

Special Bulletin

SP13-326B

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Revision: B THIS BULLETIN SUPERSEDES ALL PREVIOUS VERSIONS
May. 2014 Added figure numbers/ Updated steps 5-6-10 / Step 10: Drill was #2 size, is 7/32".

TITLE: STRUCTURAL REINFORCEMENT BI-FOLD DOOR AFT CYLINDER SUPPORT
Prevost vehicles

DESCRIPTION

On the vehicles affected by this bulletin, addition of a bolted structural reinforcement is required on the aft bi-fold door cylinder support.

MODEL YEAR(S) AND VEHICLES INVOLVED

NOTICE TO SERVICE CENTERS	
Verify vehicle eligibility by checking warranty bulletin status with SAP or Vehicle Warranty Information tool found on Prevost-Systems tab of the Volvo Trucks Dealer Portal	
Model	VIN 
X3-45 Commuter Model Year : 2012	From 2PCG33495CC73 <u>5053</u> up to 2PCG33495CC73 <u>5232</u> incl.
This bulletin does not necessarily apply to all the above-mentioned vehicles, some vehicles may have been modified before delivery. The owners of the vehicles affected by this bulletin will be advised by a letter indicating the Vehicle Identification Number (VIN) of each vehicle concerned.	

The above list of VIN was valid at the time of publishing this document. Please refer to SAP for most recent information about outstanding vehicles

ORDER KIT 145031 WHICH INCLUDES:

Part No.	Description	Qty
145030	Structural reinforcement	1
502848	Thread cutting screw 1/4-20 x 3/4"	4
500247	Hex nut 1/4-20	1

ADDITIONAL COMPONENTS:

Part No.	Description	Qty
680038	243 Loctite, 50ml	1
685353	Torque seal, 0.5 Oz.	1

PROCEDURE



DANGER

Park vehicle safely, apply parking brake, stop engine. In the battery box, set the battery cut-off switch to the OFF position prior to working on the vehicle.

1. On the vehicle, right side, first row of seats. Remove the first short section of the trim panel between floor and wall. (Fig. 1 & 2)

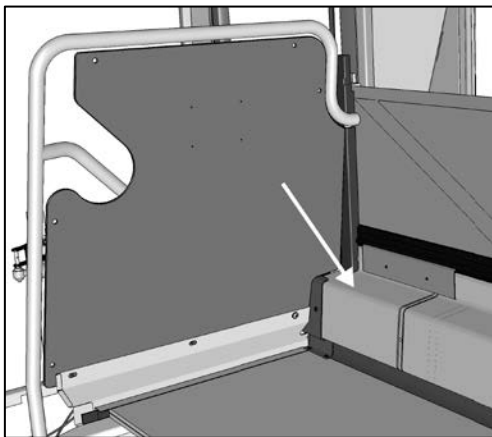


Figure 1

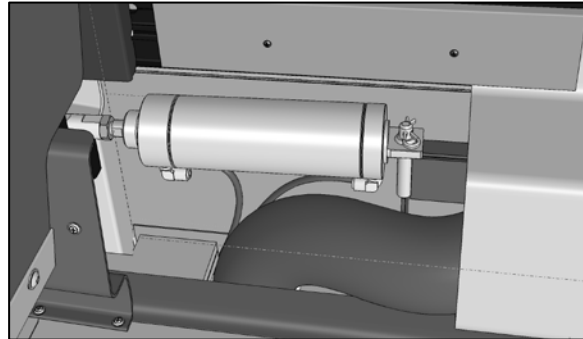


Figure 2

2. Inspect the aft cylinder anchor bracket and pin. Make sure the welds and bracket are structurally sound before undergoing any work. (Fig. 3)
Inform Prevost of any apparent defect.

