

SERVICE PROCEDURE

24513
October, 2024

SUBJECT: SAFETY RECALL
Caliper mounting bolts on certain 2024 and 2025 IC Bus® CE Series school buses and Electric CE Series school buses built 08/01/2023 thru 09/03/2024 with feature codes 0004XCJ, 0004XCK, or 0004XGM.

CUSTOMER LETTER

Print ready (PDF file) copy of the [Customer Letter](#)

DEFECT DESCRIPTION

The mounting bolts that fasten the brake caliper to the caliper anchor plate may not have been tightened to their specified torque. If the caliper mounting bolts loosen and detach, reduced braking performance could occur, resulting in longer stopping distances which could increase the risk of a crash.

MODELS INVOLVED

This safety recall involves certain 2024 and 2025 IC Bus® CE Series and Electric CE Series school buses built 08/01/2023 thru 09/03/2024 with feature codes 0004XCJ, 0004XCK, or 0004XGM.

ELIGIBILITY

This procedure applies ONLY to vehicles marked in the International® Service PortalSM with Safety Recall 24513. Also complete any other open campaigns listed on the Service Portal at this time.

TOOLS REQUIRED

Description	Tool Number
Air Disc Caliper Wrench	04-617-02

Table 1 Tools Required

PARTS INFORMATION

Part Number	Part Description	Quantity
30091R1	Bolt HH, M20 X 60 PHC CLS	As Required
30179R1	Washer, 21.8 X 37 X 4 MM PHC	As Required

Table 2 Parts information

SERVICE PROCEDURE

WARNING! To prevent personal injury and / or death, or damage to property, NEVER service a high-voltage vehicle without completing High-Voltage Safety training. Before working on vehicle, read and obey High-Voltage Safety, and Lock-Out Tag-Out safety procedures and information.

WARNING! To prevent personal injury and / or death, wear and use approved high-voltage Personal Protective Equipment (PPE) when near a high-voltage electric vehicle. Inspect PPE before use. Do not use gloves or other PPE with expired dates, holes, cracks, or damage. NEVER touch energized ORANGE high-voltage cables or high-voltage components without wearing approved high voltage PPE.

WARNING! To prevent personal injury and / or death, or damage to property, park vehicle on hard flat surface, key OFF, set the parking brake, and install wheel chocks to prevent the vehicle from moving in both directions.

WARNING! To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

WARNING! To prevent personal injury and / or death, or damage to property, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

WARNING! To prevent personal injury and / or death, or damage to property, if the vehicle must be raised, do not work under the vehicle supported only by jacks. Jacks can slip or fall over.

WARNING! To prevent personal injury and / or death, or damage to property, read all information in the Safety Information and High-Voltage Safety sections of the service manual.

1. Park vehicle on flat surface.
2. Shift transmission / drive mode selector to Park or Neutral and set parking brake.
3. Install wheel chocks.
4. To gain access to front wheel upper caliper bolts, unlatch and open hood.
5. For an Electric CE Series school bus, turn both 12V and high-voltage disconnect switches to OFF.



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Figure 1. Brake Caliper Mounting Bolts

1. Witness marking

NOTE: If brake caliper mounting bolts do not have witness marking (Figure 1, Item 1) or are loose, tighten to the specification.

NOTE: If brake caliper mounting bolts are detached, replace bolts and tighten to the specification.

6. Inspect brake caliper mounting bolts (six per caliper) for witness marking on all wheel ends:
 - a. If witness marking (Figure 1, Item 1) is present on all bolt heads and all **wheel ends**, proceed to Step 11.
 - b. If witness marking (Figure 1, Item 1) is not present on all bolt heads per wheel end, proceed to Step 7 for front axle and / or Step 8 for rear axle.

NOTE: Only the caliper bolt(s) that had no witness marking (Figure 1, Item 1) or was loose should be tightened. Vehicles will need to be lifted to have enough clearance for bolt tightening.

7. If a caliper bolt on front wheels is found without a witness marking or with a loose or detached bolt, raise vehicle and support with jack stands. Refer to Technician Manual for instructions.
 - a. Using a torque wrench with Air Disc Caliper Wrench 04-617-02, tighten all affected brake caliper mounting bolts to 350 lb-ft (475 N·m).
 - b. Using WHITE / YELLOW permanent marker, mark brake caliper bolts after they have been tightened.
 - c. If required, repeat Steps 7a and 7b for opposite side.
 - d. Remove jack stands and lower vehicle.

