



AUTHORIZED FIELD CHANGE – 23901

17 August 2023

SUBJECT: Sealing roof joints during Safety Recall 23501 or 23502 is performed if required.

MODELS INVOLVED:

IC Bus® RE, CE, and Electric CE Series buses

DEFECT DESCRIPTION:

Certain IC Bus® applications may have roof water leaks resulting from incorrect assembly described in Roof Joint Recalls 23501 and 23502. This document will guide the user through resealing the source of the roof water leaks.

ELIGIBILITY:

This procedure applies ONLY to vehicles marked in the International® Service PortalSM with AFC 23901. Also complete any other open campaigns listed on the Service Portal at this time.

TOOLS REQUIRED:

No special tools required

PARTS REQUIRED:

NOTE: A tube of sealant may seal up to two rows of rivets and / or screws. Up to four or five tubes may be required depending on the number of joints repaired.

Number	Description	Quantity
Dicor 501LSW	Sealant, White, 11 oz. Tube (Purchase Online)	As needed
810000KK	Sealant, Yellow, 11 oz. Tube (Direct Ship)	As needed

Table 1 Parts Information

SERVICE PROCEDURE

GOVERNMENT REGULATION: Engine fluid (oil, fuel, and coolant) may be a hazard to human health and the environment. Handle all fluid and other contaminated materials (such as filters and rags) in accordance with applicable regulations. Recycle or dispose of engine fluids, filters, and other contaminated materials according to applicable regulations.

WARNING! To prevent personal injury and / or death, or damage to property, park vehicle on hard flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in both directions.

WARNING! To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

WARNING! To prevent personal injury and / or death, or damage to property, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

WARNING! To prevent personal injury and / or death, or damage to property, work on a level scaffold of appropriate size and / or wear a safety harness in good working condition. IC Bus, LLC recommends the use of a fall protection system and / or scaffolding to perform this service procedure. Consult your OSHA representative for guidance.

CAUTION! To prevent damage to property, when working on the vehicle roof and / or working directly over a roof bow, ALWAYS ENSURE that clean / non-scuffing shoes or boots are worn to prevent scratches or unnecessary marking to the roof surface. AVOID walking on the roof in an upright position. Sitting or lying on the roof helps to ensure the technician's body weight is evenly distributed over a large surface to minimize denting.

CAUTION! To prevent damage to property, NEVER use cloth shop rags / towels to clean surfaces. Even if clean, cloth shop rags / towels may contain an oily residue that may negatively interfere with the sealant adhering to the surface of the bus.

IMPORTANT: Portions of this repair procedure must be performed on the roof of the bus. Please refer to the Warning depicted in this document and consult your facility's OSHA guidelines related to safety requirements before performing this procedure.

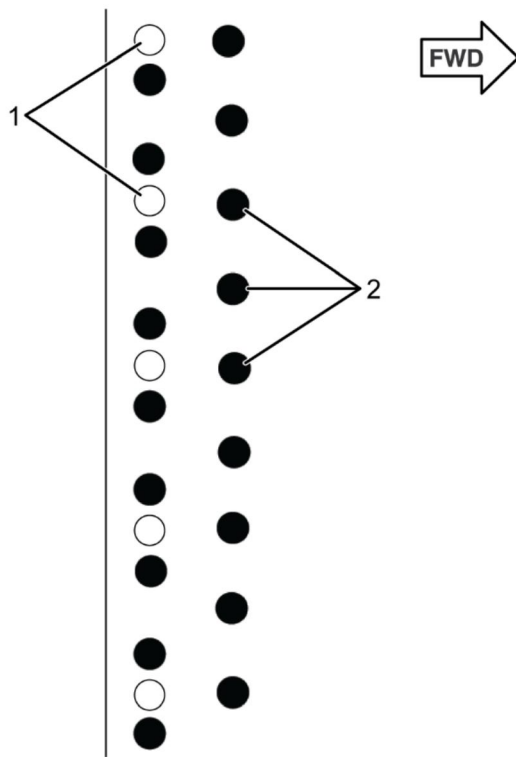
NOTE: This AFC should be performed while performing Safety Recall 23501 or 23502 if joints are repaired under such safety recall. Refer to Safety Recall 23501 or 23502 that pertains to this vehicle for detailed instructions.

1. Park vehicle on a flat surface.
2. Shift transmission to Park or Neutral and set parking brake.
3. Turn vehicle ignition to Key OFF position.
4. Install wheel chocks.

