



# Recall Service Bulletin



## Recall Service Bulletin RSB23-330-001

**DATE:** 10/25/2023

**APPLIES TO:** This service bulletin applies to certain 2021 through 2024 model year, Gladiator, Metro Star, FC-94, KME Panther, and KME Predator model emergency response chassis cabs built between June 2022 and September 2023.

**NHTSA/TC Id:** 23V-631/TC Id: 2023-512

**CONDITION:** Potential delay in the park brake setting after park brake valve is activated.

**CORRECTION:** Inspect and replace the inversion valve if qualified.

**LABOR ALLOCATION:** 0.5 hour Inspection  
0.5 hour Replacement

**CLASSIFICATION:** V3

**PARTS NEEDED:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	1617-MM5	Inversion Valve

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



## Recall Service Bulletin



**Recall Service Bulletin  
RSB23-330-001**

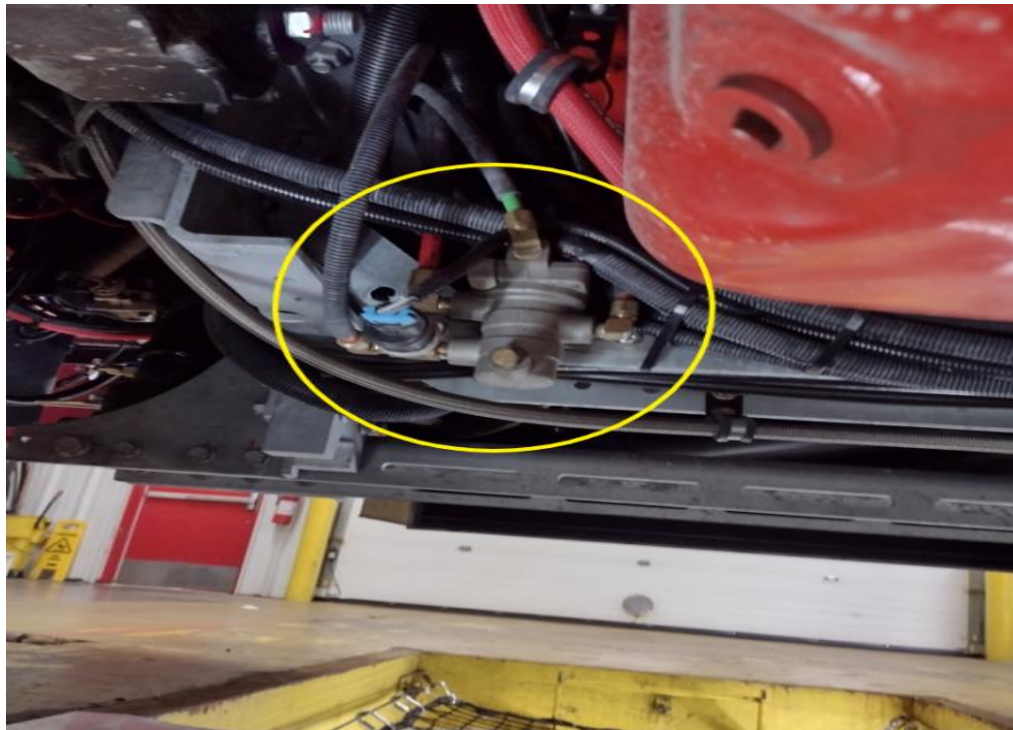
### **GENERAL INSTRUCTIONS:**

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Fire, LLC. Customer & Product Support Group (1-800-867-6478)

All applicable industry safety standards must be followed when performing work identified in this procedure.

### **Step By Step Instructions**

- 1) Ensure vehicle park brakes are set and chock the wheels.
- 2) Locate inversion valve under truck mounted to the crossmember in front of the engine on the driver's side. (See Figure 2.1)



**Figure 2.1**

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



## Recall Service Bulletin



### Recall Service Bulletin RSB23-330-001

- 3) Inspect metallic tag attached to the body of the inversion for a green mark.  
(See Figure 2.2)
  - a) If a green mark is present, the inversion valve does not require replacement. Please notify Spartan Fire of the presence of the green mark so the vehicle records can be updated. No further action is required.
  - b) If green mark is not present, inversion valve must be replaced. Please contact Rev Fire Parts to procure a certified valve with the green mark. Do not source valve locally. Replacement must be certified from Rev Fire parts, signified by a colored mark on the ID tag. Proceed to step 4.



