

Note:

ARBOC Specialty Vehicles
TS11306 Add upper A-arm suspension stop.

ECN#

SB-10054288-9271

SAFETY

Read repair procedure before beginning. If you do not understand any part of the repair procedure contact: Mel Williams, Director of Parts and Warranty at 1-866-953-5555 or by E-mail @ mwilliams@ARBOCsv.com.

Good mechanics safety practice must be followed in any repair.

Safety practices should include but not limited to properly supporting the chassis, axles, blocking tires, and a work area free of clutter.

Repair shops safety rules must be followed and safety equipment used.

O.E.M. Battery and auxiliary battery **MUST** be disconnected.

Condition / Vehicles Affected:

Inspection Guidelines:

Authorization: Prior authorization required.

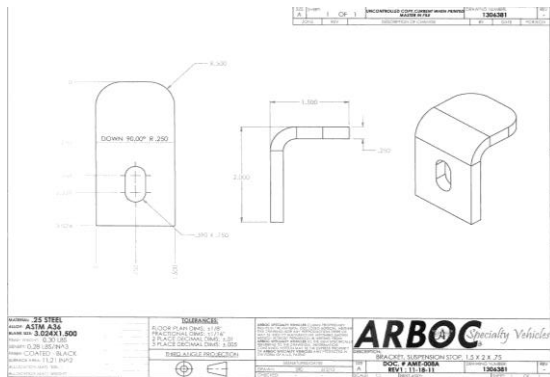
Labor Operation Code: TSI1306

Time Allowance: 1.5 Hour.

Repair Kit: 1407097 Contains:

ARBOC Part# 1306381, Bracket, Suspension Stop.

4pcs.



ARBOC Part# 616155, Screw Cap 3/8-16x1" UNC Tuf-Torg. 4pcs.

ARBOC Part# 721930, Washer Flat 3/8" USS Tru-Torg. 4pcs.

ARBOC Part# 1202088, Locknut Flange 3/8-16 UNC Grade G. 4pcs.

TOOLS REQUIRED:

1. Hoist system, able to raise and support bus.
2. 1/2" drive air impact wrench to remove front driver side wheel/tire.
3. 1/2" drive, 8"-12" long extension.
4. 1/2" drive, 22mm deep well socket.
5. 15/16" socket.
6. 3/8" deep well socket.
7. 3/8" combination wrench.
8. Thread locker, High Strength. Example: Vibra Tite 14050.
9. 1/2" Chucked Hand drill.
10. 3/8" drill bit.
11. Torque wrench settings: 24ft/lb and 140 ft/lb.

Before Beginning Repair Procedure Read Instruction Completely.

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When printing instructions, use a color printer.

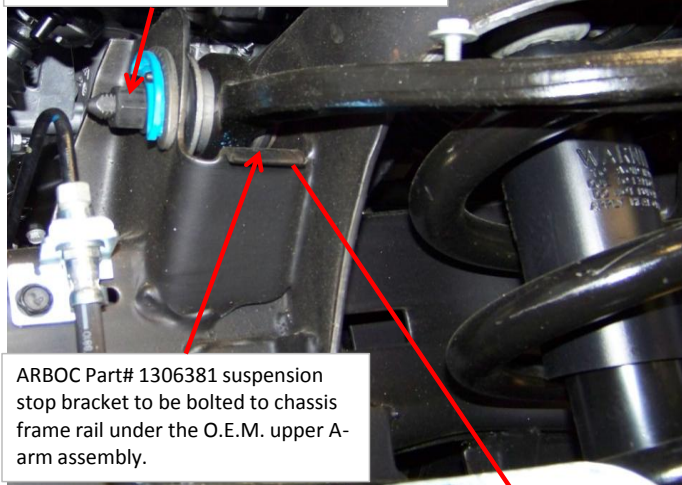
Repair Procedure: Adding suspension stop brackets to chassis frame rail under the O.E.M. upper A-arm assembly. Suspension stops will be added to both the passenger side and driver side of the front suspension system.

Step 1: Pull unit onto hoist, Chock rear tires, Kneel suspension, dump air tank, raise bus to a comfortable working height.

