



DATE: 9-10-18

APPLIES TO: This Technical service bulletin applies to certain model year 2016 through 2019, K2 and K3 model motorhome chassis built between 12/19/2014 and 2/20/2018 that are subject to Recall 18V-384.

NHTSA/TC Id: N/A

CONDITION: The Diesel Exhaust Fill Tube Support bracket may be damaged.

CORRECTION: Remove and replace DEF fill spill pan or DEF fill bracket, as required.

LABOR ALLOCATION: 5 hours

CLASSIFICATION: E3

GENERAL INSTRUCTIONS:

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Motors USA, Inc. Customer & Product Support Group.

All applicable industry safety standards must be followed when performing work identified in this procedure.

STEP-BY-STEP INSTRUCTIONS:

1. Continue from **RSB18-290-001A** (NHTSA/ TC Id: 18V-384) STEP # 5, if damage was found on DEF fill bracket or spill pan and needs to be replaced continue with these instructions.
2. Locate and remove the 4 screws indicated with red arrows. Retain hardware for reuse. Refer to FIG. 2-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

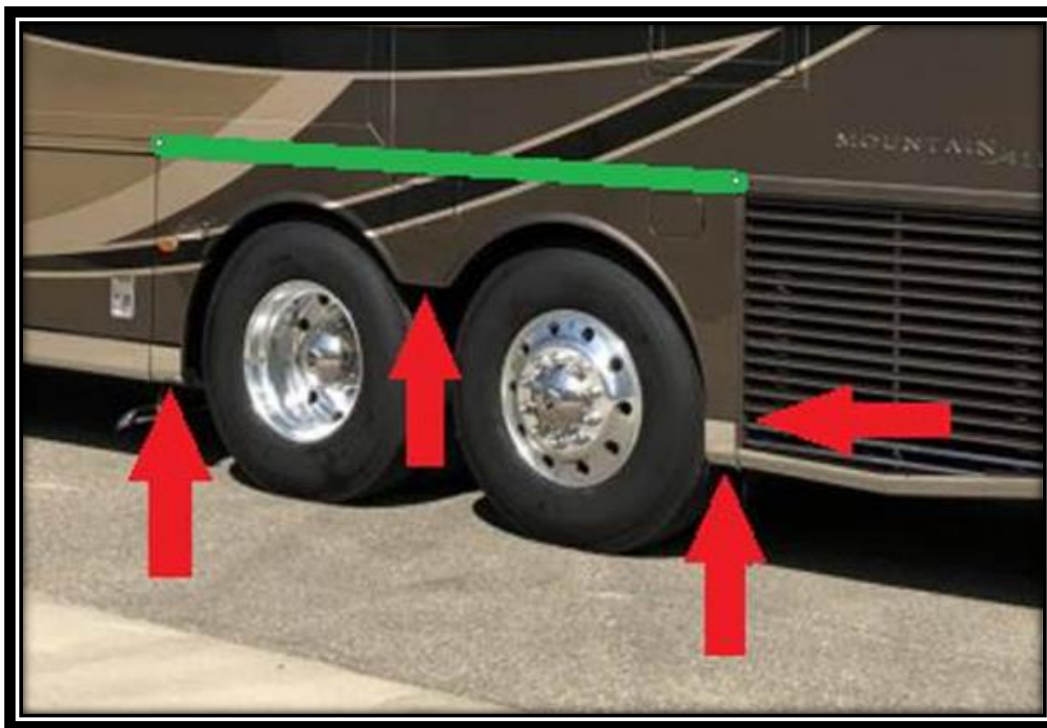


FIG. 2-1

3. Remove Sikaflex from between wheel well body panel and DEF spill pan. Clean body panel so it is free of Sikaflex. Refer to FIG. 3-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

