

# PREVOST

## Instruction Sheet

## IS-23019A

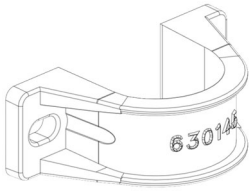
### SWAY BAR COLLARS IMPROVEMENT

Revision: A

ADD FRONT SWAY BAR SUPPORT REPLACEMENT AND  
CHANGE BOLTS LENGHT

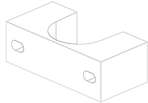
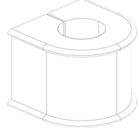



06-04-2024

Use these kits to replace sway bar collars

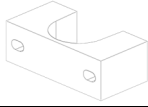
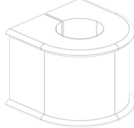

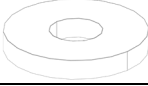

630145	FORMER COLLAR	
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### MATERIAL

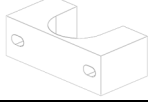
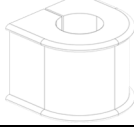



Kit #130077 (with 1 ½" sway bar) includes the following parts:

Part No.	Description		Qty
130076	COLLAR MACHINED		4
130953	RUBBER BUSHING, 1 ½" SWAY BAR		4
5001941	BOLT HEX N500 M12X1.75X120 G10.9		8
5002008	WASHER FLAT HARD N500 13X35X5		8
5001695	NUT HEX NYRT NX500 M12-1.75 G10		8
IS-23019	INSTRUCTION SHEET		1
FI-23019	FEUILLE D'INSTRUCTION		1

Kit #130078 (with 1 3/4" sway bar) includes the following parts:



Part No.	Description		Qty
130076	COLLAR MACHINED		4
630020	RUBBER BUSHING, 1 3/4" SWAY BAR		4
5001941	BOLT HEX N500 M12X1.75X120 G10.9		8
5002008	WASHER FLAT HARD N500 13X35X5		8
5001695	NUT HEX NYRT NX500 M12-1.75 G10		8
IS-23019	INSTRUCTION SHEET		1
FI-23019	FEUILLE D'INSTRUCTION		1

Order kit #130079 (with 2" sway bar) includes the following parts:

Part No.	Description		Qty
130076	COLLAR MACHINED		4
131355	RUBBER BUSHING, 2" SWAY BAR		4
5001941	BOLT HEX N500 M12X1.75X120 G10.9		8
5002008	WASHER FLAT HARD N500 13X35X5		8
5001695	NUT HEX NYRT NX500 M12-1.75 G10		8
IS-23019	INSTRUCTION SHEET		1
FI-23019	FEUILLE D'INSTRUCTION		1

For front sway bar support replacement (only)

Order if support needs to be replaced:

Part No.	Description	Qty
170002	BRACE, RIGHT 	1
170003	BRACE, LEFT 	1

<b><i>NOTE</i></b>
<i>Material can be obtained through regular channels.</i>

## SAFETY PRECAUTIONS

- Eye protection should always be worn when working in a shop.
- Rules for Personal Protection Equipment should always be respected. Wear your PPE including but not limited to the following:



# Safety First!



## PROCEDURE



### DANGER

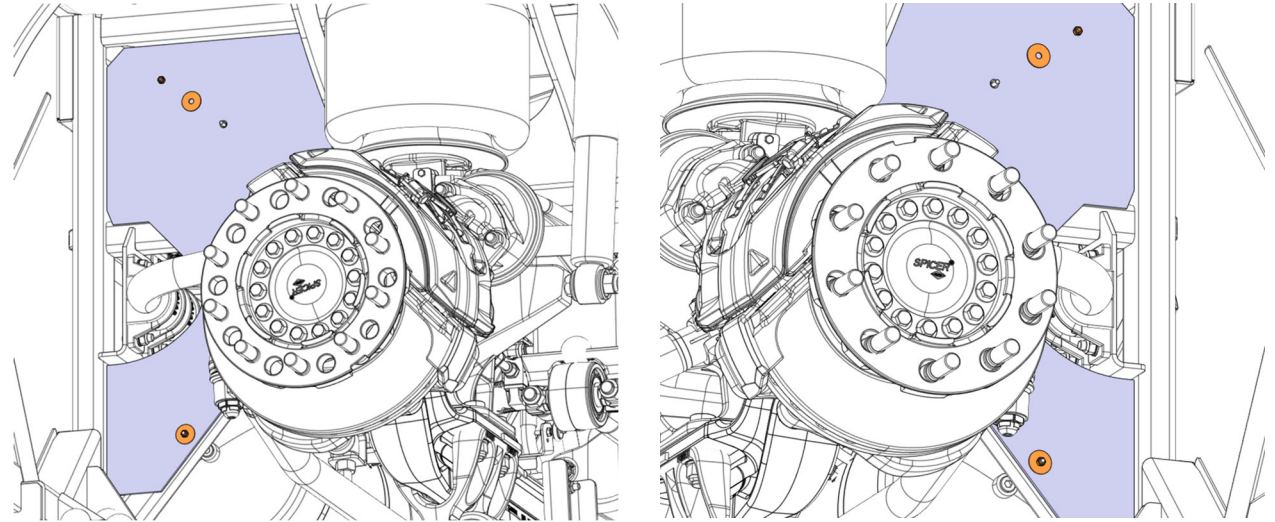
Park vehicle safely, apply parking brake, stop engine. Prior to working on the vehicle, set the ignition switch to the OFF position and trip the main circuit breakers equipped with a trip button. On Commuter type vehicles, set the battery master switch (master cut-out) to the OFF position.

