

Subject: Upper Rad Door Panel Bulging			
Field Change Program: Procedure	Procedure number: 03-263	Revision: A	Date: 11/21/2019
Coach Section: 03- Body	P/N: 03-32-3275		Type: Product Integrity

Application:

Coach Model	Model Year	VIN
D Series	2016-2020	14021 - 15855

⚠ WARNING

Read this entire procedure before beginning work.

Use Safe Shop Practices at All Times.

To avoid personal injury:

- a. Proper Personal Protective Equipment (PPE) must be worn. Safety glasses and protective gloves are required for working with DEF Fluid.*
- b. Turn the main battery disconnect switch to the OFF position.*
- c. Ensure that both the front and the rear wheels are chocked.*
- d. Positioning the ENGINE RUN and ENGINE START switches on the engine compartment remote control box to the OFF position.*
- e. Allow enough time for components to cool down prior to working in the engine compartment.*

1.0 Description

Rad door panels in “D series” coaches have the rivets bulging out due to galvanic corrosion. This procedure outlines the steps to replace the aluminum rivets with stainless-steel nuts and bolts to secure the rad panel.

2.0 Material requirements

ITEM	PART NO	QTY	U/M	DESCRIPTION
1	19-1-672	4	EA	SCREW-8-32 UNC X 1.00 SS
2	19-03-0558	4	EA	NUT-LOCK, HEX, #8-32 UNC, SST
3	T19-1173	8	EA	Washer- #8, .75" OD, SST
4	19-11-258	3	EA	Tyrap-7.31" LG

3.0 Special Tools

No special tools required.

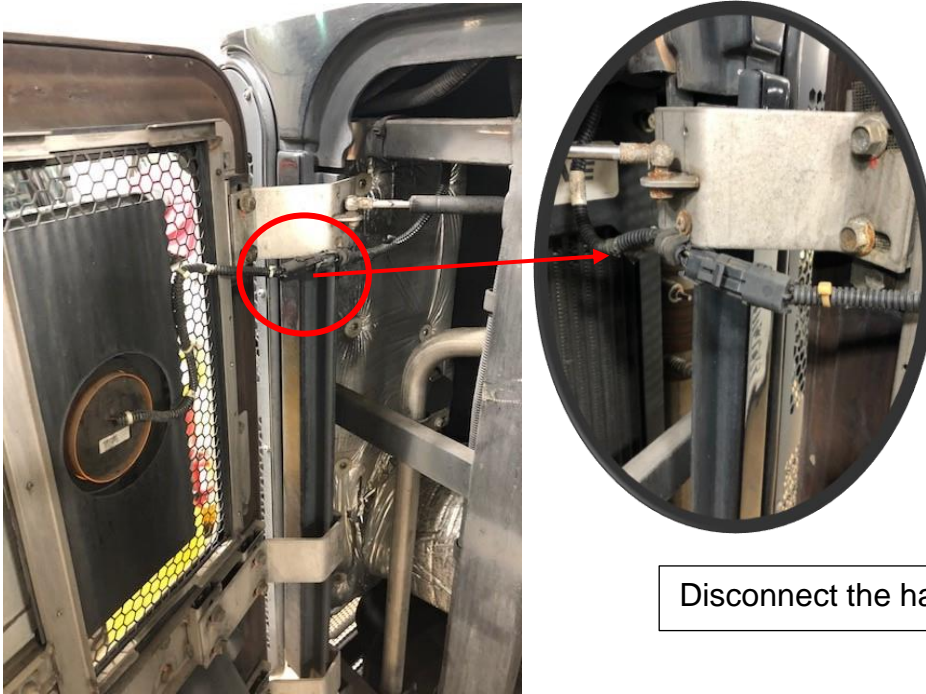
4.0 Procedure

4.1 Remove panel from the coach

Open the engine door and pull the lever to open the rad doors.

