Date: April 5, 2017

SERVICE BULLETIN

Service Bulletin No.: 2017-0013

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 cab outer skin sheet metal.

Tool(s) / Equipment Required:
Drill
Wire brush
Sanding disc
Sanding block
Standard wrench set
Flat tip screw driver
Grout removal tool
Grinding Wheel
Welder
Rubber Gloves (PPE)
Dust Mask (PPE)
Safety Glasses (PPE)
Hearing Protection (PPE)
Weld - Leathers & Gloves (PPE)
Weld - Helmet/Face Shield (PPE)
Drill Bits

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
3M Automix Panel Bonding Adhesive 8115	N/A	1 cartridge
Automotive body filler	N/A	1 can
Windshield seal		1
Kit, Repair F550 A-Pillar	CS0000103	1
6” X 9” notched 18GA sheet steel	00389831	
4” x 12” 18GA sheet steel ASTM A-569	00389811	
Sika-flex 252	E52631	1

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Procedure:

If an exterior sheet metal crack has been identified above the windshield, follow the procedure below to repair the crack.

Prep Instructions for access to cracked area.

Step 1: Carefully remove the OEM windshield seal and the undamaged windshield, setting aside the undamaged windshield for re-installation after the sheet metal is repaired.

Step 2: Scrape away or pull away dried sealant above the windshield area without damaging the fiberglass roof cap any further. Reference Figure 1.
Note: The cracked area between the OEM cab area and the fiberglass cap will need to be accessed by scraping away the sealant.

Step 3: From inside, remove the headliner to have a visual inspection of any wiring harnesses that will need to be moved so they are not damaged.

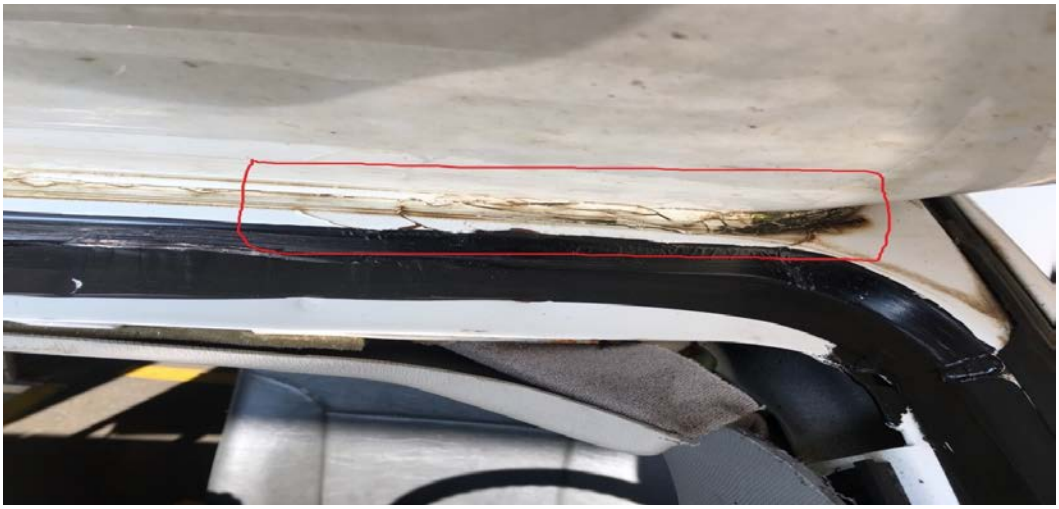

Figure 1 The area inside the red box will need sealant removed.

Apply the Support Plate:

Step 1: Apply the support plate, 0038981 (4" X 12" sheet steel) Figure 2 included for reference, by first inserting into the area above the roof and below the fiberglass front cap, in the area where the sealant was removed.

Step 2: Mark the plate along the edge of the windshield opening. Remove and cut the plate to size.

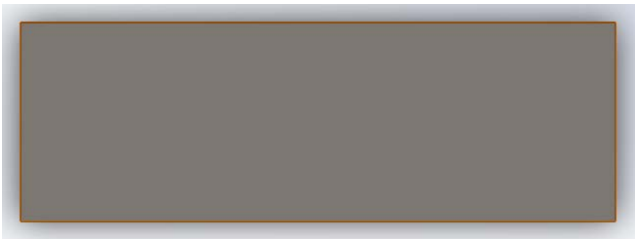

Figure 2 Support Plate 0038981.