Lock out & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

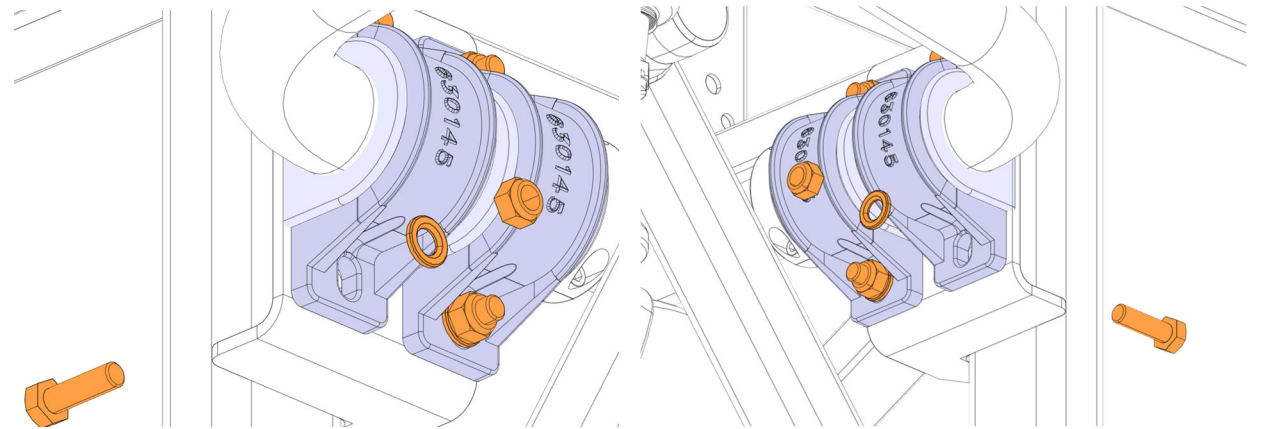
## FRONT SUSPENSION

1. Raise the vehicle using the frame jacking points.

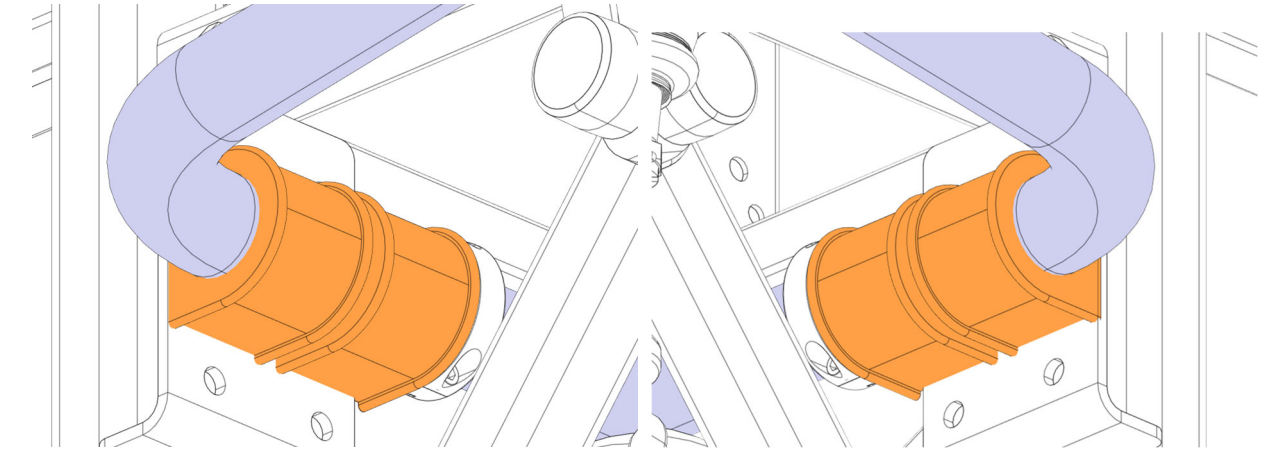
2. Remove splash guards.



