

SERVICE PROCEDURE

25514
December, 2025

SUBJECT: SAFETY RECALL

Under Floor Reinforcement in certain 2016 thru 2026 IC Bus™ CE Series school buses built 01/15/2015 thru 05/29/2025 and 2016 thru 2022 IC Bus™ RE Series school buses built 03/09/2015 thru 03/23/2021

CUSTOMER LETTER

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

DEFECT DESCRIPTION

The suspect vehicles do not conform to Federal Motor Vehicle Safety Standards (FMVSS):

- No. 210, S4.2.2: The anchorages, attachment hardware, and attachment bolts for any of the following seat belt assemblies shall withstand a 13,345 N (3,000 pound) force applied to the lap belt portion of the seat belt assembly simultaneously with a 13,345 N (3,000 pound) force applied to the shoulder belt portion of the seat belt assembly, when tested in accordance with, at the choice of the manufacturer, S5.2.

And:

- No. 222, S5.1.4 Seat performance rearward. When a school bus passenger seat that has another seat behind it is subjected to the application of force as specified in S5.1.4.1 and S5.1.4.2.

Noncompliance to FMVSS 210 S4.2.2 and 222 S5.1.4 may increase the passenger's risk of personal injury or death in the event of a crash.

MODELS INVOLVED

This safety recall involves certain 2016 thru 2026 IC Bus™ CE Series school buses built 01/15/2015 thru 05/29/2025 and 2016 thru 2022 IC Bus™ RE Series school buses built 03/09/2015 thru 03/23/2021 with a side emergency door (feature codes 00047DCJ, 00047DCL, 47DCP, or 47DCT), luggage compartments, and dual riser seats.

VEHICLE RECALL 25514

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ELIGIBILITY

This procedure applies ONLY to vehicles marked in the International® Service PortalSM with Safety Recall 25514. Also complete any other open campaigns listed on the Service Portal at this time.

TOOLS REQUIRED

| Part Number | Part Description |
|--------------------|--|
| N/A | Flux Core Welding Machine |
| N/A | Angle Grinder Equipped with Wire Wheel and Flap Disc / Wheel |
| N/A | Slag Hammer |
| N/A | Wire Brush |

Table 1 Tools Required

PARTS INFORMATION

| Part Number | Part Description | Quantity |
|--------------------|---|-----------------|
| 2215878C2 | Reinforcement, Floor Side Emergency Door 45 in Flip Seat | 1 |
| 476074C1 | Nut, Battery terminal 3/8 in UNC | 2 |
| N/A | Flux-Cored Self-Shielded (FCAW-S) Welding Wire 0.030 or 0.035 inch Diameter | Obtain Locally |
| N/A | Undercoating Seal | Obtain Locally |
| N/A | Galvanizing Spray - Cold | Obtain Locally |

Table 2 Parts Information

SERVICE PROCEDURE

GOVERNMENT REGULATION: Engine fluid (oil, fuel, and coolant) may be a hazard to human health and the environment. Handle all fluid and other contaminated materials (such as filters and rags) in accordance with applicable regulations. Recycle or dispose of engine fluids, filters, and other contaminated materials according to applicable regulations.

WARNING! To prevent personal injury and / or death, or damage to property, park vehicle on hard flat surface, turn the engine off, set the parking brake and install wheel chocks to prevent the vehicle from moving in either direction.

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, always wear safe eye protection when performing vehicle maintenance.

WARNING! To prevent personal injury and / or death, or damage to property, allow engine / vehicle components to cool before servicing.

WARNING! To prevent personal injury and / or death, or damage to property, keep flames or sparks away from vehicle and do not smoke while performing this procedure. Underbody coating / removers are flammable.

WARNING! To prevent personal injury and / or death, safety glasses or other adequate eye protection must be worn when working with grinding equipment.

WARNING! To prevent personal injury and / or death, ALWAYS wear and use approved Personal Protection Equipment (PPE) when performing welding procedures. PPE such as a full-face welder's helmet with auto-darkening filter lenses of the proper density must be used along with flame-resistant clothing, welding gloves, respiratory protection equipment, safety footwear, and hearing protection equipment. Flux Core Arc Welding (FCAW), Gas Tungsten Arc Welding (GTAW) or Tungsten Inert Gas (TIG) welding will produce intense radiation; therefore, filter-plate lenses of the deepest shade, providing adequate visibility, are recommended.

