



Spartan Motors Chassis, Inc.

SB-10056344-1364

SERVICE BULLETIN

RSB14-310-002

NHTSA Id: 14V-191

7/31/2014

SUBJECT: Fuel tank mounting cross members.

CONDITION: Fuel tank mounting cross members are susceptible to cracking at the connection to the frame.

APPLIES TO: This bulletin applies to certain chassis cabs that were altered to become a transit bus. Vehicles affected by this recall were altered between June 16, 2011 and February 13, 2014.

CORRECTION: Install new fuel tank mounting cross members.

LABOR ALLOCATION: 5 hrs.

PARTS NEEDED:

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	S-2454-001	Kit-Service, Fuel Tank Mounting

Kit # S-2454-001 Contains:

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	1029-HH1-001	Welded Forward Bracket
1	1030-HH1-001	BRKT-Fuel Tank MTG RWD
1	1031-HH1-001	Stay Strap 2
1	1032-HH1-001	Stay Strap 1
2	1049-HH1-001	Strap – GM Fuel Tank Support
2	0410-BB1-001	Nut-M10X1.50, GM Lock Nut Assy.
2	0411-BB1-001	Bolt-M10X1.50, GM Fastener
6	06160100FH8Y	Bolt-3/8-16X1.00 LG FLG GR8 YEL
6	0616FLN8Y	Nut-3/8-16 FLG LK GR8 YEL
6	08130125FH8Y	Bolt-1/2-13X1.25 LG FLG GR8 YEL
6	0813FLN8Y	Nut-1/2-13 FLG LK GR8 YEL
1	1056-HH1	Install-Fuel System
1	RSB14-310-002	Document Instruction

GENERAL INSTRUCTIONS:

Please thoroughly review entire work procedure before starting work. If there are questions and/or concerns with steps defined in this procedure, contact Spartan Motors Chassis, Inc. Customer & Product Support Group.

All applicable industry safety standards must be followed when performing work identified in this procedure.



STEP-BY-STEP INSTRUCTIONS:

1. Disconnect fuel lines on driver's side of the frame rail, forward of the tank. **NOTE: Use extreme caution as not to break the fittings.** Refer to FIG. 2-1.

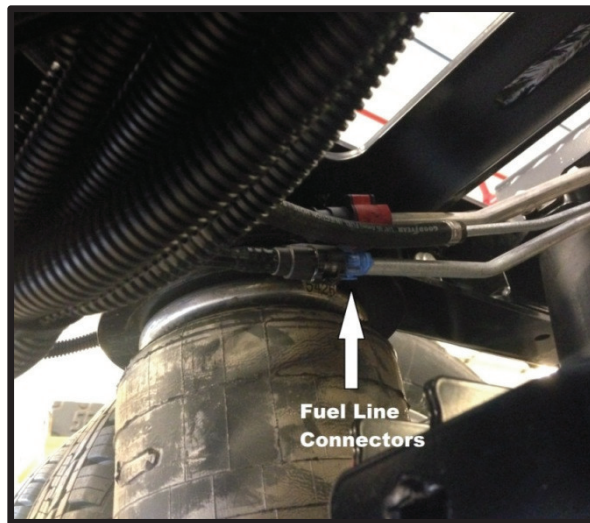


FIG. 2-1

2. Loosen clamp on fuel filler hose and slide out of frame rail.
3. Remove tank straps. Properly dispose of straps.
4. Support fuel tank using appropriate jack and remove the hardware on the four corners. Properly dispose of hardware.

NOTE: If the chassis is a diesel, there will be spacers at the rear most fuel tank mounts. These spacers and hardware should be properly disposed of as they will not be re-used with the new mounts.

5. While supporting the tank, carefully lower tank to gain access to fuel fill vent hose and fuel pump wiring harness.
6. Disconnect fuel fill vent line.
7. Disconnect fuel pump wiring connector.
8. Lower fuel tank using jack.
9. Cut off huck fasteners securing rear mount to frame.



10. Remove and properly discard rear mount.
11. Remove hardware securing wiring harness and ground wires from front mount. Properly dispose of hardware.
12. Cut off and remove the driver's side huck fastener.
13. The front fuel tank mount will have to be cut so that it can be removed. **NOTE: Protect wiring harness and air lines; use extreme caution to not damage these components when cutting bracket.** Cut off the end of the bracket. Refer to FIG. 3-1.



FIG. 3-1

14. Cut off the passenger side huck fastener and remove mount. Properly discard mount.
15. Drill the new 17/32" holes in the frame for the new brackets. Refer to FIG. 3-2.