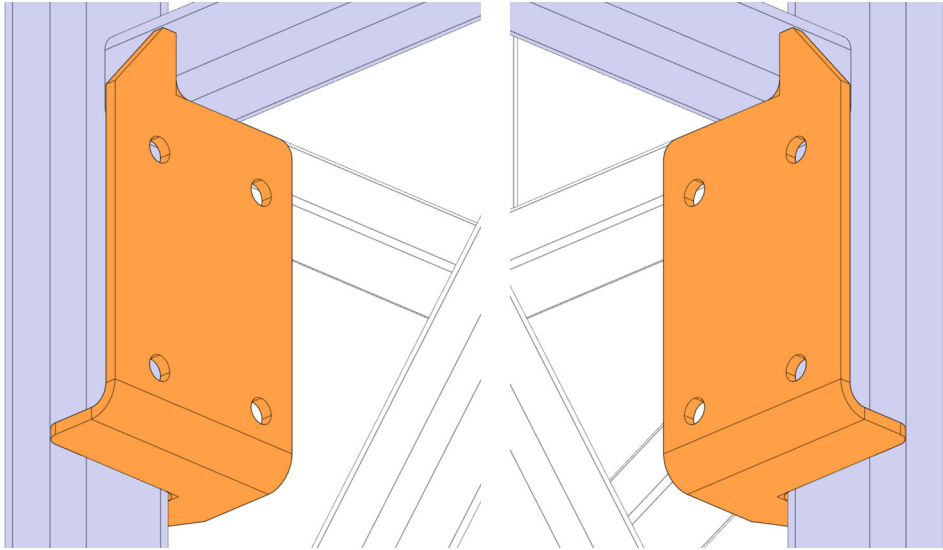
3. Remove old collars and hardware and discard.



4. Remove rubber bushings and discard.

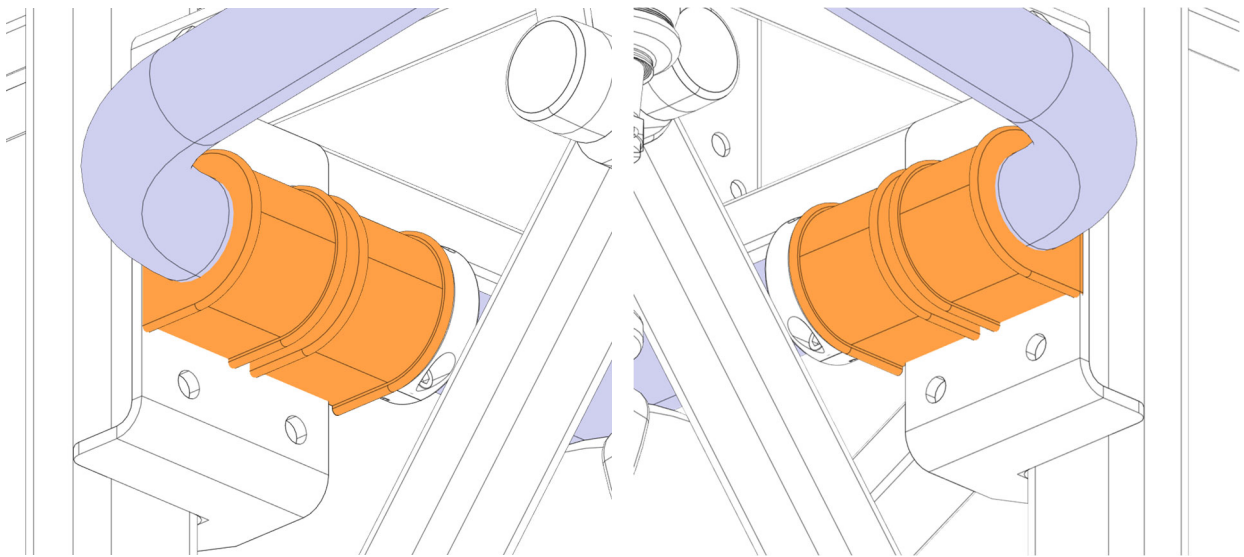


5. Inspect braces with a straight edge. If bent or cracked, they must be replaced. Go to section **FRONT SUSPENSION BRACE REPLACEMENT**.

