



Spartan Fire, LLC

Technical Service Bulletin TSB21-150-001

DATE: 2-5-2021

APPLIES TO: This service bulletin applies to 2019 through 2021 model year, Gladiator and Metro Star model emergency response chassis cabs built by TCM and DTM between July 15, 2019 and August 10, 2020.

CONDITION: Paint crack at the seam sealer in the joint between roof skin and side extrusion.

CORRECTION: Inspect and add adhesive as needed

LABOR ALLOCATION: 3 hours inspection 32 Hours repair

CLASSIFICATION: T3

PARTS NEEDED:

- SEM 39537 Dual-Mix Weld-Bond adhesive as needed

GENERAL INSTRUCTIONS:

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Fire LLC. Customer & Product Support Group.

All applicable industry safety standards must be followed when performing work identified in this procedure.

Service Bulletins are intended for use by Professional Technicians only. They are written to guide Professional Technicians in performing service to vehicles of specific nature in conjunction with industry standards. Professional Technicians should be appropriately trained on industry standards and have the tools and equipment to perform procedures safely and properly.

INSPECTION:

Remove inner head liner to verify proper application of adhesive between the seams as indicated in Fig. 2-1, 2-2, 3-1, 3-2, and 3-3.

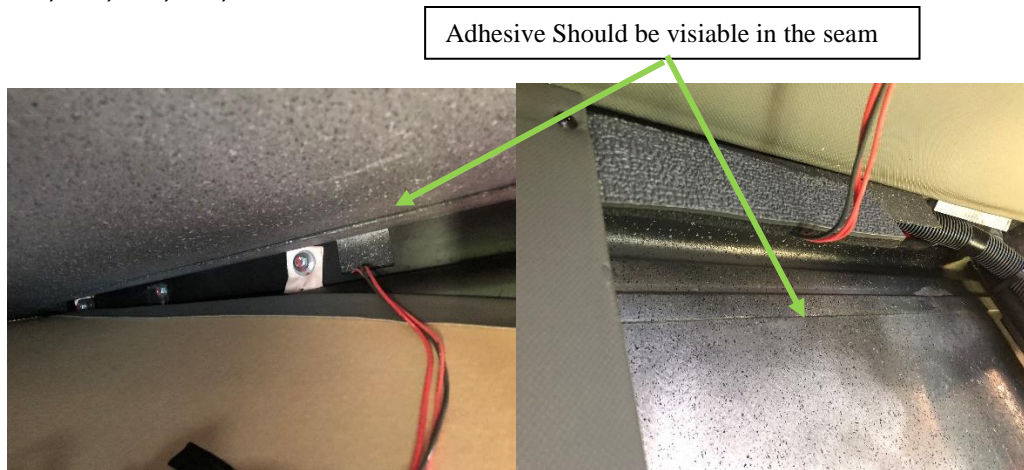


Fig 2-1

ADHESIVE SHOULD BE VISIBLE ALONG THIS SEAM.

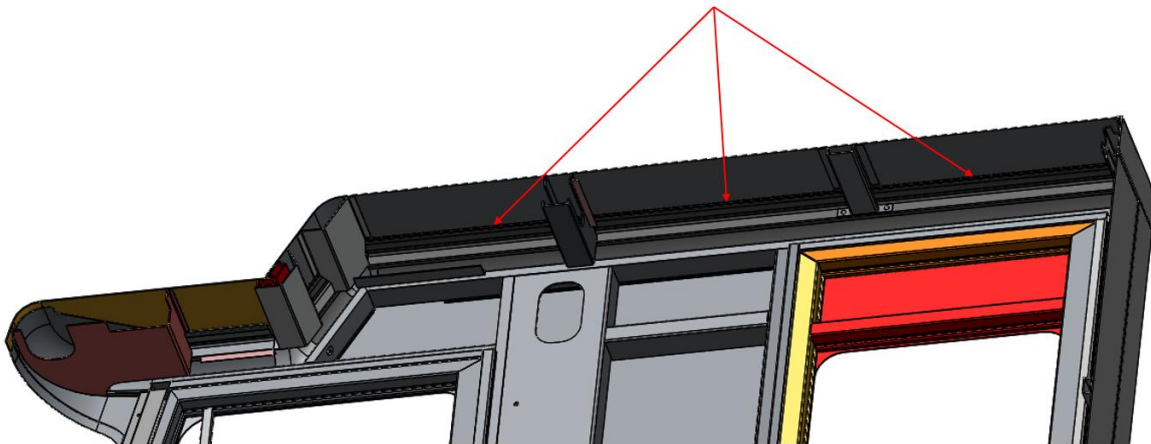


Fig 2-2

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ADHESIVE SHOULD BE VISIBLE ALONG THIS SEAM.

