

Date	Expiration	Release	Page
01.2022	01.2023	1	1(10)

First Release -

01-13-2022

FRONT & TAG AXLE AIR SPRINGS - ADHESIVE INSTALLATION

B13R (9700 us/can)

DESCRIPTION

On the vehicles affected by this bulletin, perform the correct installation of double bonded tape on the air springs for the front and tag axle.

MODEL YEAR(S) AND VEHICLES INVOLVED

NOTICE TO SERVICE CENTERS	
Verify vehicle eligibility by checking warranty bulletin status with SAP or via ONLINE WARRANTY SYSTEM available on Service / Warranty tab of Prevost website.	
Model	VIN
Volvo 9700 US/CAN Model Year: 2020	3CET2W429 <u>L</u> 520 <u>1926</u>
	3CET2W422 <u>L</u> 520 <u>1931</u>
	3CET2W424 <u>L</u> 520 <u>1932</u>
	3CET2W426 <u>L</u> 520 <u>1933</u>
	3CET2W428 <u>L</u> 520 <u>1934</u>
	3CET2W42X <u>L</u> 520 <u>1935</u>
This bulletin does not necessarily apply to all the above-mentioned vehicles, some vehicles may have been modified before delivery.	

MATERIAL NEEDED

Order the following parts:

Part No.	Description	Qty
1621452	TAPE, DOUBLE BONDED TAPE	4

NOTE

Material can be obtained through regular channels.

PROCEDURE

Date	Expiration	Release	Page
01.2022	01.2023	1	2(10)



DANGER

Park vehicle safely, apply parking brake, stop the engine. Prior to working on the vehicle, set the ignition switch to the OFF position and trip the main circuit breakers equipped with a trip button. On Commuter type vehicles, set the battery master switch (master cut-out) to the OFF position.

Lockout & Tag out (LOTO) must be performed during set-up, maintenance, or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.



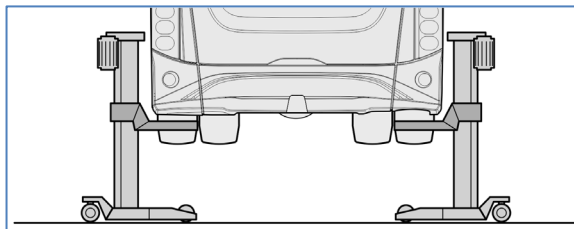
WARNING

Please follow the instructions carefully to avoid personal injuries and damages to equipment. Negligence can lead to fatal or serious injury. A risk of crushing is present during the lowering phase.

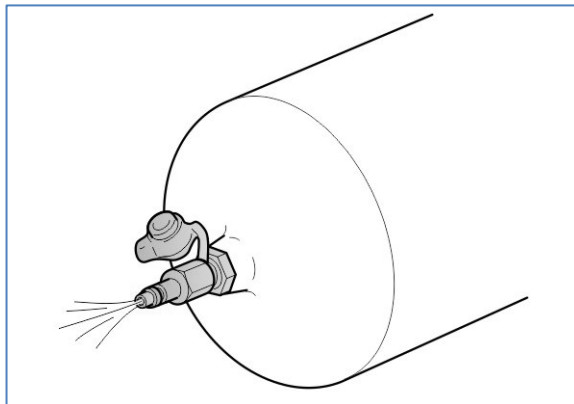
TAG AXLE

1. Lift and support the vehicle by the wheels. Support the tag axle with jacks or ideally wheel lifters.

Note: It must be possible to lower the tag axle 4 inches for the removal of the air springs.

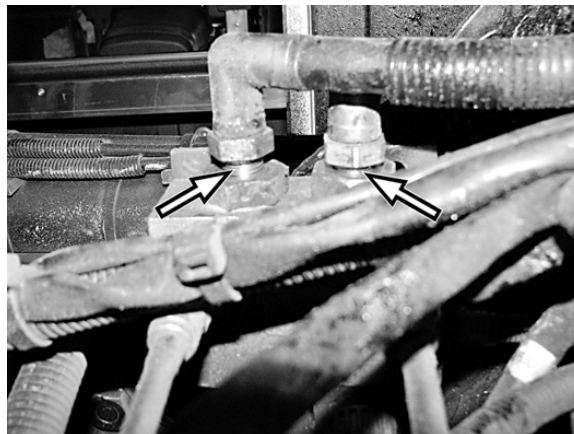


2. Empty the air suspension system by purging the compressed air tanks.



Date	Expiration	Release	Page
01.2022	01.2023	1	3(10)

3. **Proceed simultaneously for both air springs.** Remove the locking nut and pneumatic connection on top of the air springs.

