

PREVOST

Instruction Sheet

IS-14154

X3 New Fuel Tank Installation: Support beam modification instructions (Part # 30022 Installation)

MATERIAL

Kit #036364 includes the following parts:

Part No.	Description	Qty
030013	Fuel Tank (X3 Series)	1
032956	Fuel Tank Gasket	1
033959	Accessory Plate	1
033962	Inner Frame	1
5001198	M6-1x16 Machine Screw	2
5001392	Copper Washer 6x12x1.5	10
502686	Cap Screw Hex SS M6x30	10
030022	Support Plate	1
IS-14154	Instruction Sheet (EN)	1
FI-14154	Instruction Sheet (FR)	1

NOTE

Material can be obtained through regular channels.

When installing a # 030013 fuel tank on an older X3 Series vehicle, it is necessary to modify one of the fuel tank support beams to clear the molded tank sump at the bottom of the tank.

Follow the procedure outlined below to proceed to the support beam modification using the supplied # 030022 support plate.

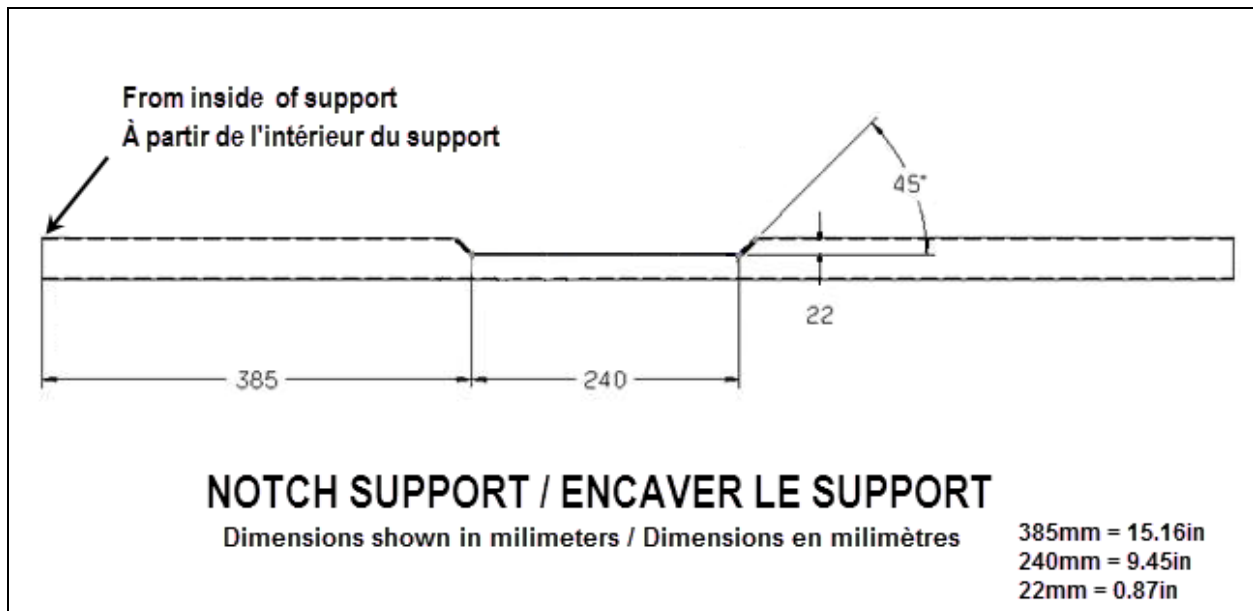
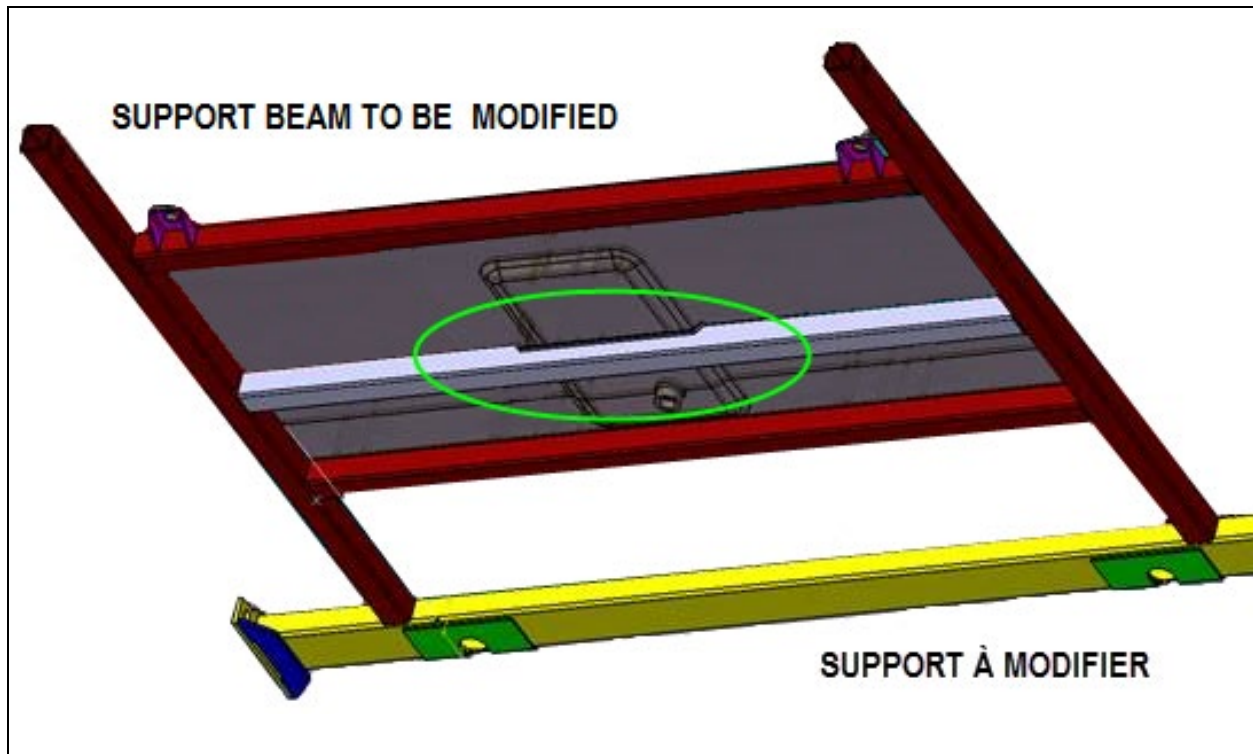
PROCEDURE



