



Work Instructions – HVAC Relay & Fuse Block Revision

NHTSA Recall 26V-652
Author: E-ONE Engineering
Date: October 12, 2026

1. Purpose

This work instruction defines the process for removing the existing Bussmann fuse block, installing the updated fuse block assembly and associated HVAC harness components, and restoring vehicle functionality following installation.

All work shall be performed in accordance with this instruction, applicable E-ONE engineering documentation, connector identification information, and harness prints.

No deviations from this work instruction or associated engineering documentation are permitted without documented approval from the responsible E-ONE Engineering and/or Quality representative.

2. Required Parts

Prior to beginning work, verify that all required parts are available and match the specified part numbers.

Part Description	Part Number	Quantity
HVAC Harness	1167253	1
Bracket	1167276	1
Red Power Cable	1166364	1
Power Relay Fuse Module	1121588	2
Busbar	539695	1
30-Amp Fuse	1110116	4

Note: Parts substitution is not permitted unless specifically authorized by E-ONE Engineering.

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3. Work Instructions

Step 1 - Disable Vehicle Electrical Power

Before beginning the repair:

1. Place the vehicle in a safe condition for service.
2. Turn vehicle electrical power **OFF**.
3. Verify vehicle power is OFF before accessing or disconnecting any fuse block or electrical connections.

Battery disconnection is not required for this procedure.

Warning: Do not perform any electrical disassembly while vehicle power remains ON.

Step 2 - Access the Repair Area

Remove the hardware identified in the accompanying photographs to gain access to the driver-side kick plate area.

- Retain all removed hardware for reinstallation unless replacement is specifically required.
- Protect adjacent finished surfaces, wiring, and components from damage during removal.

Step 3 - Remove Gauge Cluster

Remove the gauge cluster as shown to gain access to the existing Bussmann fuse block.

- Support and protect the gauge cluster and associated wiring throughout the repair process.
- **Do not allow the gauge cluster to hang unsupported by its wiring harnesses or connectors.**

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Step 4 - Remove Existing Bussmann Fuse Block

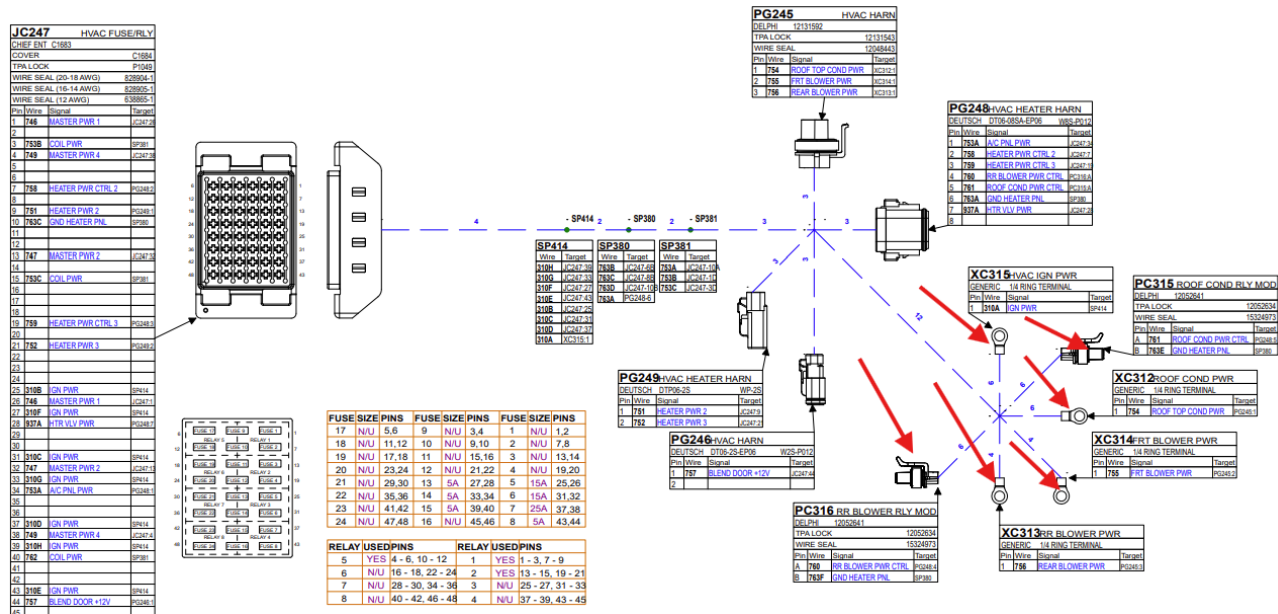
Disconnect and remove the existing Bussmann fuse block and the cable connecting the fuse block to the ignition solenoid.