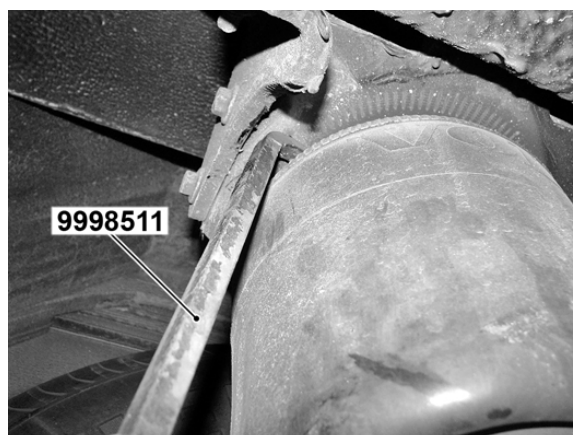


Warning

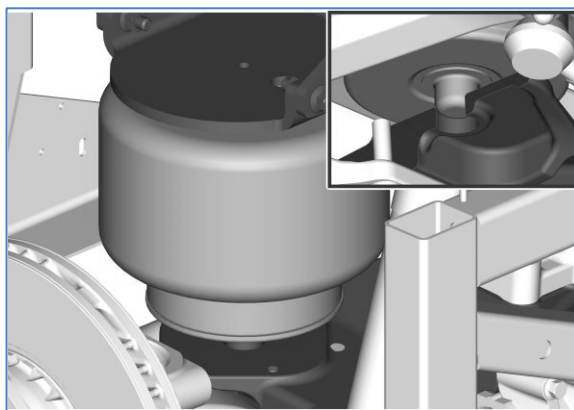
Please follow the instructions carefully to avoid personal injuries and damage to equipment. Negligence can lead to fatal or serious injury. Risk of being crushed during lowering!

4. Using jack or wheel lifters, lower the tag axle 100 mm (4 in).
5. Remove the air spring along with the piston.

If necessary, pull off the edge against the clincher board with a tire lever or pry bar.



6. Detach the air spring from the lower plate using a pry bar if necessary.



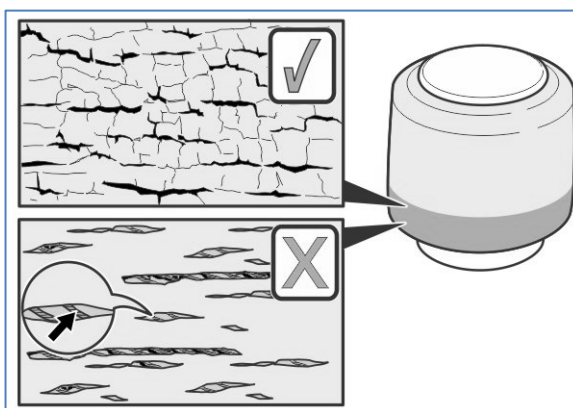
7. Separate the air spring from the piston.

Date	Expiration	Release	Page
01.2022	01.2023	1	4(10)

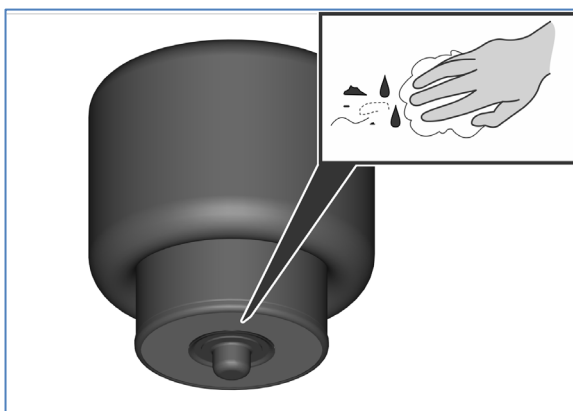


AIR SPRING AND PISTON

8. Check the air spring for damage.



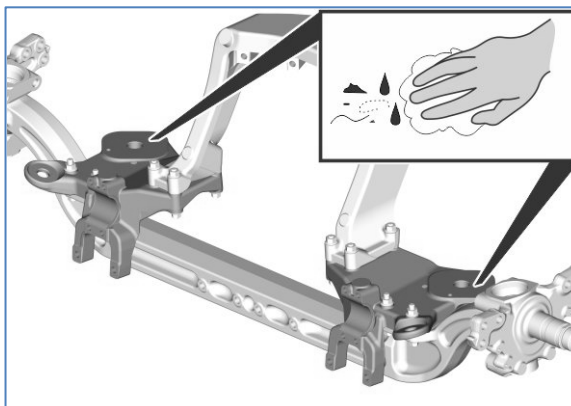
9. Clean the air spring, the piston and the clincher board mating surfaces.
10. Clean the air spring bottom surface in preparation of double bonded tape installation.



