



Spartan Fire, LLC

Technical Service Bulletin TSB23-250-001

DATE: 10/12/2023

APPLIES TO: This service bulletin applies to certain 2011 through 2024 model year, Gladiator and Metro Star model Emergency Response chassis cabs built between January 2011 and June 2023.

CONDITION: Reyco front IFS cradle may experience a crack in the structure.

CORRECTION: Weld repair crack and then weld gusset per instructions.

LABOR ALLOCATION: 2 hours

CLASSIFICATION: T3

PARTS NEEDED:

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	716143-01	Weld-on Gusset

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.

Step By Step Instructions

- 1) Remove air brake line from brackets located on the front and side to be repaired.
See figure 2.1

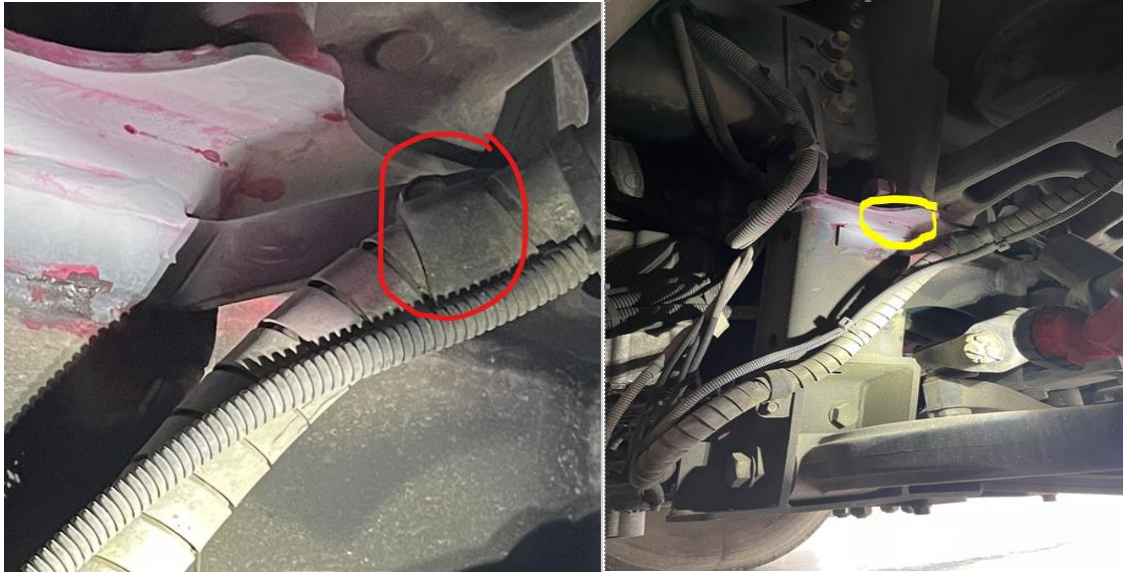


Figure 2.1

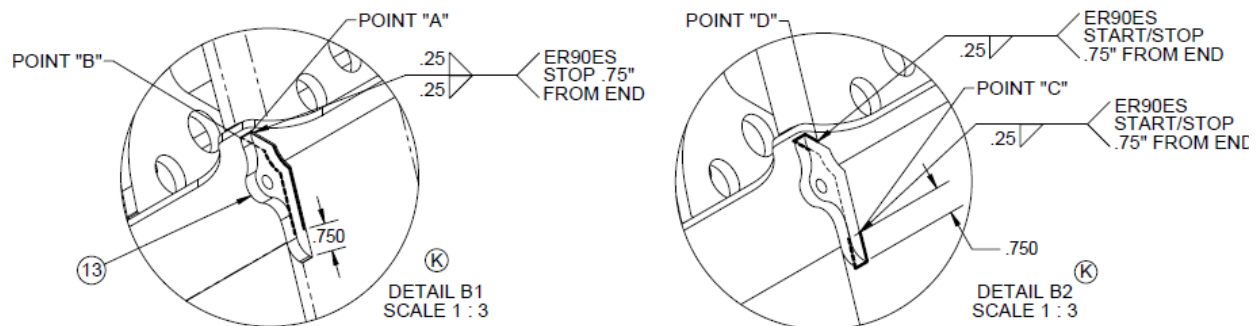
- 2) Remove air line bracket on side to be repaired with grinder or cutting wheel. Do not cut into/gouge parent material behind bracket. Then grind the area smooth. *See figure 2.2*



Figure 2.2

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- 3) Locate the beginning and end of crack. Gouge out crack with grinder, the full length of crack and slightly beyond. Remove all paint and contaminants from weld area.
- 4) Weld full length of crack with one continuous weld. Apply additional weld beads if needed to properly cover the crack or undercuts. If additional beads are needed, clean welds between passes.
- 5) Fully weld gusset 716143-01 in place as instructed below. *See figure 3.1*



WELD IS ALL AROUND GUSSET (#13) USE THIS WELD ORDER (REORIENT CRADLE AS NEEDED):

1. IN DETAIL B1 ON NEAR SIDE WELD, START POINT "A" STOPPING .75" FROM END
2. IN DETAIL B1 ON FAR SIDE WELD, START POINT "B" STOPPING .75" FROM END
3. IN DETAIL B2 FOR LOWER WELD START AT POINT "C" AT LEAST .75" FROM EDGE OVERLAPPING PREVIOUS WELD WRAPPING AROUND TO BACKSIDE STOPPING AT LEAST .75" FROM EDGE OVERLAPPING PREVIOUS WELD ON BACKSIDE
4. IN DETAIL B2 FOR UPPER WELD START AT POINT "D" OVERLAPPING TO WRAP TO BACKSIDE OVERLAPPING PREVIOUS WELD TO COMPLETE WELD

Figure 3.1

- 6) Apply desired paint to repair region
- 7) Reattach air line to gusset.

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