WARNING! To prevent personal injury and / or death, ALWAYS wear and use approved Personal Protection Equipment (PPE) when removing / applying underbody and / or galvanized coating. PPE such as thick, chemical-resistant gloves and sleeves to protect your skin from harsh chemicals and sharp edges, safety glasses / goggles or an approved face shield are crucial to prevent flying debris and / or chemical splash injuries, and a respirator mask with appropriate filters to avoid inhaling fumes and / or sanding dust.

WARNING! To prevent personal injury and / or death, **ALWAYS** work in a well-ventilated area when removing / applying underbody coating or galvanized coatings, preferably outdoors, to minimize exposure to fumes. If working indoors, ensure adequate ventilation with fans or open windows.

WARNING! To prevent personal injury and / or death, **A QUALIFIED WELDER** is required to perform this procedure.

WARNING! To prevent personal injury and / or death, **CLEAN** prepared surfaces with hot soapy water and a stiff-bristled brush. Chemical cleaners such as acetone, petroleum, mineral spirits, and similar substances are not recommended for this procedure as these are flammable.

WARNING! To prevent personal injury and / or death, **ENSURE** welding equipment is calibrated to the applicable standards / requirements.

CAUTION! To prevent damage to property, disconnect and isolate both negative and positive battery cables before performing welding procedure(s) on vehicle. Attach welder ground cable as close as possible to the part being welded.

CAUTION! To prevent damage to property, remove **ONLY** the galvanized coating from the desired welding area. **DO NOT** remove base metal.

IMPORTANT: This procedure requires preparation and welding in an overhead position.

IMPORTANT: Refer to welding equipment manufacturer's recommended settings for detailed information related to voltage, wire feed speed, current, and so on.

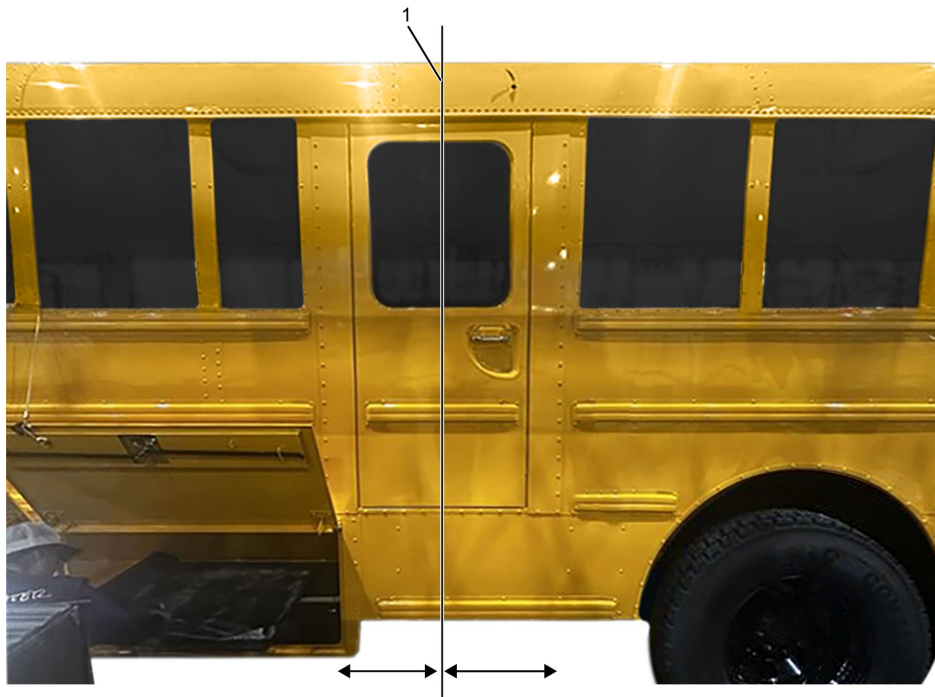
1. Park vehicle on flat surface.
2. Shift transmission to Park or Neutral and set parking brake.
3. Turn vehicle ignition to Key OFF position.
4. Install wheel chocks.

CAUTION! To prevent damage to property, disconnect and isolate both negative and positive battery cables before performing welding procedure(s) on vehicle. Attach welder ground cable as close as possible to the part being welded.

5. Disconnect and isolate BOTH negative and positive battery cables from main vehicle battery.
6. If necessary, raise and support vehicle for access.



