

Subject: RGB LED REPLACEMENT

Bulletin Type: FIX AS FAIL

Bulletin No: TS45-FC-2519

PQR No: 500000007924

Rev No: 00

Ref. No: 70004783

Vehicle Model: TS45

Flat Rate Time / Code: 120 minute

Date of issue: 16.10.2025

Modify Before: 16.10.2028

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 service bulletin will be applied for RGB Led replacement.If any problem occur on the RGB LED.

Bullet-in Responsible: FUNDA BAŞ ULUDAĞ

Published & Approved By: ESİN ARISOY

SAFETY INSTRUCTIONS

1. Mechanical Requested Dress Code

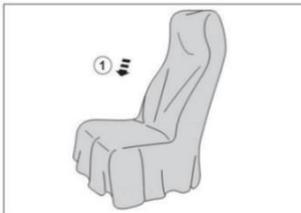


WARNING:

- 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

- Always disconnect the batteries (starting with the negative lead).
- 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.
- 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.
- The earth terminal must make good contact and be placed as close as possible to the part to be welded.
- Plastic pipes, rubber parts and parabolic springs should be well protected against welding spatter and temperatures higher than 70°.
- The contact switch must not be in the accessory or contact position. The contact key should be removed.
- 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
1	402403Y	RGB Led (RIGHT) 10.500mm		1/1
	402404Y	RGB Led (LEFT) 12.300mm		

OUT PART LIST

No	Part No	Part Name	Picture	Qty
1	401248Y	500 mm RGB LED		1/1
	401249Y	300 mm RGB LED		

TECHNICAL INSTRUCTIONS

For disassembly

1. Make the following preparations.
 - a-Take the vehicle to the service and stop the engine,
 - b-Before starting the process, be sure to turn off the vehicle switch.
 - c- Replacement part is RGB Led. **(Figure-1)**



Figure-1

2. Locate and identify the open section at the junction where the two lens pieces are joined. Handle and lift the part by its edges, using a soft tool to avoid damage. **(See Figure-2).**



Figure-2

3. Remove the part by gently pulling it out. (See Figure-3).



Figure-3

4. After removing the lens, unscrew the screws located at the beginning, middle, and end of each LED using bit number 1. Take care not to damage the vehicle roof. (See Figure-4)



Figure-4

5. Press the clips at the indicated points with a flat-tipped tool and disconnect them from the adjacent LED. Repeat the specified procedure for all LEDs and ensure their complete removal (See Figure-5)



For reassembly

6. Replace it with the new RGB LED. For left side use 402404Y (12.300mm) and for right side use 402403Y (10.500mm). Place the new strip LED from beginning to end and press firmly to ensure the proper adhesion of the backing tape. (See Figure-6)



Figure-6

7. Gently press the lenses into place, ensuring that the clips are properly engaged.
(See Figure-7)



Figure-7



TEMESA

SERVICE BULLETIN

LABOR BREAKDOWN

Application	Time
RGB LED replacement	120 min
Total Labor Time	