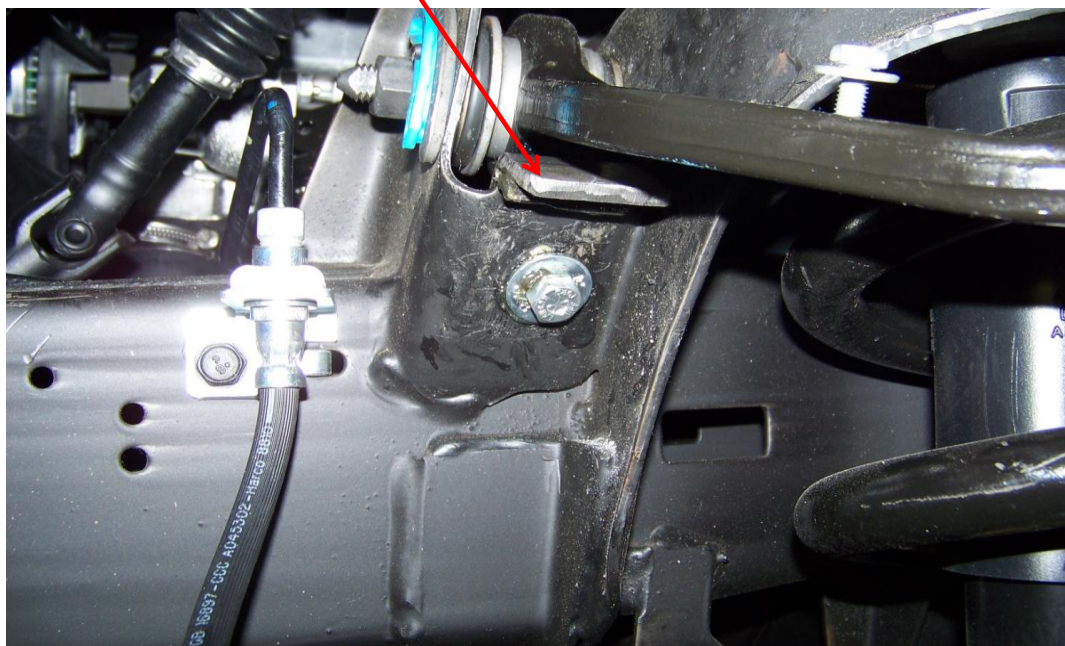
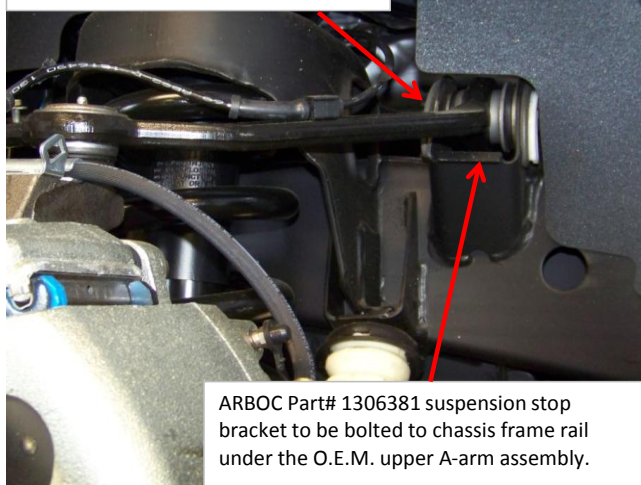
Step 2: Remove the front wheels.

Step 3: Installation of the suspension stop bracket (ARBOC Part# 1306381) to the chassis frame rail under the O.E.M. upper A-arm assembly: Use provided pictures as reference, driver side of front suspension system shown passenger side follow same installation method.

Driver side upper A-arm assembly. Forward



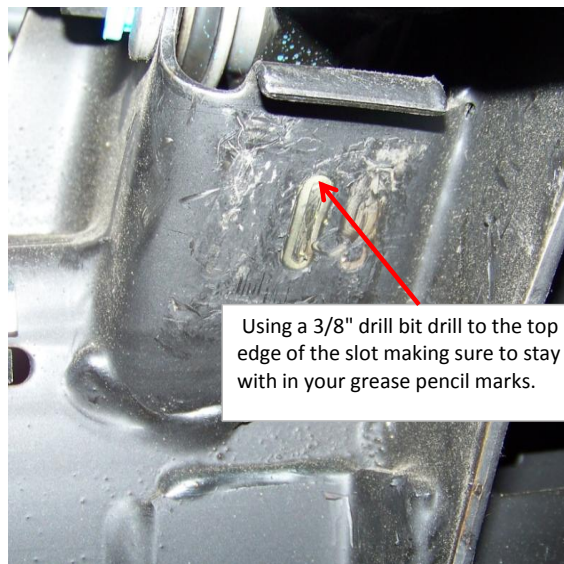
Driver side upper A-arm assembly.