NOTE: Refer to Figure 5 in Safety Recall 23501 or 23502 for screws with sealant.

NOTE: The first revisions of Safety Recall 23501 and 23502, which included sealing of the screws, were released in May 2023.

5. Starting at rearmost top panel of bus, determine if panel(s) were repaired under Safety Recall 23501 or 23502.
 - a. If panel(s) had repairs completed and roof bow screws sealed, applying sealant to rivets is required. Perform Steps 6 through 10 and then proceed to Step 16.
 - b. If panel(s) had repairs completed in April or May 2023 and before Revision 1 of Safety Recall 23501 and 23502 released in May 2023, applying sealant to rivets and screws is required. Perform Steps 11 through 17.
 - c. If panel(s) had no repairs needed, applying sealant to rivets and screws is not required. Proceed to Step 17.



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Figure 1. Roof Joint Leak Repair Rivet Location

1. Rear row of screws
2. Forward row of rivets

CAUTION! To prevent damage to property, when working on the vehicle roof and / or working directly over a roof bow, **ALWAYS ENSURE** that clean / non-scuffing shoes or boots are worn to prevent scratches or unnecessary marking to the roof surface. **AVOID** walking on the roof in an upright position. **Sitting or lying** on the roof helps to ensure the technician's body weight is evenly distributed over a large surface to minimize denting.

6. Starting with rearmost top panel that required screws (Figure 1, Item 1), locate forward row of rivets (Figure 1, Item 2).

CAUTION! To prevent damage to property, **NEVER** use cloth shop rags / towels to clean surfaces. Even if clean, cloth shop rags / towels may contain an oily residue that may negatively interfere with the sealant adhering to the surface of the bus.

7. Clean surface with non-oil-based cleaner and wipe dry.

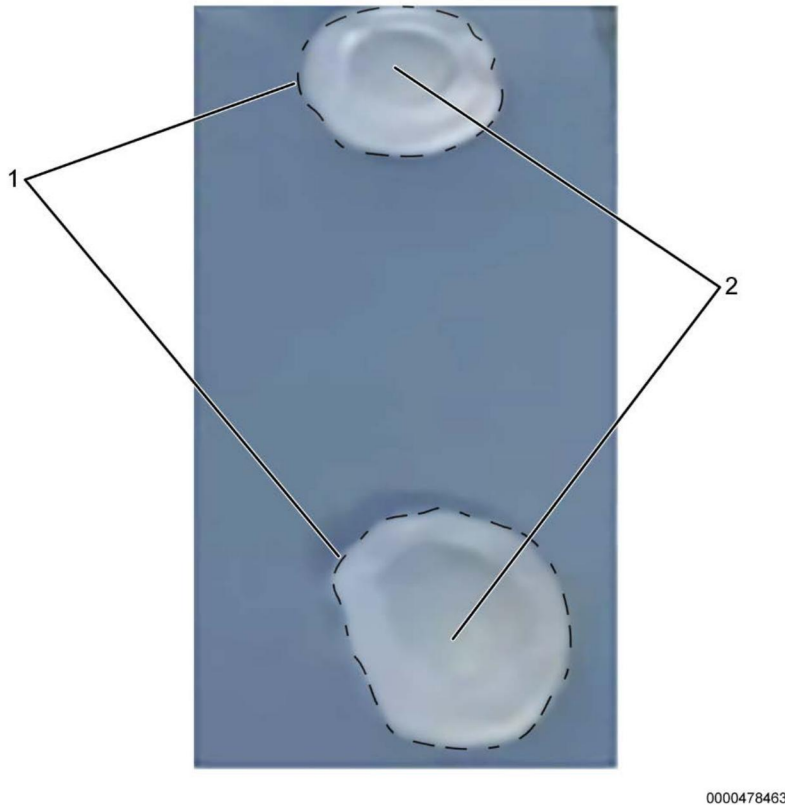
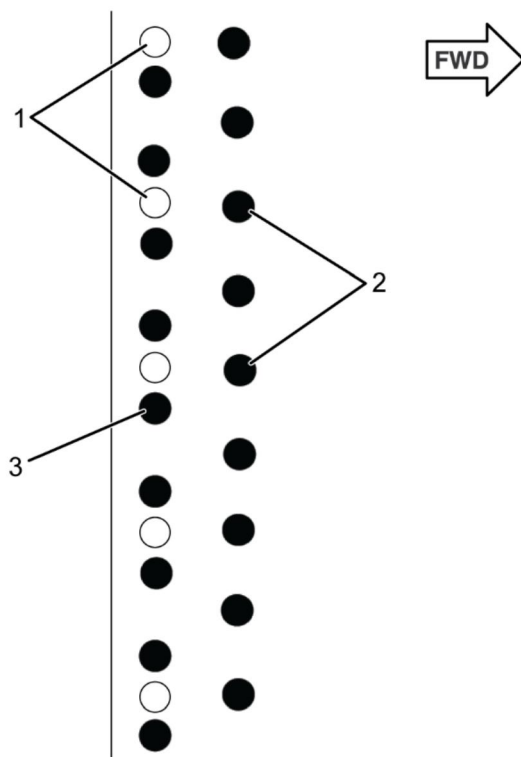


