

Date: April 10, 2019

Service Bulletin

Bulletin No.: 2018-0030

Product Models Affected:

World Trans 2xx – 2017MY thru 2019MY

FORM Rev 2019-0319

Purpose:

To inspect and repair by adding a weld in the bottom step entry door assembly, as necessary.

Tool(s) / Equipment Required:

Welder
Grinder
Scraper
Chocks
Wire brush
Safety Glasses (PPE)
Gloves (PPE)
Weld Helmet (PPE)
Weld Gloves (PPE)
Weld Leather (PPE)

Part(s) / Material Required:

<u>Description</u>	<u>Quantity</u>	<u>Part Number</u>
Dupli-color Truck Bed Coating, TR250 Black	1 can	N/A
Anti-corrosion spray paint	A/R	N/A

General:

1. Park the vehicle on a level surface.
2. Chock the front wheels of the vehicle.
3. Disconnect battery(ies), PCM/ECM Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis.
4. Protect adjacent areas from overspray and/or weld spatter during installation operations.
5. Ensure a fire extinguisher or other fire control apparatus are available during hot work operations.
6. Upon completion of all work, remove any covers installed for protection of paint overspray and/or weld spatter during installation operations.
7. Upon completion of all work, reconnect battery(ies), PCM/ECM Modules, and other electrical device connections that may have been disconnected during the process operations.
8. Wear appropriate PPE during process operations.
9. Ensure that product use dates are not greater than one (1) year from the manufacturing date for all adhesives and sealants. Ensure product handling and storage processes meet manufacturer requirements.

Procedure:

1. Inspect entry door on the underside at the front of lower step for weld as identified in Illustration #1 and Illustration #2 on each side of the entry step.
 - If a weld is present, no further action is required.
 - If a weld is not present, then complete the repair as identified beginning with Step #2.
2. Remove undercoat on entry step in location identified in Illustration #1 on both sides of entry on the back side of flange.

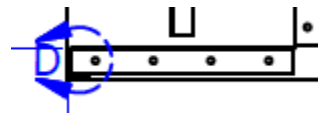


Illustration #1

3. Grind area to remove paint/E-coat and prep area for welding.
4. Weld on front side of break/flange as shown in Detail D, Illustration #2. Ensure fillet weld captures both vertical edges and fuses into the corner of the multilayered steel assembly.

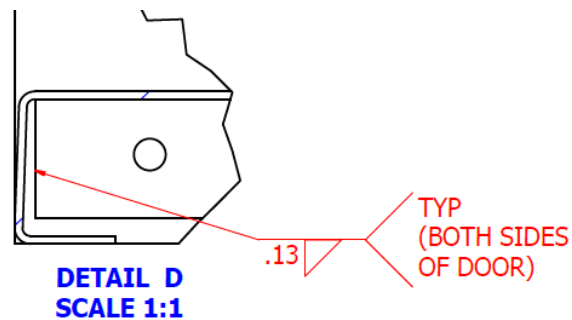


Illustration #2

5. Spray weld with anti-corrosion spray paint and allow to dry.
6. Spray area where undercoat was removed from entry step with Dupli-color Truck Bed Coating and allow to dry.
7. Apply additional coats of Dupli-color Truck Bed Coating as necessary.
8. Complete repair of the other side of entry step underside per Step 1 thru Step 7.
9. Reconnect battery(ies), PCM/ECM Modules, and harnesses that were disconnected in preparation for welding on the chassis.

Contact Information:

Contact Eldorado Customer Service, 1655 Wall Street, Salina, KS 67401; or by calling (785) 827-1033 / (800) 955-9086; or by Email: bussupport@eldorado-bus.com; or by Fax: (785) 827-3017.