

Date: February 7, 2018

SERVICE BULLETIN

Service Bulletin No.: 2017-0018

Product Models Affected:

| | |
|--------------------------------|---------------------------|
| Aero Elite Ford 2xx-series | Aerolite Ford 1xx-series |
| Aero Elite Ford 3xx-series | Aerolite Ford 2xx-series |
| Aero Elite Navistar 2xx-series | Aerolite Chevy 1xx-series |
| Aero Elite Navistar 3xx-series | Aerolite Chevy 2xx-series |
| Aerotech Ford 2xx-series | |
| Aerotech Chevy 2xx-series | |

FORM Rev 2017-0323

Purpose:

Seal water leak path at top of wheelchair door and ensuring operational functionality of the wheelchair frame/door assembly.

Tool(s) / Equipment Required:

| | |
|----------------------------------|---------------------|
| Screwdriver, Phillips 2 or 3 | Sanding Disk |
| Drill | Sanding Block |
| Drill Bit, 3/16-inch diameter | Plastic Putty Knife |
| Safety Glasses (PPE) | Flat Pry Bar |
| Dust Mask (PPE) | Steel Wool |
| Weld – Helmet/Face Shield (PPE) | Wire Brush |
| Weld – Leathers and Gloves (PPE) | Welder |

Part(s) / Material Required:

| <u>Description</u> | <u>Quantity</u> | <u>Part Number</u> |
|-----------------------------------|-----------------|--------------------|
| 2.00 x 48.00 inch Plywood ¾ BCX | 1 | 010670-038 |
| 1.50 x 48.00 inch 14 GA CRS Strap | 1 | N/A |
| 2.00 x 5.75 inch Plywood ¾ BCX | 1 | 010670-015 |
| 1.50 x 8.00 inch 14 GA CRS Strap | 1 | N/A |
| 2.00 x 70.00 inch Plywood ¾ BCX | 1 | 010670-037 |
| 1.50 x 70.00 inch 14 GA CRS Strap | 1 | N/A |
| Sikaflex 252 | As Required | E52631 |
| Screw, SMS 14 x 1.50 PH PHIL SS W | 22 | 0035634 |
| Washer, Nylon 5/32 x 3/8 | 22 | 0024025 |
| Screw, TEK #6 X 1 BLG PHIL ZINC | 9 | 0019373 |
| Metal Gusset Plate | 2 | 0034831 |

General:

1. Inspect the wheelchair door frame for cracks in the metal.
 - If there are no cracks evident in the metal door frame, proceed to the Door Frame Preparation. Then proceed to the Interior Frame Support Procedure.
 - If there are cracks evident in the metal door frame, proceed to the Door Frame Preparation. Second, complete the Door Frame Gusset Installation Procedure. Last, complete the Interior Frame Support Procedure.
2. Disconnect battery(ies), PCM/ECM Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis.
3. Reconnect battery(ies), PCM/ECM Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis only after completing all weld process operations.

Procedures:

Door Frame Preparation

1. Remove interior padding at the top and right side of the wheelchair door. Handle with care, these parts will be reused. Reference Figure 1.



Figure 1

2. Remove exterior wheelchair door screws at the top and the left side (rearward side of vehicle) of the wheelchair door. Discard the screws. Reference Figure 2.



Figure 2

3. Remove the one (1) piece of wood at the top of the wheelchair door, and two (2) pieces of wood to the right side of the wheelchair door. Discard pieces of wood. Reference Figure 3.



