

AR878 2018-2019 SOI-F Front Frame Reinforcement

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR878	2018-2019 SOI-F Front Frame Reinforcement	1	-	SERVICE-E	Brad Fisher	11/18/20

Read process before beginning. If you do not understand any part please contact: Brad Fisher, Service Manager at 1-866-953-5555 or by e-mail at bfisher@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: Structural stress crack of chassis frame at front of rear suspension

Cause : Concentrated stress loads

Correction: Drill stop holes into frame,weld cracks and weld provided reinforcement plate to affected area

Vehicles Affected: 2018/2019 Spirit of Independence - Ford (SOI-F)

Labor Op code : 0127801

Labor Time Allowance : 4.0 hrs per unit

Parts Return : No

Pre Auth Required: Yes

Tools Required:

Hoist (ability to raise and support the unit)
Welder
Flame/Spark Resistant Tarp (use to protect interior harness, fuel lines, brake lines, etc.)

Parts Required :

Qty (2) - #1314122-PLATE, REINFORCEMENT GR 50 HRS 2.37" X 3.18" X 10.88"

Repair Instruction

Step 1) Pull unit onto hoist, chock tires to prevent bus from moving

Step 2) Disconnect negative battery cable from both batteries

Step 3) If needed for clearance - loosen/remove exhaust hangers etc.

Step 4) If unit has cracks in frame - drill 1/8 inch holes at the ends of the cracks , grind surface clean and weld cracks and holes closed



Step 5) Grind surface smooth , install reinforcement plate and weld plate into place following weld guidelines below.

NOTE : While repairing this area inspect Drawn Over Mandrel Tube (DOM) in frame for cracking (see green arrows in picture) - If cracking has occurred perform repairs per ARBOC repair instrucion AR880.



AR78 2018-2019 SOI-F Front Frame Reinforcement

- Step 6) Using a high quality undercoating or rust protectant paint , coat repaired area.
- Step 7) Repeat Step 4 thru Step 6 on other side of frame
- Step 8) Reinstall / tighten any loosened components etc. if necessary
- Step 9) Reconnect both negative battery cables
- Step 10) Remove unit from hoist.

Weld Guidelines/order below