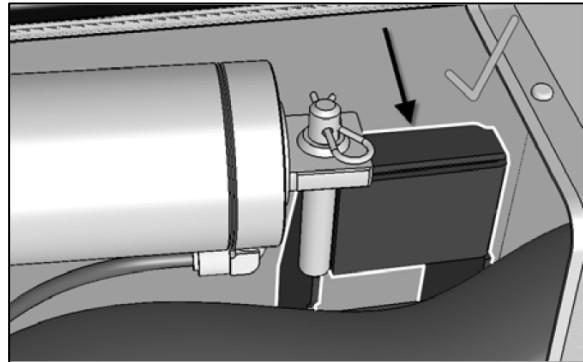


Figure 3

3. Protect flexible ventilation duct, any piping or electrical cables/connectors in the area before undergoing any work.
4. Remove air to the door by turning the emergency release air valve.
5. Remove airline from cylinder.
6. Remove hitch pin (Fig. 3) and cylinder rod end cap screw (Fig. 4), remove pneumatic cylinder from support.

Reserve removed hardware for re-assembly.



Figure 4

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7. Position the structural reinforcement part as shown. Slip the reinforcement over the cylinder anchor pin.(Fig. 5)

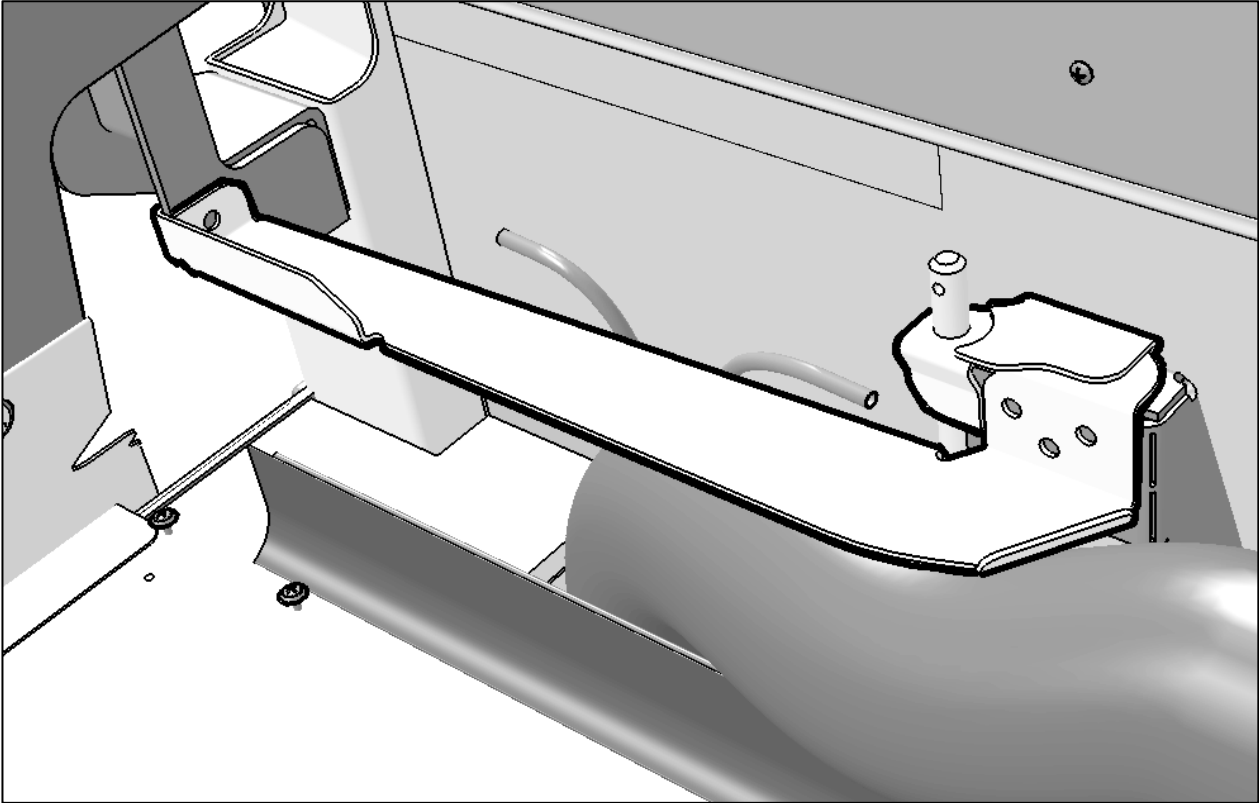


Figure 5

8. The front connection makes a "sandwich".

The two tabs on the part should be slipped in front & behind the vertical structure in this location. (Fig. 6)