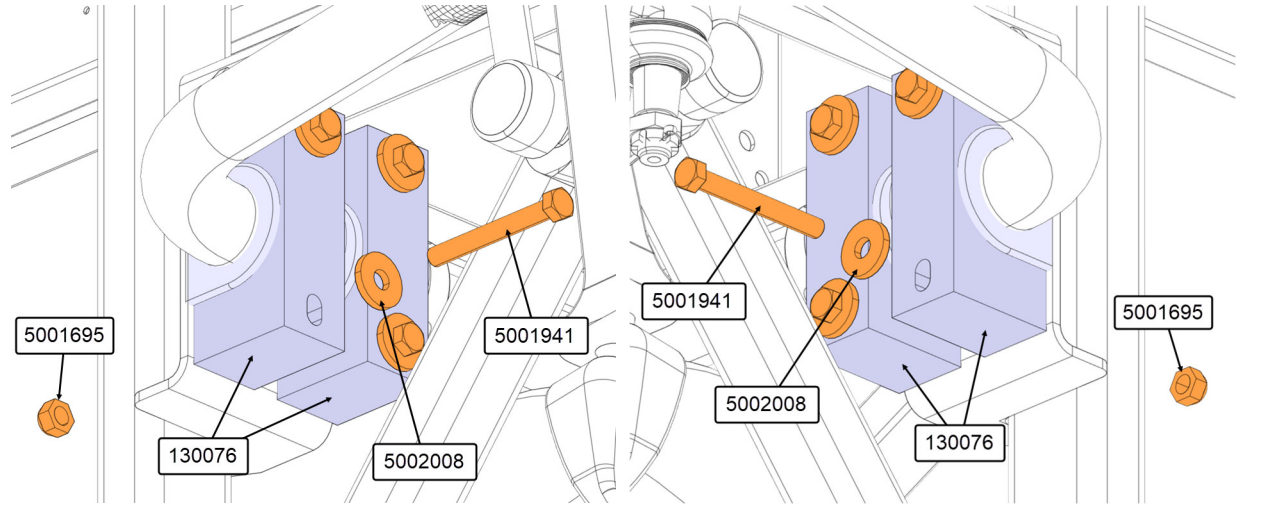


6. Install new rubber bushings (4x).

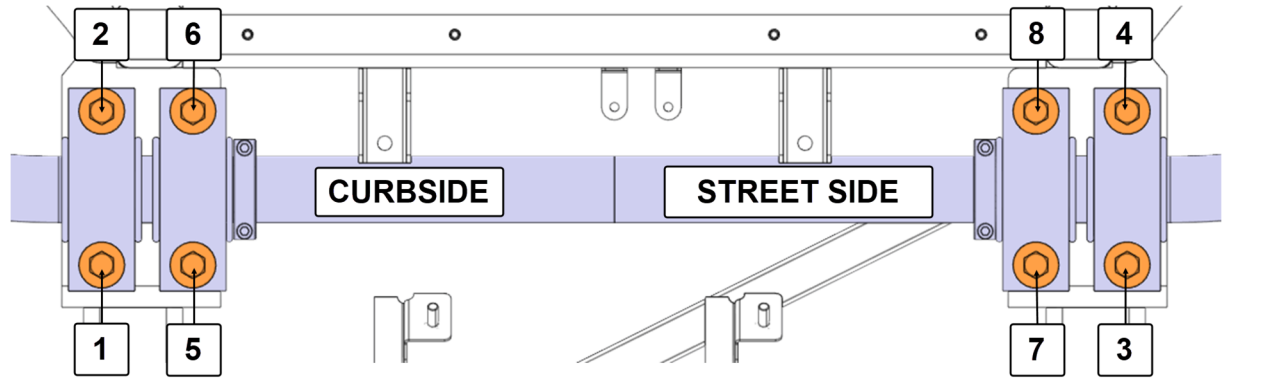
- For sway bar 1 ½" use rubber bushings 130953
- For sway bar 1 ¾" use rubber bushings 630020
- For sway bar 2" use rubber bushings 131355