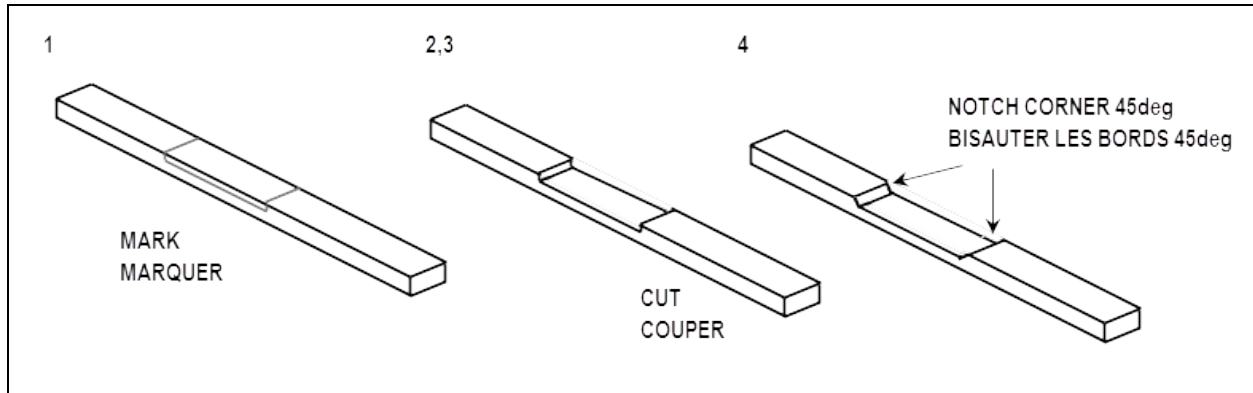
DANGER

This procedure requires cutting and welding of the fuel tank support. Only qualified personnel should proceed to this modification.

