PREVOST

Warranty Bulletin 97-08

Date: **May 1997**
Section: **16**
Subject: **SECURING OF RADIUS ROD**
Application:

Model	VIN 
All H3 vehicles Model Year: 1990 up to 1997	From 2P9H33408L1001031 up to 2PCH33490V1011919 incl. **EXCEPT** 2PCV33498V1011684, 2PCH33498V1011732, 2PCV3349XV1011766 **AND** from 2PCH33496V1011830 up to 2PCH33493V1011834 **AND** 2PCH33497V1011836 **AND** from 2PCH33490V1011838 up to 2PCH33490V1011841 **AND** 2PCH33494V1011843, 2PCH33491V1011850, 2PCH33497V1011853, 2PCH33499V1011854, 2PCH33492V1011856 **AND** from 2PCH33499V1011871 up to 2PCH33494V1011874 **AND** 2PCH33498V1011876, 2PCV33495V1011885, 2PCV33498V1011895, 2PCH33410V1011896, 2PCV33491V1011916

DESCRIPTION

On the above-mentioned vehicles, installation of reinforcement plates on rear subframe radius rod supports ensures rigidity of joint to structure. **Note that this is a SAFETY RECALL CAMPAIGN.**

MATERIAL

Kit #213575 includes the following parts:

Part No.	Description	Qty
213259	Horizontal Reinforcement Plate, right	1
213260	Horizontal Reinforcement Plate, left	1
172168	Vertical Reinforcement Plate, right	1
172169	Vertical Reinforcement Plate, left	1
121418	Shim (thin)	3
121419	Shim (thick)	3
500781	Stove Bolt, Nut	8
131065	Radius Rod Support	2
110340	Plate Lock Nut	4

Note: *Material can be obtained through regular channels*.

PROCEDURE

Warning: *Park vehicle safely, apply parking brake, stop engine and set battery master switch(es) to the OFF position prior to working on the vehicle.*

1. Welding must be done only by a qualified and experienced person.
2. Protective shields must be placed in order to protect components against heat, welding flash, welding arc and other elements associated with welding.
3. Always wear the appropriate safety equipment.
4. Weld in clean and well-ventilated area, and always have an appropriate fire extinguisher within your reach.
5. The following precautions are to be taken to protect the electronic control components :

- Cut off battery power (battery master switch) from battery compartment.
- Disconnect wiring harness connectors from ECM (Electronic Control Module). The ECM is mounted on the starter side of the engine.
- For vehicles equipped with an automatic transmission, disconnect wiring harness connectors from ECU (Electronic Control Unit). The ECU is located in rear electrical compartment.
- For vehicles equipped with ABS (Anti-Brake System), disconnect wiring harness connectors from ABS Electronic Control Unit. The ABS Electronic Control Unit is located in the front service compartment.
- Do not connect welding cables to electronic control components.

6. Safely support the vehicle at the axle jacking points with a suitable hydraulic floor jack.

Warning: *Only the recommended jacking points must be used as outlined in Section 18 of Maintenance Manual: "Body" or in Operator's Manual.*

7. Remove the drive axle four wheels. Disconnect radius rod from radius rod support.
8. Remove radius rod support (2) (refer to fig. 1). The two bolts located inside the baggage compartment must be removed.

