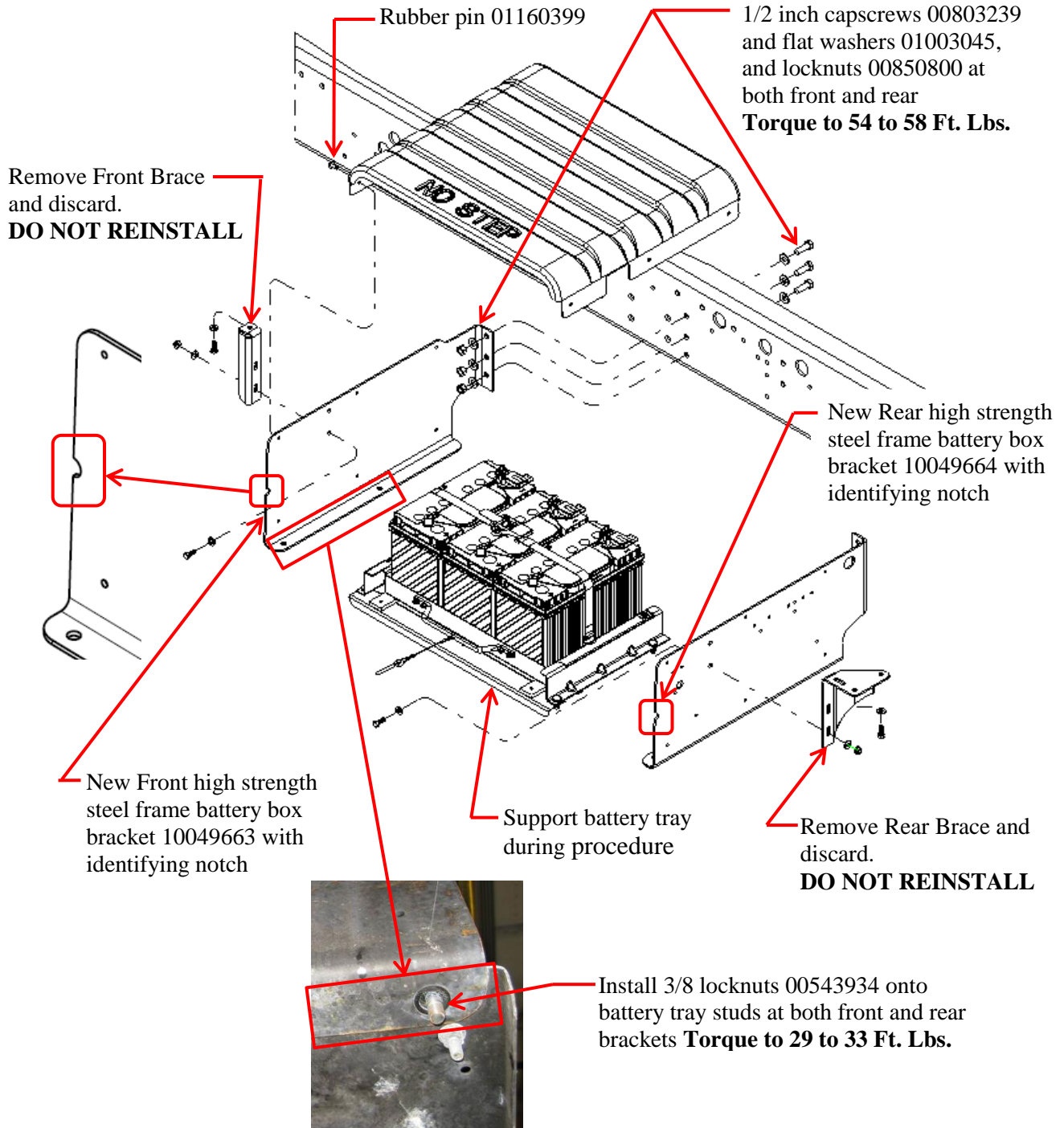


# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## REPAIR D

### INSTALL FRONT AND REAR BATTERY BOX FRAME MOUNTING BRACKETS



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**VISION CHASSIS MOUNTED  
BATTERY BOX SUPPORT**

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**PARTS LIST 1: REINFORCEMENT KIT  
REPAIR B**