Figure 2. Add Sealant to Rivets

1. Sealant
2. Rivet head

NOTE: In line with the forward row of rivets of the repaired joint, up to approximately 35 rivets will require sealant.

8. Starting at 20 in (508 mm) up from drip rail, apply appropriate color sealant (Figure 2, Item 1) to perimeter of rivet head (Figure 2, Item 2).
9. Repeat Steps 7 and 8 for each rivet in forward row of rivets of repaired joint.
10. Repeat Steps 7 through 9 for each repaired joint.



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Figure 3. Roof Joint Leak Repair Screw Location

1. Rear row of screws
2. Forward row of rivets
3. Existing rivet

CAUTION! To prevent damage to property, when working on the vehicle roof and / or working directly over a roof bow, **ALWAYS ENSURE** that clean / non-scuffing shoes or boots are worn to prevent scratches or unnecessary marking to the roof surface. **AVOID** walking on the roof in an upright position. Sitting or lying on the roof helps to ensure the technician's body weight is evenly distributed over a large surface to minimize denting.

11. Starting with rearmost top panel that required screws, locate forward row of rivets (Figure 3, Item 2) and rear row of screws (Figure 3, Item 1).

CAUTION! To prevent damage to property, **NEVER** use cloth shop rags / towels to clean surfaces. Even if clean, cloth shop rags / towels may contain an oily residue that may negatively interfere with the sealant adhering to the surface of the bus.

12. Clean surface with non-oil-based cleaner and wipe dry.



Figure 4. Add Sealant to Screws

1. Sealant

NOTE: In line with the rearmost row of rivets of the repaired joint, up to approximately 19 screws and 35 rivets will require sealant.

13. Starting at 20 in (508 mm) up from drip rail, apply appropriate color sealant (Figure 4, Item 1) to perimeter of rivet and screw head.
14. Repeat Steps 12 and 13 for each rivet in forward row of rivets and each screw in rear row of rivets of repaired joint.
15. Repeat Steps 12 through 14 for each repaired joint.

16. Once all appropriate rivets and / or screws have been sealed, carefully remove scaffolding and / or safety harness.

17. Remove wheel chocks.

LABOR INFORMATION

Operation number must appear on all claims.

Operation Number	Description	Time
A40-23901-1	Repair One Joint	0.3 hrs
A40-23901-2	Repair Each Additional Joint; As Needed	0.2 hrs

Table 2 Labor Information

WARRANTY CLAIMS

Warranty claim expense is to be charged to Warranty. Claims are to be submitted in the normal manner, making reference to Field Service Campaign 23901.

Section 7 of the Warranty Policy and Procedures Manual contains further information related to the submission and processing of AFC / Recall claims.

As with all claim submissions, items acquired locally must be submitted in the “Other Charges” tab. The cost of any bulk items (such as a bag of cable tie straps, roll of wire, barrel of oil, or tube of silicone) should be prorated for the cost of the individual pieces / amount used during each repair.

To make sure this important improvement is made in a timely manner, all claims for 23901 activity must be submitted by 17 August 2023 or within the normal warranty period for the component, if after 17 August 2024.

GROUP	NOUN	C	WARR.	TP	PAD

GROUP — Enter number ←

NOUN — Leave blank ←

C (CAUSE) — Enter either 1, 2, 3. (See below)

- 1. Inspected (No repair required).
- 2. Inspected and repaired.
- 3. Defective part from parts stock.

WARRANTY — (Warranty Code) Enter 40. ←

TYPE PART — Enter P for type part causing failure. ←

PAD — Enter 100 ←

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