Figure 1. Non-Luggage Compartment Emergency Door
1. Centerline



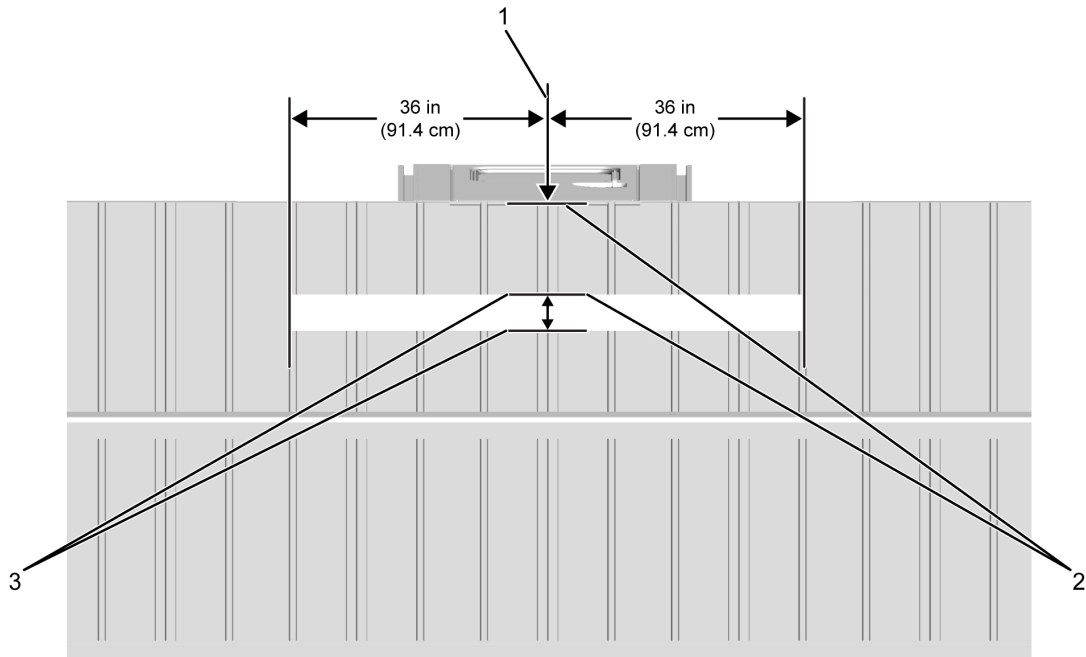
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Figure 2. Luggage Compartment Emergency Door
1. Centerline

7. Locate emergency door on side of vehicle.

NOTE: Mark centerline at bottom of body edge for measurement purposes.

8. Measure, establish, and record centerline of emergency door (Figures 1 and 2, Item 1).
9. Inspect underbody area under emergency door between body edge and frame. Ensure no components, wiring, air lines, or fuel lines are present. If present, remove / reposition accordingly.



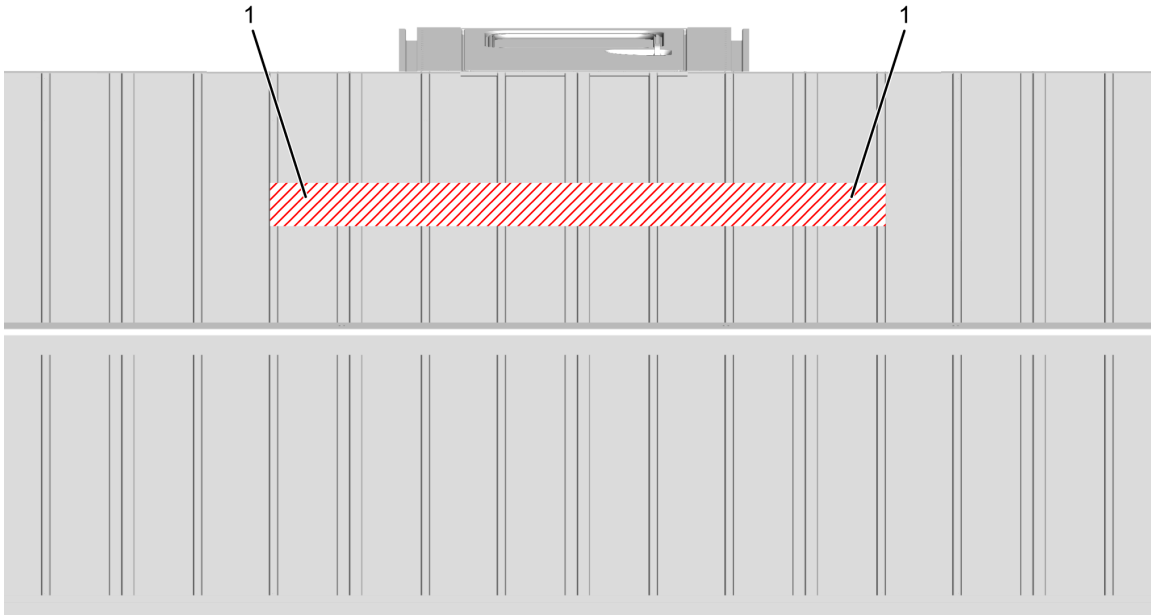
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Figure 3. Underbody Measurements

1. Centerline
2. 13 in (33 cm)
3. 5 in (12.7 cm)

NOTE: Mark measurements at bottom of body edge so they are visible from underneath the vehicle.

