

AR879 2018-2019 SOI-F Frame Outrigger Reinforcement

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
AR879	2018-2019 SOI-F Frame Outrigger 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 outrigger supports

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 : 0127901

Labor Time Allowance : 1.5 hrs. per bracket

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 :

1314178-BRACKET, OUTRIGGER SUPPORT SOI-F 12GA 2-1/2 X 2-1/8
1314278-BRACKET, OUTRIGGER SUPPORT (SOI-F) 12GA

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 (see photo below) - drill 1/8 inch holes at the ends of the cracks, grind surface clean and weld cracks and holes closed-If no cracks proceed to Step 5

Step 5) Grind surface smooth and follow reinforcement plate weld guidelines below and weld into place

Step 6) Using a high quality undercoating or rust protectant coating , coat repaired area

Step 7) Repeat Step 4 thru Step 6 on other side of frame

Step 8) Reinstall/tighten any components removed/loosened for repair

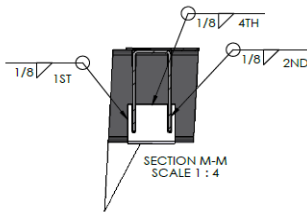
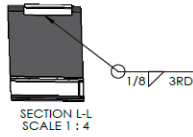
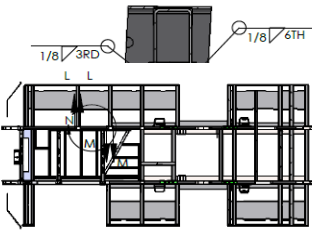
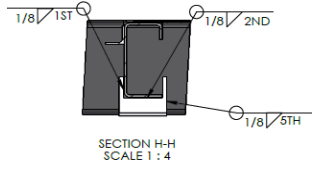
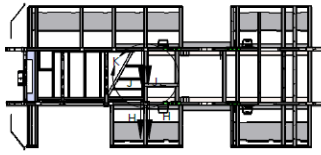
Step 9) Reconnect negative battery cables to both batteries

Step 10) Remove unit from hoist

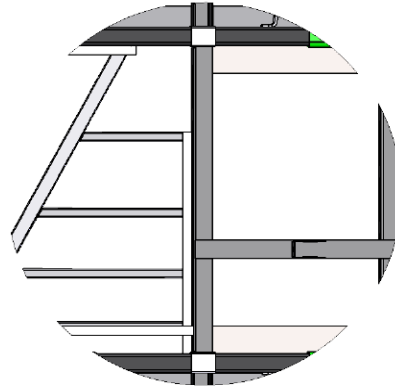


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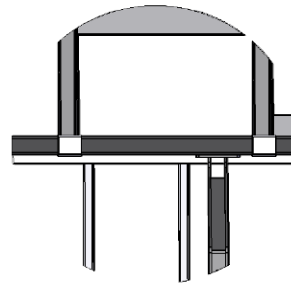
Weld guidelines/order



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