

Subject: Floor bubbling improvement work

Bulletin Type: Conditional Field Operations

Bulletin No: TS45-FC-2510

PQR No: 500000007794

Rev No:00

Ref. No: 700004700

Vehicle Model: TS45

Flat Rate Time / Code: 210 min

Date of issue: 25.04.2025

Modify Before: 25.04.2026

What to do with off coming parts:

- ☐ Scrap
- ☐ Return
- ☐ Use with additional parts
- ☐ On consignment
- ☒ No off coming parts

What to do with outstanding parts of previous revision:

- ☐ Scrap
- ☐ Return
- ☐ Use with additional parts
- ☐ On consignment
- ☒ No outstanding parts

Description of the modification:

This bulletin aims to solve the problem: This bulletin will be implemented in if any bubbling problem seen in the vehicle.

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SAFETY INSTRUCTIONS

1. Mechanical Requested Dress Code

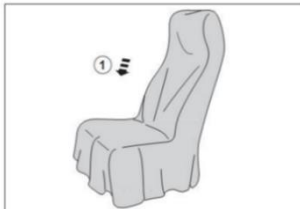


WARNING:

- Dress properly to avoid personal injury and damage to the vehicle

- ✓ Always wear protective clothing
- ✓ Do not wear any worn or loose-fitting clothing
- ✓ Remove jewelry before starting to work
- ✓ In case of long hair, use hairnet
- ✓ The illustration on the left shows some of the correct and incorrect clothing
- ✓ Sharp edged items should be avoided in order not to scratch vehicle (i.e. belts, watches, necklace)

2. Protect Seats when Mechanic Starts Working



- ✓ Seats, trimming, upholstery stuff and carpeting should be protected with appropriate coverings.

3. Welding on the Chassis

- a. Always disconnect the batteries (starting with the negative lead).
- b. Disconnect the connectors of electrical and electronic equipment (electronic control units, sensors and actuators) if they are less than 2 meters away from the chassis part to be welded or the earth terminal of the welding equipment.
- c. The earth terminal should never be attached to vehicle components such as engine, axles and springs. Arcing on these parts is not permitted, because of the risk of damage to bearings, springs, etc.
- d. The earth terminal must make good contact and be placed as close as possible to the part to be welded.
- e. Plastic pipes, rubber parts and parabolic springs should be well protected against welding spatter and temperatures higher than 70°.
- f. The contact switch must not be in the accessory or contact position. The contact key should be removed.

- g. Reconnect in reversed order of disconnecting. Ensure that a good earth connection is made between chassis, engine and ca

TECHNICAL INSTRUCTIONS

1. Make the following preparations;

-a Tools required;

- Matching Weld Cord
- Anti Cut Gloves
- Mozart Weld Trimmer
- Master Groover
- Knife with Straight Blade and Hooked Blade
- Hot Welding Gun fitted with the Turbo Roller Detail Nozzle
- Peroson PU 9225
- Sanding machine
- sand paper
- Clean white cloth
- Spiral
- Vacuum cleaner
- Scraper
- Bally

2. Clear the surface with the wet white towel

Note; Dependent on the dirtiness of the installed floor, it would be recommended to clean the whole floor area first with a high alkaline detergent. This will remove any contaminants from the floor surface. (Figure 1.)



Figure 1

3. Within the area to be fixed, cut the material into 30cm wide strips. This eases the uplifting process



Figure 2

4. Release from the floor the end of the strip to be uplifted. Attach the pulling claw and with force, pull the material off the subfloor and old adhesive.



Figure 3



Figure 4

5. After uplift has been completed, check the condition of the subfloor : Remove by sanding any adhesive residues that remain on the subfloor. If condition of subfloor is good it is going to be used after.



Figure 6



Figure 5

6. Fixed the floor wood connecting points.

- Step 1) Use the spiral to remove old PU9225 in the wood connecting point. (figure 5)
- Step 2) Using the vacuum cleaner clean the surface, (important tip !!! There must not be any dust.) . (figure 5)
- Step 3) Use the Sanding machine, to flattened the surface. Then clean the surface with vacuum cleaner (figure 5)
- Step 4) Apply the PU 9225 to floor wood connecting point. Then flattened the surface with scraper. After that surface must be straight. . (figure 7)
- Step 5) Wait until the PU 9225 gets hard as solid rock. (figure 8)

- Step 6) Use the sanding machine to flattened the surface then use the vacuum cleaner to clean the surface.(figure 9)



Figure 7



Figure 8

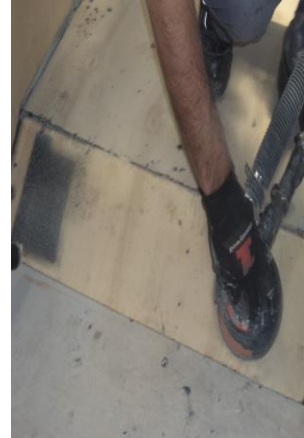


Figure 9

7. Apply the bally the wood surface with 30 cm above and vertical to the surface. (figure 10)

Note; Bally must be contact wood surface, there should be no gap to the surface.



Figure 10

8. Install the floor. (figure 11 - 12)



Figure 11



Figure 12

9. Using a welding gun with the Turbo Roller Nozzle attached, set the temperature to 7 and allow to warm. Apply the weld cord through the nozzle and start to run along the groove. Ensure constant movement, pressure and speed. Figure 13



Figure 13

10. Using the Mozart Weld Trimmer with the spacer retracted, trim flush the weld to the surface of the flooring. (Figure 14)



Figure 14

11. The final result provides an effect repair that will be watertight and not compromise the performance of the installed floor (Figure 15)



Figure 15

[illegible]