



## Liftgate Subframe Interference Service Bulletin

**Customer:** Multiple

**Situation:** Liftgate interference may cause fissures in long sills

**Corrective Action Summary:** Weld plates to long sills

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

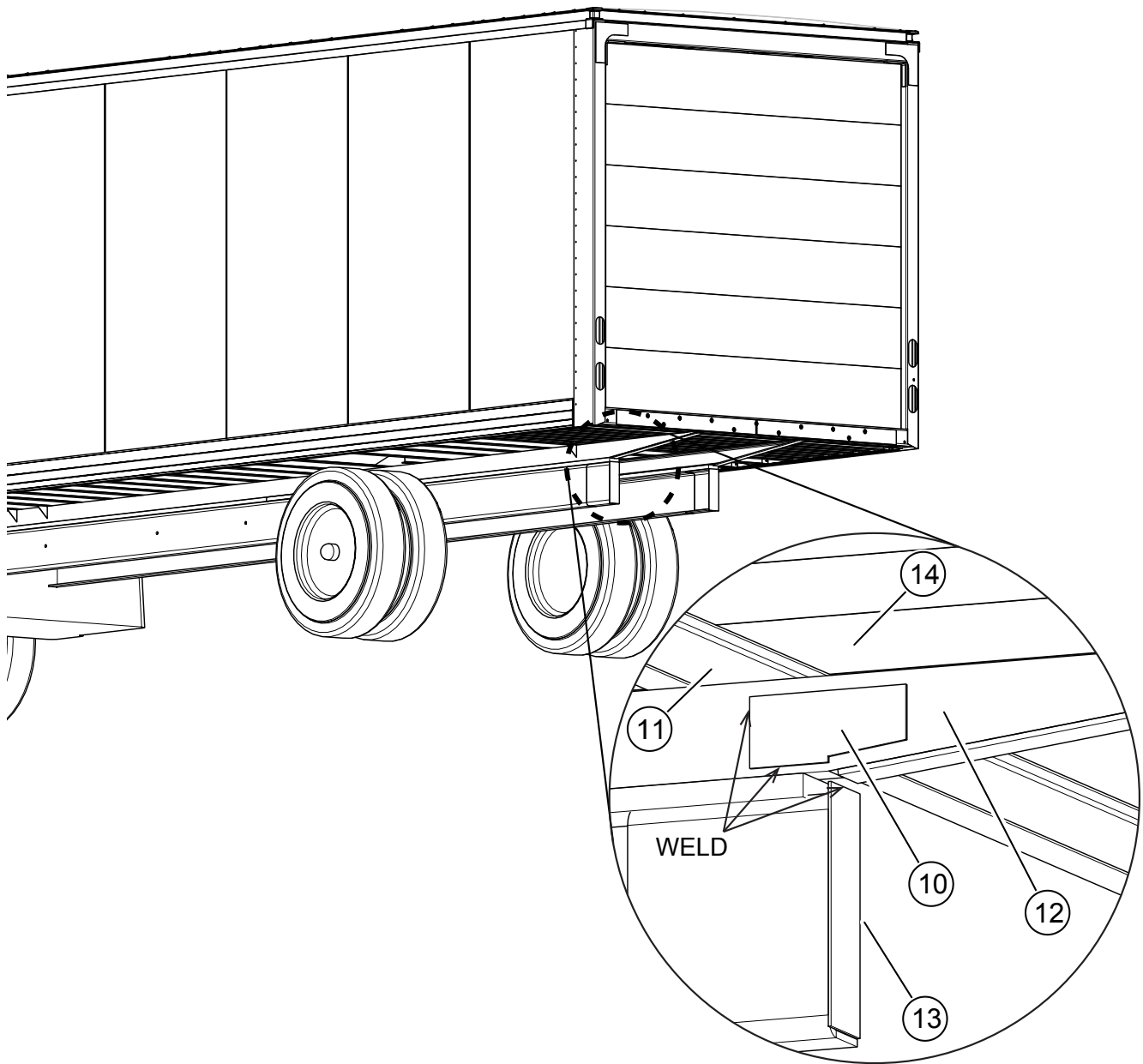
**Authorized to Perform the Work:**

- Customer or customer contractor
- Utilimaster or Utilimaster contractor

**Tools Required:**

In addition to standard shop tools this job also requires:

- Drill with 7/32" bit
- C-Clamp
- Grinder with abrasive blade and wire wheel
- Welder



*Overview of subframe long sills (liftgate omitted for clarity)*

**Parts Required:**

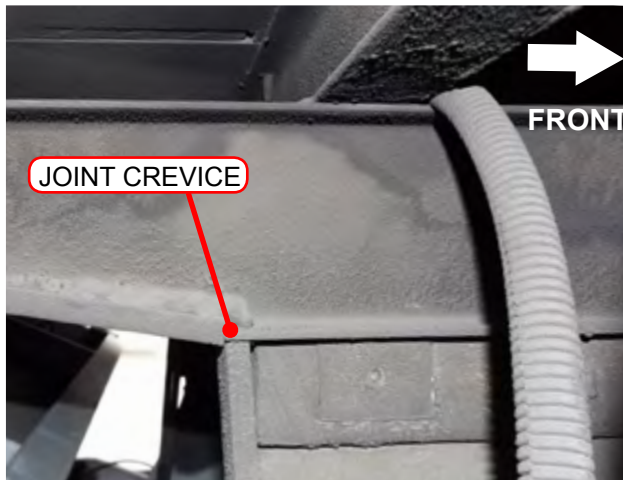
BOM ID	Part Number	Description	Qty
0	REFERENCE	64302433 SUBFRAME FOR LIFTGATE	
10	22827980	PLATE REINFORCEMENT 3.00 x 7.00	2
11	REFERENCE	CROSSMEMBER	
12	REFERENCE	LONG SILL	
13	REFERENCE	CHASSIS FRAME RAIL	
14	REFERENCE	FLOOR	
NS_1	03104479	DECAL SERVICED JOB CODE	1
NS_2	03102101-B013EN	LIFTGATE SUBFRAME INTERFERENCE BULLETIN	1