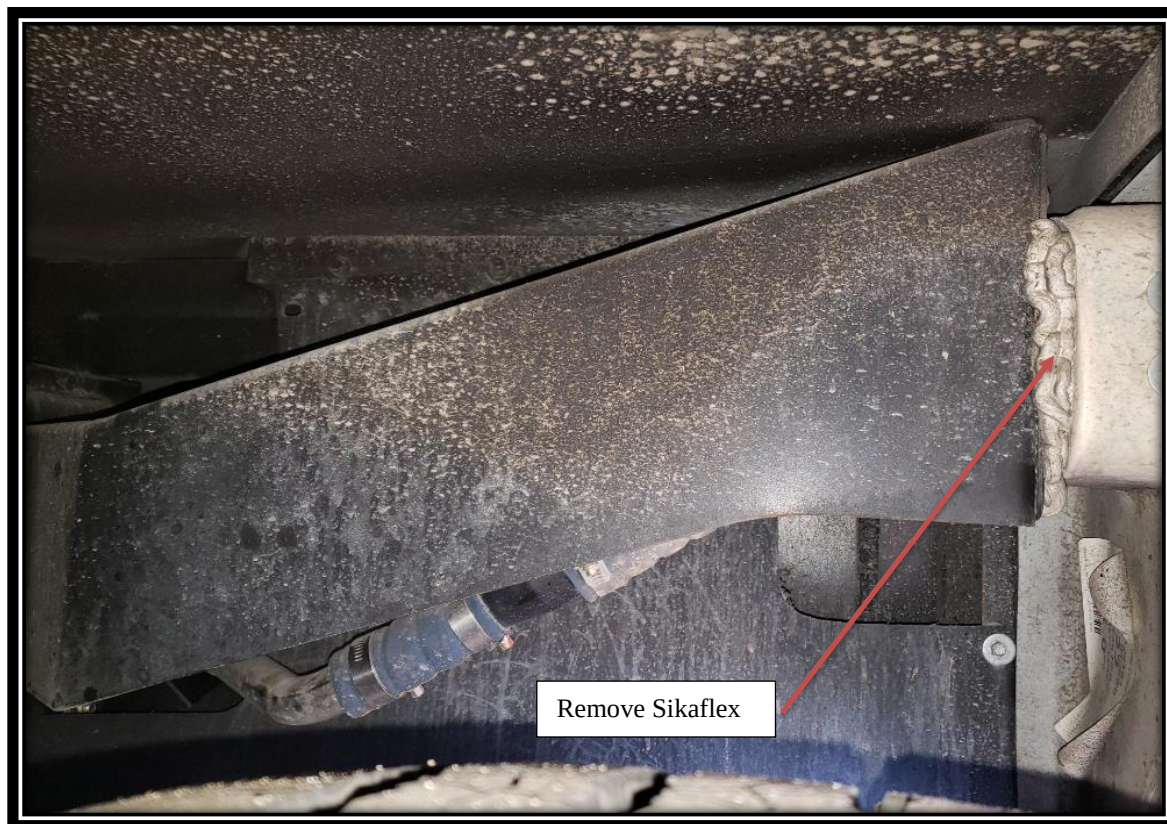


FIG. 3-1

4. Body panel is hinged at top (along green line) and can now be flipped up to expose DEF bracket and spill pan. Refer to FIG. 2-1.
5. Remove (4) ¼" screws and related hardware and retain for reuse. Refer to FIG 4-1.
6. Remove (2) ½" bolts and nuts and retain for reuse. Refer to FIG 4-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