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Outer skin repair:

Step 1: Sand the area where the sealant was removed to a smooth finish using the sanding block and sandpaper.

Step 2: Wash the surface with soap and water to remove water soluble contaminants.

Step 3: Remove all debris and loose particles and clean the area with isopropyl alcohol.

Step 4: Set previously trimmed plate in place and carefully stitch weld the entire outer edge to the OEM sheet steel. Allow the welds to completely cool before moving on.

Step 5: Grind welds smooth.

Step 6: Apply automotive body filler around the edges of the plate and sand smooth to complete the installation of the exterior plate.

Interior Skin Repair:

Step 1: Remove the farthest left fastener over the windshield opening and the farthest forward fastener between the A-pillar and B-pillar (over the driver's door opening). Figure 3 represents both fasteners that need removed.

Step 2: Apply a thin film of 3M Automix Panel Bonding Adhesive 8115 to the top side of the interior skin repair plate, 0038983.

Step 3: Install the plate above the existing plywood, against the inside of the OEM exterior sheet metal.

Step 4: Drill out the holes for the hardware that was previously removed.

Step 5: Reinstall the hardware and torque to 8 ft.-lbs.

Allow 24 hours to dry at a minimum of 70°Fahrenheit.

Note: Do not apply 3M Automix Bonding Adhesive above 90° Fahrenheit.

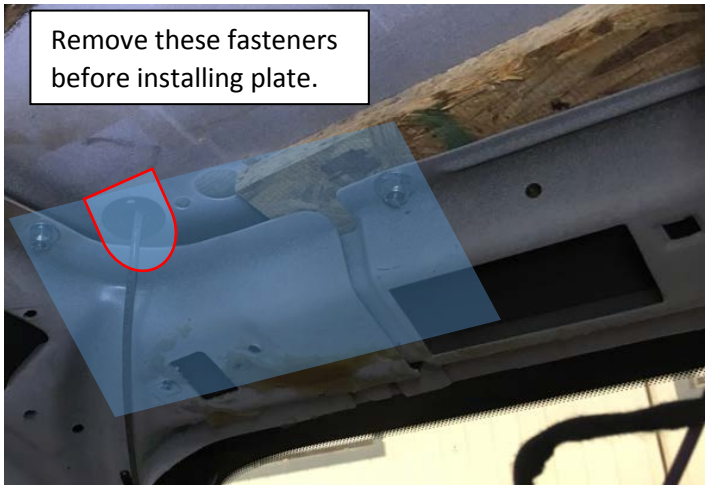

Figure 3 Roof reinforcement area with nuts that need removed.

Figure 4 Representation of 0038983

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Ready the front cap for paint

Step 1: The affected area of the fiberglass cap 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.

Step 4: Paint area with desired color.

Finish the repair process:

Step 1: Reinstall original windshield with new windshield seal.

Step 2: Clean the exterior surface with soap and water and dry.

Step 3: Clean the exterior area with isopropyl alcohol.

Step 4: Apply sika flex over the repaired area between the sheet steel and fiberglass.

Step 5: Allow the sika-flex to dry at least 24 hours.

Step 6: Replace wiring harnesses back into original position.

Step 7: Replace the cab liner pad.

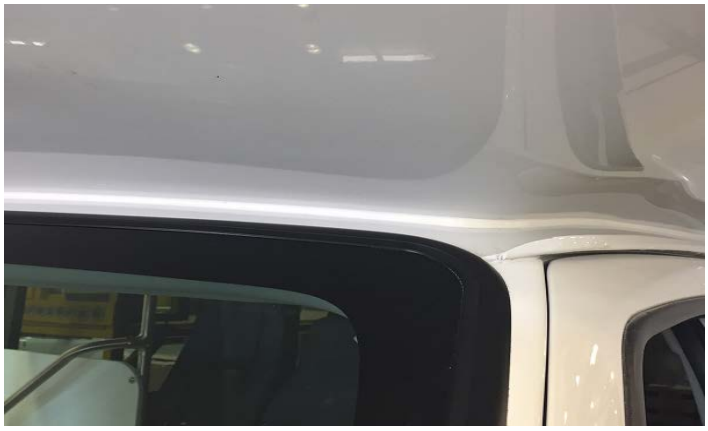

Figure 5 Finished cap included for reference.

Contact Information:

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 6 hours, not including dry time.