

# VANCRAFT

VanCraft LLC

Recall Remedy Instructions

170" Models - Bench#: HBEN-002-170 (Internal ID: Bench A-2); VBEN-001 (Internal ID: Bench C)

<b>Group</b>	<b>Model</b>
Safety Recall Campaign	2014-2024 Multiple Models Listed
<b>Recall Number</b>	<b>Date</b>
24V855	December 2024

## Subject: Bench Seat Reinforcement & Seat Belt Anchor Hardware

This bulletin provides information to inspect and remedy all 2014-2024 MY 170" WB VanCraft vehicles equipped with a rear bench seating system and type-1 seatbelts. The bench seat frame and type-1 seat belts need corrected seat belt anchoring hardware, mounting reinforcements, and frame reinforcements installed to bring the bench seating system into compliance with relevant FMVSS guidelines.

MY	Model	Production Dates
2014-2023	VanCraft LWB	August 1, 2020 - November 17, 2023
2014-2023	VanCraft LWB PRO	May 8, 2023 - November 17, 2023
2023-2024	VanCraft Rover XL	November 20, 2023 - November 1, 2024
2023-2024	VanCraft Alltrek	November 20, 2023 - November 1, 2024

**Note: There is no charge to the vehicle owner for this repair. Under applicable law, you may not sell or otherwise deliver any affected vehicle until it has been repaired pursuant to the procedures set forth in this bulletin**

# VANCRAFT

## Installation Instructions: LWB/LWB PRO/Rover XL/Alltrek (170" WB) Models

Bench Model(s): HBEN-002-170 & VBEN-001 (Bench "A-2 & "C")

Required Hardware	Required Tools
2.5" long 7/16"-20 Grade 8 Bolts	Drill
2" long 7/16"-20 Grade 8 Bolts	Impact Drill
1.5" long 7/16"-20 Grade 8 Bolts	3/8" Metric Socket Set, Ratchet, Impact Attachment
7/16"-20 Grade 8 Lock Washers	14mm, 16mm Wrenches
7/16"-20 Grade 8 Washers	Vice Grips
5/16"-18 1" Thread Cutting Bolt	1/8", 5/16", 3/8", 1/2", and Step Drill Bits
5/16" Washers	#2 Phillips, #1 Phillips, T15 Impact Bits
1/2"-13 4" Grade 8 Bolts	Various Impact Bit Extensions
1/2"-13 Grade 8 Nylock Nuts	Drill lubricant
1/2" Grade 8 Washers	
3/8" Self Tapping Bolts	
Zip Ties	

Required Parts	
(1x) Brace A1	(1x) Middle A seatbelt tab reinforcement plate
(2x) Support A2	(1x) Middle C seatbelt reinforcement plate
(1x) Support A4	

# VANCRAFT

Start by removing the existing seatbelts from the benches

- If the hardware is 7/16"-20 use a 16mm wrench and socket to remove and set aside for re-installation.
- If the hardware is 3/8" use a 14mm wrench and socket to remove; you will need to discard this hardware and upgrade to 7/16"-20 Grade 8 hardware when reassembling.

## **Step 1: Disassemble Horizontal and Vertical Bench & Prep**

Use an impact drill and #2 Phillips bit to remove the screws holding the bench tops on to the bench frames. Save this hardware aside for reinstallation.

Disconnect the bench top door struts where they connect to the bench frame by easing back the retaining clip on the connection head with a small flat head screwdriver.

Remove the bench top doors and door frames.

Remove the fridge vent from the face of the kitchen base cabinet. Save this hardware aside for reinstallation.

Remove the bench drawer box from its slides by pinching the orange tabs under the box on both sides and pulling outward.

Using an impact drill and T15 torx bit, remove the screws holding the bench frames to the storage drawer cabinet face, the bench end cabinet face, bench end cabinet side, wheel well cover, and bench end cabinet rear face. There may also be T15 screws holding the back of the drawer box assembly to the bench back; remove them as well. Set this hardware aside for reinstallation.

Use diagonal cutters to clip the zip ties holding the wiring harness in place under the side facing bench as well as inside the bench end cabinet.

With the bench end cabinet free from the bench, and the wiring to the bench end cabinet utility free from zip tie holders, move the bench end cabinet as far forward as possible allowing room to remove the drawer box and bench face from the front under the front facing bench.