Install the replacement HVAC harness in accordance with the applicable harness print and connector identification documentation. The replacement harness incorporates six new connections associated with the updated relay configuration.

Connection Verification Requirement

Before making each connection:

1. Identify the connector and terminal designation.
2. Locate the corresponding connection on the applicable harness print.
3. Verify the physical connection location against the engineering documentation.
4. Complete the connection only after all identification and location requirements have been verified



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Step 5 - Install Power Relay Fuse Modules

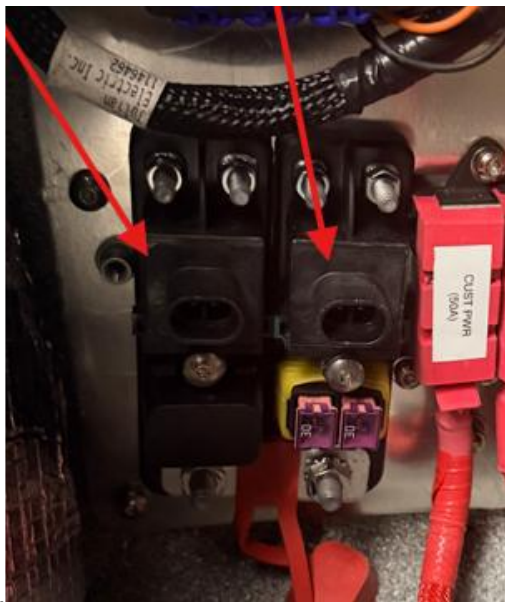
Install two Power Relay Fuse Modules (P/N 1121588) in the driver-side kick plate area as shown in the applicable engineering documentation.

Prior to installation, verify that four 30-amp fuses (P/N 1110116) are installed in the specified fuse positions.

Acceptance Criteria

- Two P/N 1121588 fuse modules were installed.
- Four required fuses installed.
- Fuse ratings verified at 30 amps.
- Modules securely mounted.
- Wiring properly routed and supported.
- No pinching, chafing, rubbing, or interference present.

Electrical harnesses shall be properly secured, and all electrical connections shall be protected from damage.



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Step 6 - Connect XC312, XC313, XC314, and XC315

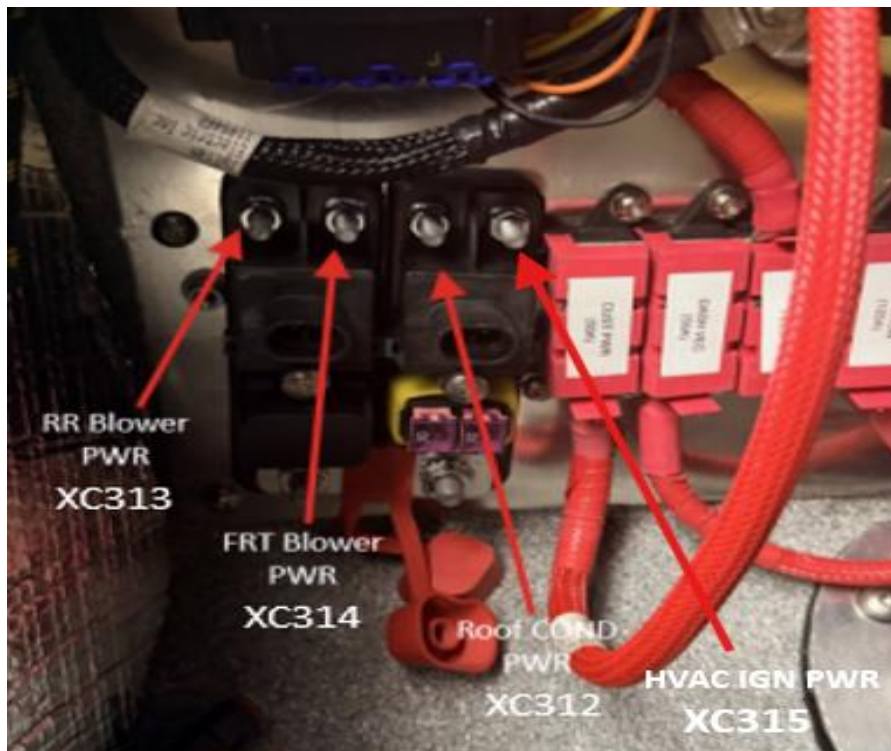
Install eyelet terminals:

- XC312
- XC313
- XC314
- XC315

onto the studs specified in the applicable harness print.