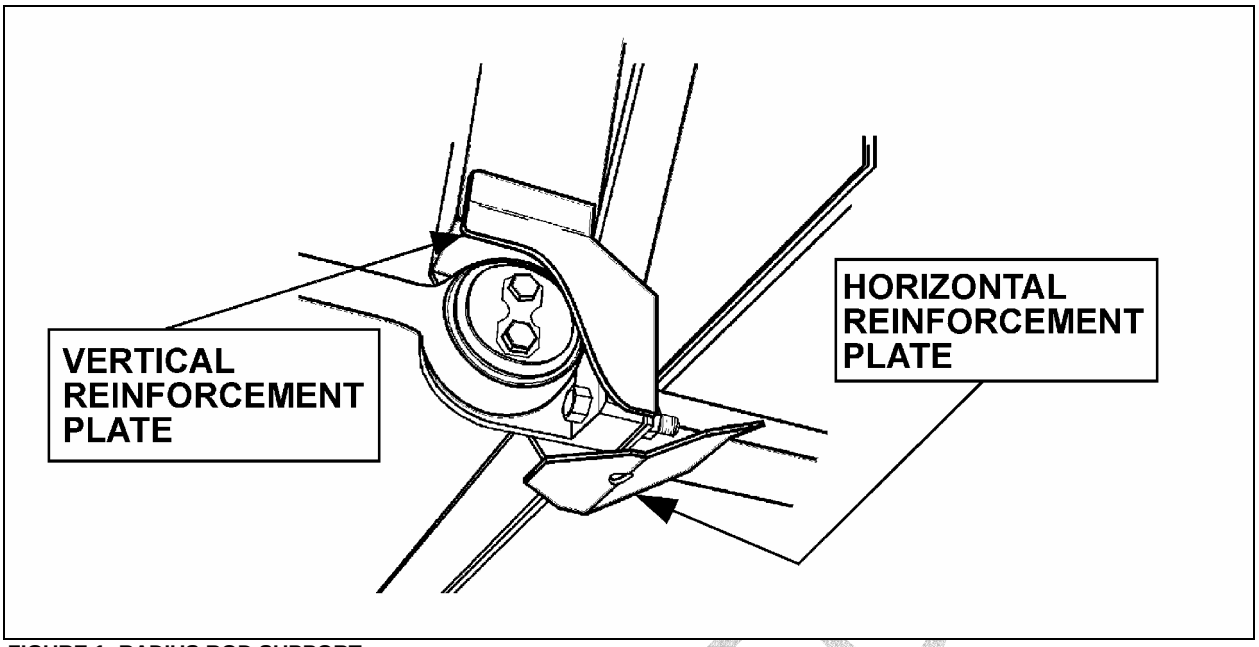

FIGURE 1: RADIUS ROD SUPPORT 16077

9. Using a grinding wheel, remove asphalt base undercoating (gravel guard) from parts requiring welding.
10. To avoid burning the inside of baggage compartment, generously damp carpeting and protect floor using a metal plate.
11. Remove bellows splash guards to facilitate welding.
12. Verify if left horizontal reinforcement plate (Prévost #213260) and right horizontal reinforcement plate (Prévost #213259) were installed on structure. If not, check if cracks are present in item 523 welding bead, gouge or grind cracked areas to bare metal and reweld (refer to fig. 2). Install horizontal and vertical reinforcement plates refering to figures 3 and 4 welding specifications.

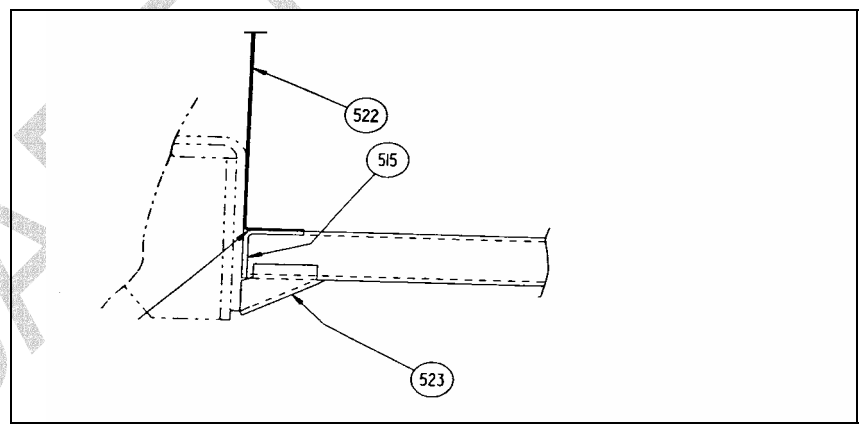

FIGURE 2: REINFORCEMENT BRACKET 16078

Note: *Weld horizontal reinforcement plates before welding vertical reinforcement plates (Prévost #172168 and 172169).*

13. Because of material thickness, it is recommended to use a semi-automatic electric arc welding in accordance with the following specifications:

STEEL - STAINLESS STEEL OR STAINLESS STEEL - STAINLESS STEEL WELDING

Note: Welding must be done only by a qualified and experienced person.

- GMAW (Gaz Metal-Arc Welding) process;
- welding wire conforms to AWS (American Welding Standards) A5.9 specifications;
- 308L type welding wire with 0.035" diameter (0,9 mm);
- voltage: 18 volts to 22 volts;
- current: 50 amperes to 200 amperes;
- shielding gas: T90-H (90% helium, 7,5% argon, 2,5% CO^2).

If necessary, with lots of precaution to avoid perforate material, it is possible, but not recommended, to use a conventional electric arc welding machine, in accordance with the following specifications:

- SMAW (Shield Metal-Arc Welding) process;
- welding rod conforms to AWS (American Welding Standards) A5.9 specifications;
- 308L-16 type welding rod with 3/32" diameter (2,4 mm);
- current: flat - 40 amperes to 70 amperes
  up - 35 amperes to 50 amperes
  overhead - 40 amperes to 60 amperes.