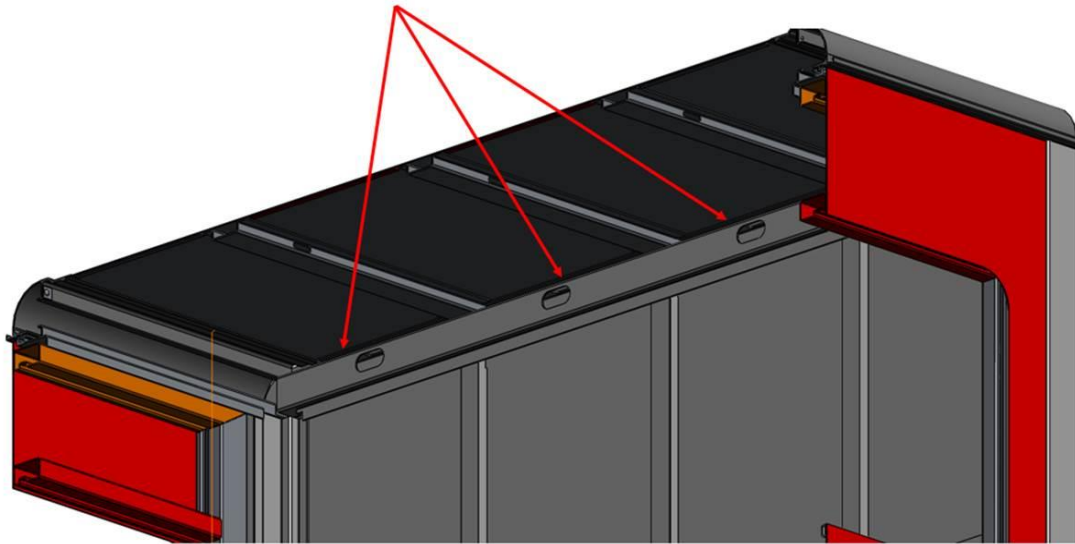


Fig 3-1



Adhesive not visible in the seam

Adhesive visible in the seam

Defective

Correct

FIG 3-2

FIG 3-3

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INSTRUCTIONS:

After inspection use the following instructions if determined that adhesive is missing.

Roof Skin/Side Wall Extrusion

Fig.4-1, 5-1, 5-2

- Using a drill bit that matches the size of the smallest opening on the epoxy extruder nozzle, drill a pilot hole through the lower lip of the roof extrusion and the cab skin inside the cab. Do not drill through the upper extrusion lip.
- Using a drill that matches the size of next opening on the epoxy extruder nozzle, drill only through the lower extrusion lip in the same location as the pilot hole
- Repeat every 6" over the length of the extrusion.
- Using the smallest opening in the epoxy extruder, firmly seat the extruder nozzle in the pilot hole and inject SEM 39537 Dual-Mix Weld-Bond adhesive into the top section of the extrusion.
- Repeat the prior step with the next largest extruder opening to inject adhesive into the lower section of the extrusion.