**Note:** For Alltrek or LWB PRO units that have a water heater and/or Inverter charger installed under the bench: It may be necessary to detach these items so they can be moved out of the way of the reinforcement bars installed later on.

# VANCRAFT

## Step 2: Prep & Install New Bench Mounting Reinforcement Plates

Remove the bench hold down bolts. Utilize vice grips on the underside nut to prevent it from spinning while unscrewing from the top with a socket and impact drill:

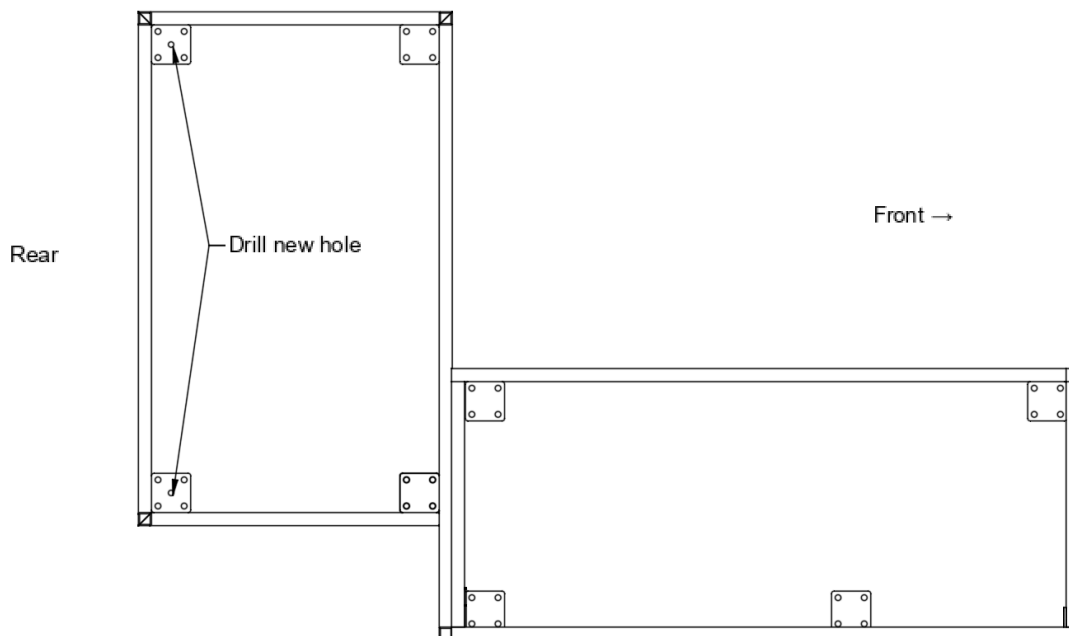
- If the hardware is 7/16" use a 16mm socket to remove and set aside for re-installation.
- If the hardware is 3/8" use a 14mm socket to remove; you will need to discard this hardware and upgrade to 7/16-20 Grade 8 hardware when reassembling.

Install chassis reinforcement plates on both driver and passenger side frame rails for the forward facing bench rear bolts:

- For each side, through bolt with 1/2" bolt > washer > bracket > washer > Nylock nut
- Torque the bolts to 15 ft/lbs

Drill updated holes for through bolts

- With the chassis reinforcement plates in place, drill through the reinforcement plate from inside the van with a 1/2" drill bit on the previously existing holes.
- Add a new hole for a second bolt on the center of each rear horizontal mounting plate (as shown in the diagram below).
- Drill out all 6 of the other previously used holes to 1/2" of the previously used hardware size was 3/8".



# VANCRAFT

## **Install the hold down bolts:**

- Use 7/16"-20 Grade 8 Yellow Zinc bolts in either 2" or 1.5" lengths depending on floor thickness.
- Use 7/16" Grade 8 Yellow Zinc washers on both the top and bottom side of the bolt.
- This hardware can be reused if 7/16"-20 hardware was used originally.
- Use vice-grips on the bolt head to hold the bolt from spinning while using a 16mm socket and impact drill to tighten the 7/16" Grade 8 Yellow Zinc nut from below.
- Tighten the bolt to 15 ft/lbs.
- With the addition of the new center holes on the rear two mounting plates, there should be 10 bolts total.

