

**"DOCUMENT UNCONTROLLED IF PRINTED"**

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR873	2019-SOI-F Driveshaft Repair	1 of 1	-	SER-E	B. Fisher	2/10/20

Read process before beginning. If you do not understand any part please contact: Chris Ward, VP of Parts and Warranty 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: Driveshaft angles incorrect

Cause: Production installation error

Correction: Replace middle and rear carrier bearing bracket assemblies and brackets. Set driveshaft angles and align driveshaft to spec. Inspect u-joints and carrier bearings for damage/wear. If damage is found, replaced affected components.

Vehicles Affected: 2019 Ford Transit Buses-May Include Bus #'s (3627-3631, 3640-3644, 3694-3703, 3928, 3993-3994, 4026-4030) 28 buses.

Labor Operation Code: 018101

Labor Time Allowance: 1 hour per unit

Parts Returned: No

Tools Required

Torque Wrench

Driveline Angle Gage- If needed

Parts Required

Qty - 1 - # 1310379 - BRACKET ASSY, CARRIER BEARING SOI-F 35.153" (PAINTED BLACK)

Qty - 1 - # 1310403 - BRACKET, CARRIER BEARING ANGLE 4 DEG SOI-F REV A

Qty - 1 - #1310380 - BRACKET ASSY, CARRIER BEARING SOI-F 35.803"

Qty - 1 - #1310404 -BRACKET, CARRIER BEARING ANGLE 2 DEG SOI-F REV A

**Repair Instruction**

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

Step 2: Unbolt drive shaft carrier bearings from brackets at crossmember 2 and 3.

Step 3: Remove/discard 2nd and 3rd driveshaft bracket assemblies.



Step 4: Install new 2nd and 3rd driveshaft bracket assemblies. (Torque = 102 FT/LBS)

Step 5: Install new drive shaft carrier bearing brackets to bracket assemblies. (Torque = 45 FT/LBS)

Step 6: Re-connect driveshaft to carrier bearing brackets (Torque = 45 FT/LBS) and align driveshafts between transmission and rear differential.

Step 7: Remove from hoist.

Step 8: Test drive vehicle and check for vibrations/noises

Step 9 : If vibration/noise is excessive, measure driveshaft angles (Call ARBOC for guidance to reset angles)