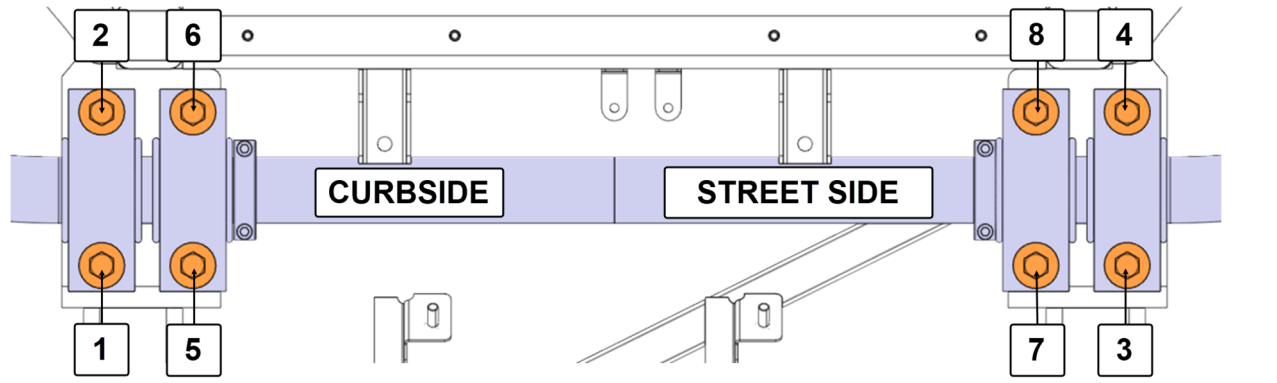
7. Install new collars 130076 (4x) with bolts 5001941 (8x), washers 5002008 (8x) and nuts 5001695 (8x).



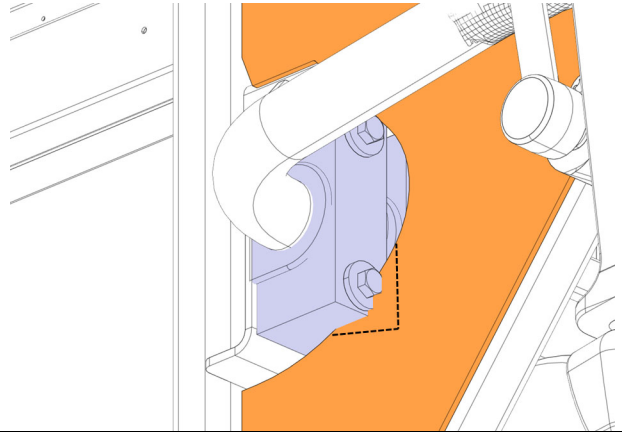
8. Perform the pre-tightening with a torque of 60lb-ft tightening with the sequence 1 to 8.



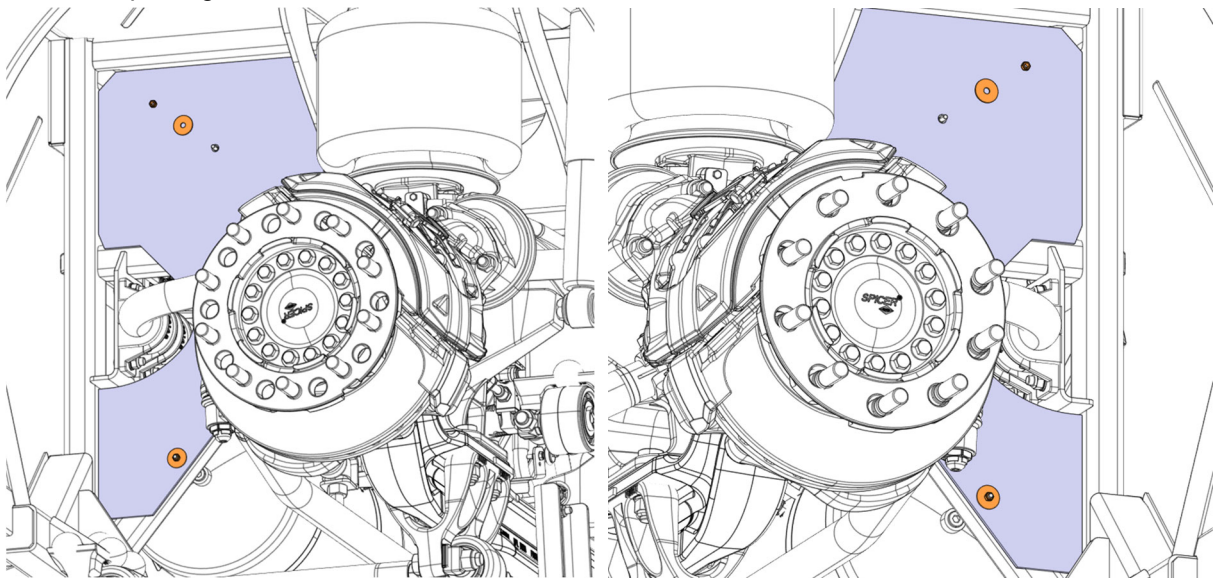
9. Perform the final tightening with a torque of 90lb-ft tightening with the sequence 1 to 8.



10. Before reinstalling splash guards, check that there is no interference with the new collar.
11. If yes, modify the splash guards.



