



SB-10056559-3160

Vision Propane Engine Crossmember Mounting Bracket

BULLETIN

Models Affected: All Ford 6.8L Propane Vision Models

ISSUE

The upper mounting capscrews and lower studs that retain both sides of the engine mount crossmember to the chassis frame bracket assembly may break.

CORRECTIVE ACTION

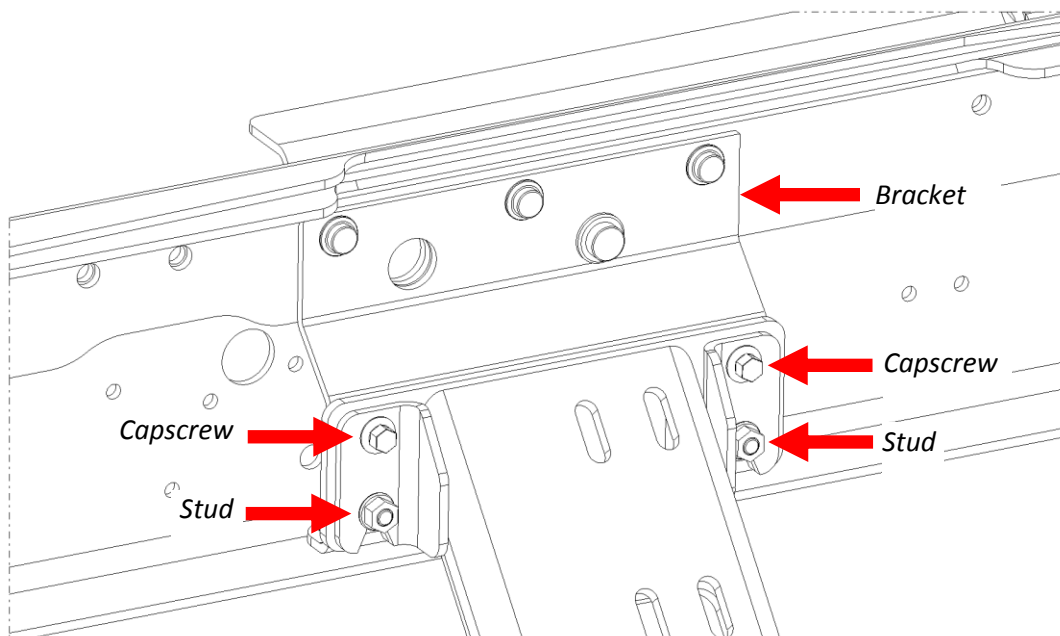
Inspect and repair per instructions below.

PROCEDURE

WARNING: Always follow all Federal, State, Local, and Shop safety standards and use proper safety equipment, and thoroughly read and understand all instructions before performing these procedures.

Inspection

1. Park the bus on a level surface, apply parking brake, turn off engine, remove keys, and chock wheels.
2. Locate the four fasteners indicated below. Two capscrews on top and two studs with nuts below. Inspect LH side and RH side for any broken fasteners. If no broken studs, re-inspect every 4,000 to 6,000 miles until the vehicle reaches 36,000 miles. If any studs are broken, repair per instructions on the following pages.



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After Inspection Actions

If no capscrews/studs are broken on initial inspection:

1. Re-inspect every 4,000 to 6,000 miles until the vehicle reaches 36,000 miles.

If capscrew(s)/stud(s) is broken on RH side:

1. Install new brace from engine crossmember to bottom of frame rail at RH bracket with **New Brace Installation** pages 3-5.
2. Repair broken capscrew/stud with **Repair Broken Stud** page 6.
3. Replace tops capscrews on RH ONLY per **Replace Upper Capscrews** page 7.
4. See Parts List A for one capscrew/stud and Parts List B for two capscrews/studs page 8.

If all fasteners fail on RH side:

1. Install new brace from engine crossmember to bottom of frame rail at RH bracket with **New Brace Installation** pages 3-5.
2. Repair broken capscrew/stud with **Repair Broken Stud** page 6.
3. Replace tops capscrews on both RH and LH per **Replace Upper Capscrews** page 7.
4. See Parts List C page 9.

If a unit has had broken capscrew(s)/stud(s) and has been repaired prior to receiving Service Bulletin S14XL:

1. Install new brace from engine crossmember to bottom of frame rail at RH bracket with **New Brace Installation** pages 3-5.
2. See Parts List D page 9.

