

**"DOCUMENT UNCONTROLLED IF PRINTED"**

| DOC #        | PROCESS NAME                          | PAGE          | REVISION | STATION      | BY            | DATE             |
|--------------|---------------------------------------|---------------|----------|--------------|---------------|------------------|
| <b>AR835</b> | <b>Upper Shock Mount Crack Repair</b> | <b>1 OF 2</b> |          | <b>SER-V</b> | <b>C.WARD</b> | <b>2/22/2017</b> |

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:** Cracks at Shock Mount Bracket on Frame

**Cause:** Inferior weld

**Correction:** Drill 1/8" Stop Holes into Frame at the end of cracks and weld Fish Plates over the affected cracked areas

**Vehicles Affected:** Units with cracking at Upper Shock Mount

**Labor Operation Code:** 0110401

**Pre-Authorization Required & Photo**

**Labor Time Allowance:** 1 hour

**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**

1306895 Plate, Fish Kick Up Repair (Modified)

NAPA Rubberized Undercoating (not supplied)

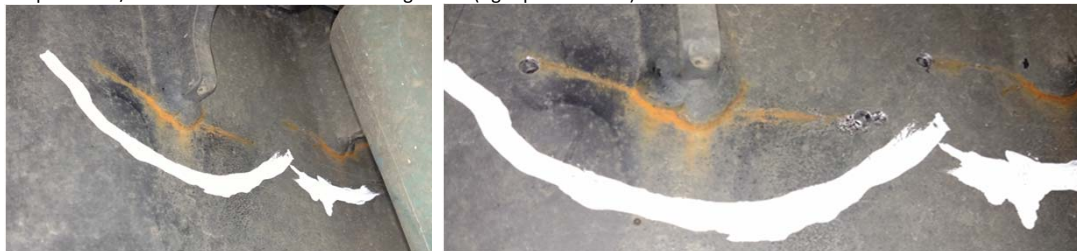
**Repair Instructions:**

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: Drill 1/8" hole at the ends of the existing cracks (right photo below)



Step 5: Weld crack and Clean



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Step 6: Add plate and stitch weld



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