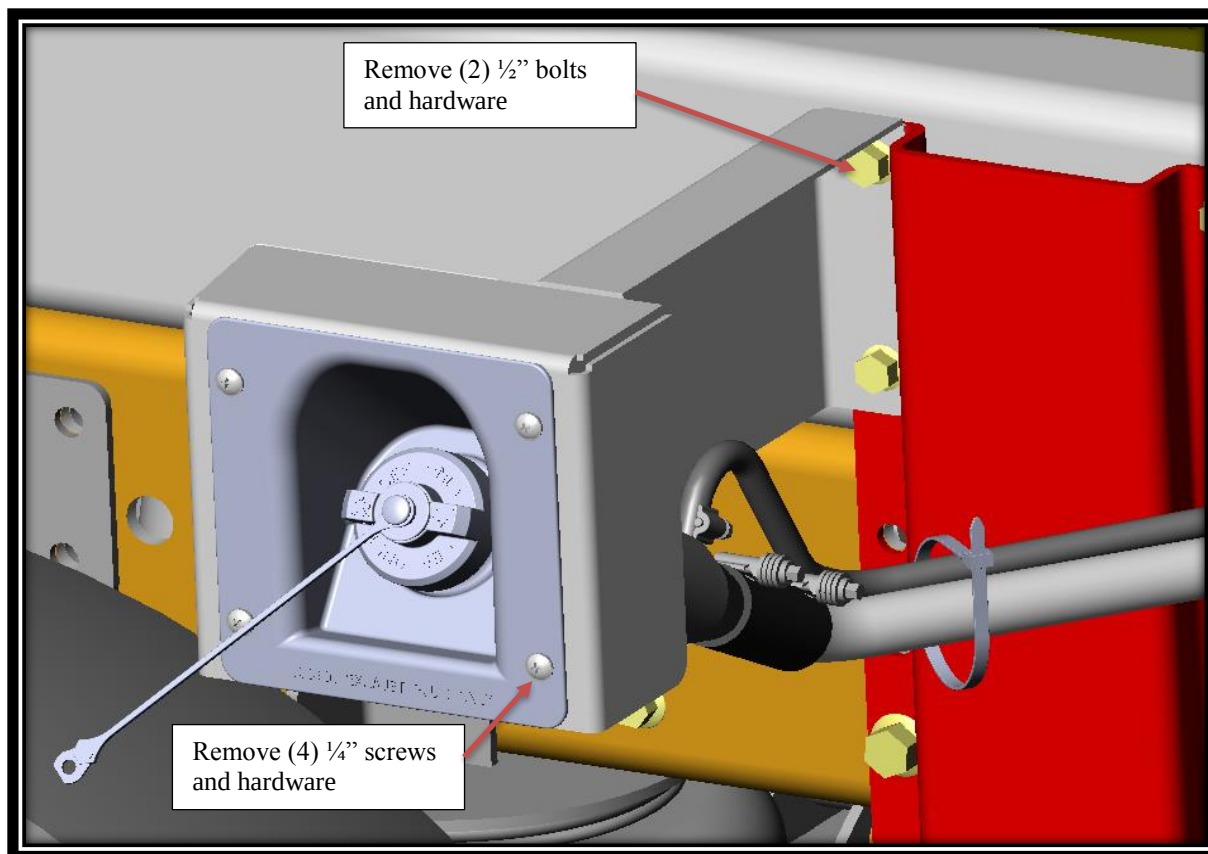


FIG. 4-1

7. Loosen hose clamps holding DEF spill pan assembly and vent hose. Retain hose clamps for reuse. Remove DEF spill pan assembly. Plug vent hose and DEF fill tube to prevent debris from entering DEF system. Refer to FIG 5-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