For each eyelet terminal:

1. Verify connector identification.
2. Verify the designated stud location on the harness print.
3. Confirm both references match.
4. Install the eyelet terminal. Verify the eyelet is fully seated and securely fastened.



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Step 7 - Connect PC315 and PC316

Connect PC315 and PC316 to the locations identified in the connector documentation and applicable harness print.

Verify each connector is:

- Installed in the correct location.
- Fully engaged.
- Positively retained.
- Properly routed without interference.



Step 8 - Install Busbar

Install Busbar P/N 539695 as specified in the applicable engineering documentation.

Verify that the busbar is:

- Installed at the correct connection points.
- Fully seated.
- Securely fastened.

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Step 9 - Install Power Cable

Install the supplied red power cable (P/N 1166364) between the ignition solenoid and the Power Relay Fuse Module in accordance with the applicable engineering documentation.

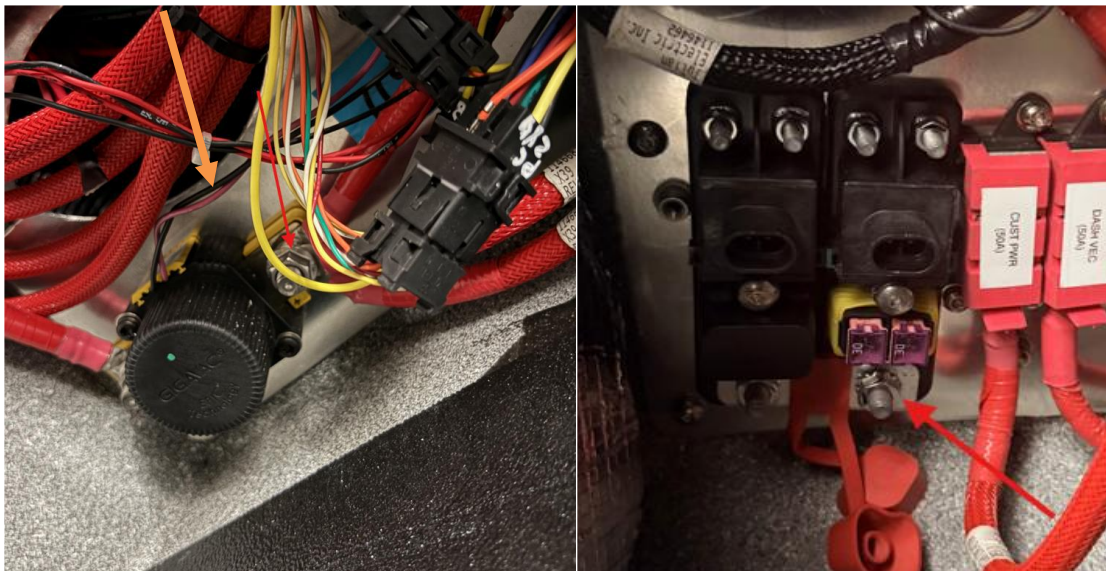
Verify:

- Correct connection points.
- Proper cable routing.
- Adequate clearance from surrounding components.
- No pinching, chafing, rubbing, or interference.
- Cable is properly secured.

All connection locations shall be verified against the applicable engineering documentation prior to installation.

Torque Requirement

Connections installed on the M6 output studs of the Power Relay Module (P/N 1121588) shall be torqued to a maximum of **48 in-lb (5.4 N·m)** and M8 input studs of the Power Relay Module (P/N 1121588) shall be torqued to a maximum of **144 in-lb (16.3 N·m)**.



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4. Final Verification

After installation is complete:

1. Verify all tools, loose hardware, wire remnants, and foreign material have been removed from the work area.
2. Verify all electrical connections are fully seated and secure.
3. Verify all wiring is free of pinching, chafing, rubbing, and interference.
4. Verify all required fuses are installed.
5. Verify all removed panels and components have been reinstalled.
6. Restore vehicle electrical power.
7. Perform the required functional verification of all affected systems.

Completed assemblies shall be free of loose parts, debris, and foreign material. All repairs shall be inspected to verify completeness, proper workmanship, and acceptable system operation.

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