## **CAUTION**

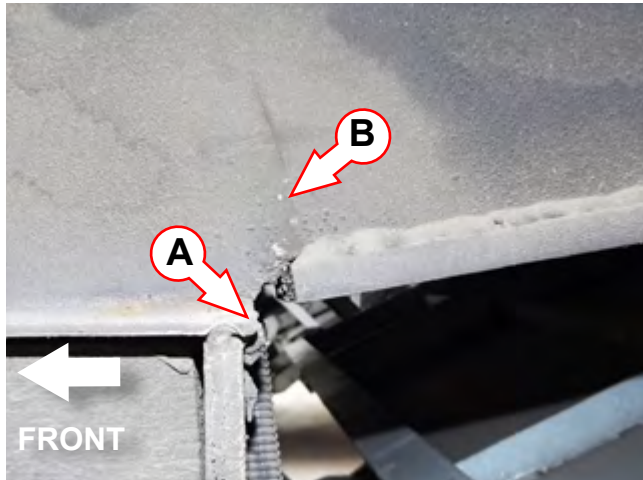
Always wear safety glasses and other proper protective equipment (gloves, hearing protection, etc.) as appropriate to the process.

### **Inspection:**

1. Read and understand all the instructions before starting the repair.
2. From below the floor at rear structure and forward of lift gate, visually inspect the long sills at the transition area from the full beam to the start of the taper cut.
3. If no fissures are visible at taper point, and welds are not missing or incorrect between lower flange and angled steel plate, NO further repair is necessary.
4. If fissures are visible between lower flange and angled steel plate, proceed with repair.



*Correct weld and no joint at flange*

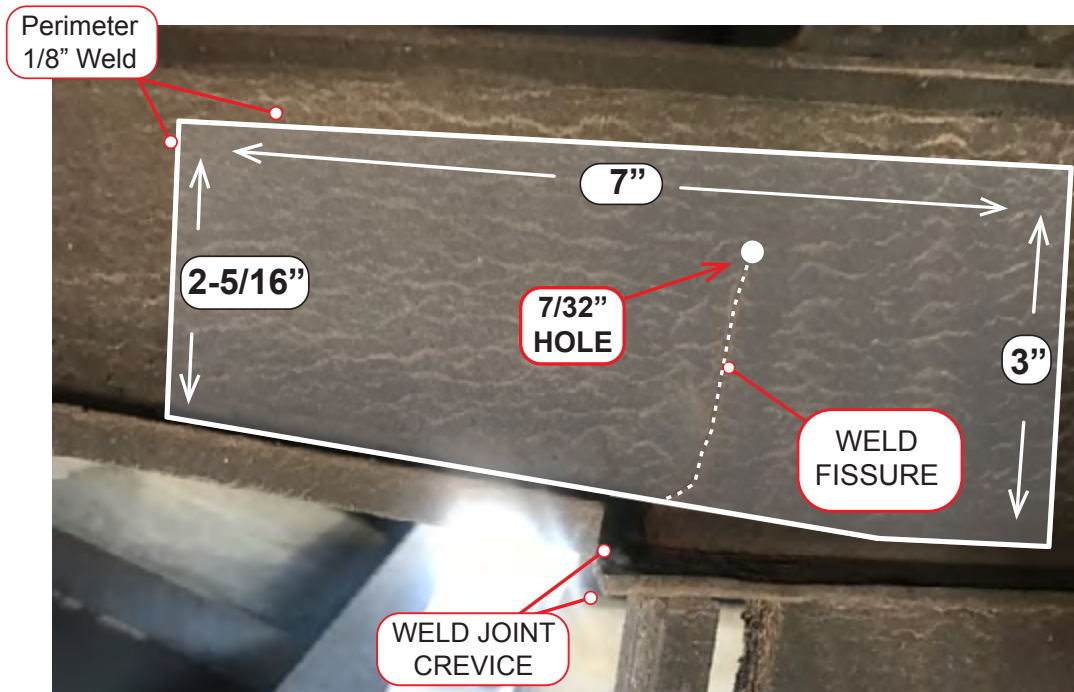


*Damaged weld (A) and fissure (B) at RH long sill*

Procedure:

## NOTICE

Regardless of which side of the truck the fissure is located, reinforcement plates will be welded onto both long sills



*Overview of plate reinforcement and fissure repair*

1. Drill 7/32" relief hole at top end of crack to stop crack growth.
2. Use a die grinder to create channel in fissure.
3. Remove undercoating around sill flange welding areas.
4. Weld fissure gap to join sides of crack.
5. Use a clamp to secure plate on outboard side of long sill at the taper point.
6. Perimeter weld reinforcement plate to web of long sill using 1/8" fillet-style continuous weld around edges.
7. 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.



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8. Use Job Code 13–Q2–C2–19 for corrective action from this document to complete the SERVICED decal.
9. Adhere the decal to the upper right-hand corner of the driver’s side sidewall near the front wall. Do NOT cover any previously applied decals.

***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: 5/31/2018**

### 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:** 1.0 hour

**Job Op Code:** 13–Q2–C2–19

**Document Part Number:** 03102101-B013EN

**Revision:** A

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