12. Reinstall splash guards.

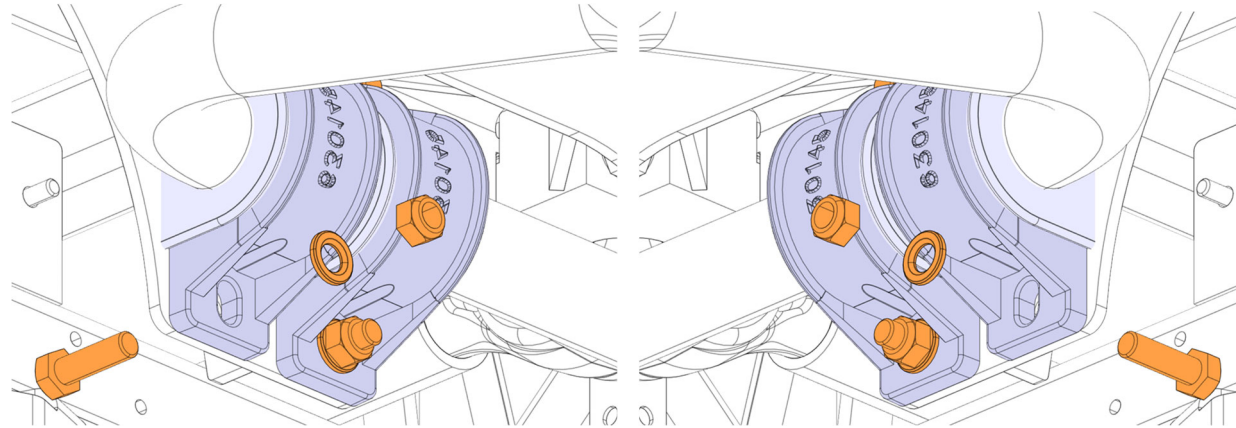




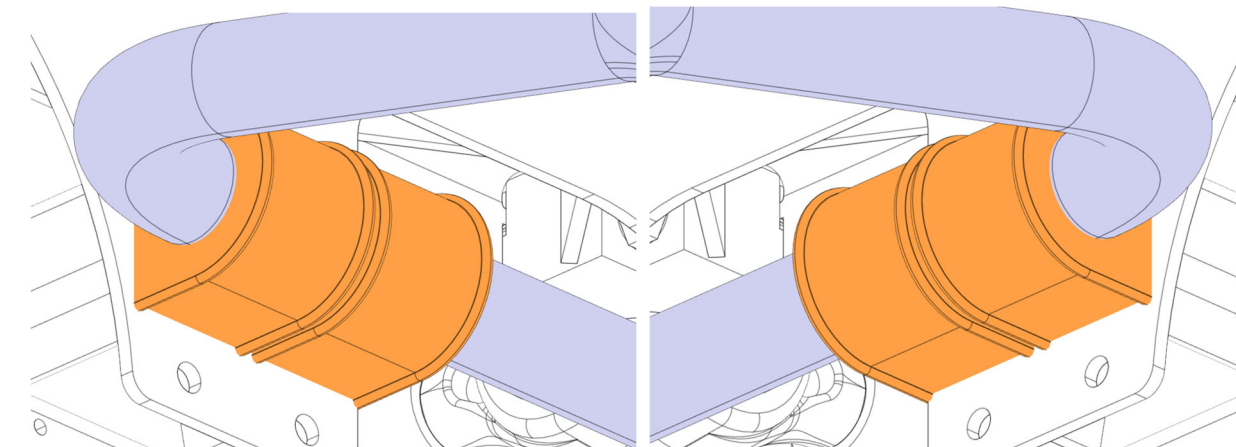
## REAR SUSPENSION

1. Raise the vehicle using the frame jacking points.

2. Remove old collars and hardware and discard.

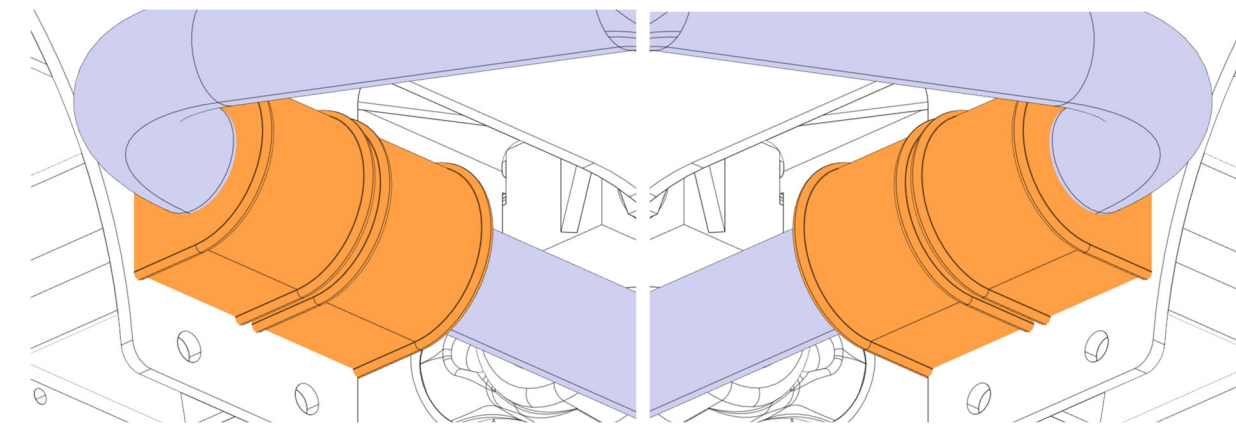


