

"DOCUMENT UNCONTROLLED IF PRINTED"

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AR856	Thomas Compressor Relocation	1 of 3	B	SER-E	C. Ward	5/1/2018

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: Customer concern about location of Thomas Compressor in wet areas

Cause: Engineering Design for Placement

Correction: Relocate Thomas Compressor to Driver Side Rear of vehicle

Vehicles Affected: SOM units

Labor Operation Code: 0118201

Pre Authorization Required

Labor Time Allowance: 3 hours

Parts Returned: No

Tools Required

Hoist (ability to raise and support the unit)
 5/16 Socket/Wrench
 7/16 Socket/Wrench
 3/8 Socket/Wrench
 3/8 Drill/Bit

Parts Required

2	616156	SCREW, CAP - 3/8X1-1/4 PERMA PLATED TUF-TORQ #633
4	721930	WASHER, FRP 3/8" USS TRU/TORQ FLAT
2	1202088	LOCKNUT, FLANGE 3/8 -16 UNC ALL METAL GRADE G
1	1311468	CABLE POWER, REAR COMPRESSOR RED
1	1305850	MUD FLAP, 19X22 LPDE BLACK W/45 DEGREE CORNERED

Repair Instructions:

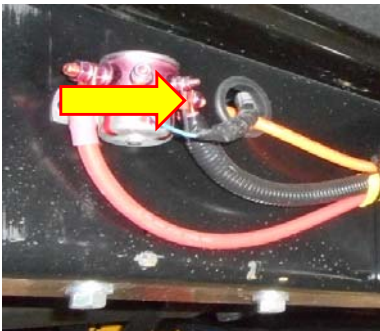
Step 1: Pull unit onto hoist, chock front tires to prevent bus from rolling forward or backwards.

Step 2: Raise unit to a comfortable working height.

Step 3: With 7/16 Wrench/Socket, remove Box Cover - (4) Nuts from top side of rubber isolators (NOTE: Save hardware to re-use later)



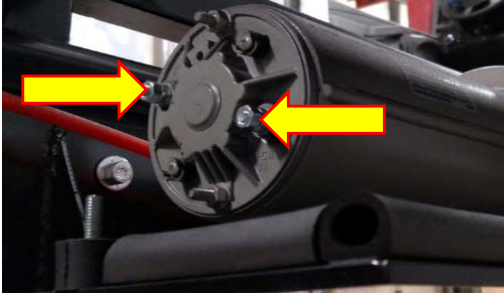
Step 4: With 5/16 Wrench/Socket, remove power supply from Solenoid (NOTE: save hardware for re-use later)



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Step 5: With 7/16 Wrench/Socket, remove Power and Ground from Compressor (NOTE: save nuts for re-use later)



Step 6: Remove Orange Air Line from Compressor

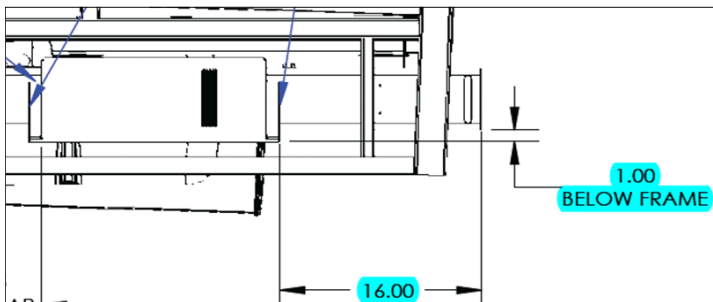


Step 7: With 7/16 Wrench/Socket, remove Compressor from Mounting Plate (NOTE: save hardware for re-use later)



Step 8: With 3/8 Wrench/Socket, remove Compressor Mount Plate from Frame Rail (NOTE: Discard hardware)

Step 9: Locate Compressor Mount on Driver Rear Frame Rail - mark and drill two 3/8" holes for mounting
NOTE: 16 inches in from rear of frame rail and compressor plate is 1 inch below frame rail.



Step 10: With 3/8 Wrench/Socket, secure Compressor Mount Plate to Frame Rail (NOTE: Install with new hardware) Torque = 40 FT/LBS

Step 11: With 7/16 Wrench/Socket, secure Compressor onto isolator bushings from step 7 (NOTE: Re-use hardware and tighten - No Torque Applicable)

Step 12: Re-route the Orange Air Line to Compressor - Route along inside of driver frame rail to compressor and re-connect

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Step 13: With 5/16 Wrench/Socket, secure new battery cable to solenoid position vacated in step 3 (NOTE: Re-use hardware) Torque = 72 IN/LBS

Step 14: Route battery cable to Compressor - over crossmember and along inside of driver frame rail

Step 15: With 7/16 Wrench/Socket, secure Power and Ground Connections to Compressor (NOTE: Re-use hardware) Torque = 40 IN/LBS

Step 16: With 7/16 Wrench/Socket, re-install Box Cover (NOTE: Re-use hardware and tighten - No Torque Applicable)

Step 17: Install Mudflap on forward side of compressor to structural floor (bottom side of floor tube) with 3/8" self-tapping fasteners



Step 18: Lower vehicle and remove from hoist