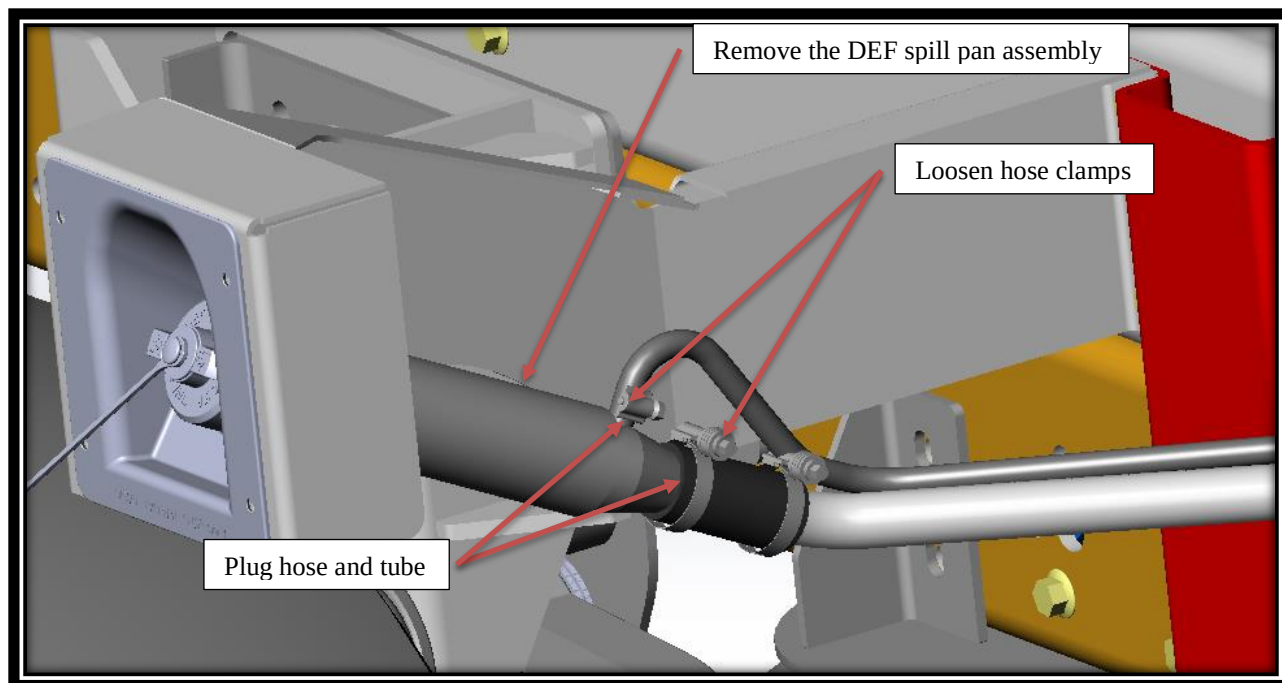


FIG. 5-1

8. Carefully cut welds holding DEF support bracket to body structure and remove and discard support, cut-off wheel or reciprocating saw preferred. Use caution to avoid damaging body, hoses, or wire harnesses that maybe routed near welds. Refer to FIG 6-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