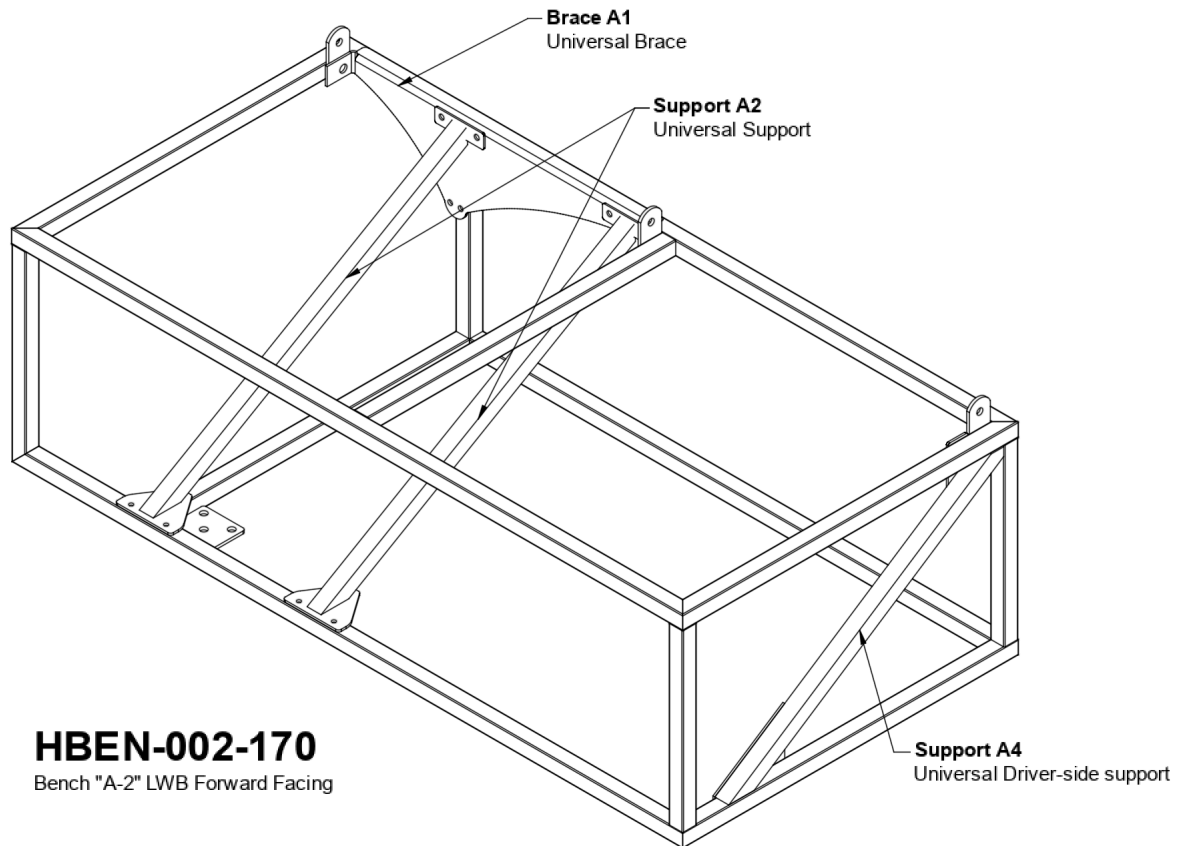
# VANCRAFT

## Step 3: Install Bench Frame Braces

### Install forward facing bench braces:

- Start with Brace A1. Use the 3/8" drill bit to predrill before installing the self drilling screws with 14mm socket and impact drill.
- There are pre-drilled holes along the top rail for both A2s, aside from the bolts used to install both A2s, no more bolts need to be drilled on the top rail of A1.
- The hole "Z" marked in the diagram below is to be through-bolted using one 3/8"-16 x 2.5" bolt, nut and washers **torque to 30 ft/lbs**.
  - Pre-drill though the seatbelt tab and bench frame tube with a 3/8" drill bit.
  - Push the bolt and washer through the hole.
  - Place a washer on the back side and thread the nut on.
  - Use a 14mm wrench on the nut and tighten the bolt head with a 14mm socket.
- Use one self tapping bolt for the bottom hole, attaching A1 to the vertical bench tube.
- Install both A2s and A4 using 14mm self tapping bolts.