10. Using established prerecorded centerline (Figure 3, Item 1), measure and record 36 in (91.4 cm) on each side of previously recorded centerline mark.
11. Using established prerecorded measurements / marks and working under the vehicle, measure 13 in (33 cm) (Figure 3, Item 2) from edge of emergency door towards center of vehicle and record mark accordingly on underbody. Measure and record an additional 5 in (12.7 cm) (Figure 3, Item 3).



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Figure 4. Prep Area – Underbody Non-Luggage Box

1. Area for prep

WARNING! To prevent personal injury and / or death, ALWAYS wear and use approved Personal Protection Equipment (PPE) when removing / applying underbody and / or galvanized coating. PPE such as thick, chemical-resistant gloves and sleeves to protect your skin from harsh chemicals and sharp edges, safety glasses / goggles or an approved face shield are crucial to prevent flying debris and / or chemical splash injuries, and a respirator mask with appropriate filters to avoid inhaling fumes and / or sanding dust.

NOTE: For vehicles equipped with luggage and / or battery boxes. If box is present within the C-channel reinforcement zone, modify reinforcement (2215878C2) so that it can be installed from the edge of the box, until it accommodates the required 36 in fore and aft of the centerline of the door.

NOTE: Only remove undercoating / galvanized coating from the bottom of floor sill support. Do not remove from the floor panel as reinforcement does not contact the flat section of the floor panels.

12. If equipped with underbody coating, using prerecorded measurements / marks and a right-angle grinder with a wire wheel, remove underbody coating in area marked (Figure 4, Item 1). Then remove an additional 2 in (50 mm) diameter outside of the marked area to be welded.

CAUTION! To prevent damage to property, remove **ONLY** the galvanized coating from the desired welding area. **DO NOT** remove base metal.

NOTE: Only remove undercoating / galvanized coating from the bottom of floor sill support. Do not remove from the floor panel as reinforcement does not contact the flat section of the floor panels.

13. Using a right-angle grinder with a flap wheel, remove galvanized coating in marked area with an additional 2 in (50 mm) diameter around area to be welded.

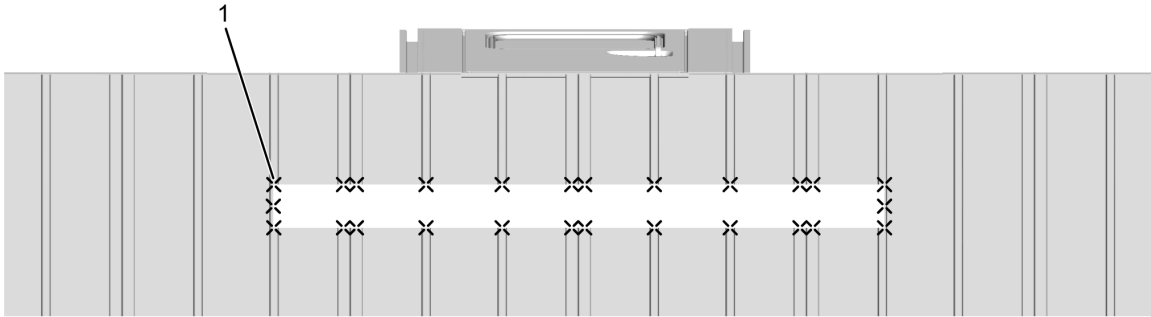
WARNING! To prevent personal injury and / or death, **CLEAN** prepared surfaces with hot soapy water and a stiff-bristled brush. Chemical cleaners such as acetone, petroleum, mineral spirits, and similar substances are not recommended for this procedure as these are flammable.

14. Clean prepped area thoroughly using a stiff-bristled brush and warm or hot soapy water. Rinse with clean water and allow to dry thoroughly.
15. Obtain reinforcement and, using a stiff-bristled brush and warm or hot soapy water, clean by removing any debris and / or oil. Rinse with clean water and allow to dry thoroughly.