Step 4: Mark the location to be drilled, align the edge of the suspension stop bracket with the edge chassis jounce stop. With a China marker (grease pencil) mark the slot onto the chassis frame rail. Use provided pictures as reference



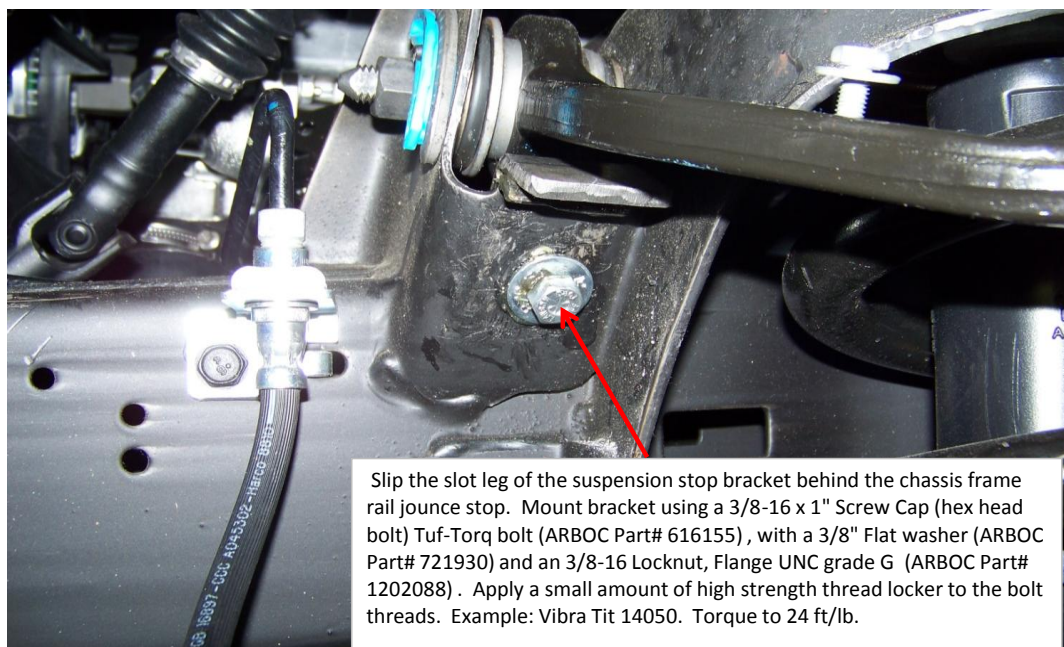
ARBOC Part# 1306381, Bracket suspension stop. Use a China marker (grease pencil) mark the slot onto the chassis frame rail.



Using a 3/8" drill bit drill to the top edge of the slot making sure to stay within your grease pencil marks.

Step 5: Clean drill shavings after drilling at each location.

Step 6: Slip the slot leg of the suspension stop bracket behind the chassis frame rail jounce stop. Mount bracket using a 3/8-16 x 1" Screw Cap (hex head bolt) Tuf-Torq bolt (ARBOC Part# 616155) , with a 3/8" Flat washer (ARBOC Part# 721930) and an 3/8-16 Locknut, Flange UNC grade G (ARBOC Part# 1202088) . Apply a small amount of high strength thread locker to the bolt threads. Example: Vibra Tite 14050.



Slip the slot leg of the suspension stop bracket behind the chassis frame rail jounce stop. Mount bracket using a 3/8-16 x 1" Screw Cap (hex head bolt) Tuf-Torq bolt (ARBOC Part# 616155) , with a 3/8" Flat washer (ARBOC Part# 721930) and an 3/8-16 Locknut, Flange UNC grade G (ARBOC Part# 1202088) . Apply a small amount of high strength thread locker to the bolt threads. Example: Vibra Tit 14050. Torque to 24 ft/lb.

Revised Date:

By:

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Step 7: Install wheels, torque to 140 ft/lb. Wheel lug nut tightening order.

