


PREVOST

Warranty Bulletin

96-04

Date: **April 1996**
 Section: **18**
 Subject: **Frame Reinforcement**
 Application:

Model	VIN	
H3-41 Coach Model Year: 1995 - 1996	From 2P9H33417S1001058 up to 2P9H33411S1001296 incl. and from 2PCH33410T1011300 up to 2PCH33411T1011466 incl.	
H3-45 Coach Model Year: 1994 - 1996	From 2P9H33495R1001012 up to 2P9H33497R1001092 incl., from 2P9H33491S1001093 up to 2P9H3349XS1001299 incl. and from 2PCH33495T1011301 up to 2PCH33498T1011468 incl.	
H3-45 VIP Converted Coach Shell Model Year: 1995 - 1996	From 2P9V33494S1001057 up to 2P9V33492S1001283 incl. and from 2PCV33499T1011305 up to 2PCV33496T1011469 incl.	

DESCRIPTION

The Prévost Car engineering department has recently made an improvement on the H3 Series vehicle engine rear door structure. The purpose of this modification is to reinforce the connection of the rear left vertical post to a perpendicular beam. It is recommended that you do this modification by performing the following procedure.

MATERIAL

Part No.	Description	Qty
213261	Rear Left Vertical Post Stiffener (1/4"X1 1/4"X4")	1

Note: Material can be obtained through regular channels.

PROCEDURE

GENERAL WELDING 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.

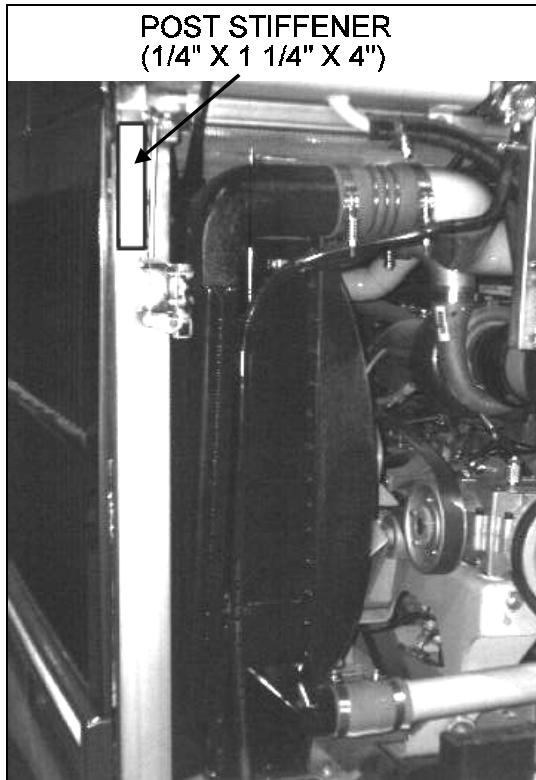
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1. Welding must be done only by a qualified and experienced person.
 2. Always wear the appropriate safety equipment.
 3. Weld in clean and well-ventilated area, and always have an appropriate fire extinguisher within your reach.
 4. The following 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.
 5. Thoroughly clean area where welding have to be made.
 6. Perform welding.
 7. Because of material thickness, it is recommended to use a semi-automatic electric arc welding
 - 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: 225 amperes to 250 amperes;
 - gas used: T90-H (90% helium, 7,5% argon, 2,5% CO²).

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.
 9. Allow welding to cool, then remove slag.
 10. Reconnect ECM, ECU and ABS electronic control unit mentioned in step 5.

REAR LEFT VERTICAL POST STIFFENER

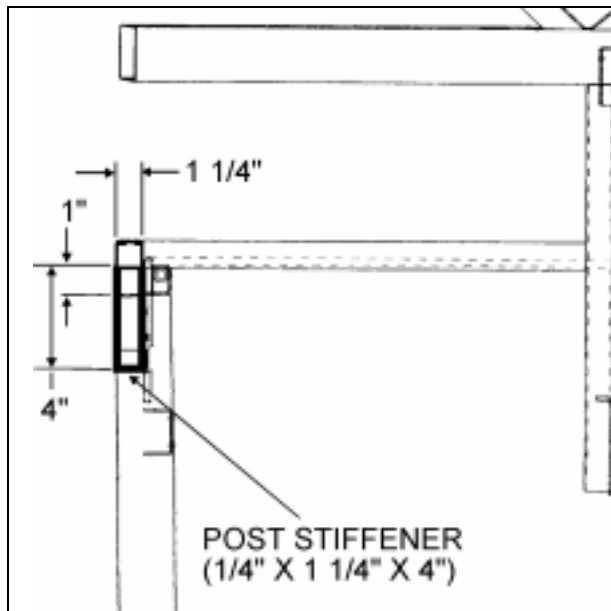
1. Open rear engine door.
2. Locate the rear left vertical post (Fig. 1).
3. Open radiator door (to protect paint).
4. Clean and grind post surface to reasonable flatness.
5. Protect paint from sparks with fireproof material.
6. Weld the stiffener on the post as per figure 2. Refer to the General Welding Procedure in this Warranty Bulletin.



POST STIFFENER
(1/4" X 1 1/4" X 4")

FIGURE 1: ENGINE COMPARTMENT

18212



POST STIFFENER
(1/4" X 1 1/4" X 4")

FIGURE 2: ENGINE COMPARTMENT

18213

WARRANTY

This modification is covered by the manufacturer's normal warranty. We will reimburse you the parts and half an hour (0.5) of labor upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 96-04".

Expiration date: April 1997