

March 3, 2016

SERVICE BULLETIN

Service Bulletin No.: 2016-0001

Product Models Affected:

Aero Elite Ford

Steel Plate Installation/Cab Crack Repair

If there is cracking in the A-pillar area of the OEM cab sheet steel and the steel reinforcement plate is being added follow the steps below.

Step 1: Remove the headliner & trim to expose the front corner above the driver A-pillar area. See Photo #1.

Step 2: Verify that the vertical channel & plate are installed. If not, weld channel and/or reinforcement plate into place. See Photo #2.

Step 3: Using 3M panel bond adhesive 8115, fill all the voids in the corner between the sheet steel layers.

Step 4: Reassemble headliner & interior trim.

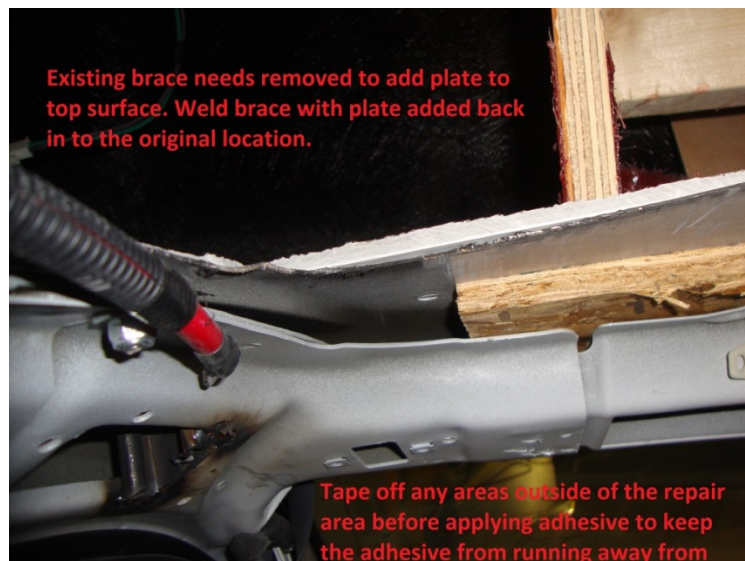


Photo #1

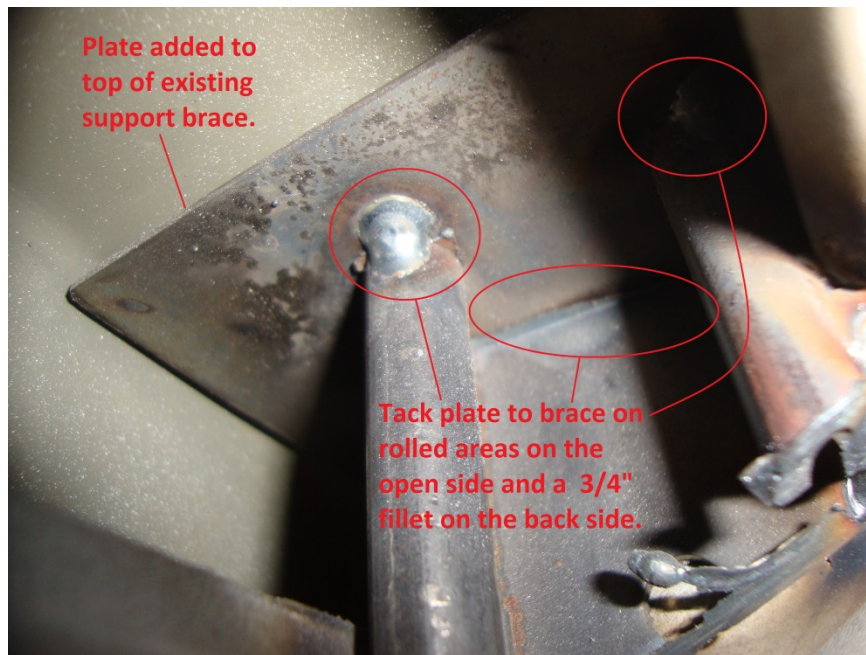


Photo #2

TIME ALLOWANCE: 1 hour total per unit.

If crack in OEM cab sheet steel does not run under the windshield or has not migrated into the windshield seat please follow the steps below.

- Step 1: Sand off paint approximately 1 ½" around the crack.
- Step 2: Stop drill a 3/32" hole at each end of the crack.
- Step 3: Weld crack. Prefer Tig weld, but Mig weld will work.
- Step 3a: After welding the crack, overlay the crack with an 18-22 gauge sheet steel patch. Where possible, patch should extend 1" from the crack. Weld patch.
- Step 4: Remove the headliner & trim to expose the front corner above the driver.
- Step 5: Verify that the vertical channel & plate are installed. If not, weld channel & plate into place.
- Step 6: Using 3M panel bond adhesive 8115, fill all the voids in the corner between the sheet steel layers.
- Step 7: Finish all bodywork to the exterior repaired areas.
- Step 8: Remove any dried & cracked sealant where the front cap meets the OEM cab.
- Step 9: Reapply sealant to front cap to OEM seam.
- Step 10: Paint repaired area.
- Step 11: Reassemble headliner & interior trim.

TIME ALLOWANCE: 12 hours total per unit.

If crack in OEM cab sheet steel runs under the windshield follow the steps below.

- Step 1: Remove the windshield.
- Step 2: Sand of paint approximately 1 ½" around the crack.
- Step 3: Stop drill a 3/32" hole at each end of the crack.
- Step 4: Weld crack. Prefer Tig weld, but Mig weld will work.
- Step 4a: After welding the crack, overlay the crack with an 18-22 gauge sheet steel patch. Where possible, patch should extend 1" from the crack. Weld patch.
- Step 5: Remove the headliner & trim to expose the front corner above the driver.
- Step 6: Verify that the vertical channel & plate are installed. If not, weld channel & plate into place.
- Step 7: Using 3M panel bond adhesive 8115, fill all the voids in the corner between the sheet steel layers.
- Step 8: Finish all bodywork to the exterior repaired areas.
- Step 9: Remove any dried & cracked sealant where the front cap meets the OEM cab.
- Step 10: Reapply sealant to front cap to OEM seam.
- Step 11: Paint repaired area.
- Step 12: Reassemble headliner & interior trim.
- Step 13: Re-install the windshield.

TIME ALLOWANCE: 14 hours total per unit.

Contact Information:

If you have questions about anything contained in this instruction document, please contact:

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