

Folsom 30L4RE-01: Rear Leaf Spring Bracket
Replacement



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Property and Top Bus Number: L4RE Blue Bird buses



Issue: Rear leaf spring bracket updated design.

Reason/ cause: The rear leaf spring bracket was updated to enhance serviceability, maintainability and durability.

Solution: Replace bracket per this work instruction (SOI).

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Number of affected buses: 5 buses

Estimate repair hours/bus: 8 hours

Necessary parts:

Bracket, rear spring mount,.5" thick,	P/N: 100-9120-010 ,	2 / bus,
M20x2.5 L200 Gr10.9 Hex head bolt,	P/N: 4752553 ,	2 / bus,
M20x2.5 nylock nut, Gr10,	P/N: 4752554 ,	2 / bus,
Shim, 1/8",	P/N: 1973312 ,	4-6 / bus as required,
Bushing, 2.5"OD,	P/N: 6331059 ,	2 / bus if required,
Clamp plate, rear axle,	P/N: 4752548 ,	2 / bus if required,
Copper anti-seize compound for bolts,	P/N: NPN ,	as required,
Torque seal,	P/N: NPN ,	as required

Necessary tools:

Usual hand tools (wrenches, sockets, hammer, pry bar, etc.), torque wrench capable for 390 lb-ft,

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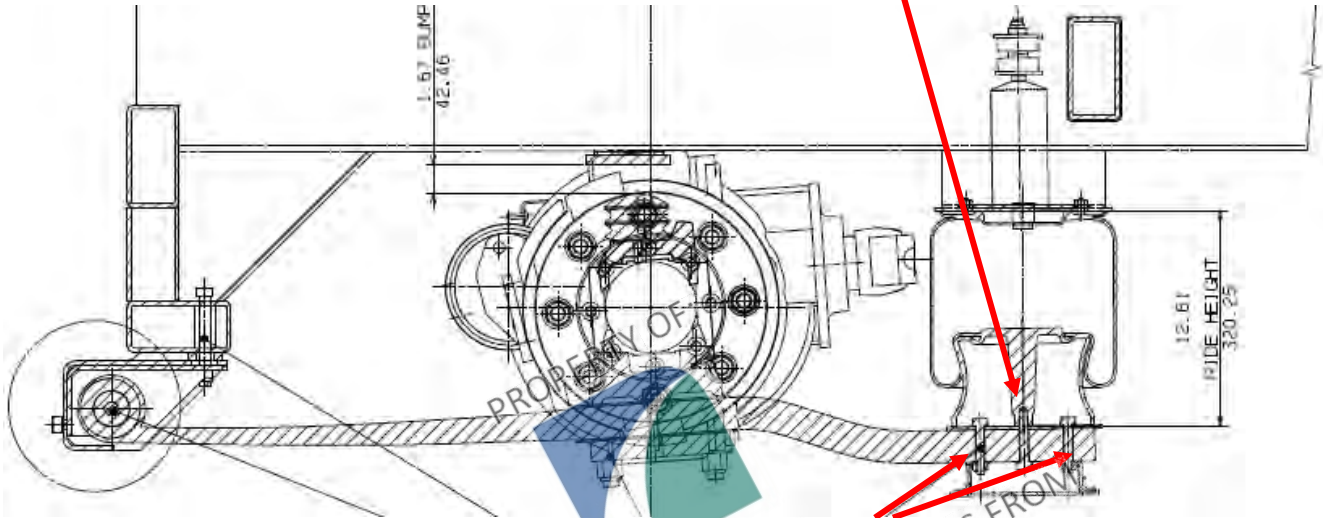
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1. Turn the battery disconnect switches off.
2. Lift the bus and place jack stands underneath the official jacking pads.
3. Mark and disconnect the rear leveling valve rod.
4. Remove rear curb side (CS) and street side (SS) air springs lower mounting bolts (size M12x1.75).