NOTE: Rear wheels require removal for access prior to tightening caliper bolts.

8. If a caliper bolt on rear wheels is found without a witness marking or with a loose or missing bolt, raise vehicle and support with jack stands. Refer to Technician Manual for instructions.
 - a. Remove rear wheel assembly.
 - b. Using a torque wrench with Air Disc Caliper Wrench 04-617-02, tighten all affected brake caliper mounting bolts to 350 lb-ft (475 N·m).
 - c. Using WHITE / YELLOW permanent marker, mark brake caliper mounting bolts after they have been torqued.
 - d. If required, repeat Steps 8a through 8c for opposite side.

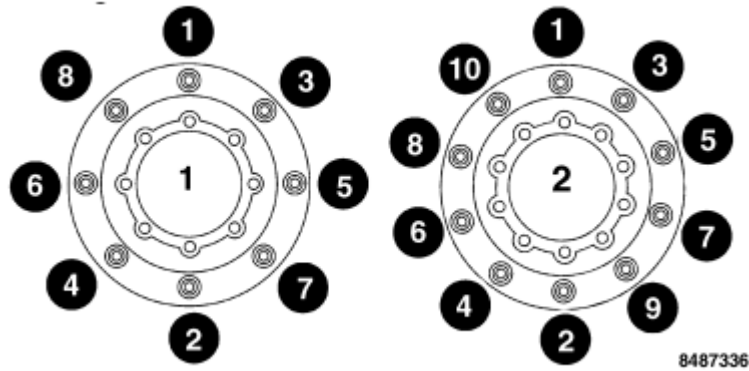


Figure 2. Flange Stud Mounts

1. Flange stud mount – 8 stud
2. Flange stud mount – 10 stud

- e. If required, install rear wheels and using torque wrench, tighten lug nuts (Figure 2, Items 1 or 2) to 450–500 lb-ft (610–678 N·m).
 - f. Remove jack stand and lower vehicle.
9. For Electric CE Series school bus, turn both 12V and high-voltage disconnect switches ON.
 10. Close and latch hood.
 11. Remove wheel chocks.

END OF SERVICE PROCEDURE

LABOR INFORMATION

Operation Number	Description	Time
A40-24513-1	Inspection Only, All Wheels	0.3 hrs
A40-24513-2	Raise and Support Front of Vehicle	0.1 hrs
A40-24513-3	Raise and Support Vehicle and Remove Rear Wheels	0.2 hrs
A40-24513-4	Isolation for Electric CE Series School Bus	0.1 hrs
A40-24513-5	Torque Brake Caliper Mounting Bolts, Each Wheel	0.1 hrs

Table 3 Labor Information

CAMPAIGN IDENTIFICATION LABEL

Each vehicle corrected in accordance with this campaign must be marked with a CTS-1075 Campaign Identification Label.

Complete the label and attach on a clean surface next to the vehicle identification number (VIN) plate.



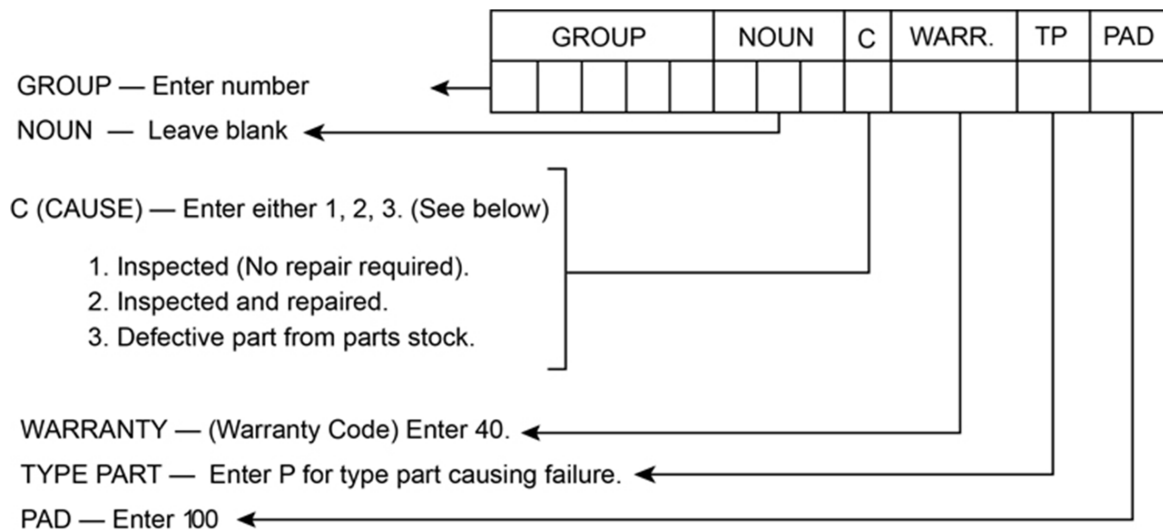
ADMINISTRATIVE / DEALER RESPONSIBILITIES

