

Subject: Water Leakage From the
Evaporator

Bulletin Type: FC

Bulletin No: TS45-FC-2513

PQR No: 500000007776

Rev No:00

Ref. No: 700004701

Vehicle Model: TS45

Flat Rate Time / Code: 0,5 hour

Date of issue:29.04.2025

Modify Before: 29.04.2026

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 prevent water ingress to
evaporator zone

Bulletin Responsible:

Published & Approved By:

SAFETY INSTRUCTIONS

1. Mechanical Requested Dress Code

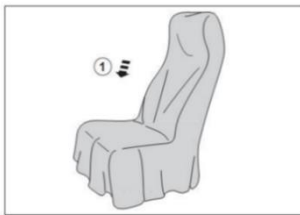


WARNING:

- 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

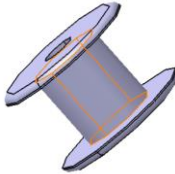


- ✓ Seats, trimming, upholstery stuff and carpeting should be protected with appropriate coverings.

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 cab.

INCLUDED PARTS LIST

No	Part No	Part Name	Picture	Qty	Unit of Measure
1	9324-4762Y	PLATE, TS45		4	Pieces
2	SM-79Y	SEALER (TEROSON PU 8590)		1	Piece
3	SM-57Y	PRIMER (TST 8517 H 500 ML)		1	Piece
4	TM900000HKY	SURFACE CLEANER TEROSTAT8550 (SURFACE CLEANER 1000 ML)		1	Piece
5	TC395118	RIVET		16	Pieces

TECHNICAL INSTRUCTIONS

1. Take the vehicle to the serviced and stop the engine,
2. Drill four 0,196 in (5 mm) diameter holes into the plate using the stopper-equipped drilling machine shown in the figure. Use the holes on the new plate as a reference for drilling. (9324-4762Y).

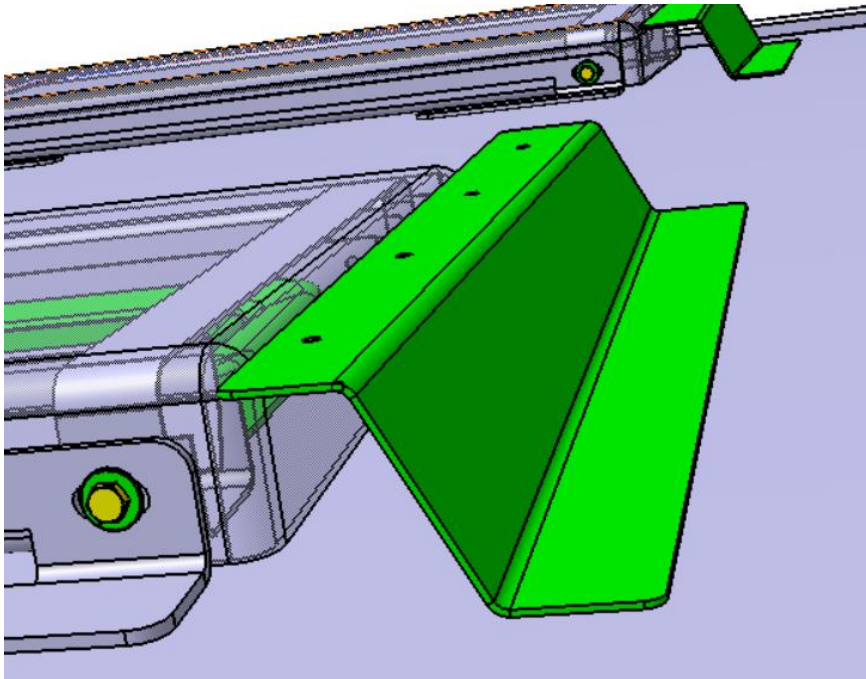


Figure.1 Drilling holes

3. Clean the surface of the plate (9321-394Y) onto the A/C intake grill with the surface cleaner. Apply the primer (SM-57Y) to the outer side of plate.

