Date: March 23, 2017

SERVICE BULLETIN

Service Bulletin No.: 2017-0011

Product Models Affected:
AeroElite Ford 270 MY2010 - MY2016
AeroElite Ford 290 MY2010 - MY2016
AeroElite Ford 300 MY2010 - MY2016
AeroElite Ford 320 MY2010 - MY2016

FORM Rev 2017-0323

Purpose:
To repair cracks in the AeroElite Ford entry door frame and fiberglass front cap.

Tool(s) / Equipment Required:
Drill
Drill bits, 0.125-inch – 0.250-inch
Masking tape
#2 cross-tip screwdriver
Sanding block
Sanding disc
Plastic putty knife
Flat pry bar
Steel wool
Wire brush
Welder
Safety Glasses (PPE)
Rubber Gloves (PPE)
Dust Mask (PPE)
Weld - Helmet/Face Shield (PPE)
Weld - Leathers & Gloves (PPE)

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Part(s) / Material Required:

Description	Part Number	Quantity
Isopropyl alcohol	N/A	A/R
Corrosion inhibitor paint	N/A	1 can
Sand paper, 220 – 600 grit	N/A	A/R
Fiberglass primer	N/A	A/R
Fiberglass catalyst	N/A	A/R
Fiberglass resin	N/A	A/R
Repair Kit	CS0000102	1
Double sided tape, 3M Automotive adhesive	E52627	48-inches
Chopped strand matt – Fibre Glast	1.5oz/sq ft mat x .045”	1 YD
Drip rail	0025438-16	40”
Metal gusset plate	0034831	2
Metal backer plate	CS0000101	2
Sika-flex 252	E52631	2 tubes

Procedures:

Door Frame Preparation

Step 1: Carefully remove the drip rail if the unit has one in place and discard.

Step 2: Remove all screws on the upper part of door and remove the top two screws on either side of the vertical door frame.

Step 3: Scrape away sika-flex around the door seal on the upper part of door and down to the 2nd screw on either side of vertical door frame. Use flat pry bar and plastic putty knife to remove sika-flex and pry frame away from the body. Reference Figure 1.
Note: Ensure that the cork seal does not get damaged during this process.

Figure 1 Removed sika-flex and cork seal shown for reference.

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Door Frame Repair

Step 1: Metal backer plates, CS0000101, will need to be cut down to size on the top based on width of door. **Note: The metal backer plate length will vary based on actual door size; cut length dimensions are not included for this reason.**

Step 2: Spray both metal backer plates with corrosion inhibitor paint and allow to dry.

Step 3: Insert backer plates between the door frame and the body, the long side on top and short side on the side. **Note: The bracket should be concealed by the door frame and the body of the unit and the backer plates should meet on the top. Figure 2 and figure 3 are included for reference.**

Step 4: Reapply sika-flex to the inside of the door frame and the backer plates.

Step 5: Drill holes through the metal backer plates as it sits inside the door frame in line with the screw holes in the body of the unit.

Step 6: Re-insert screws that were previously removed, securing the backer plates and door frame to the body of the unit.

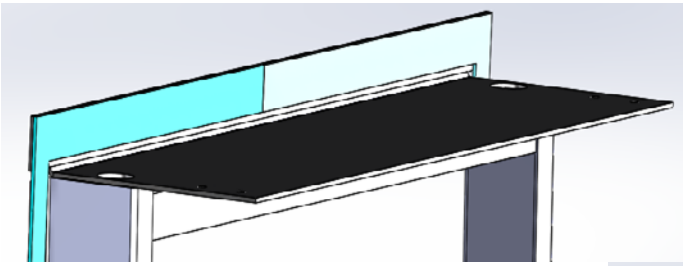

Figure 2 Metal backer plates should touch at top of frame.

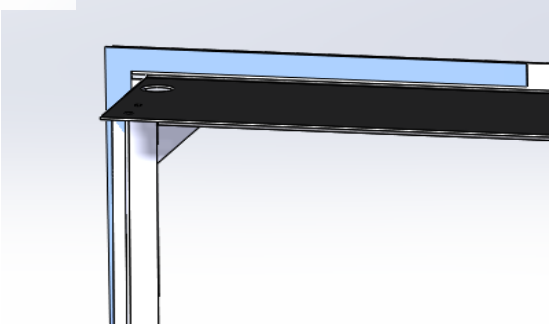

Figure 3 Back Side, metal backer plates is between frame and body.