STEEL - STEEL WELDING

Note: Welding must be done only by a qualified and experienced person.

- SMAW (Shield Metal-Arc Welding) process;
- welding rod conforms to CSA W48.3 - 93 specifications;
- E7018 type welding rod with 1/8" diameter (3,2 mm) or E48018;
- current: flat - 90 amperes to 160 amperes
  up - 90 amperes to 135 amperes
  overhead - 90 amperes to 160 amperes.
- FCAW (Flux cored-Arc Welding) process;
- welding rod conforms to CSA W48.5 - M1990 specifications;
- E4801 - T9CH type welding rod with 0.045" diameter (1,2 mm)
- voltage: 27 volts;
- current: 260 amperes;
- wire feed rate: 450 ipm;
- shielding gas: 75% argon and 25% CO^2 or 100% CO^2

14. Allow welding to cool, then remove slag.

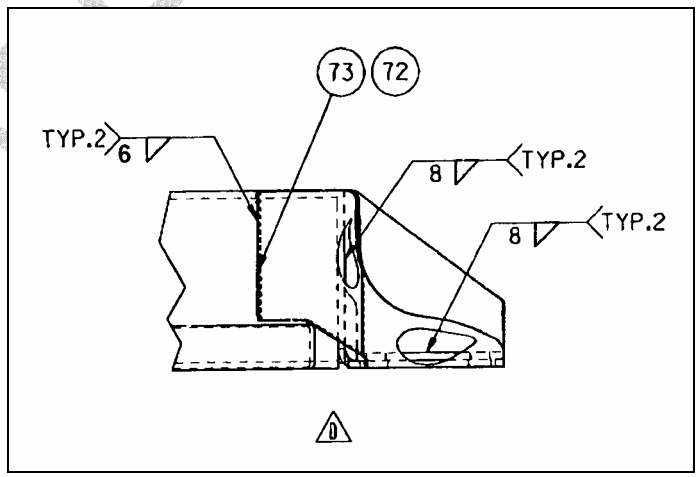

FIGURE 3: VERTICAL REINFORCEMENT PLATE 16079

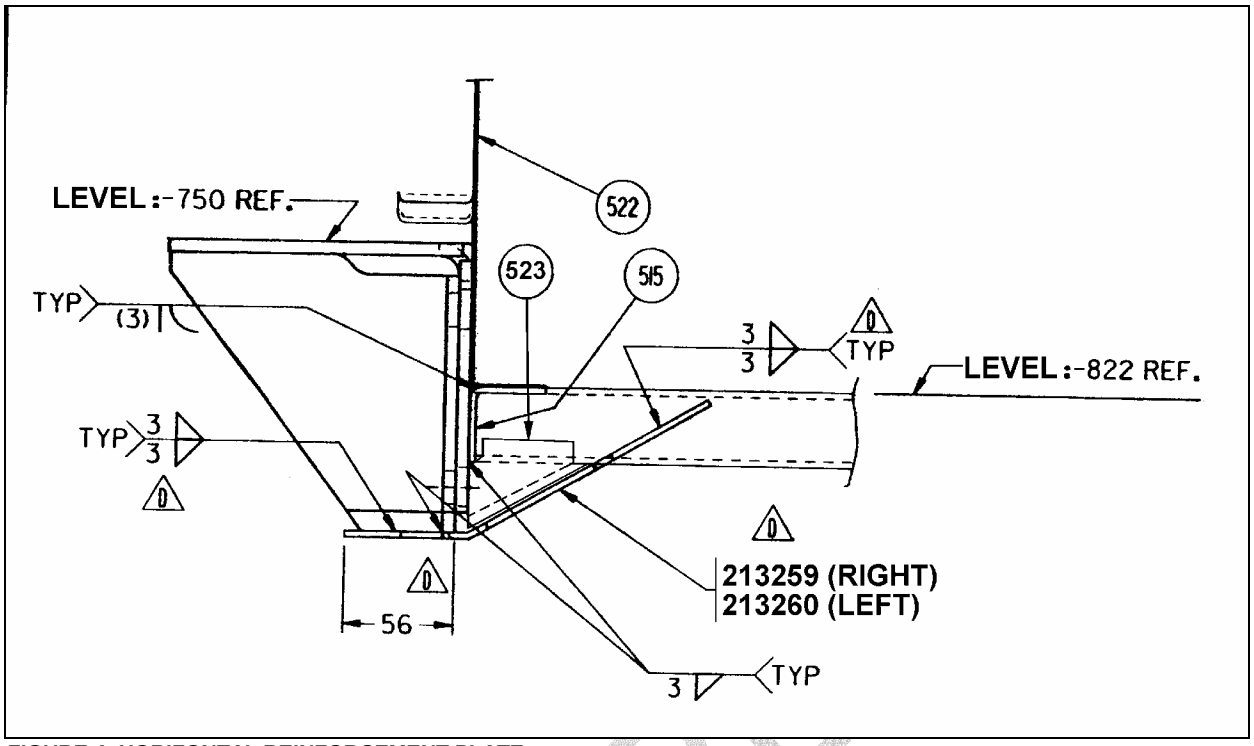

FIGURE 4: HORIZONTAL REINFORCEMENT PLATE 16080

15. Install new shims (Prévost #121418 and #121419) as needed, keeping the exact same thickness.

16. In the baggage compartment, locate the two holes for the radius rods retaining bolts (Fig. 5.)