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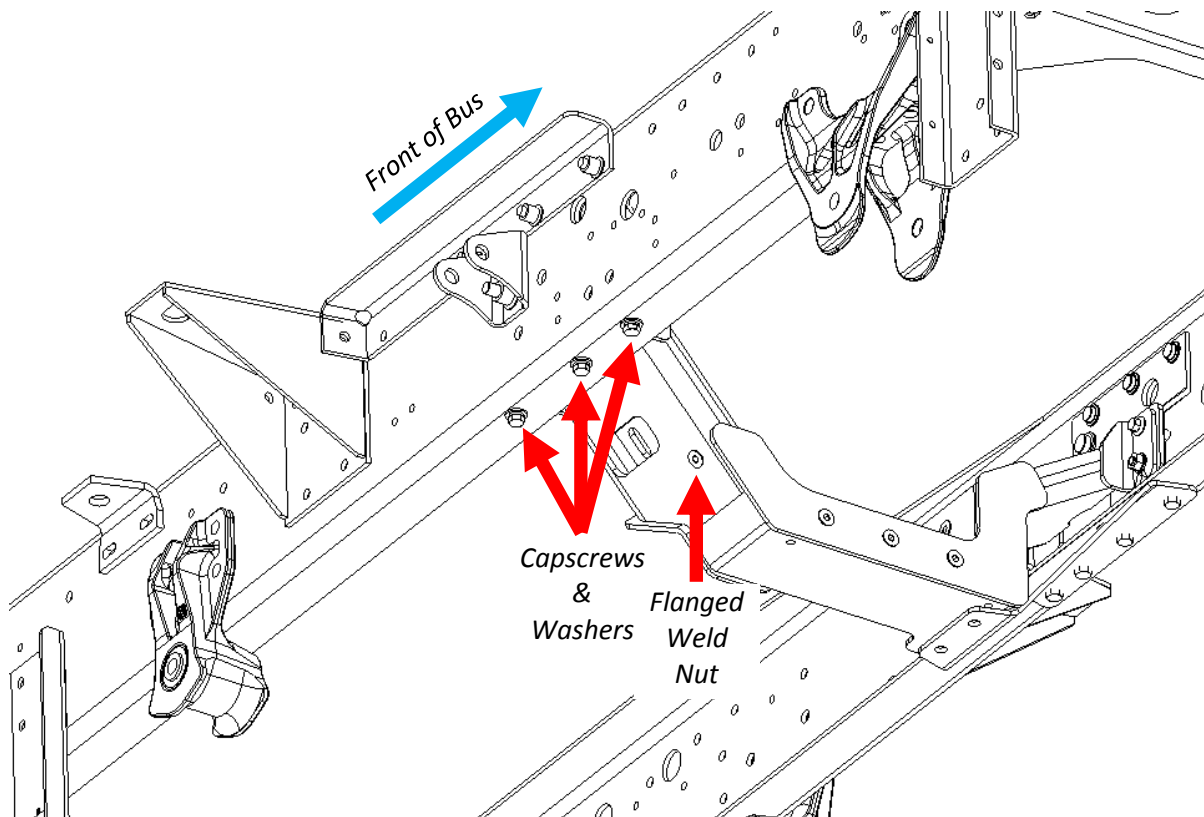


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New Brace Installation

1. Park the bus on a level surface, apply parking brake, turn off engine, remove keys, disconnect battery and chock wheels. Disconnect the battery cables by disconnecting the negative cable first.
2. Locate and remove three capscrews and washers that attached bottom of RH engine mounting bracket to the frame rail. Retain capscrews for step 4, discard washers.
3. Remove flanged weld nut from right hand outside of engine crossmember by grinding off welds. Paint to prevent corrosion.