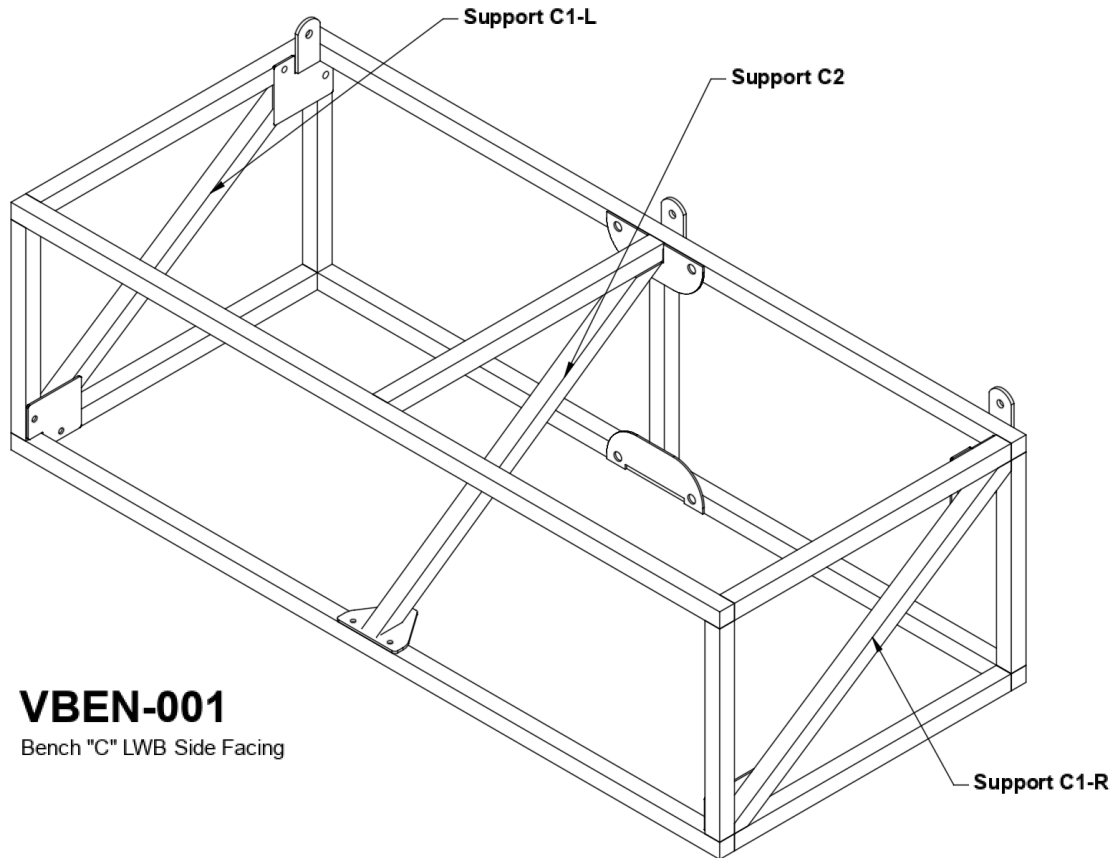
*Note: It may be necessary to rearrange the mounting location of the water heater to fit both A2 bars in place.*



# VANCRAFT

## Install Side facing bench braces:

Install C1-L, C2, and C1-R Using 14mm self tapping bolts.