5. Remove CS and SS leaf springs to cross beam mounting bolts (size M12x1.75).
6. Remove nuts from axle mounting U-bolts. Clean threads with wire brush and apply penetrate lubricant as required.



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7. Remove rear axle clamp plate from leaf springs.



8. Clean and inspect clamp plate. Replace if damaged.

9. Remove size M20x2.5 L200 front leaf spring mounting bolts.



10. Slide leaf spring back to provide clearance for removing the mounting bracket.

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11. Remove the 5/8 size mounting bolts and remove the bracket. Mark the number of shims (if any) behind the bracket and save them for the reinstallation. These shims are for the axle alignment and must be reinstalled to the same location with the new bracket.



12. Inspect CS and SS leaf spring bushings. Replace them as required.



13. Install new bracket with shims (as it was originally). Torque 5/8 size mounting bolts to 148-184 lb-ft.

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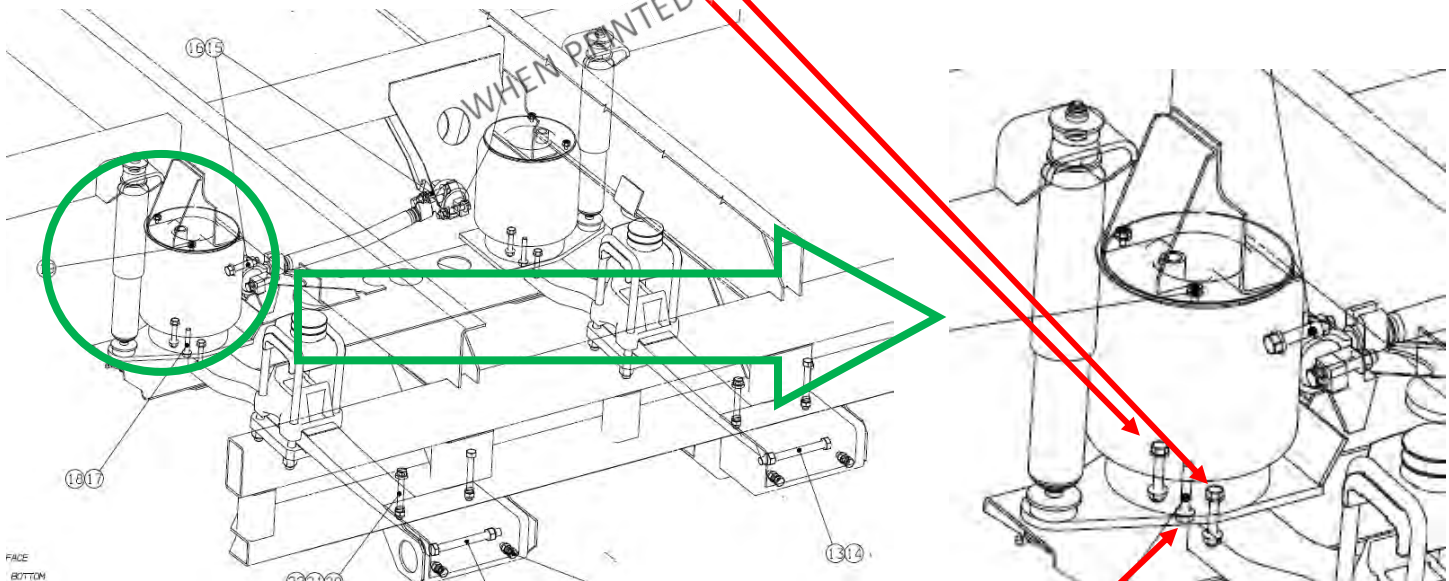


14. Install shims between the leaf spring bushing and mounting bracket as required and install **new** M20x2.5-L200, 10.9Gr bolts with **new** locknuts. Apply anti seize compound onto the shank of the bolts. **Do not torque these M20 bolts yet!**

Shim



15. Clean threads of axle mounting U-bolts and apply anti-seize compound to the bolt shank.
16. Reinstall rear axle clamp plate and hand tighten the M22x1.5 nuts of axle U-bolts.
17. Reinstall M12x1.75 size mounting bolts between the leaf spring and cross beam and tighten them to 50-60 lb-ft.



