

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR860	Front Pivot Mount Inspection and Repair	1 OF 2		SER-E	C.WARD	8/2/2018

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: Pivot Mount Bolts having repeated premature failure

Cause: Spring Pivot Bolt movement allowed by elongated mounting hole

Correction: Inspect/replace bolt

Vehicles Affected: Units completed AR831 and built with the Front Pivot Mount bolted to the ARBOC Frame without welding

Labor Operation Code: 0116001

Pre-Authorization Required

Labor Time Allowance: 2 hour per unit

Parts Returned: No

Tools Required

Hoist (ability to raise and support the unit)

Welder

Flame/Spark Resistant Tarp (use to protect interior harness, fuel lines, brake lines, etc.)

Parts Required

1310070 Pivot Mount Reinforcement Gusset

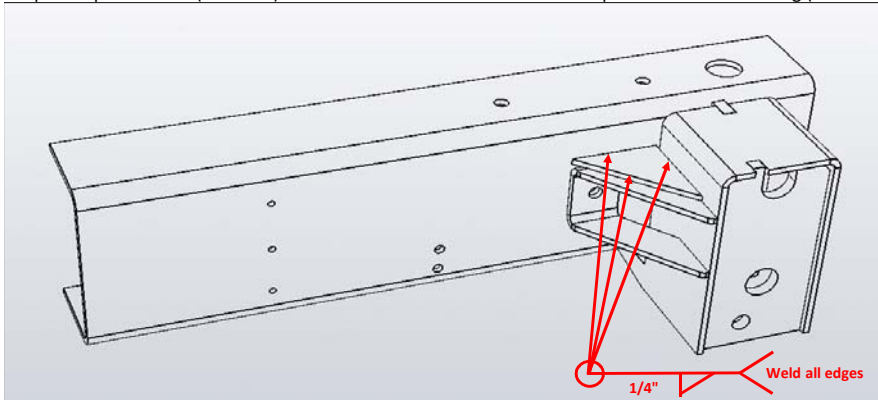
NAPA Rubberized Undercoating (not supplied)

Inspection Instructions:

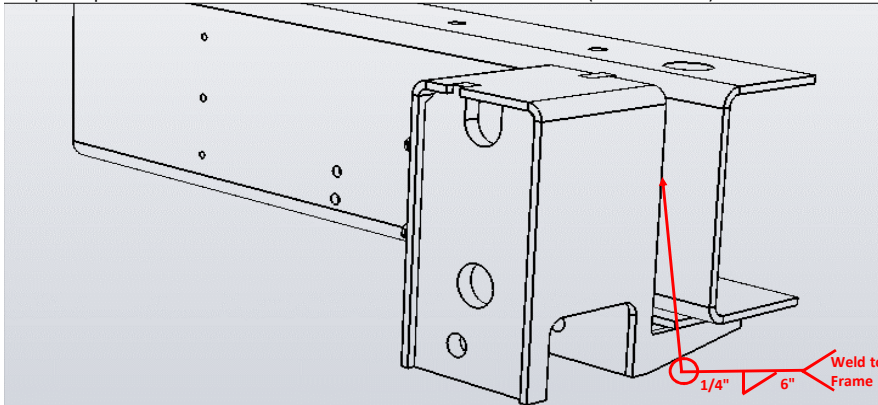
Step 1: Pull unit onto hoist, chock front tires to prevent bus from rolling forward or backwards.

Step 2: Raise unit to a comfortable working height following suggested jacking procedures.

Step 3: Inspect Gusset (1310070) to ensure it has been welded to the top side of the bracket leg (forward side) and all edges per illustration below



Step 4: Inspect bracket to ensure it has been welded to chassis frame (rearward side)

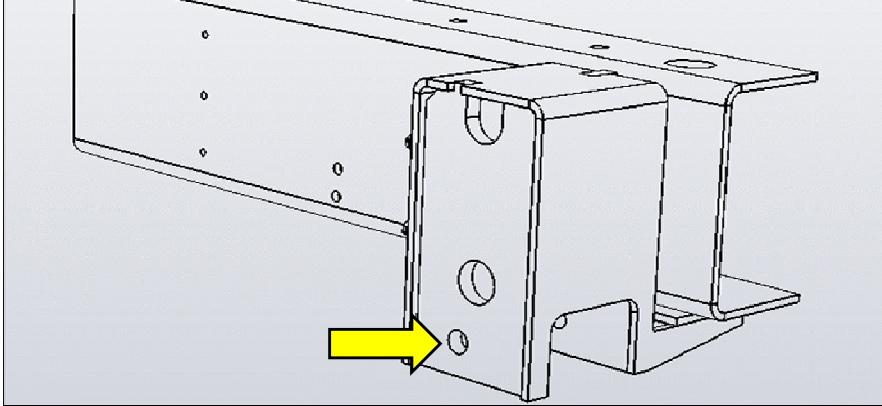


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Step 5: Remove Spring Beam Bolt and discard.

Step 6: Inspect mounting hole and ensure hole has not been elongated



Repair Instructions (Hole NOT Elongated):

Labor Operation Code: 0118800

Labor Time Allowance: .2 hours per side

Tools Required

Hoist (ability to raise and support the unit)

Parts Required

2001861 BOLT, HCS M18 - 2.5 X 130 GR 10.9 PLAIN BLACK

Repair Instructions:

Step 1: Lift the Z-Spring back into place and install new bolt (torque = 315 FT/LBS).

Step 2: When both sides are completed, lower the vehicle and remove from hoist.

Repair Instructions (Hole Elongated):

Labor Operation Code: 0118800

Labor Time Allowance: 2 hours per side

Photo must be supplied with Pre-Authorization

Tools Required

Hoist (ability to raise and support the unit)

Welder

Flame/Spark Resistant Tarp (use to protect interior harness, fuel lines, brake lines, etc.)

Parts Required

2001861 BOLT, HCS M18 - 2.5 X 130 GR 10.9 PLAIN BLACK

1306500-18 MOUNT, FRONT SPRING PIVOT ROAD SIDE (BOLT ON)

1306500-19 MOUNT, FRONT SPRING PIVOT CURB SIDE (BOLT ON)

1310070 PIVOT MOUNT REINFORCEMENT GUSSET

Repair Instructions:

Step 1: Disconnect positive (red lead) battery cable from the chassis and auxiliary battery.

Step 2: Remove Bracket by cutting welds and removing three 1/2-13 bolts (discard)

Step 3: Remove connections (p-clamps and/or clips) for fuel lines, brake lines, hoses, etc. on the interior side of chassis frame rail

Step 4: Insert Flame/Spark Resistant Tarp (not supplied) between the fuel lines, brake line, hoses, harnesses, etc. to protect from damage during welding

Step 5: Install new bracket by following welding guidelines supplied in step 3 & 4 in the inspection process

Step 6: Lift the Z-Spring back into place and install new bolt (torque = 315 FT/LBS).

Step 7: When both sides are completed, lower the vehicle and remove from hoist.