

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR866	SOI-F Rear Upper Shock Mount Bracket Installation	1 of 1	-	SER-E	C.Ward	3/22/2019

Read process before beginning. If you do not understand any part please contact: Chris Ward 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:** Upper Shock has movement during Jounce

**Cause:** Insufficient structural support

**Correction:** Add bracket with weldment

**Vehicles Affected:** SOI-F

**Labor Operation Code:** 0121000

**Labor Time Allowance:** 2 hours per unit

**Parts Returned:** No

**Tools Required**

18M Socket/21M Wrench – Upper Shock Bolt  
15M Socket/18M Wrench – Lower Shock Bolt

**Parts Required**

2 1312336 BRACKET, SHOCK REINFORCED BLACK  
NAPA Rubberized Undercoating (not supplied)

**Inspection Procedure:**

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

Step 2: Disconnect positive (red lead) battery cable from the chassis and auxiliary battery.

Step 3: Raise unit to a comfortable working height.

Step 4: Remove upper and lower shock bolts and remove shock.

Step 5: Use supplied bracket (P/N: 1312336) and reinstall shock, placing the bracket in between the upper shock bolt and shock. Rotate the bracket until it is free of the potential shock travel (Approx. 45 degrees). Use a paint marker to mark the location of the shock bracket.



Step 6: Remove shock and add just the bracket and hardware to the frame. Weld the outside of the bracket to the frame; ¼" fillet weld, 2.75" long. Make sure the bolt is installed to prevent hole misalignment.



Step 7: Remove bolt.

Step 8: Using a high quality Rubberized Undercoat, paint repaired area. NAPA Rubberized Undercoating or Mac's 8400 Rubberized undercoat (not supplied).

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Step 9: Reinstall shock and torque hardware to correct specification. (46 Ft/Lbs Upper Shock - 66 Ft/Lbs Lower Shock, per Ford Specs)



Step 10: Lower unit and connect positive (red lead) battery cable to the chassis and auxilliary battery.

Step 11: Remove from hoist