WARRANTY CLAIMS

Warranty claim expense is to be charged to Warranty. Claims are to be submitted in the normal manner, making reference to Safety Recall 24513.

Section 7 of the Warranty Policy and Procedures Manual contains further information related to the submission and processing of AFC / Recall claims.

As with all claim submissions, items acquired locally must be submitted in the “Other Charges” tab. The cost of any bulk items (such as a bag of cable tie straps, roll of wire, barrel of oil, or tube of silicone) should be prorated for the cost of the individual pieces / amount used during each repair.



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UNITED STATES AND POSSESSIONS

The National Traffic and Motor Vehicle Safety Act, as amended, provides that each vehicle that is subject to a vehicle recall campaign must be adequately repaired within a reasonable time after the owner has tendered it for repair. A failure to adequately repair within 60 days after a tender of a vehicle is prima facie evidence of failure to repair within a reasonable time. If the condition is not adequately repaired within 60 days, the owner may be entitled to replacement with an identical or reasonable equivalent vehicle at no charge, or to a refund of the purchase price less a reasonable allowance for depreciation.

Dealers must correct all vehicles subject to this campaign at no charge to the owner, regardless of mileage, age of vehicle, or ownership, from this time forward.

Dealers should proceed immediately to make necessary correction to units in inventory. All inventory vehicles subject to this recall campaign must be corrected prior to sale, transfer or delivery. If vehicles have been sold or transferred and you are in receipt of Customer Notification Letters and Authorization for Recall Service cards for those vehicles, the transfer location or customer must be notified immediately from your dealer location.

Dealers must make every effort to promptly schedule an appointment with each owner to repair his or her vehicle as soon as possible. However, consistent with the customer notification, dealers are expected to complete the repairs on the mutually agreed upon service date.

Dealers involved in the recall process will be furnished a listing of owner names and addresses to enable them to follow up with owners and have the vehicles corrected. Use of this listing must be limited to this campaign because the list may contain information obtained from state motor vehicle registration records, and the use of such motor vehicle registration data for purposes other than this campaign is a violation of law in several states.

CANADA

Dealers must correct all vehicles subject to this campaign at no charge to the owner, regardless of mileage, age of vehicle, or ownership, from this time forward.

Dealers should proceed immediately to make necessary correction to units in inventory. All inventory vehicles subject to this recall campaign must be corrected prior to sale, transfer or delivery. If vehicles have been sold or transferred and you are in receipt of Customer Notification Letters and Authorization for Recall Service cards for those vehicles, the transfer location or customer must be notified immediately from your dealer location.

Dealers must make every effort to promptly schedule an appointment with each owner to repair his or her vehicle as soon as possible. However, consistent with the customer notification, dealers are expected to complete the repairs on the mutually agreed upon service date.

Dealers involved in the recall process will be furnished a listing of owner names and addresses to enable them to follow up with owners and have the vehicles corrected. Use of this listing must be limited to this campaign because the list may contain information obtained from state motor vehicle registration records, and the use of such motor vehicle registration data for purposes other than this campaign is a violation of law in several states.

EXPORT

Export Distributors should proceed immediately to make necessary correction to units in inventory. All inventory vehicles subject to this recall campaign must be corrected prior to sale, transfer or delivery. If vehicles have been sold or transferred and you are in receipt of Customer Notification Letters and Authorization for Recall Service cards for those vehicles, the transfer location or customer must be notified immediately from your distributor location.

Export Distributors are to submit warranty claims in the usual manner making reference to this recall number.

Export Distributors are expected to provide full cooperation and follow-up with respect to this important subject matter. If you have any questions or need further assistance, please contact the Regional Service Manager at your regional office.

IC Bus, LLC.