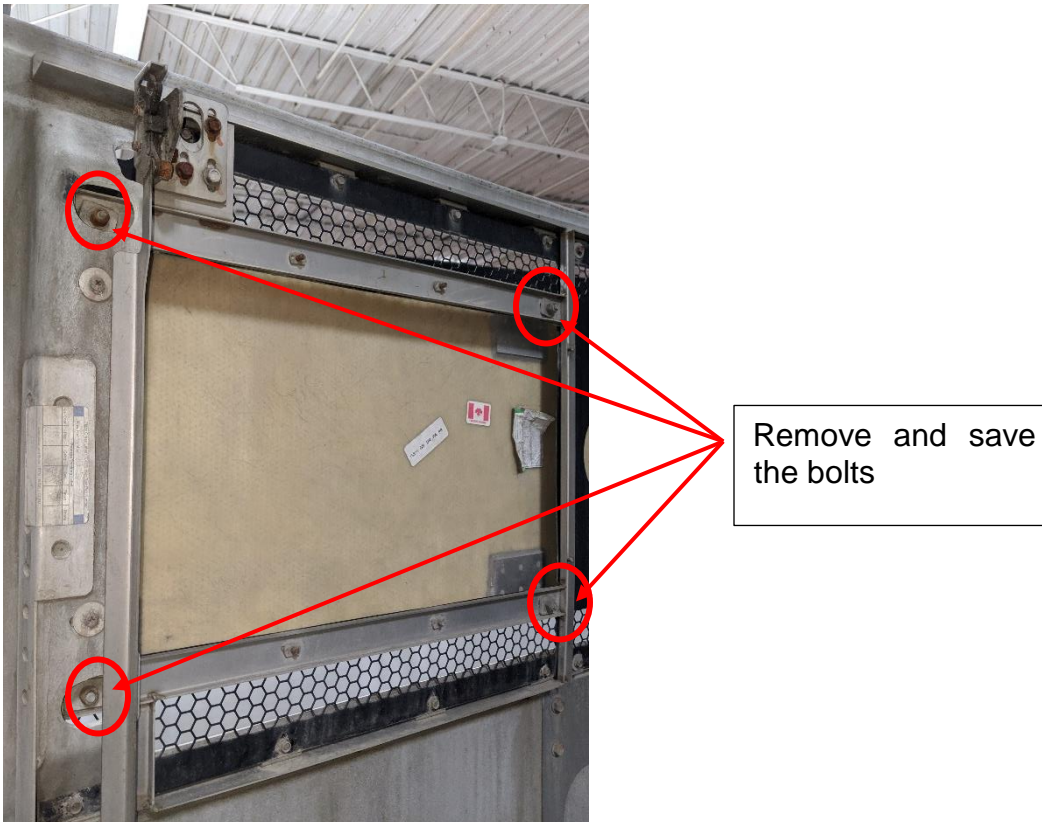


Disconnect the light harness behind the rad panel.



Disconnect the harness

Remove and save the 4 bolts securing the driver side upper rad panel to the rad door. Save the rad panel, washers, gaskets, and nuts.



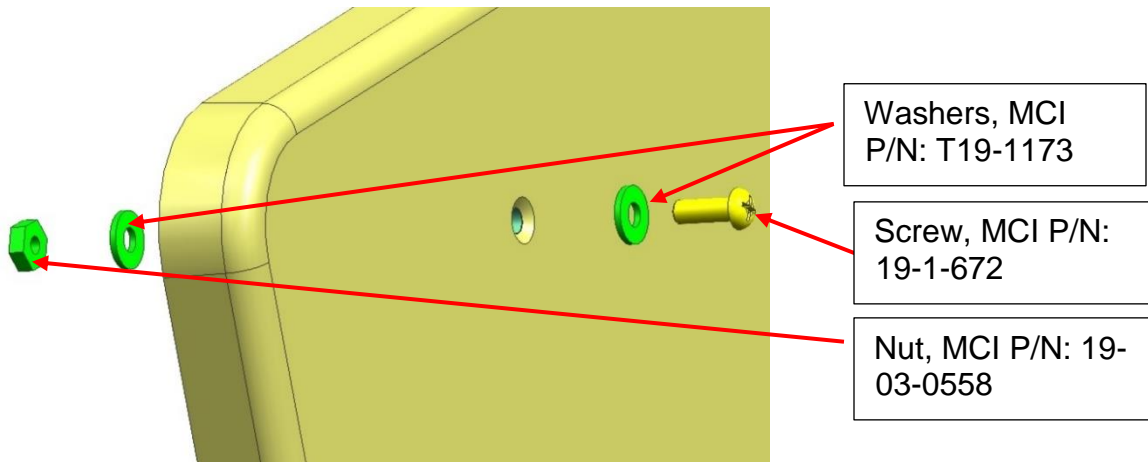
Remove and save the bolts

4.2 Replace the rivets with nuts and bolts

Remove the four rivets on the rad panel by drilling through them.

