



**DATE:** 2-13-17

**APPLIES TO:** This service bulletin applies to 2011-2017 model year transit bus chassis cabs altered by Spartan Motors, USA Inc. built between June 16, 2011 and December 1, 2016.

**CONDITION:** Inadequate air spring clearance from sway bar.

**CORRECTION:** Replacement of front sway bar

**LABOR ALLOCATION:** 1.0 hrs.

**CLASSIFICATION:** V

**PARTS NEEDED:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	S-2573-001	Kit-Swaybar SVC, Bus

**Kit # S-2573-001 Contains:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	0460-SS2-001	Kit, Sway Bar SVC, Bus
1	TSB16-250-003	Instruction Document
1	TSB16-250-004	Instruction Document

**GENERAL INSTRUCTIONS:**

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Motors USA, Inc. Customer & Product Support Group.

All applicable industry safety standards must be followed when performing work identified in this procedure.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



STEP-BY-STEP INSTRUCTIONS:

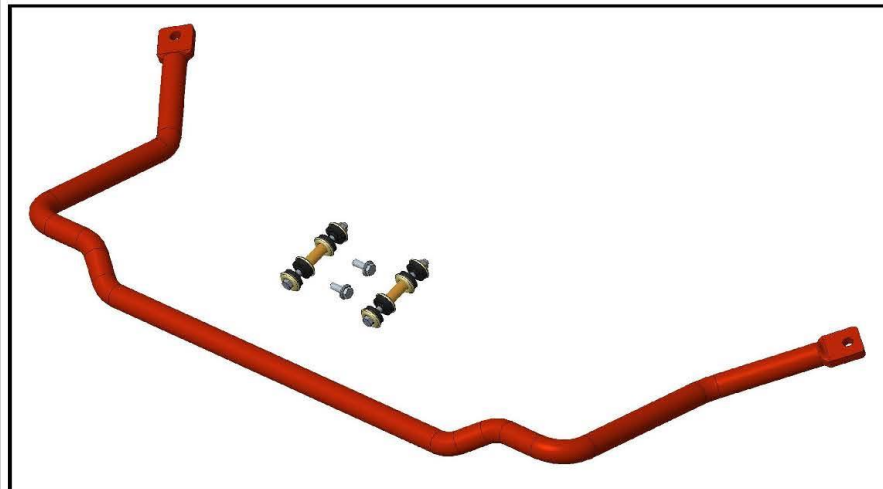
FRONT SWAY BAR REPLACEMENT MANUAL



# Glaval Titan II LF Bus

Replacement Front Sway Bar

Link Kit 800M0266



For Replacing Front Sway Bar in Link Suspension 8M000133  
Part of Glaval's Titan II LF Bus

80003241  
JAN 26, 2017

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



Read this manual before replacing Front Sway Bar in your UltraRide® suspension.



223 15th Street N.E.  
Sioux Center, Iowa 51250

For questions with your UltraRide suspension, please contact us toll free at (800) 222-6283

Visit [www.LinkMfg.com](http://www.LinkMfg.com)





## INTRODUCTION

All information in this manual is based on the latest information available at the time of printing. Link Manufacturing reserves the right to change its products or manuals at any time without notice. Contact Link at (800) 222-6283 for information on recent changes to products.

Damaged components should be returned to Link with a pre-arranged Returned Goods Authorization (RGA) number through the Customer Service Department. The damaged component may then be replaced if in compliance with warranty conditions.

No alterations of any Link component is permitted without proper authorization from qualified Link personnel.

## SAFETY SYMBOLS and TORQUE SYMBOL

	This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.	 CAUTION	CAUTION indicates a potentially hazardous situation which, if not avoided, could result in minor or moderate injury.
 WARNING	WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.		The torque symbol alerts you to tighten fasteners to a specified torque value.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



# FRONT SWAY BAR REPLACEMENT

This procedure requires a vehicle lift or floor jack, jack stands, and torque tools (refer to Figure 2 for required torque values).

## 1. Disassembly of the Front Sway Bar

 <b>CAUTION</b>
The vehicle lift can damage the body due to the low ground clearance. Use caution when rolling vehicle lifts under wheels.