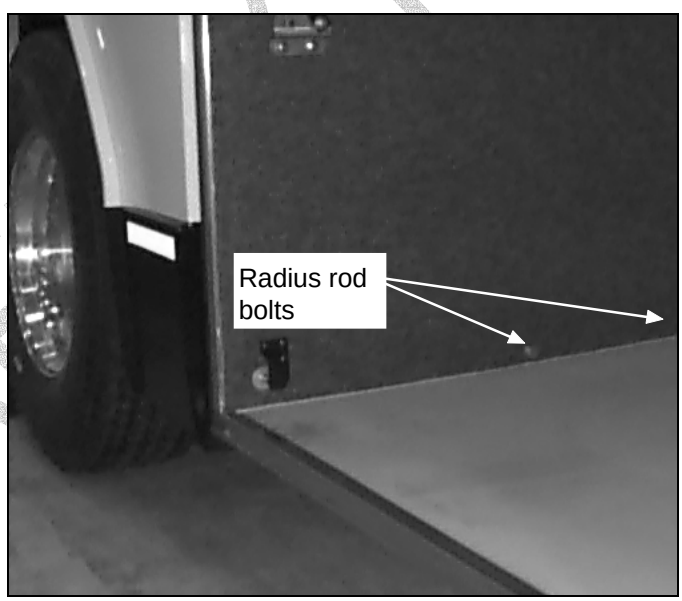

FIGURE 5: BOLTS LOCATION 16075

17. Make sure that the washers between the bolts and the structure were not installed over carpeting. If bolts and washers were installed over carpeting, complete the following steps for each of the two bolts:

    a. With a knife, enlarge hole in carpeting to allow washer to come into contact with metal structure without touching carpeting (fig. 6).

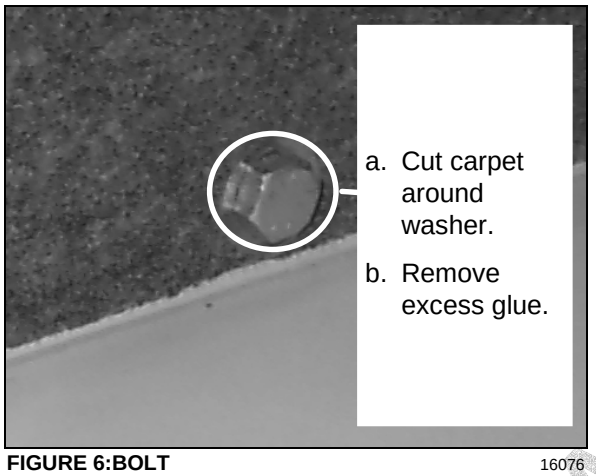

FIGURE 6:BOLT 16076

b. Remove excess glue from metal surface.

18. Bolt two new supports (Prévost #131065). Torque to 115 ⌖ 11 lbf⋖ft (156 ⌖ 15 N⋖m) with lubrified threads (white grease Prévost #680343) or to 150 ⌖ 11 lbf⋖ft (204 ⌖ 15 N⋖m) with dry threads. Coat uncovered threads with Valvoline Tectyl 127 CG.

Note: *If one of the supports got loose, alignment shims may have been lost. In this case, drive axle realignment is necessary.*

19. Coat reinforcement plates with Gravel Guard 3M undercoating.
20. Reinstall radius rods using recommended torques (refer to fig. 7).