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	10054518	BRACKET, MTG, BATT BOX, FRAME,HD, RH	1
2	10054519	BRACKET, MTG, BATT BOX, FRAME,HD, LH	1
3	00803239	CAPSCREW, HEX HD, 1/2-13 X 1.50,GR8,YEL ZN	6
4	01003045	WASHER,FLAT,17/32 X 1 1/16 X 7/64 HDN, BLKZN	12
5	00850800	NUT, HEX, 1/2 -13 , LOCK,CADWAX	6
6	00559195	CAPSCREW, HEX HD ,3/8-16 x 1, GR 8, YEL ZN DICH	11
7	01107085	WASHER, FLAT, 13/32 x 13/16 x 3/32, HDN BLK ZN	11
8	00543934	NUT,HEX HD, 3/8-16, ZINC, LG FLG LK, YEL ZNDICH	11
9	00870477	CAPSCREW, HEX HD ,1/4-20 x 1, GR 8, YEL ZN DICH	3
10	01991108	WASHER, FLAT, 17/64 x 1, GR 8, YEL ZN DICH	6
11	02001345	NUT,HEX HD, .25-20, LOCKING,YEL ZN DICH	3

**PARTS LIST 2: REINFORCEMENT KIT AND FRONT BRACKET  
REPAIR C**

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	10054518	BRACKET, MTG, BATT BOX, FRAME,HD, RH	1
2	10054519	BRACKET, MTG, BATT BOX, FRAME,HD, LH	1
3	00803239	CAPSCREW, HEX HD, 1/2-13 X 1.50,GR8,YEL ZN	6
4	01003045	WASHER,FLAT,17/32 X 1 1/16 X 7/64 HDN, BLKZN	12
5	00850800	NUT, HEX, 1/2 -13 , LOCK,CADWAX	6
6	00559195	CAPSCREW, HEX HD ,3/8-16 x 1, GR 8, YEL ZN DICH	11
7	01107085	WASHER, FLAT, 13/32 x 13/16 x 3/32, HDN BLK ZN	11
8	00543934	NUT,HEX HD, 3/8-16, ZINC, LG FLG LK, YEL ZNDICH	13
9	10049663	BRACKET, MTG,BATT BOX,FRAME,HD,FRONT	1
10	01160399	PIN, RATCHET,TYPE ONE, RUBBER PAD, PC 47486	4
11	00870477	CAPSCREW, HEX HD ,1/4-20 x 1, GR 8, YEL ZN DICH	3
12	01991108	WASHER, FLAT, 17/64 x 1, GR 8, YEL ZN DICH	6
13	02001345	NUT,HEX HD, .25-20, LOCKING,YEL ZN DICH	3

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# VISION CHASSIS MOUNTED BATTERY BOX SUPPORT

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## PARTS LIST 3: REPLACE FRONT AND REAR BRACKETS REPAIR D

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	10049663	BRACKET, MTG,BATT BOX,FRAME,HD,FRONT	1
2	10049664	BRACKET, MTG,BATT BOX,FRAME,HD,REAR	1
3	00803239	CAPSCREW, HEX HD, 1/2-13 X 1.50,GR8,YEL ZN	6
4	01003045	WASHER,FLAT,17/32 X 1 1/16 X 7/64 HDN, BLKZN	12
5	00850800	NUT, HEX, 1/2 -13 , LOCK,CADWAX	6
6	01160399	PIN, RATCHET,TYPE ONE, RUBBER PAD, PC 47486	7
7	00543934	NUT,HEX HD, 3/8-16, FLG, LOCK, YELZN	4

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