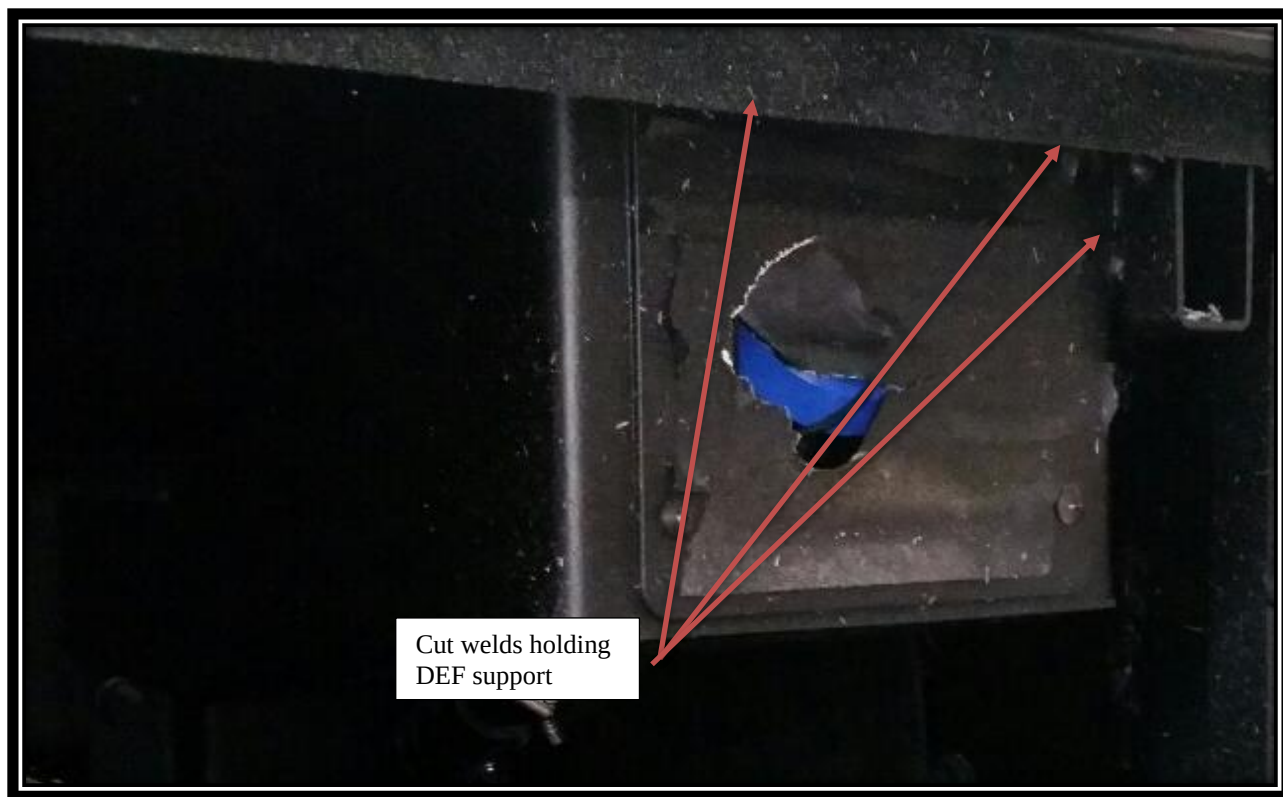


FIG. 6-1

9. Clean weld area by removing remaining weld remnants.
 10. Reinstall (2) ½" bolts that were removed in step #6 and torque to 74 lbf-ft. Refer to FIG 7-1
 11. Remove (2) ½" bolts and hardware from opposite side of frame tie and install new DEF support (3317-LL2-001) using (2) ½" bolts and hardware. Torque to 74 lbf-ft. Refer to FIG 7-1.
 12. Weld new DEF support bracket into body using same weld locations as was used with damaged bracket. A minimum of (3) 1/8" fillet welds x 1.0" long will be required for installation of DEF fill bracket. Refer to FIG 6-1
- ◆ Use only trained and qualified weld personnel.
 - ◆ Disconnect BOTH positive and negative battery cables.
 - ◆ Disconnect ground cable to alternator.
 - ◆ Disconnect power cables and connectors to multiplex controller(s) and nodes.
 - ◆ Disconnect connectors from all Electronic Control Units (ECU's).

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



- ◆ The DPF (Diesel Particulate Filter) sensor(s) **must** be disconnected before welding activity.
- ◆ Inspect electrical components such as an ECU, which has a case grounded to the frame; these **must** be removed. ECU's may include, but are not limited to:
 - Engine
 - Transmission
 - ABS System
 - Instrumentation (gauges)
 - Any ECU installed by the Apparatus Builder
- ◆ Ground' the welding apparatus as close to the area to be welded as possible. Never use the engine, transmission, or U-bolts as a ground point.
- ◆ Protect all chassis components from weld splatter including, but not limited to, all air springs, axle springs, spring leaves, fuel lines and fuel system components, wheels/tires, steering wheel, all air and hydraulic hoses/lines, and all electrical wiring and panels.