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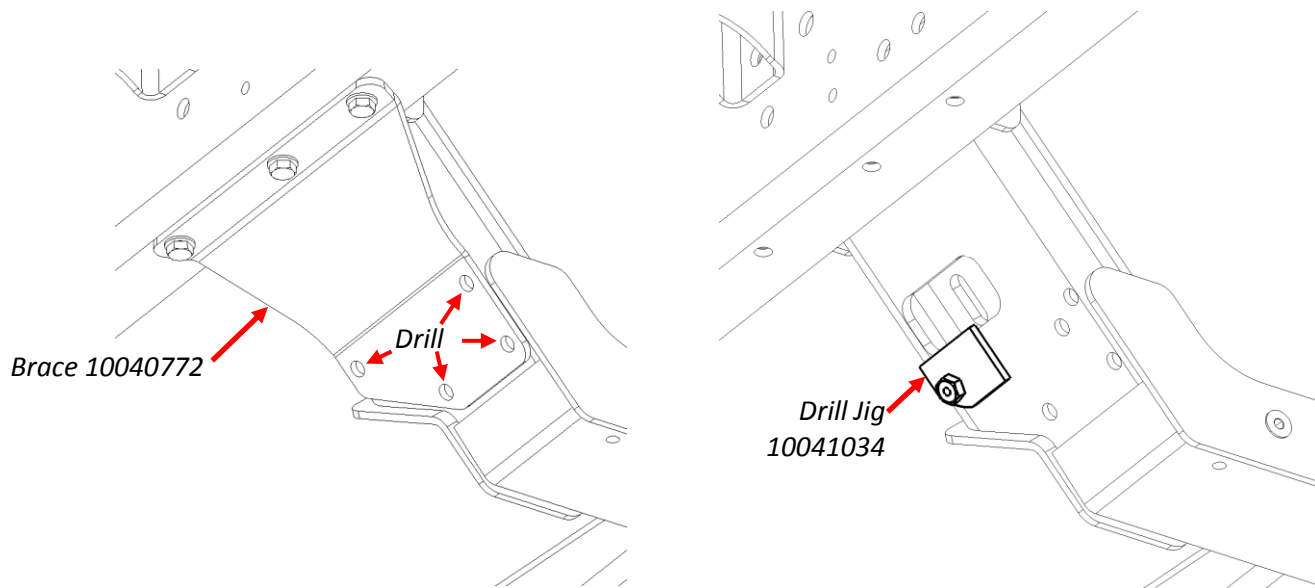


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New Brace Installation

4. Using the three capscrews removed in step two, install brace 10040772 to bottom of frame rail and tighten, do not torque.
5. Using brace as a drill jig, drill four 17/32 inch diameter holes into the outside of engine crossmember. Note: Use short drill bits. Do not drill into other side of crossmember at this time.
6. Remove brace by removing three capscrews in bottom of frame rail. Discard these three capscrews.
7. Using jig 10041034, drill four 1/4 inch pilot holes in the opposite side of engine crossmember. Then drill these out to 17/32 inch diameter.



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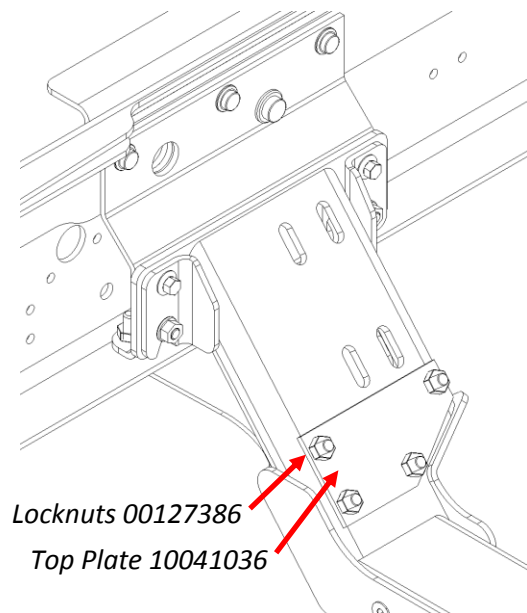
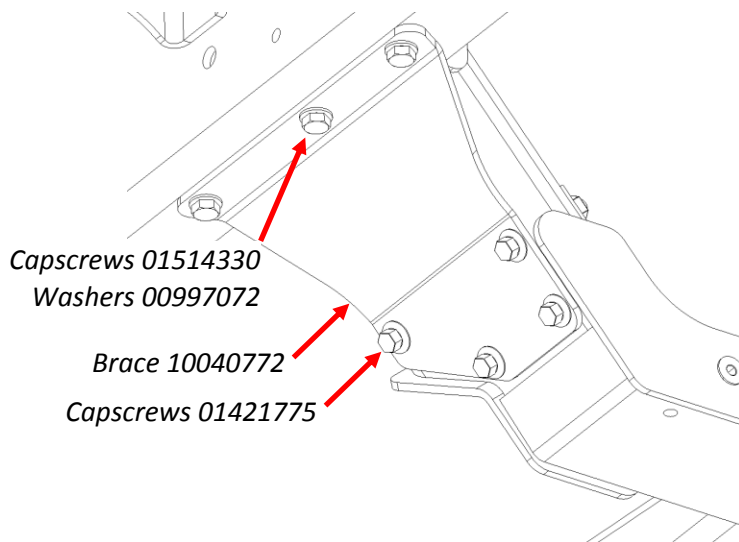


