

SSM  
46219

Some 2015-2017 Low Roof Transit vehicles built on or before 30-Sep-2016 and upfitted with a roof rack may exhibit interior roof bow bracket to side panel separation. During repair, in addition to renewing the original spot welds with metal inert gas (MIG) plug welds, MIG skip weld the entire perimeter of the horizontal bracket tabs to the side panel. MIG skip welding is required to avoid excessive heat during the welding process. After finishing operations and painting, restore corrosion protection following the applicable Workshop Manual (WSM) guidelines in section 501-25. The roof rack should be mounted according to Transit Roof Rack Mounting Guidelines found in Quality Vehicle Modifier Bulletin (QVMB) Q-249 published 1-Aug-16. Refer to [www.fleet.ford.com/truckbbas/topics/qvmp.html](http://www.fleet.ford.com/truckbbas/topics/qvmp.html).