

PREVOST

ENREGISTRÉ - REGISTERED
ISO 9001 & ISO 14001


**WARRANTY
BULLETIN**

Wb09-15



DATE : OCTOBER 2009	SECTION : 16 - Suspension
EXPIRATION: OCTOBER 2010	
SUBJECT : PANHARD ROD SUPPORT WELD BEAD VERIFICATION	


APPLICATION

Model	VIN	
X3-45 Coaches Model Year : 2009	2PCG334979C729778 - 2PCG334999C729779 - 2PCG334959C729780 2PCG334979C729781 - 2PCG334999C729782 - 2PCG334909C729783 2PCG334929C729784 - 2PCG334949C729785 - 2PCG334969C729786 2PCG334989C729787	
<p>This bulletin does not necessarily apply to all the above-mentioned vehicles, some vehicles may have been modified before delivery. The owners of the vehicles affected by this bulletin will be advised by a letter indicating the Vehicle Identification Number (VIN) of each vehicle concerned.</p>		

DESCRIPTION

On the vehicles affected by this bulletin and equipped with an I-beam suspension, there is a possibility that the welding bead between the Panhard rod support vertical tubing and C-channel be insufficient.

PROCEDURE

 **DANGER**

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

PART - A

INSPECTION



WARNING

Ensure to safely support the vehicle by its jacking points during repair. Only the recommended jacking points must be used as outlined in Section 18 of Maintenance Manual: "Body" under heading "Vehicle jacking points" or in Operator's Manual.

Check size of weld bead located between Panhard rod support vertical tubing and C-channel.

Size of weld bead must be 3/8 in (10 mm) minimum (Refer to figures 1, 2 and 3).