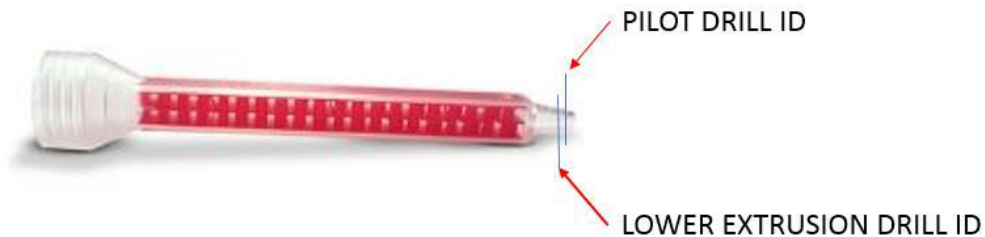


Fig 4-1

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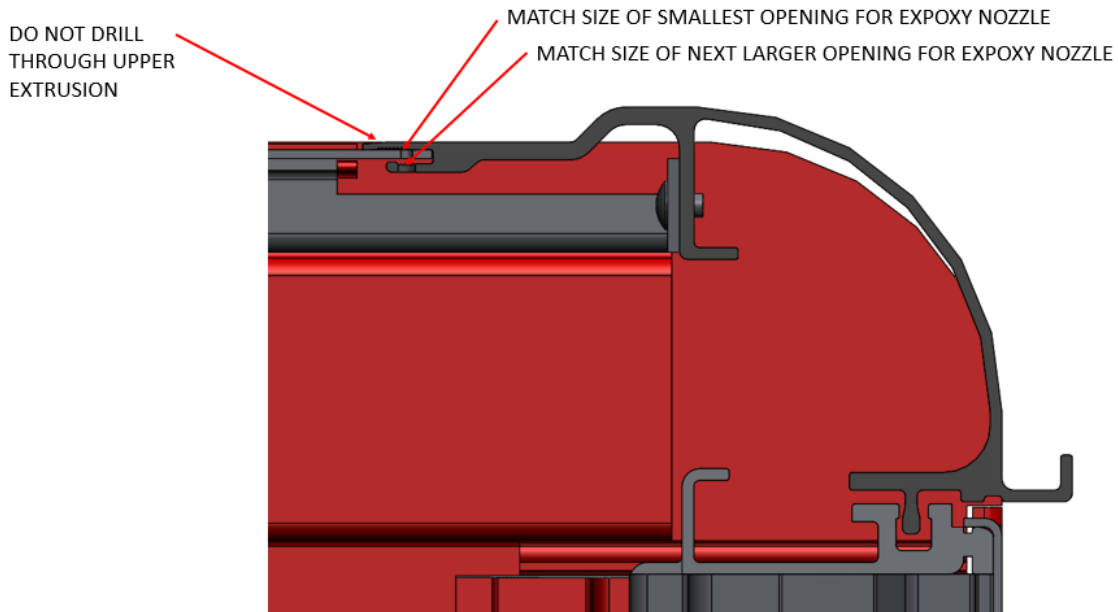


Fig 5-1

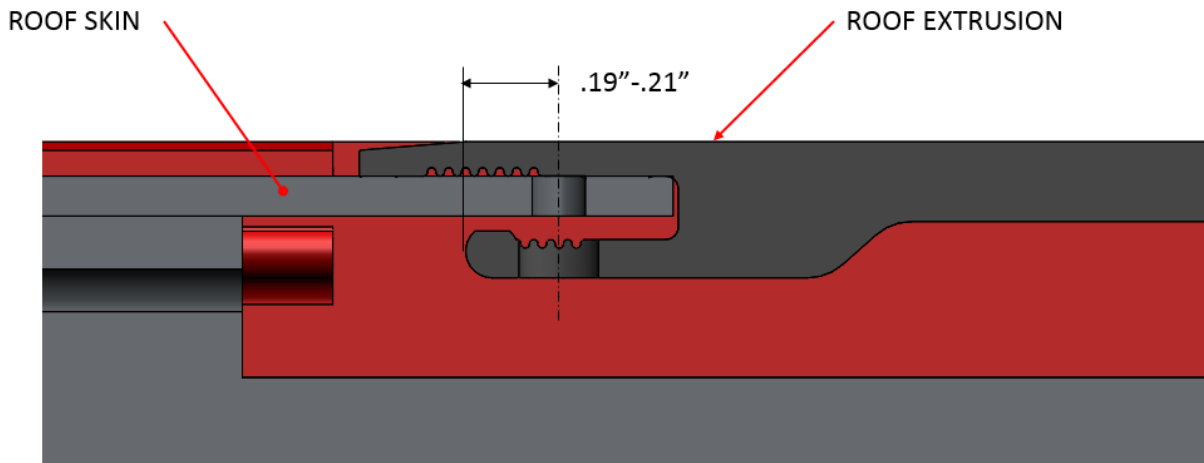


Fig 5-2

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Roof Skin/Rear Wall Extrusion

Fig.6-1, 7-1, 7-2

- Using a drill bit that matches the size of the smallest opening on the epoxy extruder nozzle, drill a pilot hole through the upper lip of the roof extrusion and the cab skin inside the cab. Do no drill through the Lower extrusion lip.
- Using a drill that matches the size of next opening on the epoxy extruder nozzle, drill only through the Upper extrusion lip in the same location as the pilot hole
- Repeat every 6" over the length of the extrusion
- Using the smallest opening in the epoxy extruder, firmly seat the extruder nozzle in the pilot hole and inject SEM 39537 Dual-Mix Weld-Bond adhesive into the lower section of the extrusion.
- Repeat the prior step with the next largest extruder opening to inject adhesive into the upper section of the extrusion.
- Adhesive may squeeze out of the joint seams