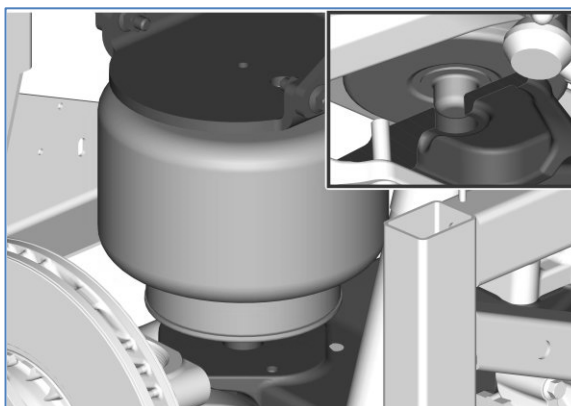
11. Clean the area where the DOUBLE BONDED TAPE will be installed. Trailing axle bracket.

Date	Expiration	Release	Page
01.2022	01.2023	1	5(10)

12. Install 1621452 double bonded tape on the air spring bottom surface.



13. Remove the protect film on the DOUBLE BONDED TAPE. Reinstall the air spring and piston. Tighten the M10 nuts to **48±8 Nm** (35±6 ft lb). Tighten the air connection.



Date	Expiration	Release	Page
01.2022	01.2023	1	6(10)

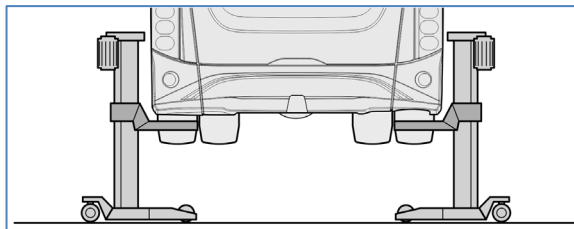


Date	Expiration	Release	Page
01.2022	01.2023	1	7(10)

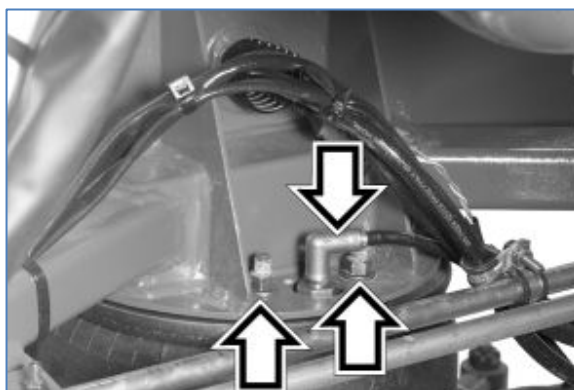
FRONT AXLE

1. Lift and support the vehicle by the wheels. Support the front axle with jacks or ideally wheel lifters.

Note: It must be possible to lower the front axle 4 inches for the removal of the air springs



2. **Proceed simultaneously for both air springs.** Loosen the air connection from the air spring and both M10 screws on the air spring plate.



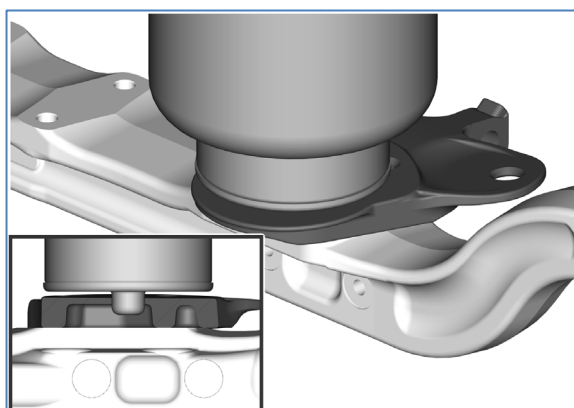
Warning

Please follow the instructions carefully to avoid personal injuries and damage to equipment. Negligence can lead to fatal or serious injury. Risk of being crushed during lowering!