## Step 4: Seatbelt Tab Weld Inspection

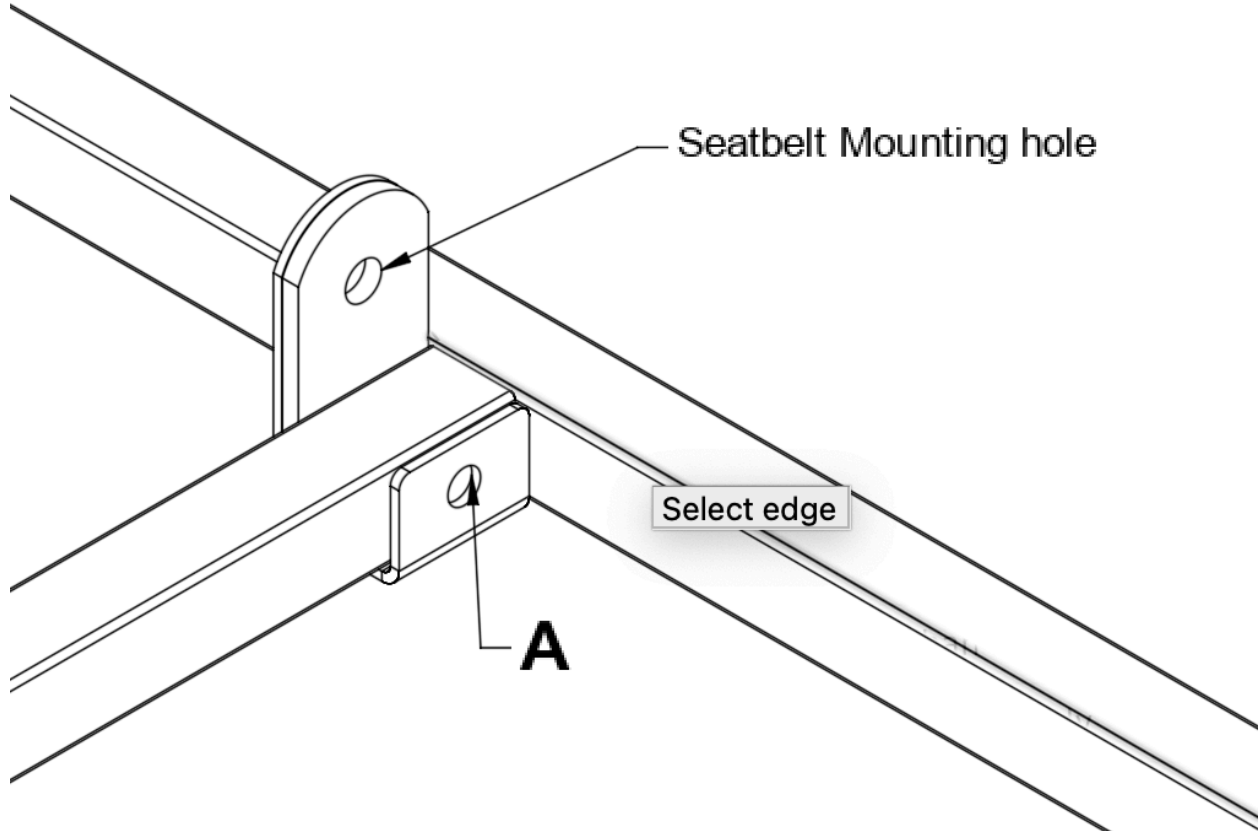
All seatbelt mounting tabs must be inspected for structural integrity. A correct tab installation will have 4 welds holding it to the frame (top, bottom, and both sides.) Anything short of 4 welds will constitute a fail and will need to be through-bolted to ensure its structural integrity.

*Note: the forward facing passenger side seatbelt tab is through bolted by default when installing Brace A1.*

Forward Facing Middle seatbelt tab reinforcement bracket installation:

1. Set the reinforced in as pictured in the diagram below. Drill through hole "A" using a 3/8" drill bit to drill clear through both tube walls. Keep your drill straight to make sure the bolt will line up through the other side of the bracket.
2. Bolt the bracket to the tube with a 3/8"-16 x 2" Grade 8 bolt and Nut using washers on both sides.
3. Drill a 1/2" hole through the bracket using the original seatbelt mounting hole as a guide for the 7/16"-20 Grade 8 seatbelt mounting bolt.

