

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR831	Front Pivot Mount Reinforcement	1 OF 2		SER-E	C.WARD	12/2/2016

Read process before beginning. If you do not understand any part please contact: Chris Ward, VP of Parts and Warranty at 1-866-953-5555 or by E-mail @ cward@ARBOCSV.com.

Good Mechanics safety practice must be followed on any repairs.

Safety practices should include but not be limited to properly supporting the chassis, axles, blocking tires, and a work area free of clutter.

Complaint: Pivot Mounts 1306500-18 (RS) and 1306500-19 (CS) = bolts coming loose/shearing causing bracket failure

Cause: Inferior bracket support leading to bolt shearing and pivot mount movement

Correction: Add gussets and welding per instruction

Vehicles Affected: Units built with the Front Pivot Mount bolted to the ARBOC Frame without welding (SOM only between SO# 2202 and 2736)

Labor Operation Code: 0116001

Pre-Authorization Required

Labor Time Allowance: 2 hours per unit

Parts Returned: No

Tools Required

Hoist (ability to raise and support the unit)

Welder

Flame/Spark Resistant Tarp (use to protect interior harness, fuel lines, brake lines, etc.)

Parts Required

1310070 Pivot Mount Reinforcement Gusset

NAPA Rubberized Undercoating (not supplied)

Repair Instructions:

Step 1: Pull unit onto hoist, chock front tires to prevent bus from rolling forward or backwards.

Step 2: Disconnect positive (red lead) battery cable from the chassis and auxiliary battery.

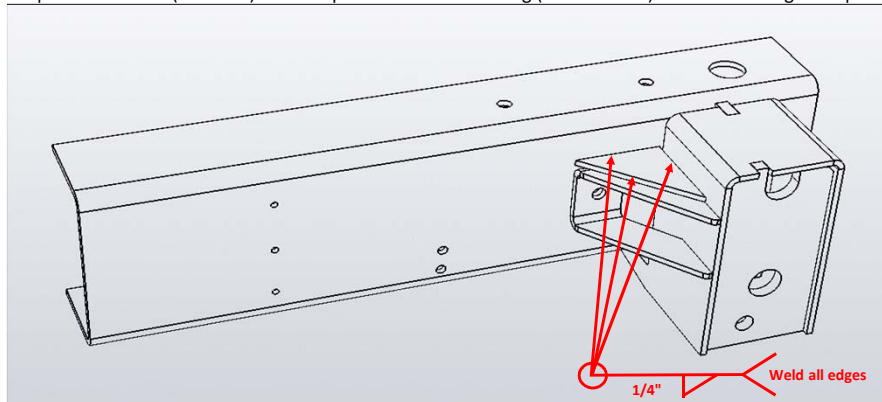
Step 3: Raise unit to a comfortable working height.

Step 4: Remove connections (p-clamps and/or clips) for fuel lines, brake lines, hoses, etc. on the interior side of chassis frame rail

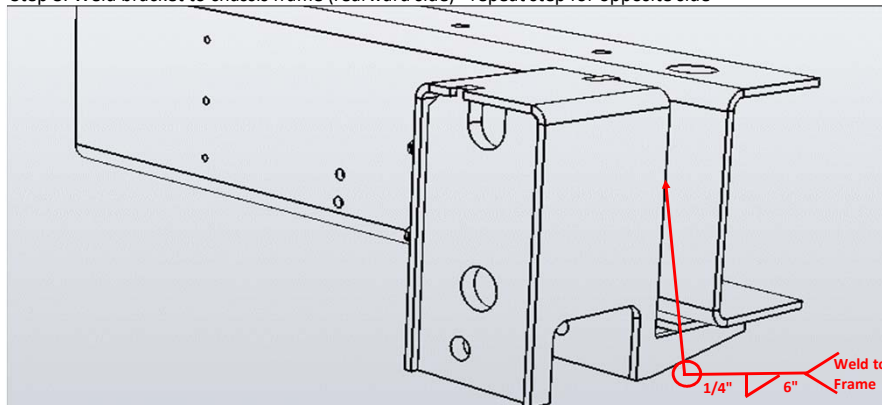
Step 5: Inspect and Torque (4) 1/2-13 Bolts to 90ft/lbs (broken bolts need to be replaced) used to mount bracket.

Step 6: Insert Flame/Spark Resistant Tarp (not supplied) between the fuel lines, brake line, hoses, harnesses, etc. to protect from damage during welding

Step 7: Add Gusset (1310070) to the top side of the bracket leg (forward side) and weld all edges - repeat step for opposite side



Step 8: Weld bracket to chassis frame (rearward side) - repeat step for opposite side



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Step 8: Remove fire/spark resistant tarp. Check area around the repair area to see no damage has occurred to the electrical harness, hose, and brake lines from grinding or welding sparks. Inspect welds for cracks.

Step 9: Using a high quality Rubberized Undercoat, paint repaired area. NAPA Rubberized Undercoating or Mac's 8400 Rubberized undercoat (not supplied).

Step 10: Lower unit and connect positive (red lead) battery cable to the chassis and auxilliary battery.

Step 11: Remove from hoist