- Apply the parking brake. Lift the vehicle up to a comfortable working height. If a vehicle lift is not available, jack up the front of the vehicle so the wheels are just touching the ground.
- Lower the vehicle onto jack stands supporting the front frame cross member.

 <b>WARNING</b>
<b>Serious injury</b> could occur if components are removed and the vehicle is not well supported. Prior to removing components, make sure the vehicle is secure in the lift and the parking brake is applied.

- Inspect air springs before draining pressure. If there has been extended wear on either air spring from frictional contact with the sway bar such that a visible layer of rubber is worn away, replace that air spring.
- To remove air pressure from the springs, locate the suspension manifold block located on the driver side frame rail towards the rear of the vehicle.

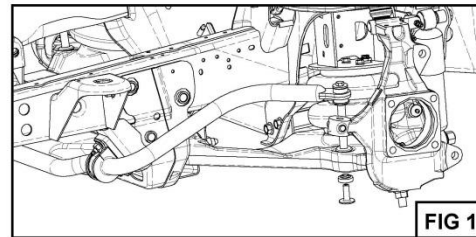
 <b>WARNING</b>
<b>Serious injury</b> could occur if components are removed while the air system is pressurized. If maintenance or service is to be done on the suspension, be sure to drain <b>all</b> air from system.

- Drain the air pressure from the front springs using the Schrader valve at port C of the manifold block.
- After draining air, remove the Schrader valve from port C to relieve any residual pressure. The Schrader valve may be reinstalled immediately after relieving pressure.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

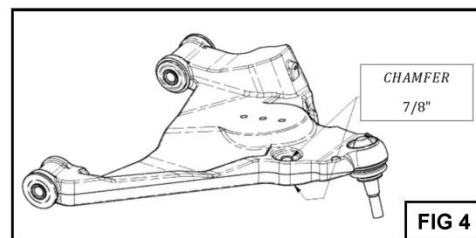
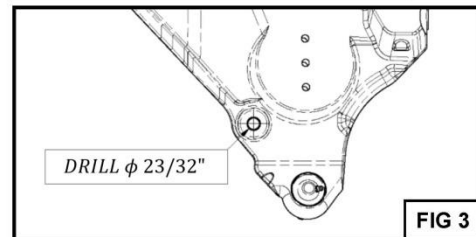
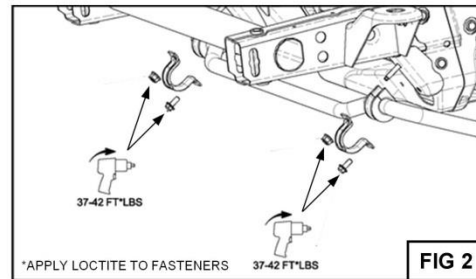


- ❑ Remove the nut and bushing from the stabilizer bar linkage. Disconnect the stabilizer bar linkage from the stabilizer bar and lower control arm (LCA). Fig. 1
- ❑ Remove the bolt and nut from both sway bar "D" bushing straps and remove the sway bar and sway bar shims. Retain the nuts and straps for reuse. Fig. 2



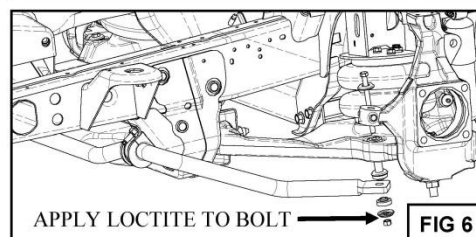
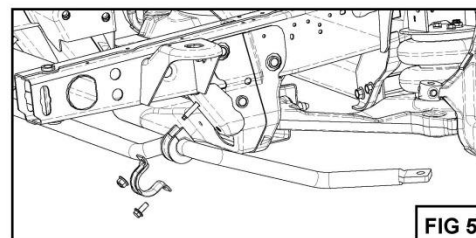
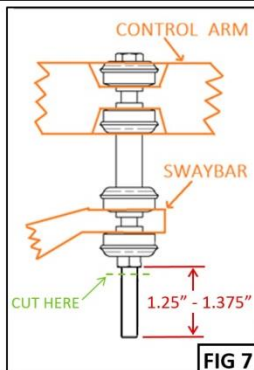
**2. Assembly and Installation of the New Sway Bar**