# VANCRAFT



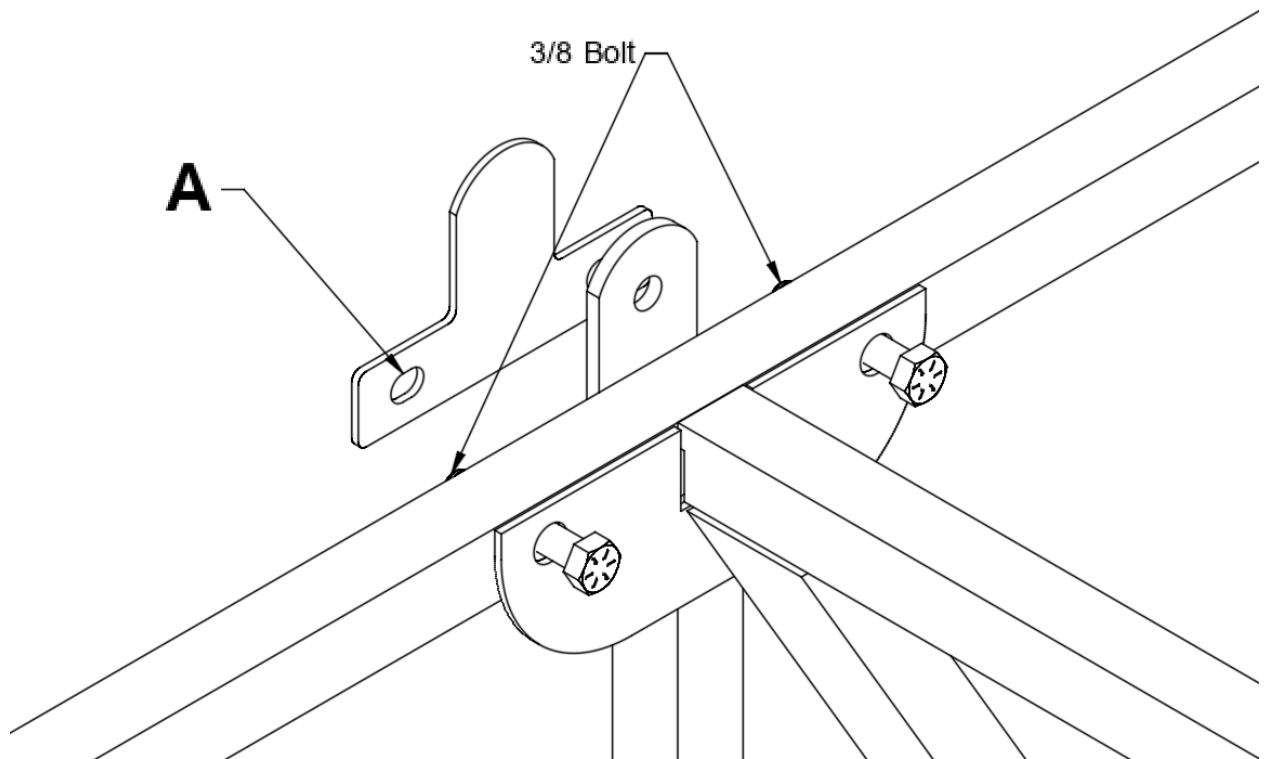
## Driver side forward facing seatbelt tab reinforcement:

1. In the bottom middle of the seatbelt tab, drill a 3/8" hole through the tab, tube frame, and closet face.
2. Drill through the closet face slowly to avoid "blow out" of the laminate.
3. Hold the drill square and level so the bolt will sit flat against the seatbelt tab.
4. Use a 3/8"-16x 2.75" bolt and nut with washers on both sides to bolt the seatbelt tab to the bench frame tube and closet face.

# VANCRAFT

## Side Facing Middle seatbelt tab reinforcement plate installation:

- Remove the two previously installed 14mm self tapping bolts on the top of Support “C-2”.
- Drill through the now empty holes using a 3/8” bit to drill clear through the square tube.
- Insert two (2) 3/8” x 2” Grade 8 bolts through the holes to bolt the reinforcement plate onto the back of the bench through holes “A” in the below diagram.
- Tighten down with 3/8” Grade 8 nylon nuts and washers to **30 ft/lbs.**
- Drill a new 1/2” hole into the reinforcement bracket for the seat belt bolt using the o;d hole as a guide.



# VANCRAFT

## Step 5: Reassemble Cabinets

**Re-assemble the cabinets in the reverse order they were disassembled. That is:**

1. Install the bench drawerbox/ face frame. Use all the same T15 Torx head screws to fasten it back to the bench frame. Keep the front face tight against the kitchen base cabinet.
2. Put the bench end cabinet back in place and screw back to the bench frame with all the same T15 Torx screws that were removed.
3. Place the bench tops back on top of the bench frame. The top will sit slightly off plane due to the rise in Brace A1. Use the same Phillips head screws removed in the disassembly step to fasten back to the bench frame. Where screws may pass through new bracing you'll need to predrill for the screw with the 1/8" drill bit.
4. Reconnect the bench door struts.
5. Install the Refrigerator Vent
6. Replace any zip ties that were removed on the plumbing and electrical lines beneath the bench and sink box.

## Step 6: Install The Seatbelts

1. Use 7/16"-20 Grade 8 bolts paired with washers on both sides of the seat belt mounting tabs and Grade 8 nylon locking nuts.
2. Tighten the seatbelt bolts so the seat belts are angled toward the passengers waist line or at roughly 45 degrees upward from the bench top surface.
3. Torque the seatbelt bolts to **25 ft/lbs**