13. After welding, paint welded areas with black paint. (Paint not included in service kit)

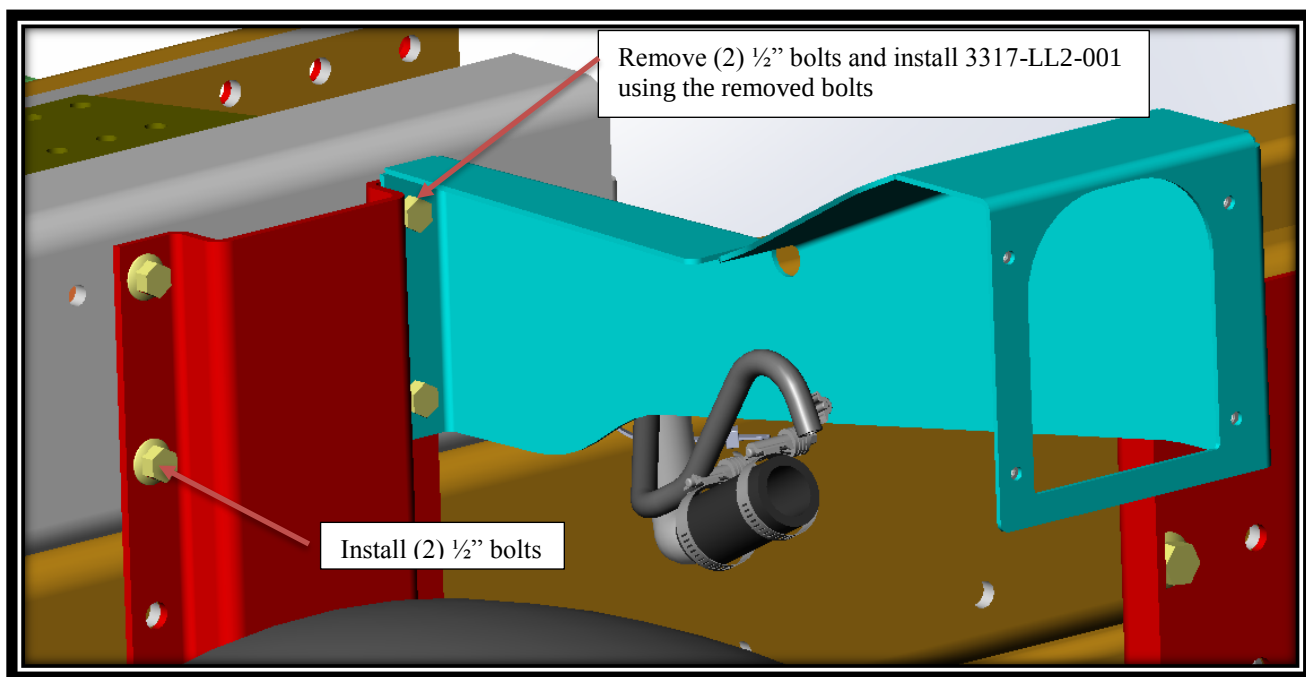


FIG. 7-1

14. Install new spill pan (P/N 2768-LL2-001). Refer to FIG 8-1.
- a. DEF spill pan P/N 908-1808-01 is not part a of a service kit. Contact Customer Service for replacement part.
 - b. Make certain that plugs have been removed from vent and fill tube prior to installation of spill pan.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



- c. Use (4) ¼" screws and hardware retained from step 5 to mount spill pan to support.
- d. Use (2) clamps retained from step 7 to secure fill tube and vent hose to spill pan assembly. Torque clamps to 55 lbf-in.