**Figure 2.2**

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



## Recall Service Bulletin



### Recall Service Bulletin RSB23-330-001

- 4) Label the air lines at the inversion to ensure proper re-installation.
- 5) Remove air lines from the inversion valve.
- 6) Remove the two 5/16" bolts from the inversion valve and remove the inversion valve.
- 7) Remove fittings from old inversion valve. Coat threads with new thread sealant. Install fittings into new inversion valve.
- 8) **Retain old inversion valve to return to Spartan Fire. Contact Spartan Fire LLC (1-800-867-6478) for a return shipping label.**
- 9) Install new inversion valve to cross-member using same two 5/16" bolts.
- 10) Reconnect air lines in their respective locations. (See Figure 5.1 and 6.1)
- 11) Start the engine and permit the air system to build to full governed air pressure.
- 12) Chock the wheels, release the park brake, and apply the service brakes. Check inversion valve for leaks.
- 13) If no leaks are present, the repair is complete, and the vehicle is ready for operation.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



# Recall Service Bulletin



## Recall Service Bulletin RSB23-330-001

ITEM	PART NUMBER	DESCRIPTION	QTY
1	0108-GG3-031	SW-PRESSURE N.C. 5 PSI, 1/8 NPTF	1
2	1617-MM5	VALVE-INVERSION	1
3	05180100H8xx	BOLT - 5/16-18 X 1.00LG HEX GR8 YEL	2
4	05F00SAExx	WASHER - 5/16 FLAT SAE YEL	4
5	0518LNxx	NUT - 5/16-18 LOCK YEL	2
6	0716-MM5-R02	FIT BRASS STREET TEE -4	1
7	3092-MM5-A08	MALE ELBOW SWIVEL 90°	1
8	3092-MM5-A05	MALE ELBOW SWIVEL 90°	3
9	0716-MM5-J01	FIT BRASS BUSHING 4-2	1