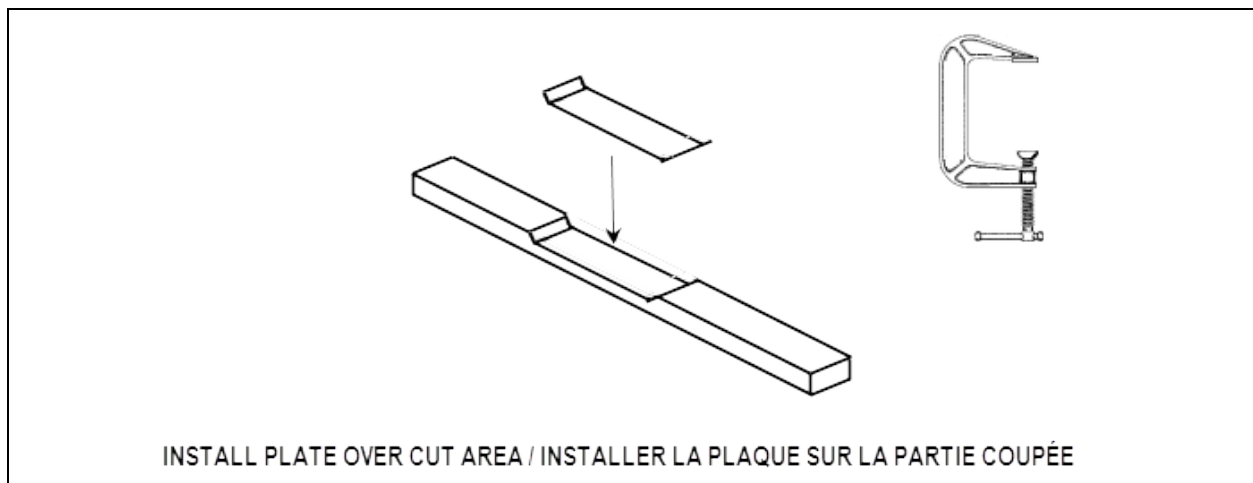
Follow all safety rules regarding arc welding and handling of metal cutting devices.



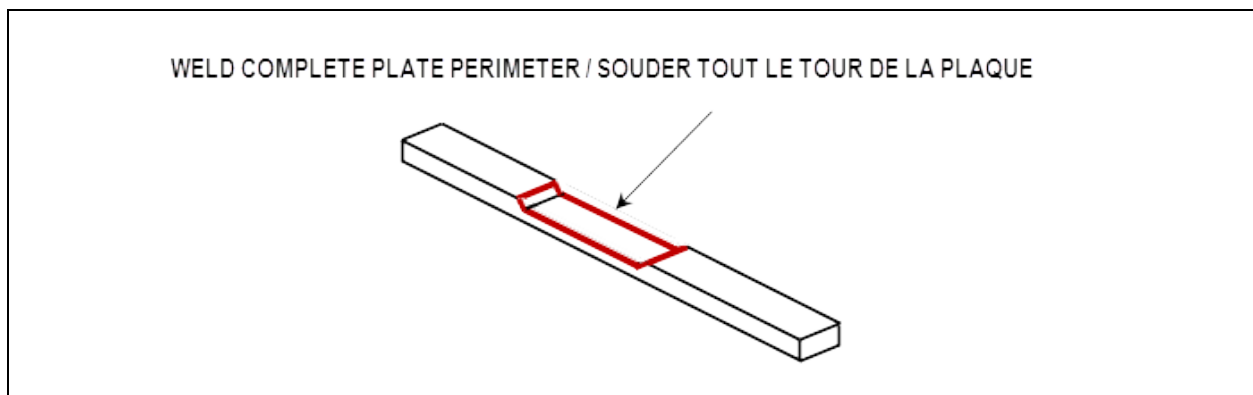
1. With the fuel tank removed from the support, locate and mark the support beam to be cut following the dimensions on the drawing above.
2. From the top of the beam, make two vertical cuts 22mm deep.
3. From both sides, cut horizontally between the two vertical cuts.
4. Notch the two corners at 45deg angle.