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New Brace Installation

8. Attach brace 10040772 to bottom of frame rails with three new M12-1.75 X 40 MM long capscrews 01514330 and hardened flat washers 00997072. Do not tighten. Apply Loctite® Threadlocker Blue 242® to capscrew threads before installing.
9. Place top plate 10041036 on top of engine crossmember. Install four (4) M12-1.75 X 80 MM long capscrews 01421775 through new brace, engine crossmember, and top plate. Install four (4) flanged hex head lock nut 00127386 finger tight.
10. Torque all seven capscrews to 70-80 ft-lb.



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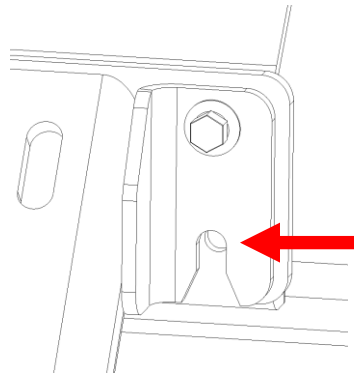


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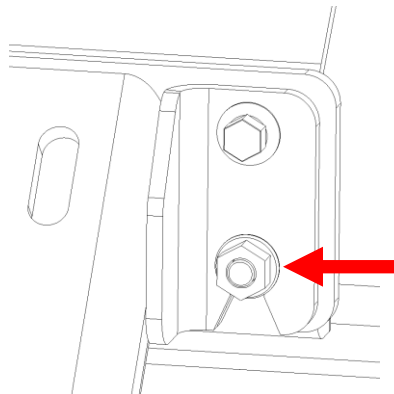
Repair Broken Stud

1. Park the bus on a level surface, apply parking brake, turn off engine, remove keys, and chock wheels.
2. Disconnect the battery cables by disconnecting the negative cable first.
3. Remove wires/cables to the starter on the right side of the engine for rear stud repair.
4. Drill out the broken stud with $\frac{1}{2}$ inch bit. Recommend short bit due to limited space.
CAUTION: Do not drill into objects between the mounting brackets and frame rail such as hydraulic brake lines.



Broken/Missing lower rear stud (RH shown).

5. Install M12-1.75 X 40 MM long capscrews 01514330 from inside brackets with the threads pointed toward engine. Install hardened flat washers on both sides of bracket and flanged hex head lock nut 00127386 on engine side of bracket. Torque to 70-80 ft-lb.



New capscrew with flat washer and flanged lock nut

6. If starter wires/cables were removed, re-install and torque small nut to 3.0 - 3.5 ft-lb. and large nut to 6 - 8 ft-lb. Add protective coating to cable nuts.

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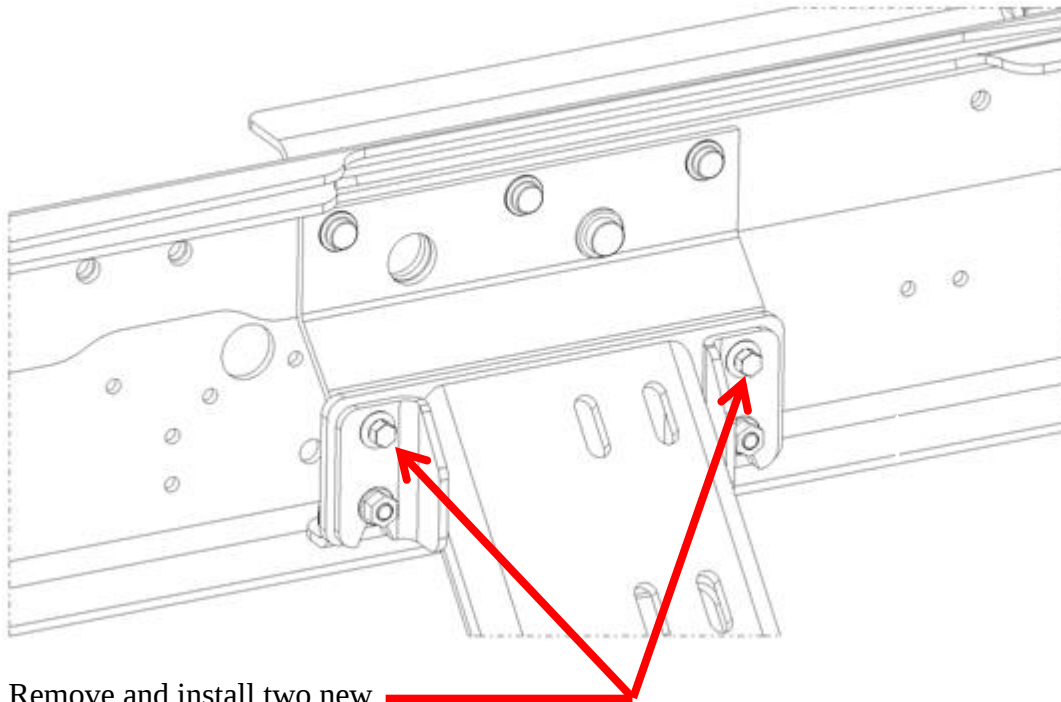