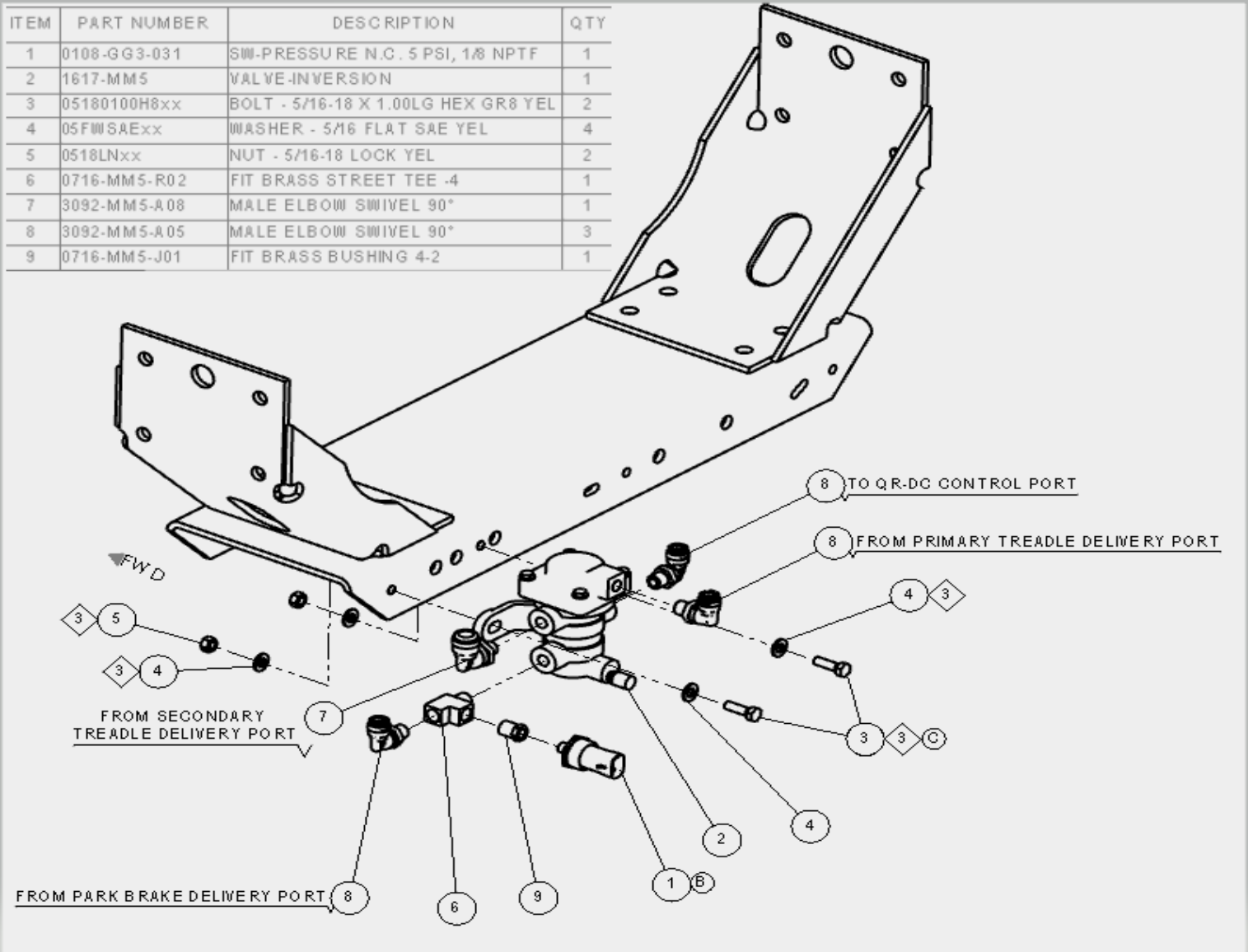


Figure 5.1

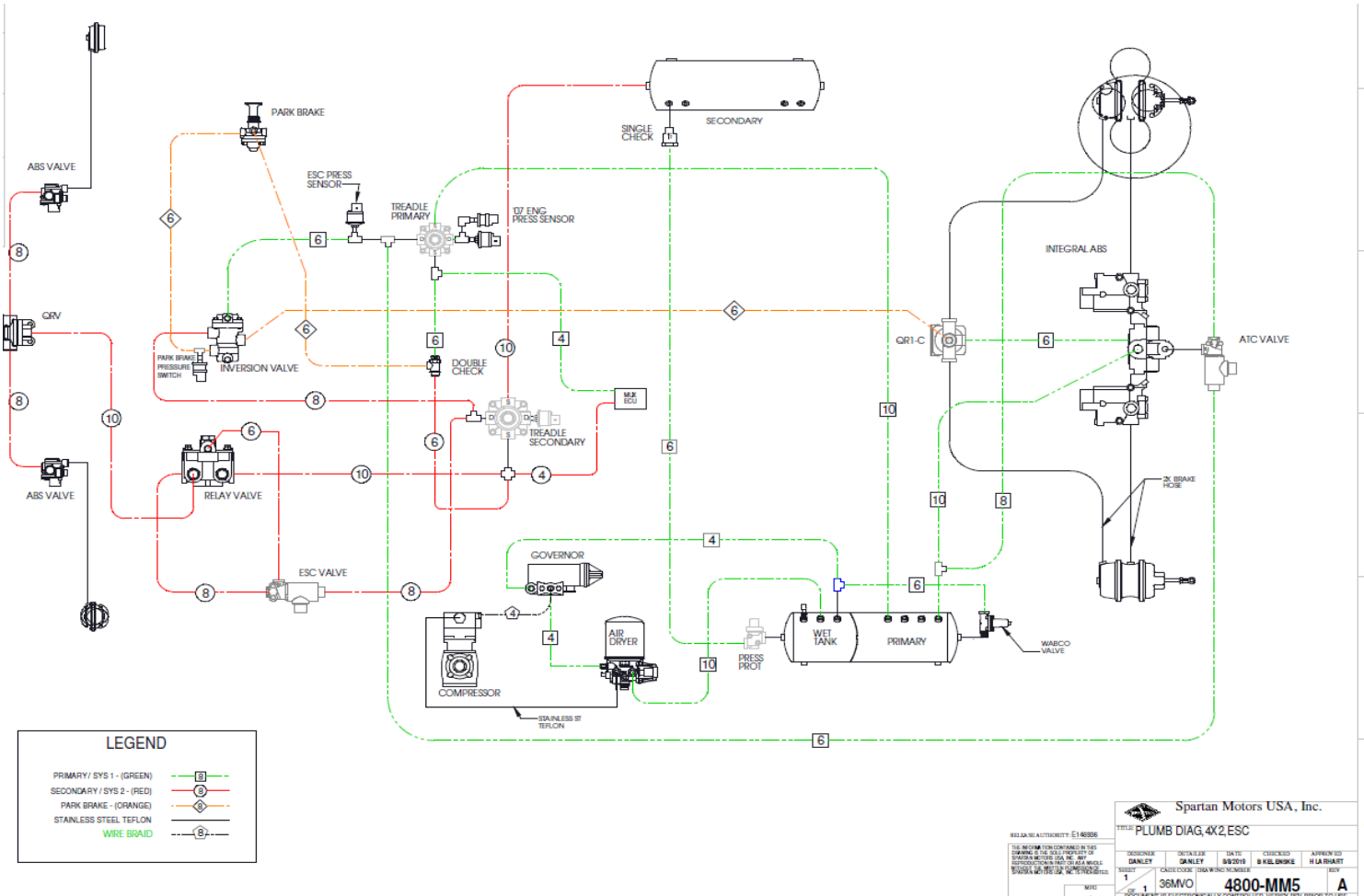
Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



# Recall Service Bulletin



## Recall Service Bulletin RSB23-330-001



Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.