



## Long Sill Welds Service Bulletin

**Customer:** Multiple

**Situation:** Missing welds at long sill angles

**Corrective Action Summary:** Weld long sill joints

**Range of Units Affected:** 2015-2016 Truck Body on the 16' and 24' International cab chassis equipped with Maxon liftgate, manufactured between March 2014 and June 2015. Contact Utilimaster Warranty Department to verify chassis VIN.

**Authorized to Perform the Work:**

- Customer or customer contractor
- Utilimaster or Utilimaster contractor

**Tools Required:**

In addition to standard shop tools this job also requires:

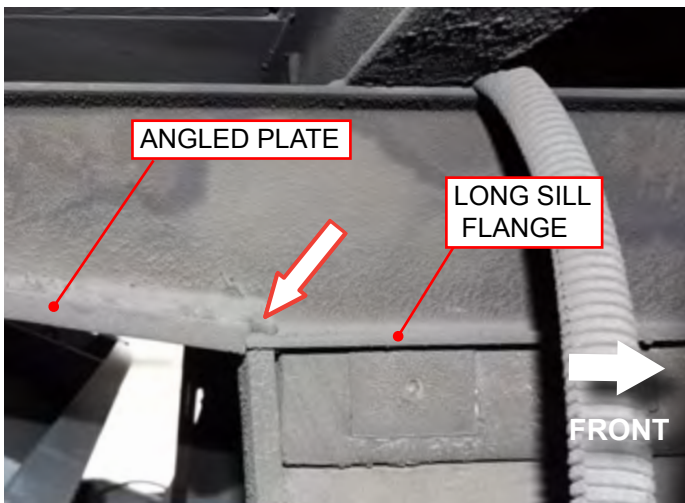
- Grinder with abrasive blade and wire wheel
- Welder
- Spray undercoating

## **CAUTION**

Always wear safety glasses and other proper protective equipment (gloves, hearing protection, etc.) as appropriate to the process.

### Inspection:

1. Read and understand all the instructions before starting the repair.
2. From below the floor at rear structure and forward of liftgate, visually inspect the long sills at the transition area from the full beam to the start of the taper cut.
3. If no welds are missing or incorrect between lower flange and angled steel plate, NO further repair is necessary.
4. If weld is incomplete between lower flange and angled steel plate joint, proceed with repair.



*Correct weld at flange*



*Incomplete weld (A) at LH long sill*



*Separation at wood keeper does not affect safety of the motor vehicle. This is a non-structural component.*

## Procedure:



*Overview of weld reinforcement repair*

1. Use a die grinder to remove undercoating around sill flange welding areas.
2. Weld any gaps on bottom flange and angled steel plate joints at the long sill. Weld a continuous bead with no gaps between lower flange and angled plate. Fill in joint crevice with 1/8" weld between long sill flange and angled plate.
3. Spray undercoating around weld area.
4. Reference Job Op Code 13-Q2-C2-19 when submitting warranty.

***NOTE: In order to be reimbursed for labor, the repair MUST be completed and warranty claim filed within 1 year from the initial date of this publication.***

**File Warranty By: 5/31/18**

**Contact Utilimaster to Order Parts and File Warranty**

**Email:** [Warranty@Utilimaster.com](mailto:Warranty@Utilimaster.com)

**Phone:** 574-848-2000

**Mail or Express Service:**

**Fax:** 574-848-2809

Utilimaster

Attn: Warranty Dept.

603 Earthway Blvd.

Bristol, IN 46507-9182, USA

**Inspect and Repair:** 0.75 hour

**Job Op Code:** 13-Q2-C2-19

**Document Part Number:** 03102101-B014EN

**Revision:** A

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