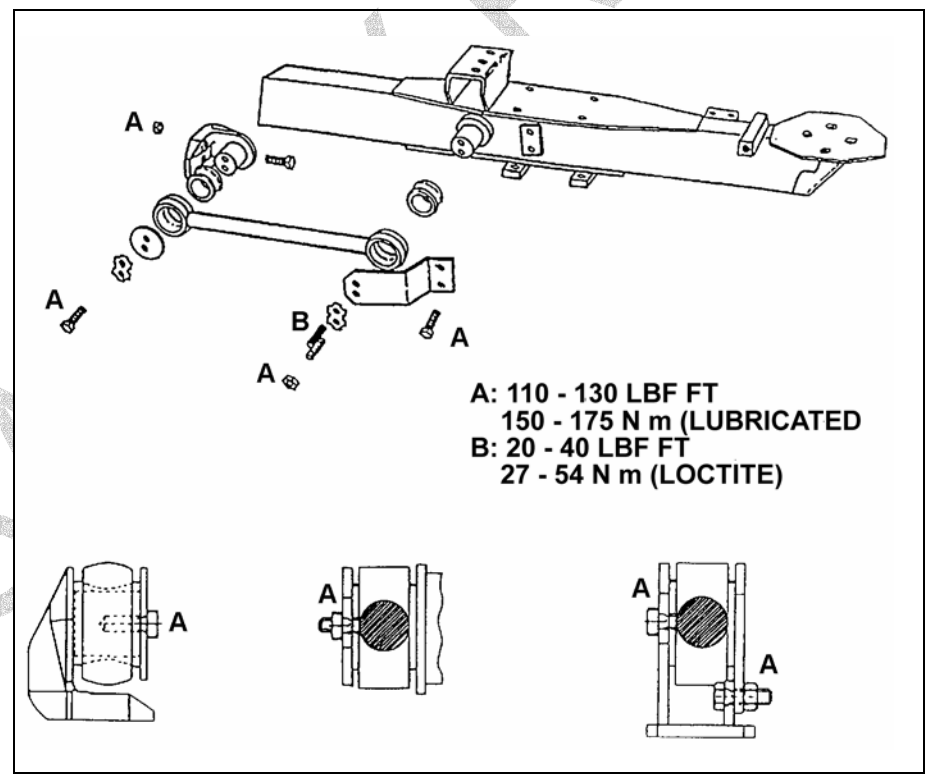

FIGURE 7: RADIUS ROD 16013

21. Reinstall splash guards and wheels. Torque wheel nuts to 450 - 500 lbf•ft (610 - 680 N•m) using tightening sequence indicated on figure 8.

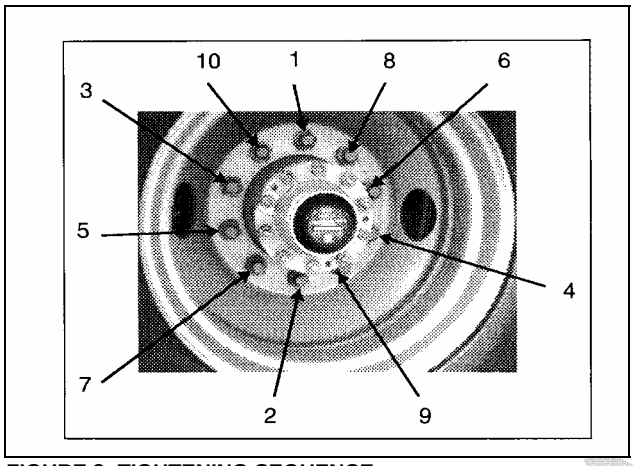

FIGURE 8: TIGHTENING SEQUENCE 13006

22. Reconnect components mentioned at step 5.

WARRANTY

This inspection/modification is covered by the manufacturer's normal warranty. We will reimburse you the parts and four hours (4,0) of labor upon receipt a completed A.F.A. form on which you must specify as per "Warranty Bulletin 97-08." **You have to fill the safety recall notification card provided with this bulletin and return it with your A.F.A. form to be reimbursed.**

Parts disposition:

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

PREVOST

Safety Recall Certification Sheet

We hereby certify that Safety Recall Instructions with regards to Warranty Bulletin # 97-08 have been performed on vehicle serial number:

2 P _ _ _ _ _ _ _ _ _ _ _ _ _ _ _ _ (Please complete)

Company name			
Mailing address			
Phone		Fax	
Signature:			
Date			
A.F.A. #			

Please return this completed document with your A.F.A. form.