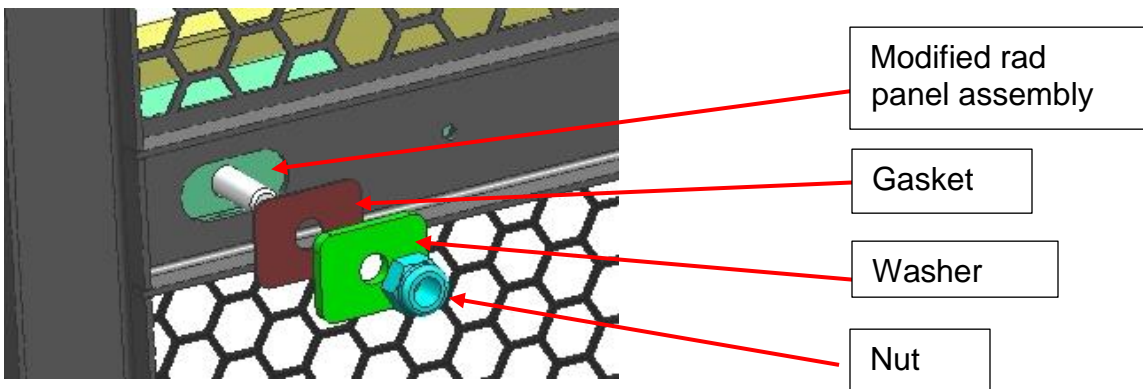


Secure the panel to the bracket using screws, MCI P/N: 19-1-672, washers, MCI P/N: T19-1173, and nuts, MCI P/N: 19-03-0558 as shown below. Torque the nuts to 20 In-Lbs.

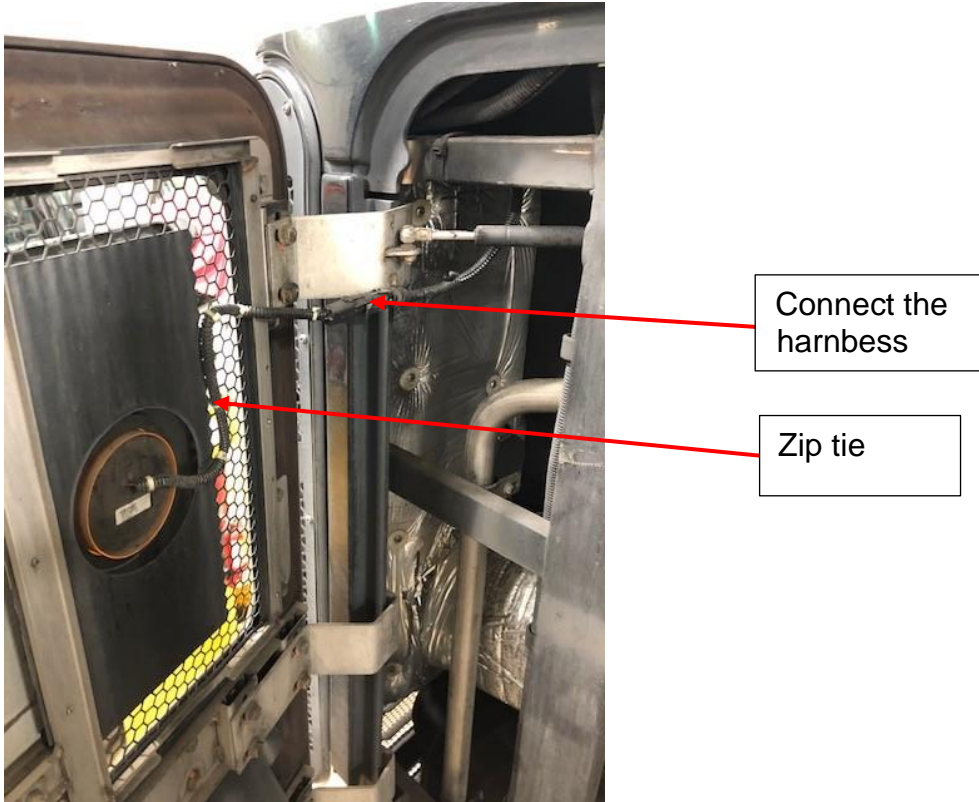


4.3 Re-install the rad panel

Install the modified rad panel assembly to the coach using existing hardware. Torque the nuts to 22 In-Lbs.



Connect the light harness to back and secure the harness to rad door using zip ties, MCI P/N: 19-11-258, as required.



End of the procedure