3. Lower the front axle and remove the air spring along with the piston.

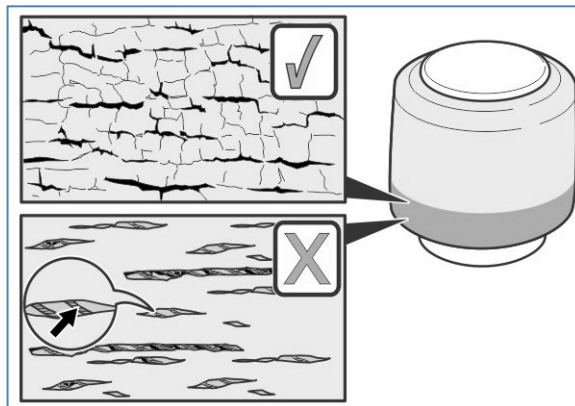
If necessary, pull off the edge against the clincher board with a tire lever or pry bar

4. Separate the air spring from the piston.

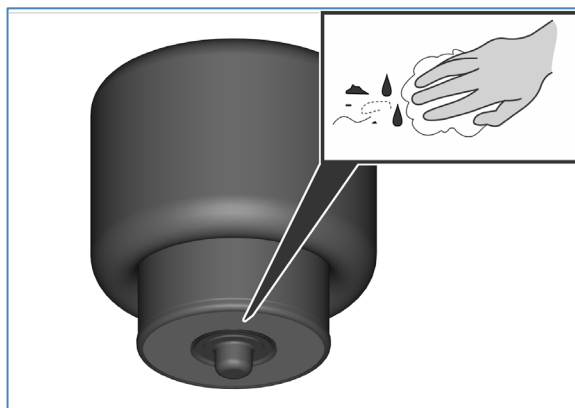
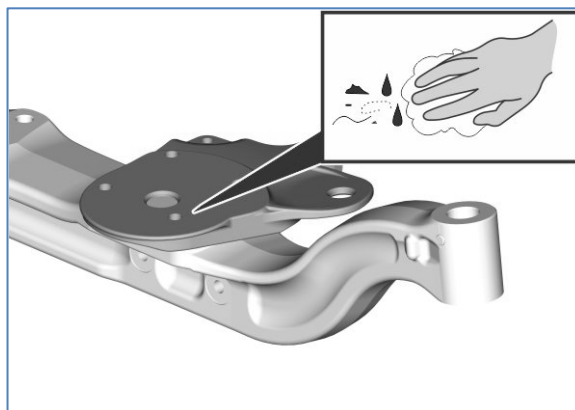


Date	Expiration	Release	Page
01.2022	01.2023	1	8(10)

5. Check the air spring for damage.



6. Clean the air spring, piston and the clincher board mating surfaces.
7. Clean the air spring bottom surface in preparation of double bonded tape installation.

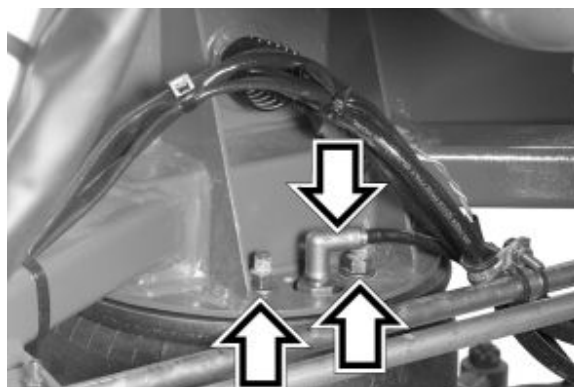
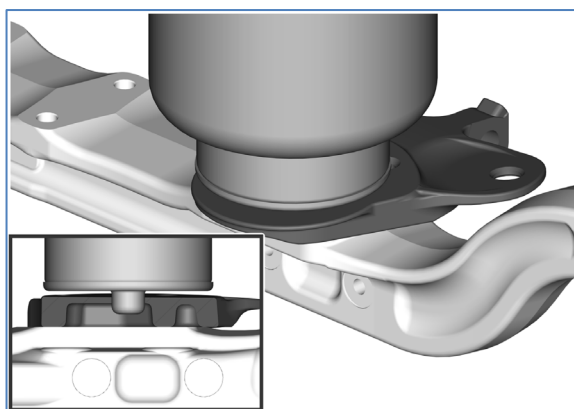


8. Install 1621452 double bonded tape on the air spring bottom surface.

Date	Expiration	Release	Page
01.2022	01.2023	1	9(10)



9. Attach the air spring and tighten the M10 nuts to **48±8 Nm** (35±6 ft lb).
10. Tighten the air connection.



11. Lift the front axle or wheel suspension so that the air spring fits tightly against the piston and the clincher board's seal edge.
12. Remove the jack stands if applicable and lower the bus.

Date	Expiration	Release	Page
01.2022	01.2023	1	10(10)

FINAL STEP

1. Start the engine and run it until full air pressure is attained. Check that the air spring and air connection are airtight.

ESTIMATED TIME

The time allowed to perform this special bulletin is **2.5** hours.

OTHER

VBC Bulletin	N/A
Fail Code	16.01
Defect Code	09
Syst. Cond	B
Causal Part	22445751

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