

PREVOST

Instruction Sheet

IS-22900A

VOLVO 9700 - LUGGAGE BAY DOOR BRACKET INSTALLATION – From MY 2019

Revision: A

Welding process added

09/06/2022

MATERIAL

Order the following parts:

| Part No. | Description | Qty |
|----------|------------------------|-----|
| 22199750 | BRACKET, PARALLEL LINK | 12 |

NOTE

Material can be obtained through regular channels.

SAFETY PRECAUTIONS

- Eye protection should always be worn when working in a shop.
- Rules for Personal Protection Equipment should always be respected. Wear your PPE including but not limited to the following:



Safety First!



PROCEDURE



DANGER

Park vehicle safely, apply parking brake, stop engine. Prior to working on the vehicle, set the ignition switch to the OFF position and trip the main circuit breakers equipped with a trip button. On Commuter type vehicles, set the battery master switch (master cut-out) to the OFF position.

Lock out & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

1. Identify the bracket position, place the bracket and make welding points according to installation drawing.

NOTE

GMAW PROCESS: MIG-MAG
SHIELDING GAS: Mixture 98/2
FILLER MATERIAL: ER309LSi .035"
VOLTAGE: 24.5 - 25 Volts
AMPERAGE: 185 - 192 Amps

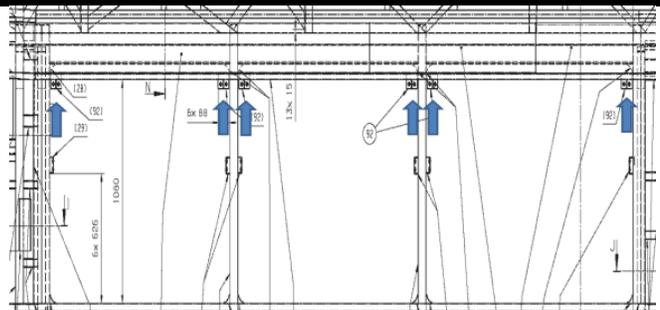


FIGURE 1

2. Weld the bracket to the frame. Apply the welding sequence according to the installation drawing.

Fillet weld one side (Pict.7)

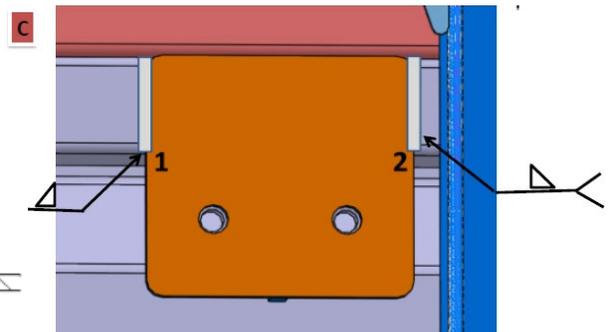
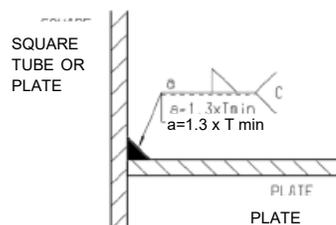
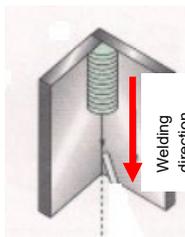


FIGURE 2

3. Weld the back side bracket to the frame.

Fillet weld one side (Pict.7)

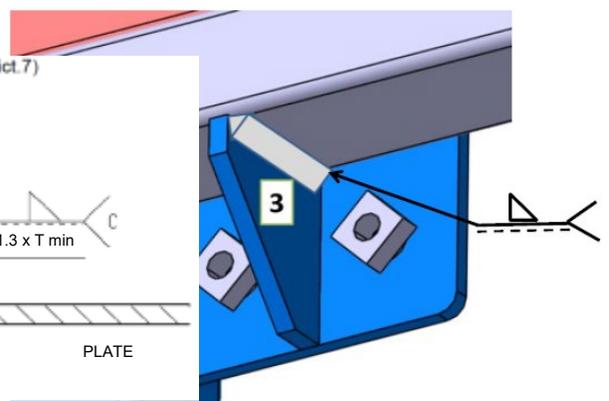
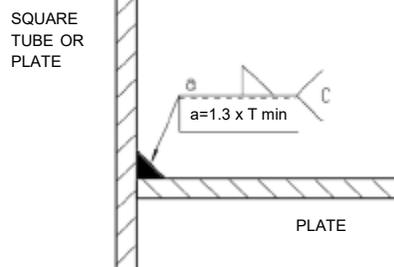
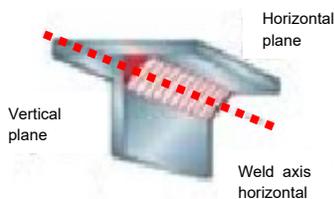


FIGURE 3

4. Remove the welding excess using pneumatic angle grinder and sandpaper disc grade 60

PARTS / WASTE DISPOSAL

Discard waste according to applicable environmental regulations (Municipal/State[Prov.]/ Federal)