PREVOST

Warranty Bulletin 95-27

Date: **July 1995**
Section: **18**
Subject: **Reinforcement of baggage compartments structure**
Application:

Model	VIN 
H3-40 coach	All
H3-41 or H3-45 coach	From 2P9H33495R1001012 up to 2P9H33419S1001109 inclusively except 2P9H33492S1001099, and 2P9H33417S1001108
H3-40 VIP converted coach shell	All
H3-45 VIP converted coach shell	From 2P9V33494S1001057 up to 2P9V33496S1001111 inclusively

DESCRIPTION

The Prévost Car engineering department has recently made an improvment on the baggage compartments structure on H3 Series vehicles. The purpose of this modification is to reinforce baggage compartments floor. We recommend that you do this modification by performing the following procedure.

MATERIAL

Part No	Description	Qty H3-40 and H3-40 VIP	Qty H3-41	Qty H3-45 and H3-45 VIP
212903	Strengthening piece	0	3	5
212904	Strengthening piece	4	1	1

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.*

Prior to working under a air-suspended vehicle, it is strongly recommended to securely to support the body at the recommended jacking points.

1. Disconnect DDEC, ABS, electronically controlled transmission, and optional preheater conrol modules in order to protect these system from voltage surges during welding procedure.

2. Under vehicle, identify positions where strengthening pieces should be installed (Refer to Fig. 1, showing vehicle from under, between front and rear axles, and Fig. 2).

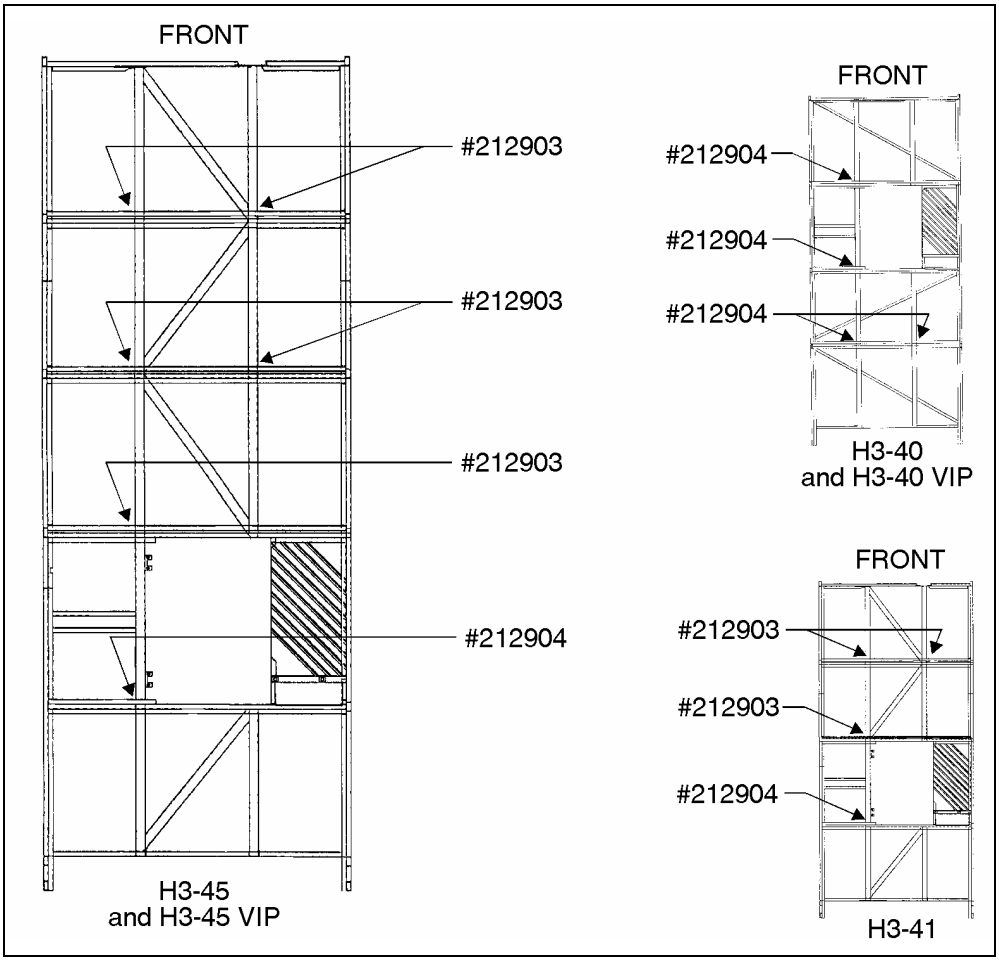


FIGURE 1: LOCALIZATION OF STRENGTHENING PIECES

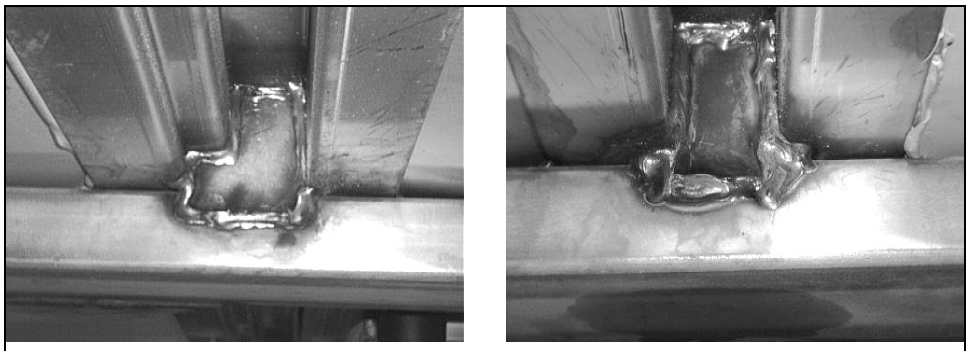
3. Thoroughly clean area where welding have to be made.

Warning: *Protect the urethane and other flammable components from sparks with a fireproof material. Always keep an appropriate fire extinguisher within your reach.*

From inside baggage compartments, continuously spray water on surfaces near welding is made to prevent fire.

Note: *If longitudinal and transversal beams are separated, longitudinal beams (3" X 1½" (76 mm X 38 mm)) should be lifted to rest against transversal beams before welding the strengthening pieces.*

4. Perform weldings as seen on figure 2 (Refer to step 5 for welding instructions).



#212903 #212904

FIGURE 2

Warning: *Only qualified personnel should perform welding task. Always wear the appropriate safety equipment. Weld in well-ventilated area.*

5. Because of material thickness, it is recommended to use a semi-automatic electric arc welding
   - SMAW (Shield 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: 225 amperes to 250 amperes;
   - gas used: 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: 80 amperes to 85 amperes.
6. Allow welding to cool, then remove slag.
7. Reconnect control modules mentionned in step 1.

WARANTY

This modification is covered by the manufacturer's normal warranty. We will reimburse you the parts and one hour and a half (1.5) of labor upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 95-27".

Expiration date: July 1996