3. Remove rubber bushings and discard.

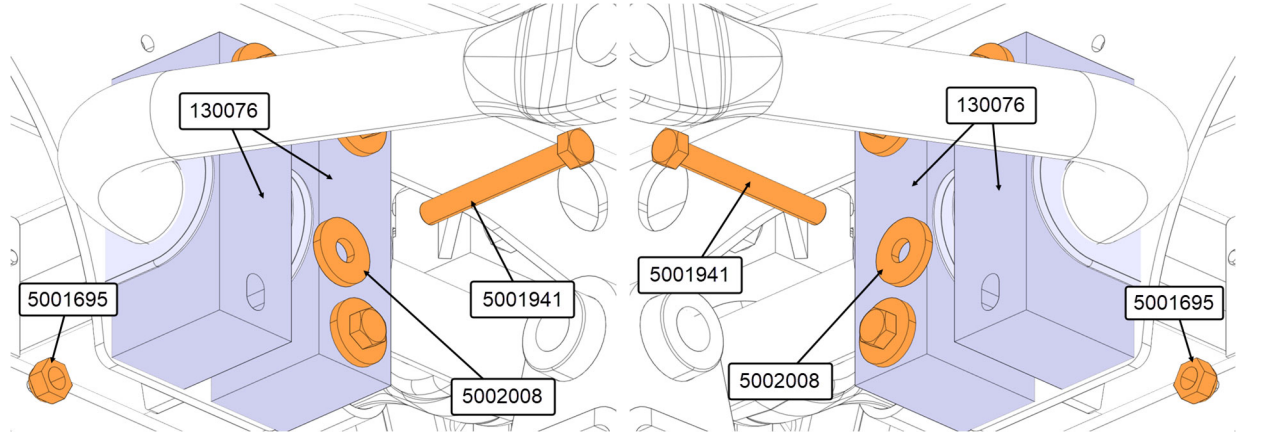


4. Install new rubber bushings (4x).

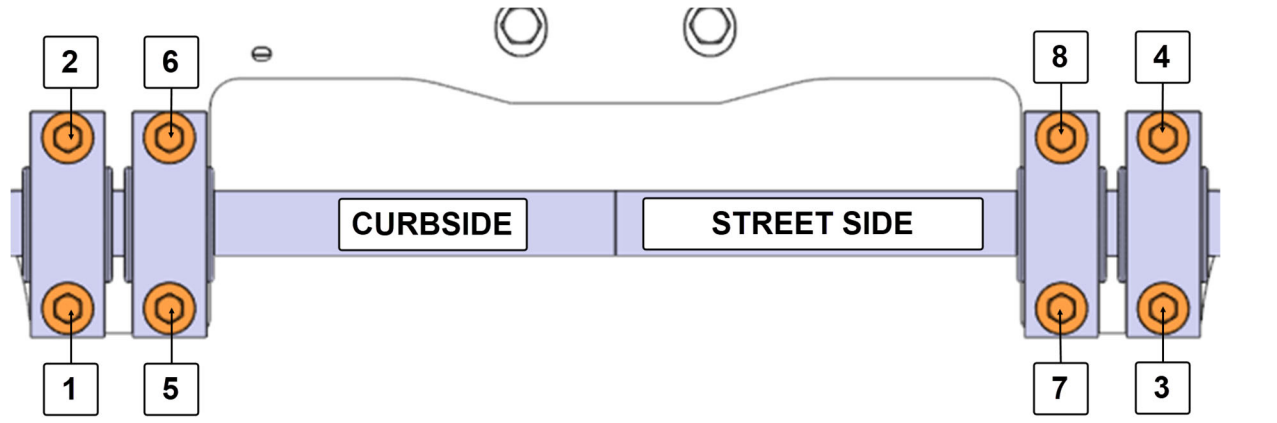
- For sway bar 1 ½" use rubber bushings 130953
- For sway bar 1 ¾" use rubber bushings 630020
- For sway bar 2" use rubber bushings 131355