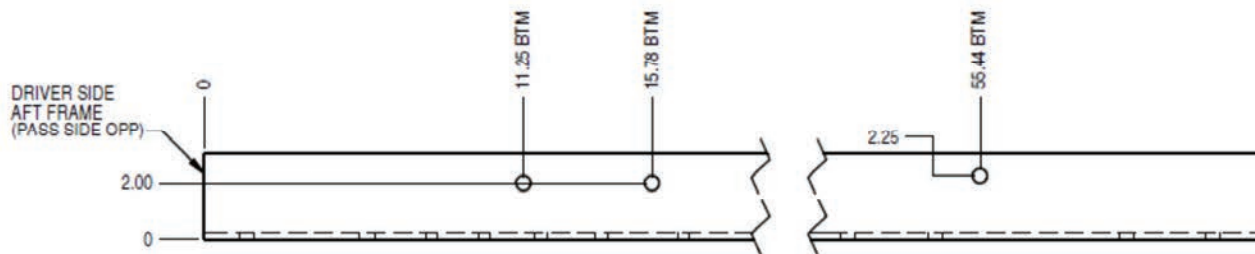


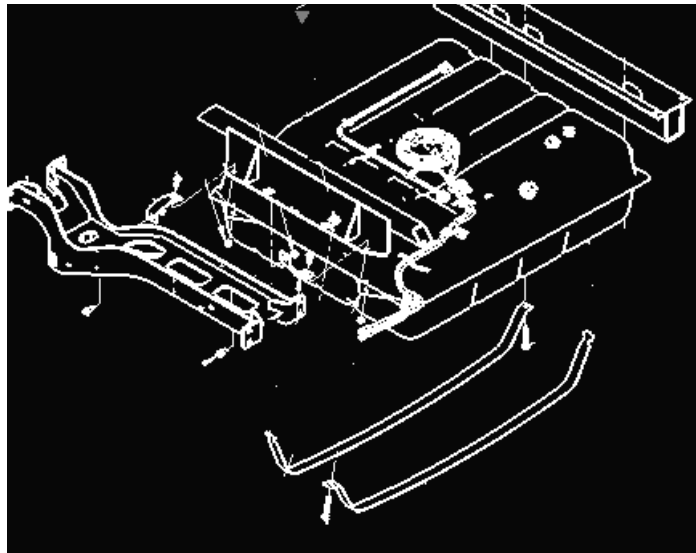
FIG. 3-2

16. Temporarily install the front fuel tank mount.



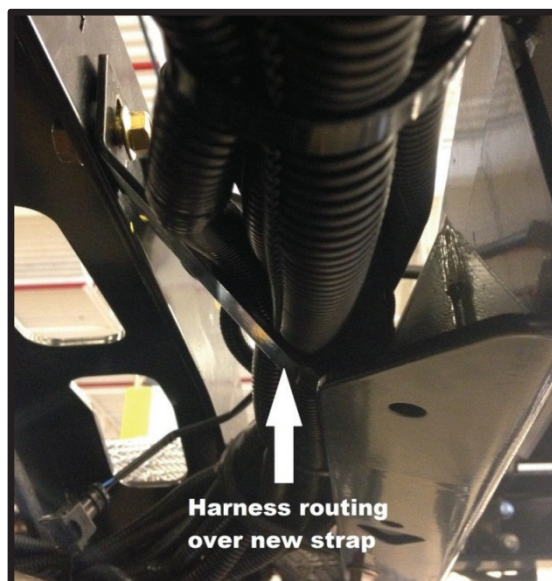
17. Align the short straps as shown in FIG. 4-1 and the holes to be drilled in the suspension cross member. After holes have been marked remove temporarily installed front fuel tank mount to allow access to drill holes. **NOTE: Use caution when marking the hole on the driver's side to clear the weld on the back side of the bracket then drill holes to 21/64".**

FIG. 4-1



18. Install front fuel tank mounting bracket and torque hardware to 67-82 lbs. ft.
19. Install short straps on top of fuel tank bracket and suspension. Be sure to route wiring and air lines above the driver's side strap. Refer to FIG. 4-2. Failure to do so will cause interference between suspension parts, harnesses, and air lines. Install retained wiring clamp and ground screw to new bracket.

FIG. 4-2





Spartan Motors Chassis, Inc.

SERVICE BULLETIN

RSB14-310-002

NHTSA Id: 14V-191

7/31/2014

20. Install provided rear fuel tank mount.
21. Carefully raise fuel tank into position and reconnect fuel fill breather hose and fuel pump wiring harness. Be sure to route harness through the clips on the tank.
22. Continue to raise the fuel tank and install the four corner fasteners. Torque hardware to 31 lbs. ft.
23. Install fuel tank straps and torque to 15 lbs. ft.
24. Reconnect fuel lines in front of tank and ensure proper lock engagement.
25. Start chassis and verify there are no leaks.