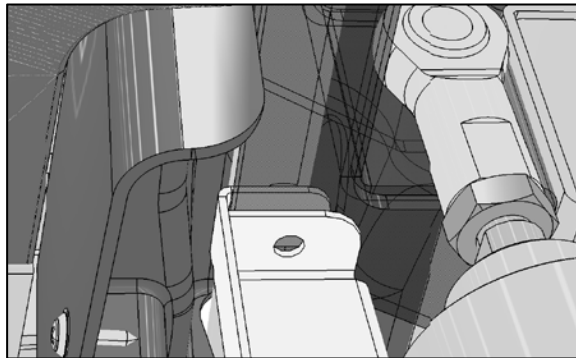


Figure 6

9. Secure the part and use as a template

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for drilling the fore hole.

- Drill a 9/32" hole.
- Install the fore screw & nut with #680038 Blue Loctite 243. (Fig. 7)
- Tighten to 70 lbf-in dry (6 lbf-ft dry).
- Mark with torque seal

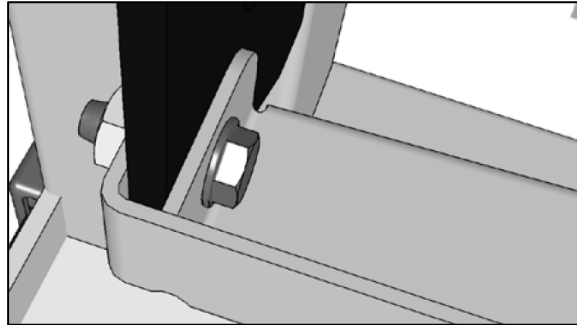


Figure 7

10. Change the drill bit to a smaller-size 7/32" drill.

- With the front end installed, drill a first hole using the part as a template. (Fig. 8)
- Install screw with blue Loctite, hand tighten to about 60 lbf-in dry (5 lbf-ft dry) Hole should be in a clean, dry condition prior to screwing.
- Drill the remaining holes and tighten with blue Loctite to about 60 lbf-in dry (5 lbf-ft dry). Holes should be in a clean, dry condition prior to screwing.
- Mark screws with torque seal.

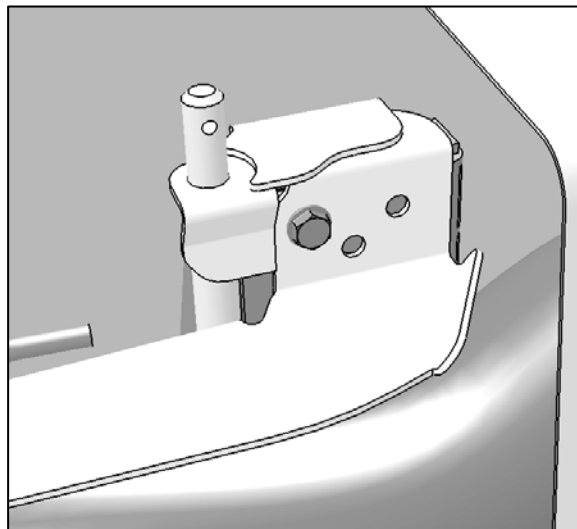


Figure 8

Clean work area, re-install cylinder and trim panel.

Reapply air pressure and confirm proper door operation.

PARTS / WASTE DISPOSAL

Discard waste according to applicable environmental regulations (Municipal/State[Prov.]/ Federal)

ESTIMATED TIME

The time required to perform this special bulletin is approximately 45minutes.

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OTHER

VBC Bulletin	n/a
Fail Code	18.01
Defect Code	09
System Condition	B
Causal Part	289561

Prevost engages in a continuous program of testing and evaluating to provide the best possible product. Prevost, however, is not committed to, or liable for updating existing products.