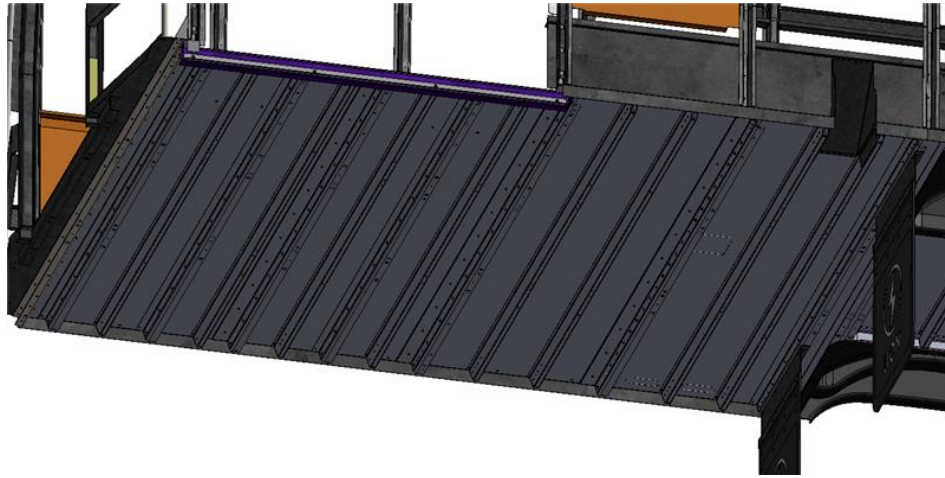



RETROFIT

WHEELCHAIR LIFT FLOOR REINFORCEMENT



RETROFIT: RETRO – 0095
Instruction: N/A
EPN:0713-00

	 LION		
Date:	2020-11-25	Version:	01
Subject:	RETROFIT: RETRO – 0095		
Year / Make / Models affected:	2016 -02019 Lion LionC/Lion360	NHTSA Recall#:	20V-697
Problem:	The wheelchair anchors had torn the floor beam when we passed the CMVSS 222.		
Remedy:	Structural rivets need to be added to stiffener the beam and pass the CMVSS 222.		

VALIDATION REVISION: 01		
Engineering Manager	Service Manager	Quality Manager
Maxime Dupras	Mykaël Lemelin	Guy Lecompte

Table of Contents

LISTE OF EQUIPMENT:..... 3

LISTE OF TOOLS : 3

1. FLOOR REINFORCEMENT..... 4

RELEVANT MANAGER..... 5

REVISION HISTORY 5

LISTE OF EQUIPMENT:

Option 1 (Rivet):




Lion PN	Description	Quantity
14810730	Rivet Huck Magna Bulb, Steel Zinc, ID 1/4", Grip R 0,229-0,308" Code Dark Green	112

Option 2 (Bolt and Nut):




Lion PN	Description	Quantity
14802478	Hex flanged bolt, 3/8-16 X 1 in, zinc clear, G5	112
14800516	Hex flanged lock nut, 3/8-16, zinc clear, G5, Nylon insert	112

LISTE OF TOOLS :

Option 1 (Rivet):

Item	Description	Image
A	Drill 90°	
B	Drill bit F	
C	90° riveter 1/4	

Option 2 (Bolt and Nut):

Item	Description	Image
A	Drill 90°	
B	Drill bit 25/64"	
C	Socket 1/2"	