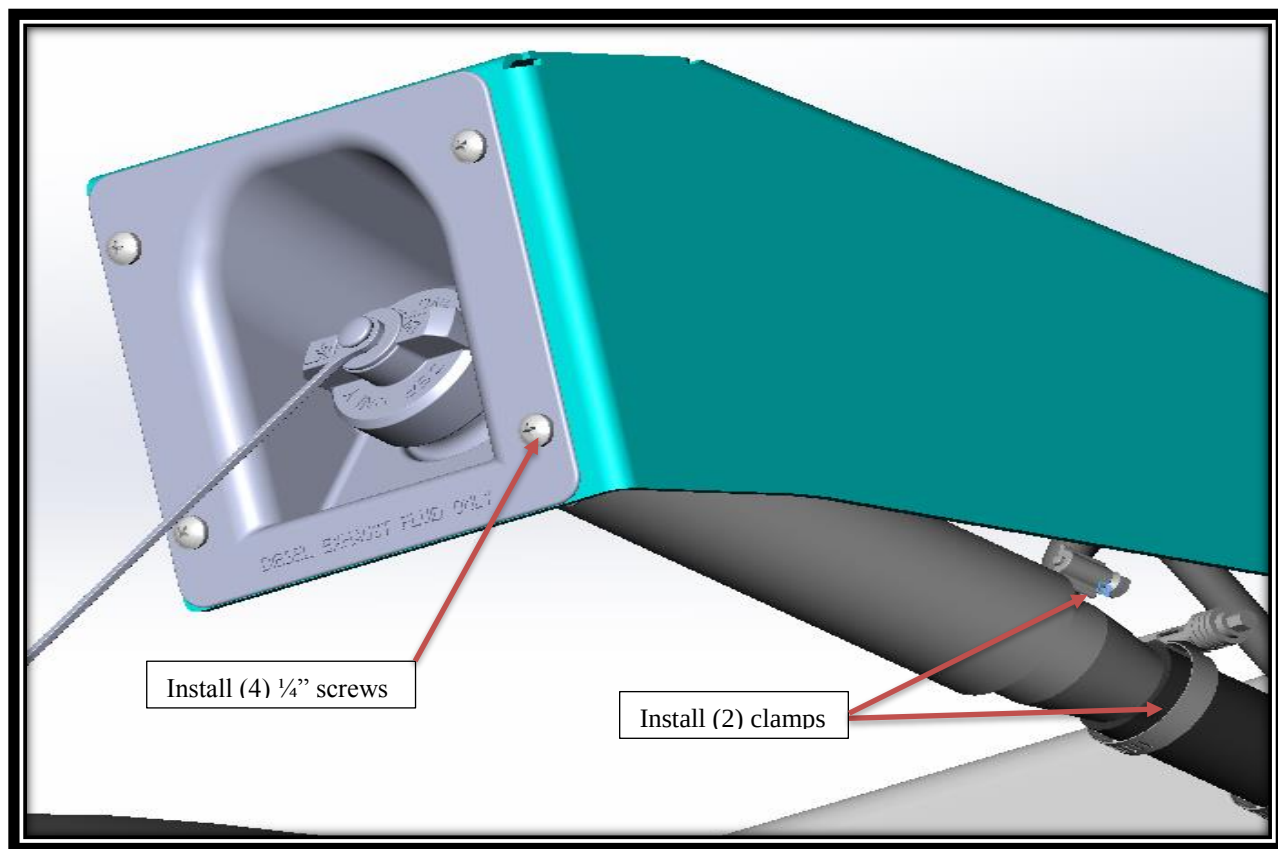
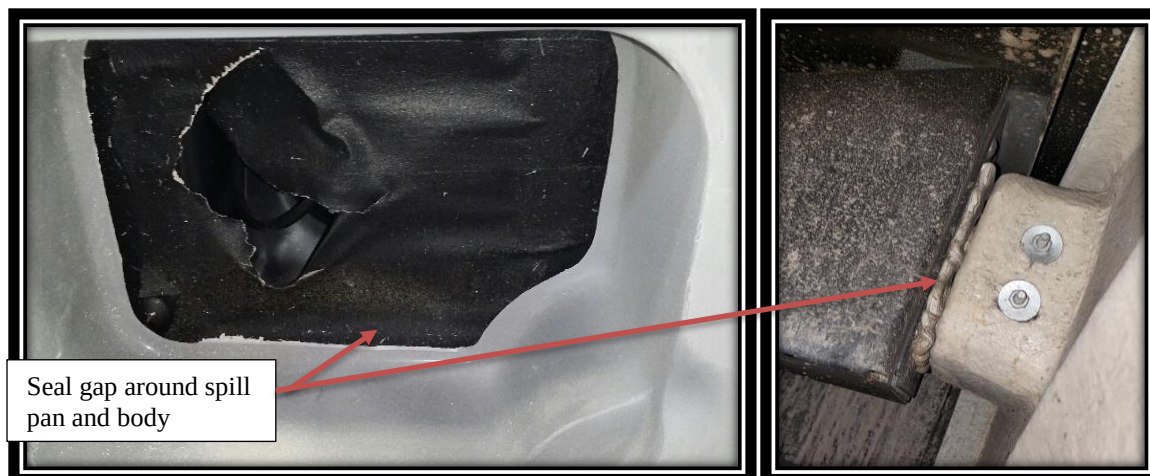


FIG.8-1

15. Lower body panel back into place and use (4) retained screws to secure body panel. Refer to FIG 2-1.

16. Use Sikaflex White 515 to seal gap between DEF spill pan and body. Refer to FIG 9-1.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



Seal gap around spill
pan and body

FIG. 9-1

17. Reinstall tag axle tire. Torque lug nuts to 475 lbf-ft using a star pattern. Refer to FIG. 10-1.



FIG. 10-1

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.



18. Carefully lower vehicle.
19. Remove wheel chocks.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.