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Door Frame Gusset Installation

Step 1: Scrape away paint in the corners of the inside of the entry door using the steel wool and wire brush. The area removed should be 4 inches down by 4 inches in. Remove all debris and ensure there is a smooth finish.

Step 2: Weld two metal gusset plates, 0034831, in place in the upper corners of the door frame, behind where the door will mount. Smooth all welds and spray welds with corrosion inhibitor paint. Figure 4 is included for reference.

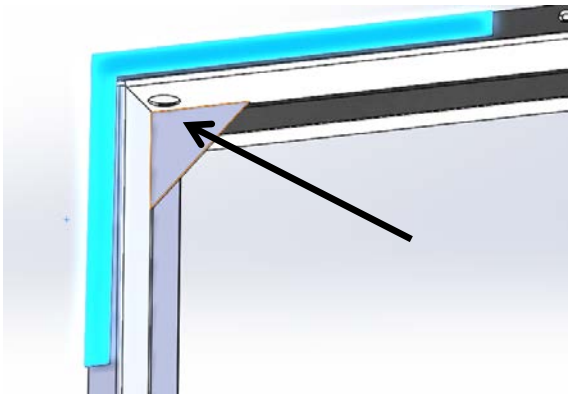

Figure 4 Front side, weld metal gusset plate in place.

Fiberglass Repair

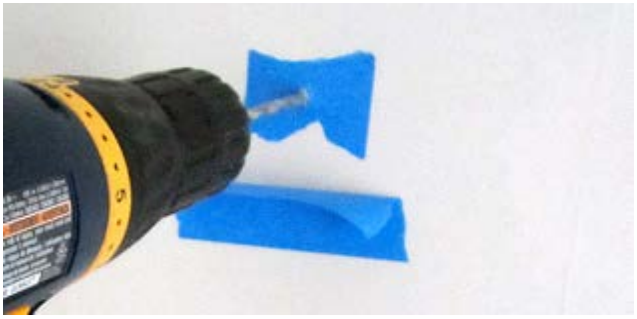

Figure 5 Apply tape over end of crack to protect the surface.

Step 1: Preparing the cracks

a. Place masking tape over the end of the crack to protect the surface. Reference Figure 5.
b. Drill a hole at the end of the crack to stop the crack from spreading.
c. Grind/Rough up 4 inches on both sides of all cracks to create a rough surface.
d. Remove all dust and debris from the roughed up surface.
e. Wipe the rough areas with isopropyl alcohol to remove fine particles and to clean area.

Step 2: Fiberglass the cracks

a. Cut fiberglass matting in strips large enough to cover at least 2 inches on both sides of the crack.
b. Mix fiberglass resin to the formula, 20 cc of catalyst to 2 quarts of resin.
c. Saturate the fiberglass matting with the fiberglass resin mixture.

Step 3: Apply fiberglass matting to the surface using a smoothing back and forth motion working from one end to the other. (This is easier than trying to apply the fiberglass matting along the whole crack at once.)

Step 4: Allow to dry 8 to 10 hours.

Ready the body for paint

Step 1: The fiberglass panel will need to be stripped and sanded before a primer is applied for painting. Using 320-grit sandpaper, remove any waxy residue or finish from the surface.

Step 2: Once the surface has the waxy residue removed, roughen the panel so the primer and the top paint can grip the surface. Use 120-grit sandpaper to roughen the surface.

Step 3: Apply a fiberglass primer to the surface of the material and allow to dry. Apply two additional coats and allow to dry.

Drip Rail Installation

Step 1: Remove all debris over the entry door area and clean the surface using isopropyl alcohol.

Step 2: Apply double sided tape to entry door in same location as it was removed. Reference Figure 6.

Step 3: Cut drip rail to size based on door frame width.

Step 4: Apply new drip rail to double sided tape. Reference Figure 6.

Step 5: Seal drip rail on top with sealant.

Figure 6 Drip rail placement and appearance for reference.

Paint the body and ensure the area stays clear of debris and the painted surface is allowed enough time to dry.

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Contact Information:
Contact ElDorado Customer Service, 1655 Wall Street, Salina, KS 67401; or by calling (785) 827-1033 / (800) 955-9086; or by Email: bussupport@eldorado-bus.com; or by Fax: (785) 827-3017.

The repair time estimate is 8 hours, not including dry time.