

Date: June 19, 2019

SERVICE BULLETIN

Bulletin No.: 2019-0037

Product Models Affected:

Aerotech (Ford E-series Chassis) – 2012MY – 2019MY

FORM Rev 2019-0417

Purpose:

To add repair cracks and add support to the second unit body outrigger.
This repair is for raised/flat floor vehicles only.

Warranty Status:

Standard warranty coverage for all product models.

Tool(s) / Equipment Required:

Welder
Grinder
Scraper
Chocks
Wire brush
Vise Grip/Clamp
Safety Glasses (PPE)
Gloves (PPE)
Weld Helmet (PPE)
Weld Gloves (PPE)
Weld Leather (PPE)

Part(s) / Material Required:

<u>Description</u>	<u>Part Number</u>	<u>Quantity</u>
Plate, Cross Member Reinforcement	0039828	A/R
Plate 2, Cross Member Reinforce.	0039829	A/R
Dupli-color truck bed coating, TR250 Black	N/A	A/R

General

1. Park the vehicle on a flat level surface.
2. Chock wheels of the vehicle.
3. Ensure that the product use date is not greater than one (1) year from the expiration/manufacturing date of adhesives and sealants. Ensure product handling and storage processes meet manufacturer requirements.
4. Protect adjacent areas, from weld spatter and debris from grinding during hot work operations.
5. Disconnect battery(ies), PCM/ECM/Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis.
6. Reconnect battery(ies), PCM/ECM/Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis only after completing all weld process operations.
7. Wear appropriate PPE during rework process operations.
8. Ensure a fire extinguisher or other fire control apparatus are available during hot work operations.
9. Follow OEM instructions regarding the removal and re-installation, or protection of alternate fuel cells and/or components of the alternate fuel system installed on the vehicle when completing hot work operations.
10. Move any hoses, electrical harnesses or wire, or other components from the immediate work area where the hot work operations may be performed.
11. Follow appropriate industry standards and best practices for welding operations.

Procedure:

1. Inspect the underside of the second unit body for cracks in the outriggers of the floor assembly. Reference Photo #1 thru Photo #3 for examples.



Photo #1



Photo #2



Photo #3

2. Identify the number of cracks in the floor assembly outriggers and order the corresponding quantity of Plates, Cross Member Reinforcement, part numbers 0039828 & 0039829.
Note: Reinforcement Plates will be installed on both sides of the outrigger that are damaged.

NOTE

It is recommended that the vehicle be lifted to complete the rework/repair operations outlined.

NOTE

The alternate fuel OEM recommends that the fuel cells be removed to complete hot work operations.

3. Move any hoses, harnesses, or other components that may interfere with the preparation and installation of the Reinforcement Plates.
4. Prep the area surrounding the cracked outrigger by grinding off paint, undercoat, rust, and/or other debris that would hinder the weld operation and weld integrity. Reference Photo #4.



Photo #4

5. Select the appropriate Reinforcement Plate for the installation configuration.
6. Clean and prep the Reinforcement Plate for installation.
7. Place the Reinforcement Plate in position for welding and clamp for securement in location.
Reference Photo #5.



Photo #5

8. Stitch weld the Reinforcement Plate in the clamped location. Reference Photo # 6.



Photo #6

9. Install Reinforcement Plates on both sides of outrigger and raised floor column, as shown Photo #6, covering all cracks in the floor outriggers that were identified in Step #2.
10. Spray Dupli-color truck bed coating on the reworked area, covering all areas that were prepped for installation of the Reinforcement Plates. Reference Photo #7.



Photo #7

11. Reinstall hoses, harnesses, or other components that were removed to eliminate interference with the preparation and installation of the Reinforcement Plates.
12. Reinstall any components of the alternate fuel system, per OEM instructions, that may have been removed to complete the rework/repair operations.

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.