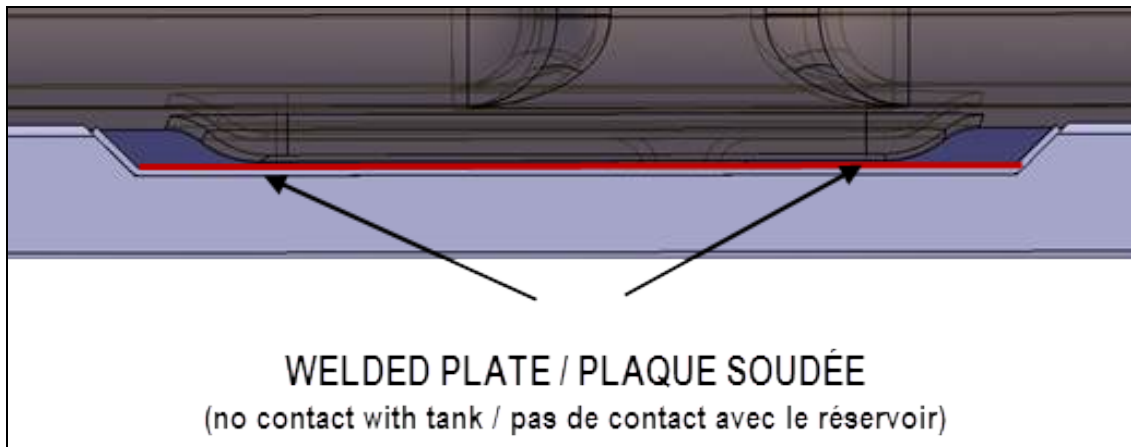
5. Position the included #030022 plate over the notched beam (hold in place with C-clamps and tack weld as required).



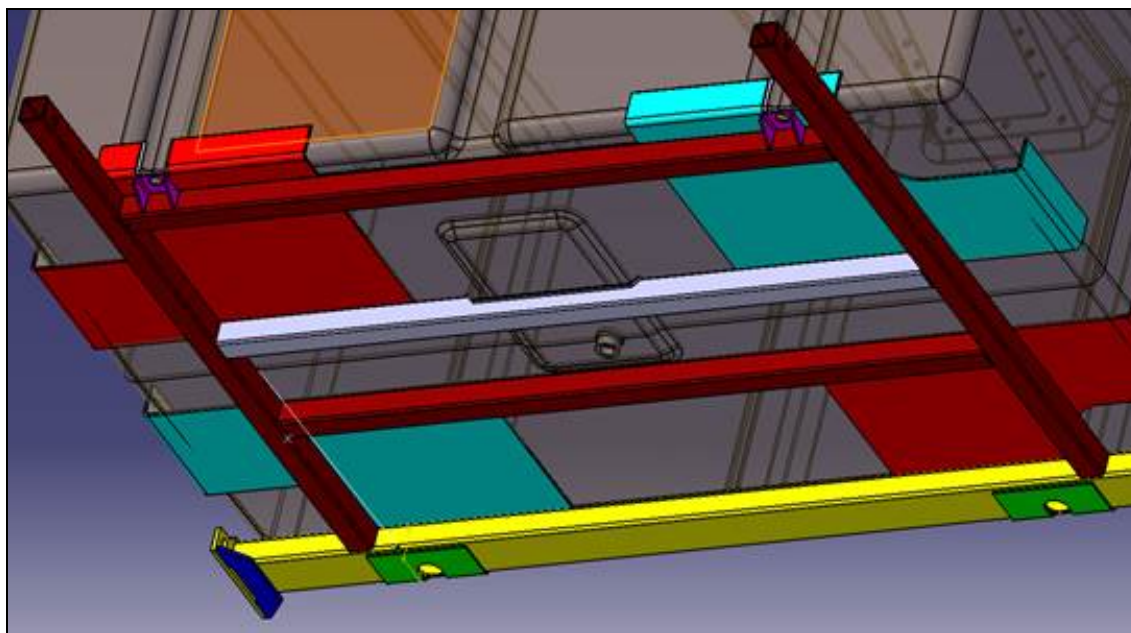
6. Weld the plate to the beam (entire perimeter of the plate must be welded to ensure correct beam structural strength).



7. Clean and grind down the weld to ensure that there is no contact area (weld high spots) between the weld and the plastic tank.



8. Install the new tank on the support.



PARTS / WASTE DISPOSAL

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