

FLA COE  
FLB COE  
FLD Conventional  
Business Class

FLC 112 Conventional  
Century Class Conventional  
Argosy COE  
Cargo

Columbia  
Condor  
Coronado  
> Business Class M2

**Freightliner  
Service Bulletin**

**Description of Revisions:** *This bulletin replaces the version dated April 2005. Under "Priming" the steps have been revised.*

## General Information

The following procedure outlines the body paint repair procedure for Business Class M2 vehicles that are equipped with ambulance bodies. This procedure is to be used to eliminate galvanic and/or crevice corrosion and to prep the unit for repainting regardless if it's a retail or warrantable repair.

**IMPORTANT:** In order to prepare the body for paint repair, a kit should be ordered from Ferguson Enterprises. It is identified as Fire Body Repair Kit #1. Please call (843)-486-7722 to order the complete kit. See [Table 1](#) for the Fire Body Repair Kit #1 materials list. See [Table 2](#) for materials selection and [Table 3](#) for paint gun and paint booth setup.

## Preparation

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### CAUTION

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**Only experienced, qualified persons using proper equipment should attempt repainting or touch-up painting. Incorrect application of chemicals or paint could damage the surface or impair the finish.**

1. Wash the vehicle body to remove all dirt and contaminants.
2. Remove all hinges, fenderettes, diamondettes, and light fixtures.
3. Sand the body to remove all corrosion.
4. Remove all seam sealant around the extrusions. Clean out all residual debris from the extrusions.
5. Use compressed air to blow dirt and contaminants from all surfaces, especially in the extrusions.
6. Remove all stainless steel fasteners that are in the door extrusions and coat them with Dolphin 6075 Corrosion Bloc™ paste.

## Surface Treatment and Conversion Coating

1. Wipe Parcosol® 263 Metal Cleaner on all stainless steel and galvaneel surfaces, then wipe it off.
2. Wipe on Alodine® 5700 Conversion Coater, and let it dry in place.

NOTE: Use Alodine 5700 on aluminum surfaces only.

3. Apply two-part polyester fillers or primer immediately after the pre-treatment is dry.

## Priming

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### WARNING

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**Wear a positive-pressure, supplied-air, vapor and particulate respirator approved by NIOSH or MSHA (TC-19C), while spraying primer or topcoat and until the work area has been exhausted of all vapor and spray mist. Breathing paint vapor or spray mist can cause personal injury.**

1. Use a tack cloth on all surfaces.

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2. Prime all surfaces with DP40LF (Gray) or DP90LF (Black) Epoxy mixed with DP401LF or DP402LF Catalyst (2 to 1 mix ratio) and 1/2 part DT Solvent. Cure for 30 to 60 minutes.

## Caulking and Sealing Exterior Cosmetic Extrusion Joint

1. Sand all exterior cosmetic extrusion joints, then fill them using two-part polyester fillers.
2. Apply Royal Adhesive Solid Bond® caulking around the perimeter of the door extrusions. Seal all cosmetic surfaces. Cure for 2 to 3 hours.

## Basecoat and Clearcoat Topcoat

1. Seal prime the body with DP40LF (Gray) or DP90LF (Black) Epoxy mixed with DP401LF or DP402LF Catalyst (2 to 1 mix ratio) and 1/2 part of an appropriate solvent. Cure for 30 minutes.
2. Apply Delfleet® Basecoat Urethane. Mix the materials per manufacturer's instructions.
3. Clearcoat with DCU® 2002 or DCU® 2035 Urethane. Mix the materials per manufacturer's instructions.
4. Bake for 45 minutes at 140°F (60°C), or air dry overnight for 24 hours prior to installation of the hinges, fenderettes, and light fixtures.

NOTE: Cut and polish the paint as needed to remove dirt, imperfections, and orange peel.

## Exterior Underbody Sealing and Caulking

Apply Royal Adhesive Solid Bond around the underside perimeter of the body to seal all joints from moisture.