Figure 3

Interior Frame Support

1. Assemble the 1.50 x 48 inch 14 GA CRS Strap to the 2.00 x 48.00 inch Plywood using four (4) of the 0019373 screws so that one (1) long edge of each component will butt against the door frame.
2. Install the 48.00 inch Plywood/Strap Assembly across the top of the wheelchair door with plywood facing the interior of the vehicle. Hold the Plywood/Strap assembly in place and drill a 3/16-inch diameter hole through the Strap from the exterior of the vehicle. Install the new Screw and Washer from the exterior of the vehicle through the Strap. Tighten screws until snug. Do not overtighten. Reference Figures 4 and 2.
3. Assemble the 1.50 x 70 inch 14 GA CRS Strap to the 2.00 x 70.00 inch Plywood using three (3) of the 0019373 screws so that one (1) long edge of each component will butt against the door frame.
4. Install the 70.00 inch Plywood/Strap Assembly on the right side of the wheelchair door with the plywood facing the interior of the vehicle, starting the Assembly at the interior lower right corner of the wheelchair door. Hold the Plywood/Strap Assembly in place and drill a 3/16-inch diameter hole through the Strap from the exterior of the vehicle. Install the new Screw and Washer from the exterior of the vehicle through the Strap. Tighten screws until snug. Do not overtighten. Reference Figures 4 and 2.
5. Assemble the 1.50 x 8 inch 14 GA CRS Strap to the 2.00 x 5.25 inch Plywood, centering the length dimension of the plywood on the length dimension of the strap, using two (2) of the 0019373 screws so that one (1) long edge of each component will butt against the door frame.
6. Install the 8.00 inch Plywood/Strap Assembly on the right side of the wheelchair door with the plywood facing the interior of the vehicle, starting at the top right corner of the installed over-wheelchair door Strap. Hold the Plywood/Strap Assembly in place and drill a 3/16-inch diameter hole through the Strap from the exterior of the vehicle. Install the new Screw and Washer from the exterior of the vehicle through the Strap. Tighten screws until snug. Do not overtighten. Reference Figures 4 and 2.

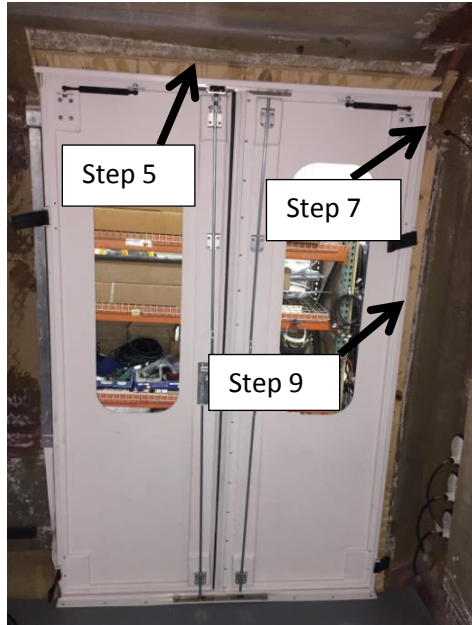


Figure 4

7. Seal around perimeter of wheelchair door frame using Sikaflex 252. Reference Figure 5.



Figure 5

8. Reinstall the interior pads, over top of wheelchair door and to the right side of the wheelchair door, using the take-off pads and hardware. Reference Figure 6.



Figure 6

Door Frame Gusset Installation

1. Scrape away paint in the corners of the inside of the entry door using the steel wool and wire brush. The area removed should be 4 inches down by 4 inches in. Remove all debris and ensure there is a smooth finish.
2. Tack weld two metal gusset plates, 0034831, in place in the upper corners of the door frame, behind where the door will mount.

Caution:

Protect the fiberglass wall material. Welding the metal gusset plates in place while the door frame is assembled to the fiberglass may cause the fiberglass to discolor or show burn marks from weld spatter.

3. Weld along the cracks ensuring good filler material fusion to the base material, and smooth weld.
4. Weld two metal gusset plates, 0034831, in place in the upper corners of the door frame, behind where the door will mount, and smooth all welds. Reference Figure 7.
5. Spray welds with corrosion inhibitor paint. Then paint to match door frame, as necessary.

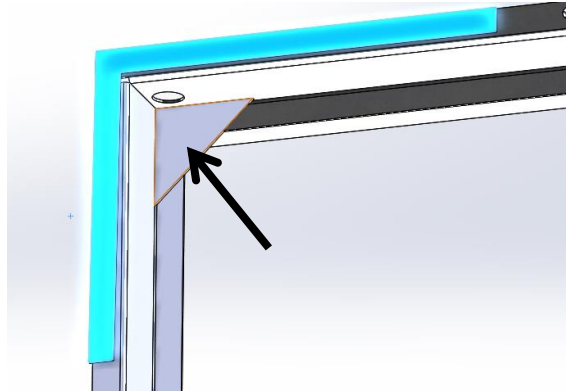


Figure 7 Front side, weld metal gusset plate in place.

6. Proceed to Interior Frame Support procedure.

Contact Information:

REV Bus Group - Salina Customer Service, 1655 Wall Street, Salina, KS 67401; or by calling (785) 827-1033 / (800) 955-9086; or by Email: bussupport@eldorado-bus.com; or by Fax: (785) 827-3017.