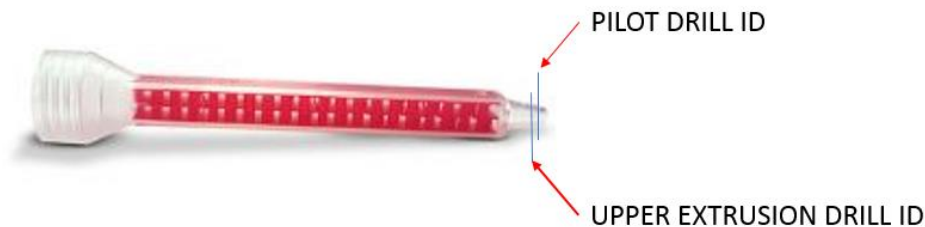


Fig 6-1

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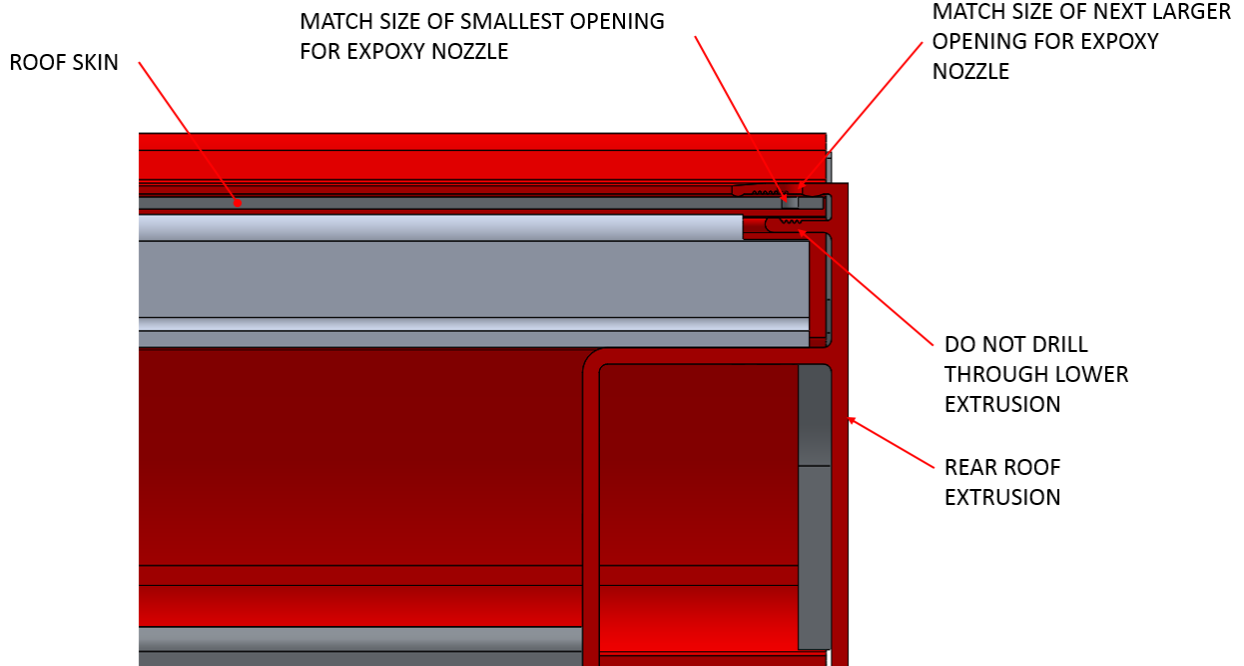


Fig 7-1

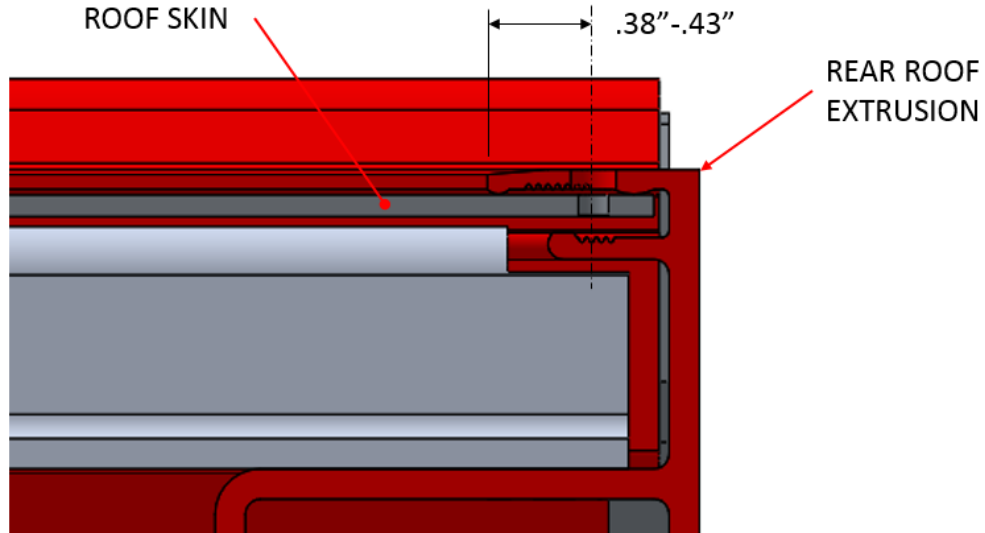


Fig 7-2

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