## Hinge and Light Fixture Installation

1. Install the hinges using Mylar® film between all the hinges to the frame and all the hinges to the extrusions to insulate from dissimilar corrosion.
2. Install the light fixtures using Dolphin 6075 Corrosion Bloc paste around all the openings and fasteners.

## Fenderette Installation

1. Apply Mylar film to the perimeter of the wheel well openings.
2. Apply Dolphin 6075 Corrosion Bloc to all stainless steel fasteners used to secure the fenderette to the body.

## Diamondette Installation

1. Apply 3M™ foam tape to the diamondette, vertically only. Do not apply horizontally.
2. Apply Dolphin 6075 Corrosion Bloc to all stainless steel fasteners used to secure the diamondette to the body.
3. After installation, apply Royal Adhesive Solid Bond caulk to the top and the sides of the installed diamondette. Do not apply caulk to the bottom.

## Exterior Metal Grab Handles and Brackets Installation

1. Apply Mylar film between any metal exterior part and any painted surface.
2. Apply Dolphin 6075 Corrosion Bloc to all stainless steel fasteners used to secure metal parts.

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## Parts

NOTE: Material Safety Data Sheets are included with all materials. Order materials through Ferguson Enterprises at (843)-486-7722.

Fire Body Repair Kit # 1				
Material	Product Number or Size	Quantity Required	Part Number	Where Used
Mylar® Tape	UHMW, 2-inch wide x 18 yards	4 Rolls (72 Yards)	710	All Hinges and Fenderettes
Dolphin™	6075, One-Pint Can with Dauber	1 One-Pint Can with Dauber	6075	Between All Joints and All Stainless Steel Fasteners
3M™ Foam Tape	VHB4646, 1-inch wide x 72 yards	2 Rolls	200-104	Diamondette Plate
Royal Adhesive Solid Bond®, Gray or White	20-Ounce Cartridge	4	200-286	Underbody and Diamondette Plate Cosmetic Seam Seal
Alodine® 5700	40 Wipes/Package	1	700-237	Aluminum Body Pretreatment
Parcosol® 263	40 Wipes/Package	1	700-218	Aluminum, Steel, and Stainless Steel Cleaner

**Table 1, Fire Body Repair Kit #1**

Material Selection	
Application Area	Product
Cleaning–Metal Substrate	Henkel Parcosol® 263 Wipes
Cleaning–Plastic or Fiberglass	PPG DX 103 (if needed)
Surface Treatment	Henkel Parcosol 263 Wipes for Aluminum, Galvanized, Galvaneel, and Stainless Steel
Conversion Coat	Henkel Alodine® 5700 Wipes for Aluminum
Seam Sealant (Underbody)	Royal Adhesive Solid Bond® DC 12250 (White or Gray)
Seam Sealant (Cosmetic)	Royal Adhesive Solid Bond DC 12250 (White or Gray)
Primer	DP40LF (Gray) or DP90LF (Black) Primer DP401LF or DP402LF Catalyst
Basecoat and Catalyst	Delta® or Delfleet® Color GXH 3640, DU 6 or DDH 526 Catalyst Global or DT Reducers
Clearcoat and Catalyst	DCU 2002 or DCU 2035 Clearcoat DCX8 or DCX61 Catalyst Global Reducers DX 830 Universal Blender
Accelerator	DX 84 for DCU 2002 and DCU 2035 Clearcoat

**Table 2, Material Selection**

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Paint Gun and Paint Booth Setup			
Parameter	Primer	Delta® Basecoat	FTC 2000 Clearcoat
Atomizing Air at Regulator	60–65 psi (415–448 kPa)	55–65 psi (379–448 kPa)	
Atomizing Air at Gun	40–45 psi (276–310 kPa)	45–50 psi (310–345 kPa)	
Fluid Delivery	13–15 oz/min (385–444 mL/min)	12–16 oz/min (355–473 mL/min)	
Booth Temperature	72–75°F (21–24°C)		

**Table 3, Paint Gun and Paint Booth Setup**

## Warranty

This bulletin is for informational purposes only.