- ❑ Enlarge the sway bar linkage mounting hole in the LCA's using a 23/32" drill bit. Use appropriate cutting fluid. Chamfer the holes using a 7/8" drill bit. Fig. 3 & 4
- ❑ Remove the "D" bushings from the sway bar and verify they are in good condition.
- ❑ Position the "D" bushings on the new sway bar.
- ❑ Mount the sway bar to the chassis. **DO NOT** reinstall the sway bar shims. The ends of the new sway bar will be below the LCA's. Apply Loctite and torque the "D" bushing M10 fasteners to the values given in Fig 2. Fig. 5
- ❑ Assemble the new linkages to the LCA's and sway bar. Orient the bolt with the threaded end down. Apply Loctite to the bolt threads and tighten the locknut until the rubber bushings deform and fill their cup washers as shown in Fig. 8. The exposed thread below the nut should fall within the range shown in Fig. 7. Remove the extra length of the bolt close to the lock nut such that 2-3 threads are visible. Then paint the cut end. Fig. 6 & 7
- ❑ Verify all fasteners have been torqued properly.
- ❑ It is recommended the vehicle be cycled to the kneeled (lowered) height once upon completed install to ensure proper operation.



**⚠ WARNING**

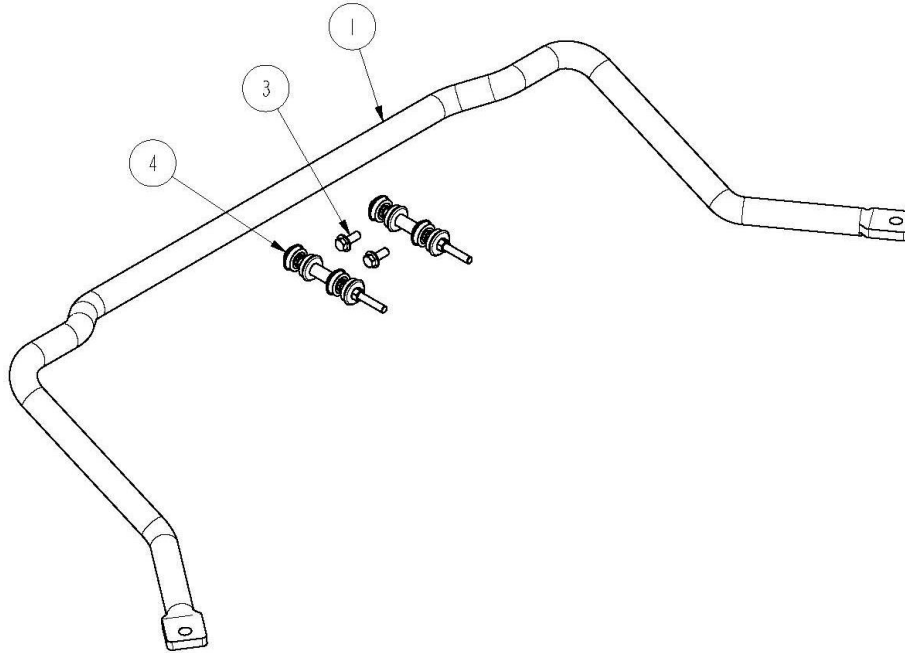
**Proper fastener torque is vital to prevent component failures which may result in injury or death.**



Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



## 800M0266 PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	QTY
1	80003225	SWAYBAR-GLAVAL	1
2	80003241	MANUAL-INSTALLATION, SWAYBAR FIELD REFIT	1
3	141B1005	HEAVY HEX FLNG SCR M10X1.5X25 CLS 10.9	2
4	800M0265	LINKAGE-SHORTENED SWAYBAR, SPARTAN GLAVAL	2

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



Link Mfg. Ltd.  
223 15th St. NE  
Sioux Center, IA USA  
51250-2120

(712) 722-4874

<http://www.linkmfg.com/>

6

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.