18. Reinstall airbag lower mounting bolts (size M12x1.75) and tighten them to 50-60 lb-ft.

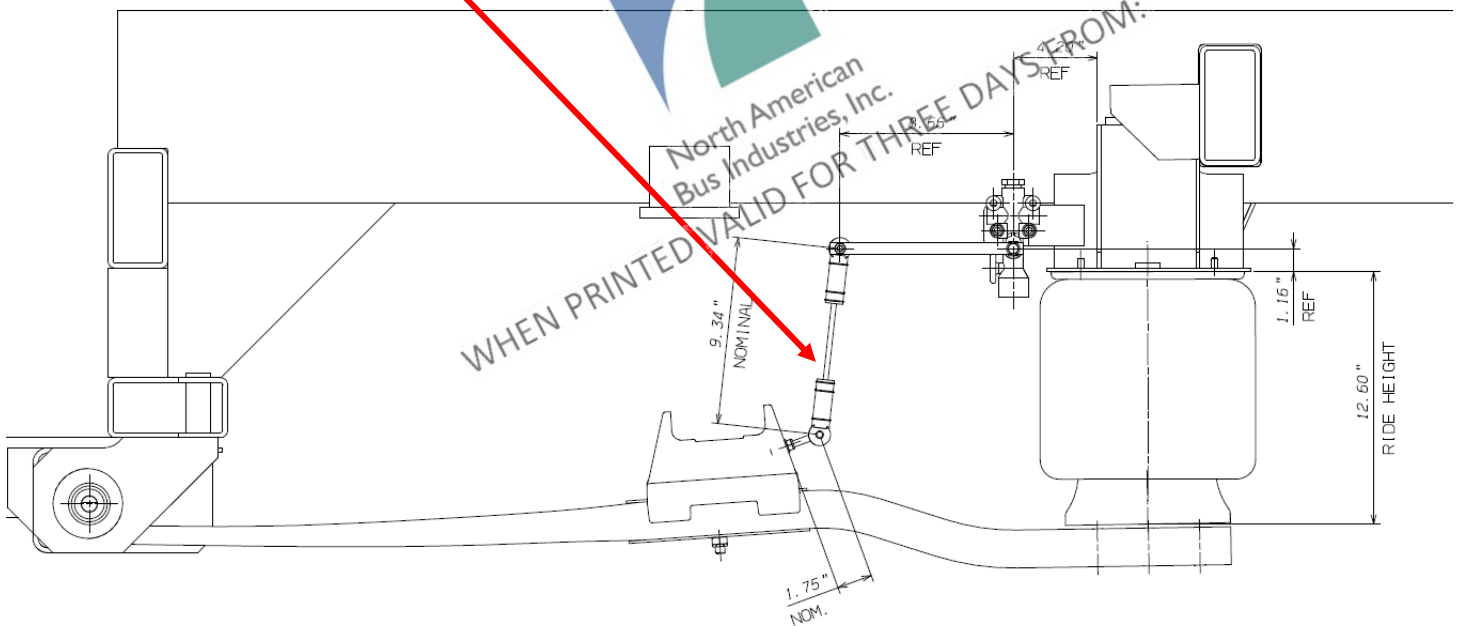
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19. Torque M22x1.5 nuts of U-bolts to 315-380 lb-ft. Apply torque seal to the hardware.



20. Reinstall leveling valve rod.



21. Connect the shop air to the bus and measure the airbag height per drawings above.
22. Adjust leveling valve rod until the 12.60" airbag height is achieved.

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23. Torque the M20 x2.5 bolts and locknuts at the leaf spring bushing to 322-390 lb-ft. Apply torque seal to hardware.



24. Check for completeness of work.

25. Remove tools and unused parts from work area.

26. Record bus number, date of repair and name of technician who completed the work.

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