WARNING! To prevent personal injury and / or death, **ALWAYS** wear and use approved Personal Protection Equipment (PPE) when performing welding procedures. PPE such as a full-face welder's helmet with auto-darkening filter lenses of the proper density must be used along with flame-resistant clothing, welding gloves, respiratory protection equipment, safety footwear, and hearing protection equipment. Flux Core Arc Welding (FCAW), Gas Tungsten Arc Welding (GTAW) or Tungsten Inert Gas (TIG) welding will produce intense radiation; therefore, filter-plate lenses of the deepest shade, providing adequate visibility, are recommended.

CAUTION! To prevent damage to property, disconnect and isolate both negative and positive battery cables before performing welding procedure(s) on vehicle. Attach welder ground cable as close as possible to the part being welded.

16. Attach welding equipment ground cable as close as possible to prepped area.
17. Ensure required welding equipment is set at required setting(s) and all welding PPE is being used.



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Figure 5. Reinforcement Weld Locations – Non-Luggage Box

1. Weld location (26)

NOTE: For vehicles equipped with luggage box, if the luggage box is present within the C-channel reinforcement zone, modify reinforcement (2215878C2) so that it can be installed from the edge of the luggage box, until it accommodates the required 36 in fore and aft of the centerline of the door.

18. Align and position flat edge / side of reinforcement to previously prepped area. Center the reinforcement with the end falling on closest main floor joint.
19. Once aligned / positioned, support reinforcement using a transmission jack or equivalent lifting device to secure in place.
20. Apply a 0.12 in (3 mm) fillet weld bead at each end of reinforcement to secure in place and if necessary, remove jack / support.
21. Apply a 0.12 in (3 mm) fillet weld bead at 26 weld locations (Figure 5, Item 1) where reinforcement is in direct contact with underbody. Repeat on all sides of reinforcement.

NOTE: Gently tap the slag edges. Be careful not to hit too hard, as this could damage the weld bead underneath.

22. Using a slag hammer, gently tap the slag edges, breaking them into chunks. Work across the weld to remove all the large pieces of slag.
23. Using a wire brush, clean and inspect weld for any signs of slag trapped within the weld. If present, grind them out and weld area again.
24. Detach welding equipment ground cable from prepped area.
25. Clean area thoroughly with warm or hot soapy water. Rinse with clean water and allow to dry thoroughly.

WARNING! To prevent personal injury and / or death, ALWAYS wear and use approved Personal Protection Equipment (PPE) when removing / applying underbody and / or galvanized coating. PPE such as thick, chemical-resistant gloves and sleeves to protect your skin from harsh chemicals and sharp edges, safety glasses / goggles or an approved face shield are crucial to prevent flying debris and / or chemical splash injuries, and a respirator mask with appropriate filters to avoid inhaling fumes and / or sanding dust.

26. Apply cold-galvanized compound. Refer to manufacturer's requirements for detailed instruction.
27. If equipped, apply underbody coating. Refer to manufacturer's requirements for detailed instruction.
28. If required, reposition / install any components, wiring, air lines, or fuel lines previously repositioned.
29. Connect positive cable to main vehicle battery.
30. Connect negative cable to main vehicle battery.
31. If necessary, remove supports and lower vehicle.
32. Remove wheel chocks.

END OF SERVICE PROCEDURE

LABOR INFORMATION

| Operation Number | Description | Time |
|------------------|---------------------------------|---------|
| A40-25514-1 | Install C-Channel Reinforcement | 2.4 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.

| |
|-------------------------|
| DO NOT REMOVE |
| INTERNATIONAL |
| Campaign No. |
| VIN Eng.# |
| COMPLETED |
| Service Location Code # |
| DO NOT REMOVE |

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 25514.

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.

| | GROUP | NOUN | C | WARR. | TP | PAD |
|--|-------|------|---|-------|----|-----|
| GROUP — Enter number | ← | | | | | |
| NOUN — Leave blank | ← | | | | | |
| C (CAUSE) — Enter either 1, 2, 3. (See below) | | | | | | |
| 1. Inspected (No repair required). | | | | | | |
| 2. Inspected and repaired. | | | | | | |
| 3. Defective part from parts stock. | | | | | | |
| WARRANTY — (Warranty Code) Enter 40. | | | | | | |
| TYPE PART — Enter P for type part causing failure. | | | | | | |
| PAD — Enter 100 | | | | | | |

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VEHICLE RECALL 25514

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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. Federal law prohibits a dealer from delivering under a sale or lease, a new motor vehicle or any new or used item of motor vehicle equipment (including a tire) covered by the notification of a recall until the defect or noncompliance is remedied.

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