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Replace Upper Capscrews

1. Park the bus on a level surface, apply parking brake, turn off engine, remove keys, and chock wheels.
2. Disconnect the battery cables by disconnecting the negative cable first.



Remove and install two new
upper capscrews.

3. Remove each capscrew and replace with new M12-1.75 X 38 MM long capscrews 10028214. Torque to 70-80 ft-lb.

NOTES:

- a. Apply Loctite® Threadlocker Blue 242® to capscrew threads before installing.
- b. On buses with Air Conditioner Compressor on right side of engine, front capscrew may be broken loose with an air ratchet but finish removing with a wrench due to reduced space.

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PARTS LIST A: ONE STUD BROKEN

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	01514330	CAPSCREW,HX HD,M12-1.75X40,CL10.9,OLVDRBCMT	4
2	00127386	NUT, HEX HD,M12-1.75,CL 10.9, FLG LK	5
3	10040772	BRACE, REINF, CROSSMEMBER	1
4	10041036	PLATE, TOP	1
5	01421775	CAPSCREW,HX HD,M12-1.75X80,FLANGE	4
6	00997072	WASHER,FLAT,HARDENED	5
7	10028214	CAPSCREW,HX HD,M12-1.75X38,CL10.9,FORD W713728	2
8		Loctite® Threadlocker Blue 242®	Procure Locally

PARTS LIST B: TWO STUDS BROKEN

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	01514330	CAPSCREW,HX HD,M12-1.75X40,CL10.9,OLVDRBCMT	5
2	00127386	NUT, HEX HD,M12-1.75,CL 10.9, FLG LK	6
3	10040772	BRACE, REINF, CROSSMEMBER	1
4	10041036	PLATE, TOP	1
5	01421775	CAPSCREW,HX HD,M12-1.75X80,FLANGE	4
6	00997072	WASHER,FLAT,HARDENED	7
7	10028214	CAPSCREW,HX HD,M12-1.75X38,CL10.9,FORD W713728	2
8		Loctite® Threadlocker Blue 242®	Procure Locally

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PARTS LIST C: ALL FASTENERS FAILED RIGHT SIDE

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	01514330	CAPSCREW,HX HD,M12-1.75X40,CL10.9,OLVDRBCMT	5
2	00127386	NUT, HEX HD,M12-1775,CL 10.9, FLG LK	6
3	10028214	CAPSCREW,HX HD,M12-1.75X38,CL10.9,FORD W713728	4
4	10040772	BRACE, REINF, CROSSMEMBER	1
5	10041036	PLATE,TOP	1
6	01421775	CAPSCREW,HX HD,M12-1.75X80,FLANGE	4
7	00997072	WASHER,FLAT,HARDENED	7
8		Loctite® Threadlocker Blue 242®	Procure Locally

PARTS LIST D: ADD BRACE ONLY

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY.
1	01514330	CAPSCREW,HX HD,M12-1.75X40,CL10.9,OLVDRBCMT	3
2	00127386	NUT, HEX HD,M12-1775,CL 10.9, FLG LK	4
3	10040772	BRACE, REINF, CROSSMEMBER	1
4	10041036	PLATE,TOP	1
5	01421775	CAPSCREW,HX HD,M12-1.75X80,FLANGE	4
6	00997072	WASHER,FLAT,HARDENED	3
7		Loctite® Threadlocker Blue 242®	Procure Locally

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