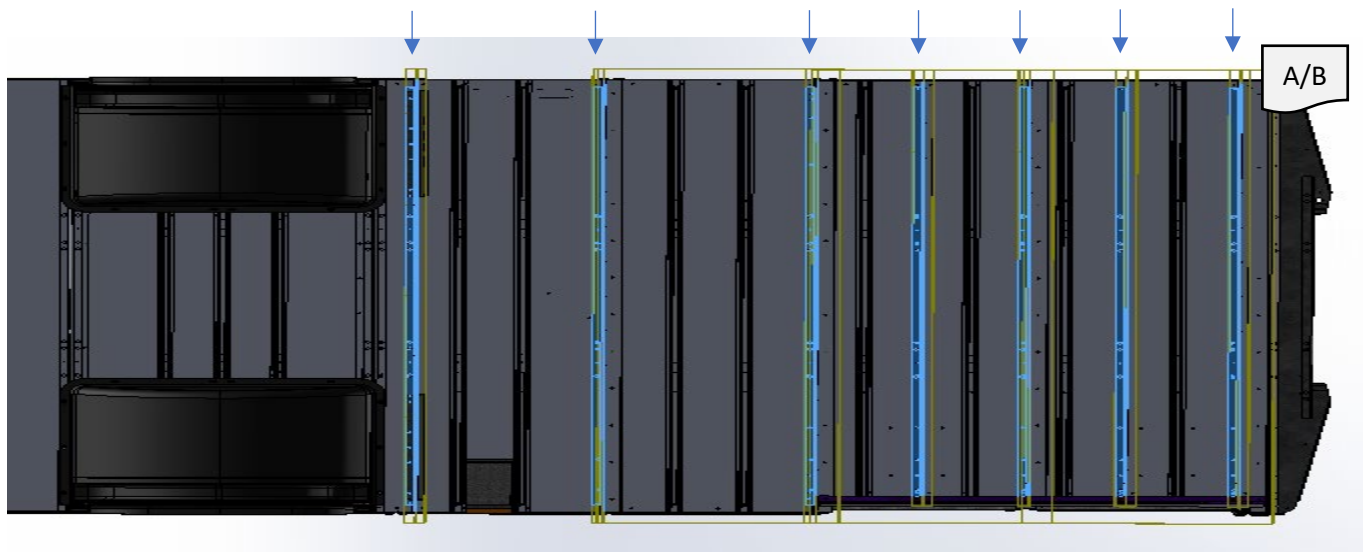
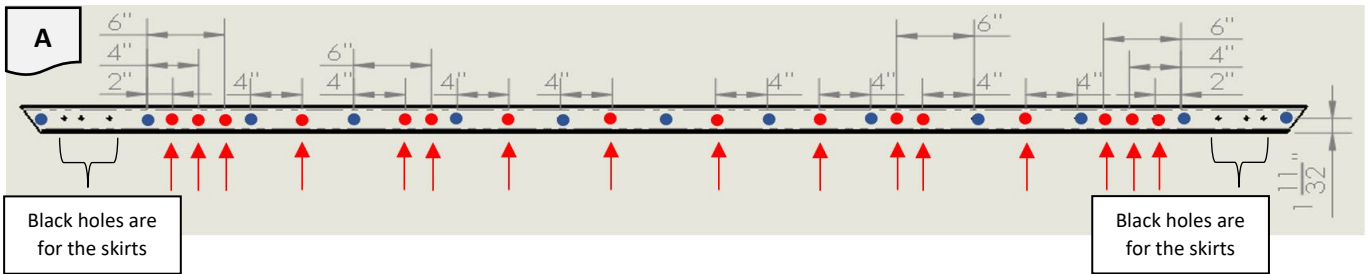
1. FLOOR REINFORCEMENT

If necessary, remove the heating system :

1. Remove exhaust from under the unit
2. Remove coolant hose (2)
3. Remove diesel lines (2)
4. Remove electrical connector (5)
5. Remove the system from his brackets

Option 1 (Rivet):

A	Drill 16 holes with drill bit F at the locations identified by red dots and arrows and at 1 11/32" from the bottom of the C channel. The blue dots represent the rivets already on the C channel.
B	Install 16 1/4 rivets (14810730) on each C channel (7) behind the wheelhouses.
Option 2 (Bolt and Nut):	
A	Drill 16 holes with drill bit 25/64" at the locations identified by red dots and arrows and at 1 11/32" from the bottom of the C channel. The blue dots represent the rivets already on the C channel.
B	Install 16 bolts 3/8-16 (14802478) and nuts 3/8-16 (14800516) on each C channel (10) identified below. Apply a torque of 31 ft-lbs in dry condition.



OPTION 1
14810730 (16x) on each C channel

OPTION 2
14802478 (16x) and 14800516 (16x)
on each C channel

Relevant Manager

Name	Email	Title	Comments
Noel Filho	noel.filho@thelionelectric.com	Tech. Genie Mécanique	
Maxime Dupras	maxime.dupras@thelionelectric.com	Lead engineer - MFG	

Revision History

Rev 00 – 22-06-20 Révision Initiale

Rev 01 – 14-08-20 Add six (6) holes and rivets/bolts to the floor's C channels