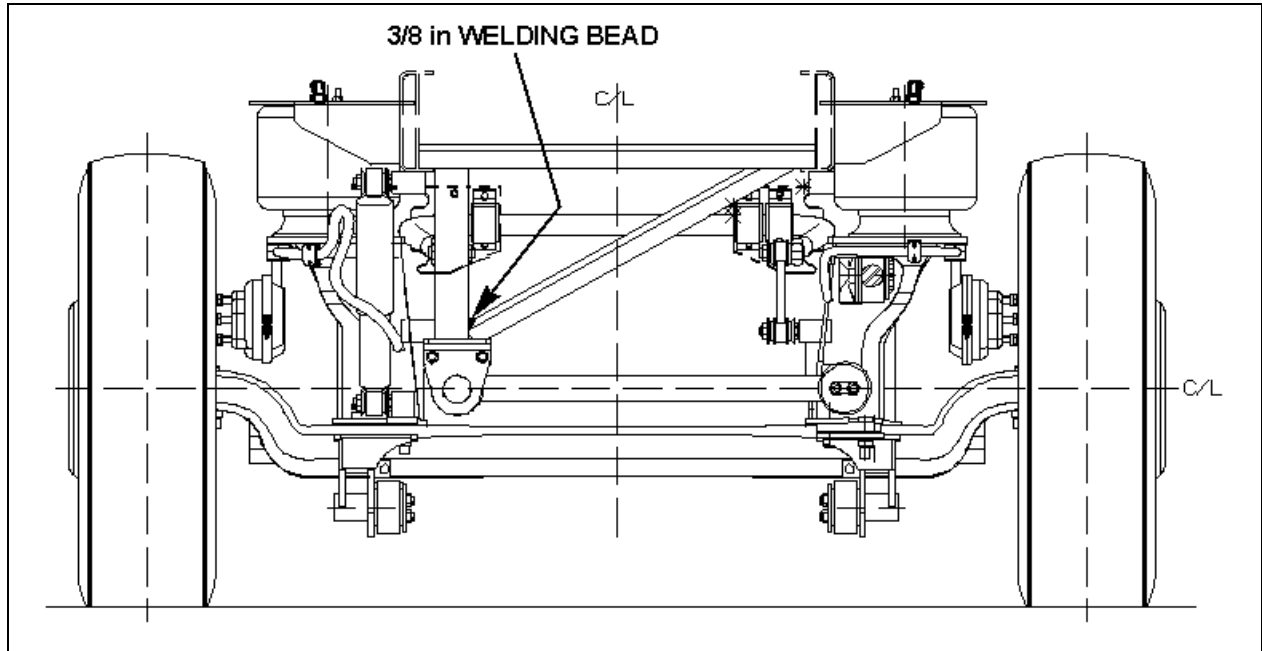


FIGURE 1

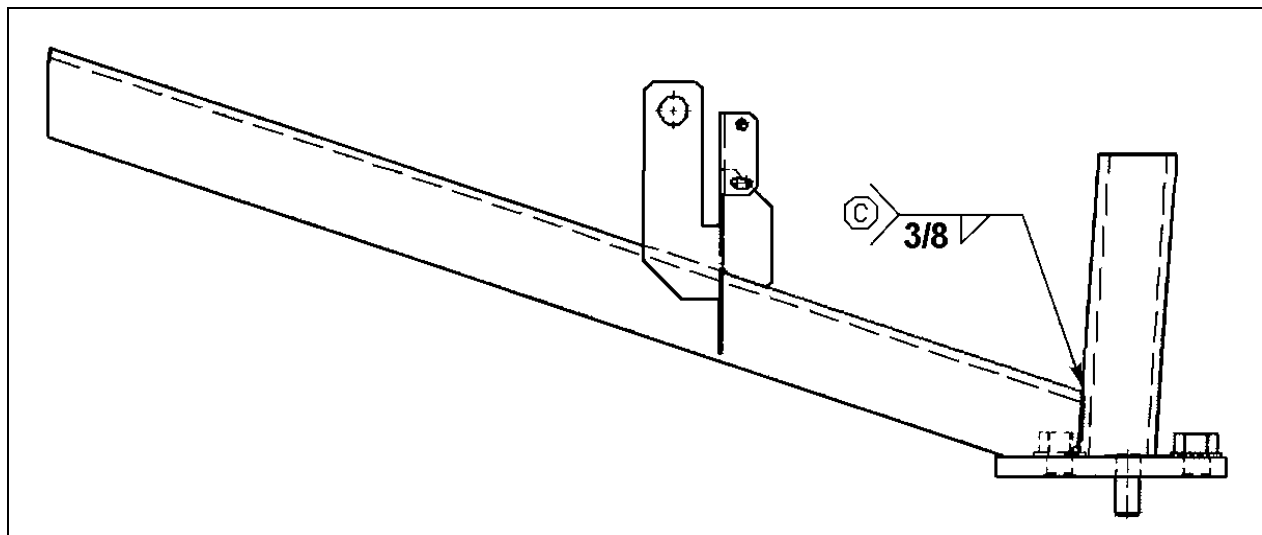


FIGURE 2

To ease verification, lean a 3/8 in (10 mm) thick plate against the vertical tubing and make sure that welding bead exceeds plate thickness. If this is the case, welding bead is acceptable (Refer to figure 3).

LEAN A 3/8 IN (10 MM) THICK PLATE AGAINST THE VERTICAL TUBING AND VERIFY THAT WELDING BEAD EXCEEDS PLATE THICKNESS



FIGURE 3

PART - B

REPAIR



CAUTION

Disconnect all electronic control modules before welding. If modules (ECM, TCM, ECU, ABS) are not disconnected before welding is done, there is a high risk of destroying the electronic components (EPROM, Chip). Refer to procedure described in Maintenance Manual.

1. Remove asphalt base undercoating (Gravel Guard 3M) and any rust present near the welding bead located between Panhard rod support vertical tubing and C-channel.



CAUTION

During cold weather, when base metal temperature is below 32 °F (0 °C), base metal must be preheated to at least 50 °F (10 °C) and this temperature must be maintained for the whole welding process. It is therefore preferable to leave the vehicle to repair in a heated area for about half a day or heat sub-frame until it reaches 50 °F (10 °C) minimum. You can also circulate warm air using a fan.

Do not heat over 150 °F (100°C).



WARNING


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. Add two welding beads referring to paragraph: **Steel – Steel Welding** for welding specifications.
6. Once the welding beads are cold, sand blast before applying a coat of primer onto the welding beads and onto both sides of part.

NOTE
Use the appropriate primer for the type of metal and follow manufacturer's instructions.

7. Then, apply an asphalt base undercoating (Gravel Guard 3M) onto both sides of part.

STEEL – STEEL WELDING

 **WARNING**
Welding surfaces must be free of scale, slag, rust, paint, grease, humidity or other foreign material that would render welding impossible.

- FCAW (Flux Cored Arc Welding) process;
- Electrode wire conforms to A5.20 AWS (American Welding Society) specifications;
- E4801T-9-CH, type electrode wire with 0,045" diameter (1,14 mm);

Material Thickness	Voltage	Current	Wire Feed Rate	Shielding Gas
1/8" to 1/2"	26 ± 2 volts	260 Amps	450 ipm. approx.	75% argon – 25% CO2 or 100% CO2

If necessary and with great care to prevent perforating the material, it is possible to use a conventional electric arc welding machine according to the following specifications:

- SMAW (Shielded Metal-Arc Welding) process;
- Welding rod conforms to A5.1 of AWS (American Welding Society) specifications; E 7018 type welding rod with 1/8" diameter (3,2 mm);
- Current: 100 amperes to 150 amperes; optimum at 120 amps.

It is important to grind weld bead starts and stops and also to grind arc strikes from surfaces.

WARRANTY

This modification is covered by Prevost's normal warranty.

PART A – INSPECTION

We will reimburse you **a quarter hour (0.25) of labor** for doing the inspection upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 09-15".

PART B – REPAIR

We will reimburse **one and a half hour (1.5) of labor** upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 09-15".