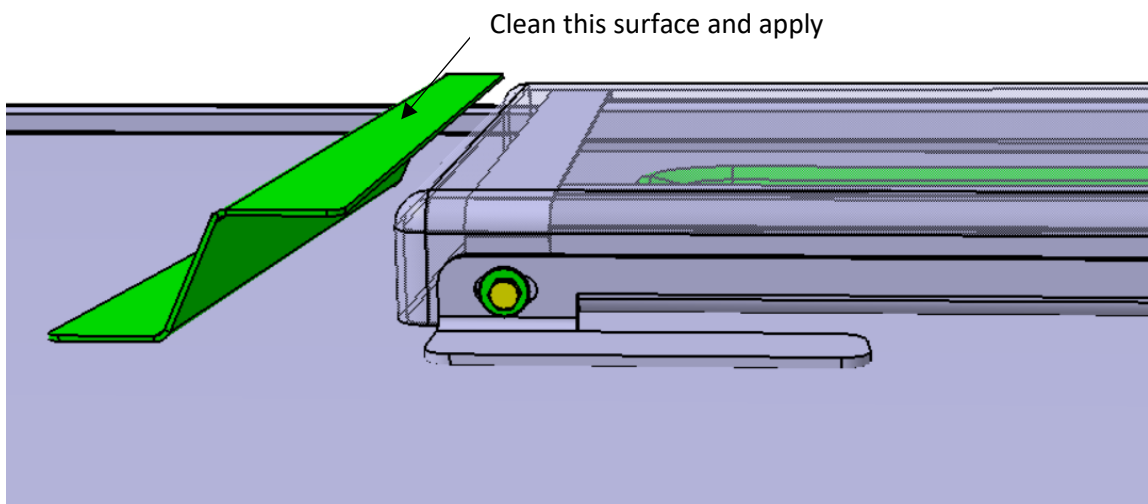


Figure. 2 Cleaning the plate onto the grill

4. Place the 9324-6742 plate onto the green plate which is shown in the following figure with sealer SM-79.

Bond plate 9324-6742Y onto the green plate

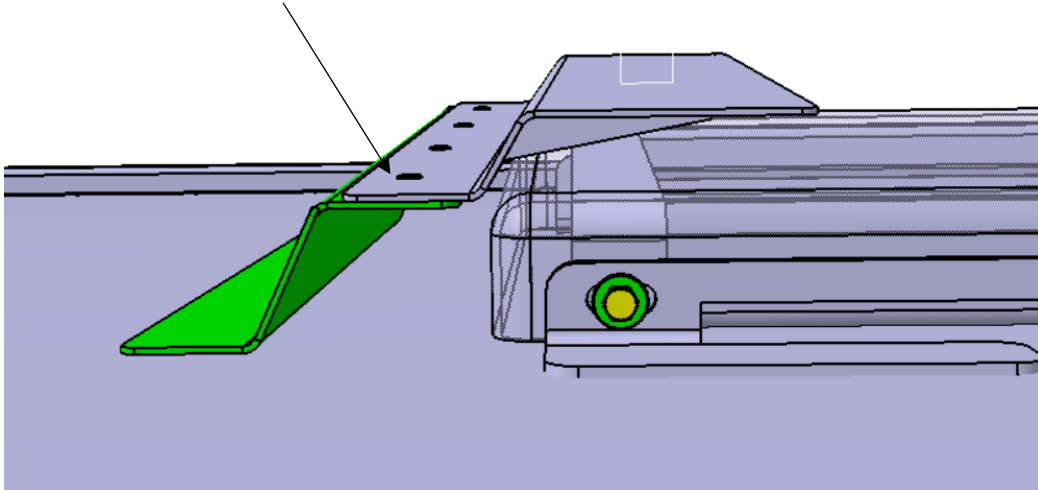


Figure.3 Bonding process

5. Assemble TC395118Y rivets onto the plate 9324-6742Y with using the pop rivet gun before curing process of the sealer.

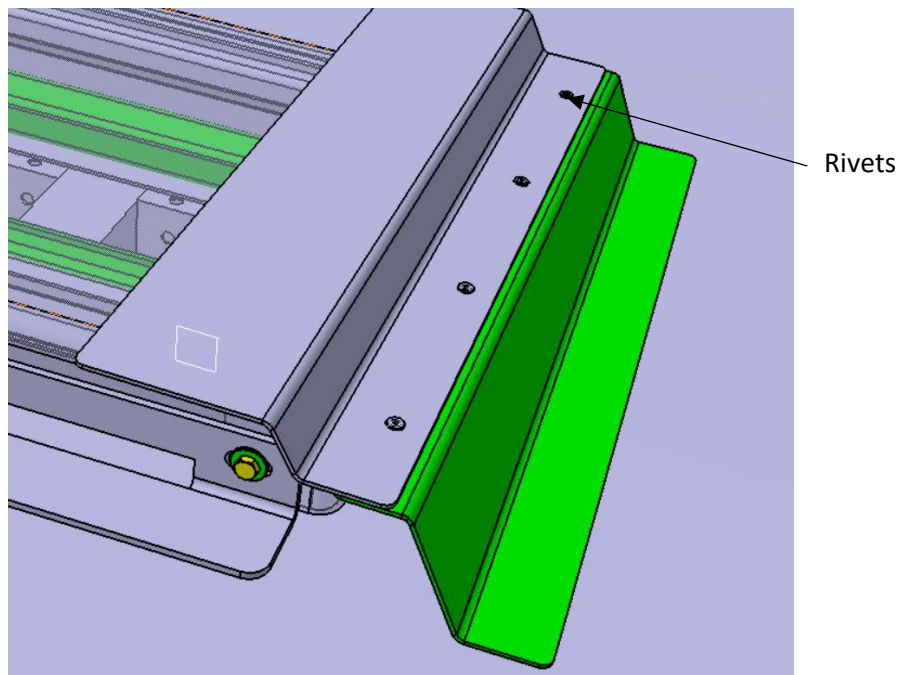


Figure.4 Assemble the rivets

6. Apply items to the other three plates.

LABOR BREAKDOWN

Application	Time
Vehicle is taken to service,	5'
Cleaning process of the surface of the plate,	5'
Apply the primer to the plates	10'
Apply the sealer and glue to the plates	5'
Assemble the rivets onto the plate	5'
Total Labor Time	30'

AFFECCTED VEHICLE LIST

No	Chassis No	Country
1	NLTEJXA93R1000457	Canada
2	NLTEJXA95R1000458	Canada
3	NLTEJXB96S1000618	Canada
4	NLTEJXB94S1000620	Canada
5	NLTEJXB98S1000622	Canada
6	NLTEJXB9XS1000623	Canada
7	NLTEJXB97S1000658	Canada
8	NLTEJXB95S1000660	Canada
9	NLTEJXB99S1000659	Canada
10	NLTEJXB97S1000661	Canada