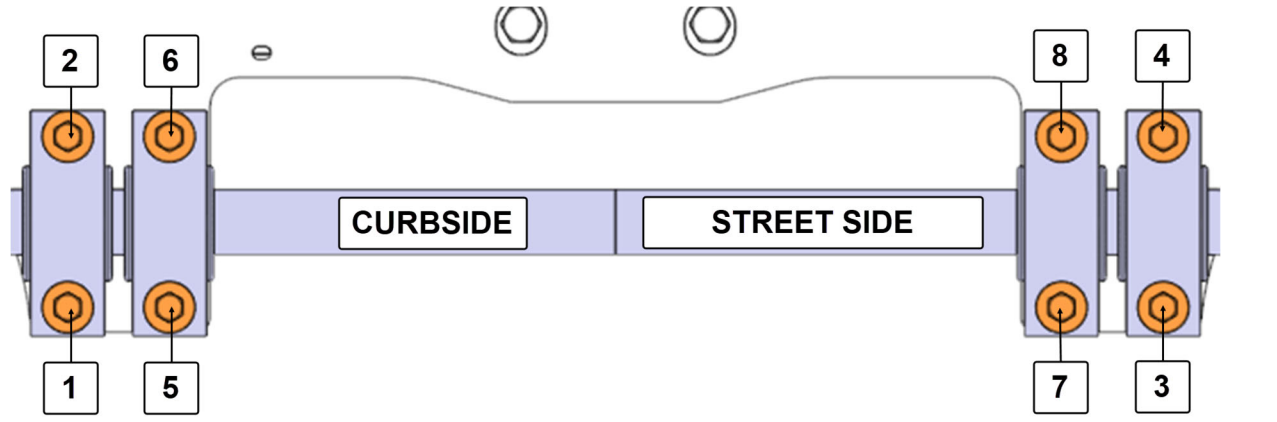
5. Install new collars 130076 (4x) with bolts 5001941 (8x), washers 5002008 (8x) and nuts 5001695 (8x).



6. Perform the pre-tightening with a torque of 60lb-ft tightening with the sequence 1 to 8.



7. Perform the final tightening with a torque of 90lb-ft tightening with the sequence 1 to 8.



## FRONT SUSPENSION BRACE REPLACEMENT



### CAUTION

Welding is required to fix the brace to the vehicle front suspension beam. Before attempting to do any kind of electric arc welding to the vehicle chassis, carefully follow the Multiplex Module Disconnection Procedure see the maintenance manual of the vehicle.

Failure to comply with the disconnection procedure may result in permanent damage to the vehicle electronic equipment.

***Only certified welder, State, National or provincial can be welding on structural components of the coach***

Volt : 24 – 28 V

Amp. : 240 - 280 A

Wire : Mild Steel FCAW 0.045

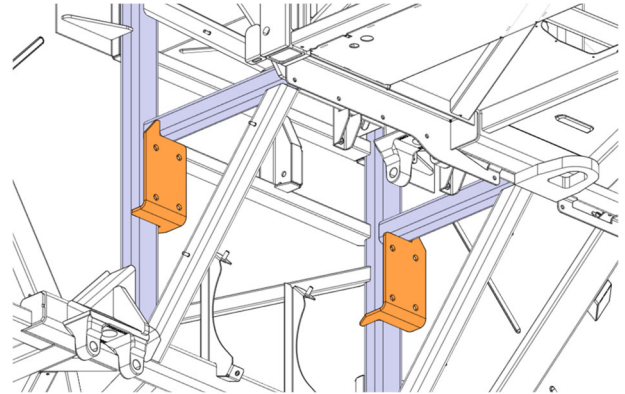
Position: In Position

Shielding Gas: 75% AR – 25%CO2

Welding Speed: 15- 22 in/min

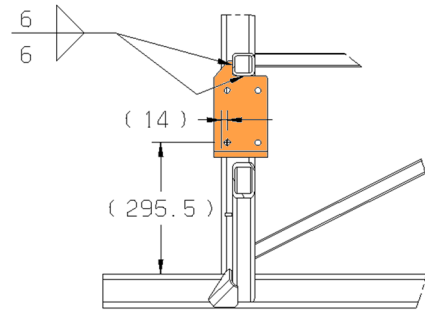
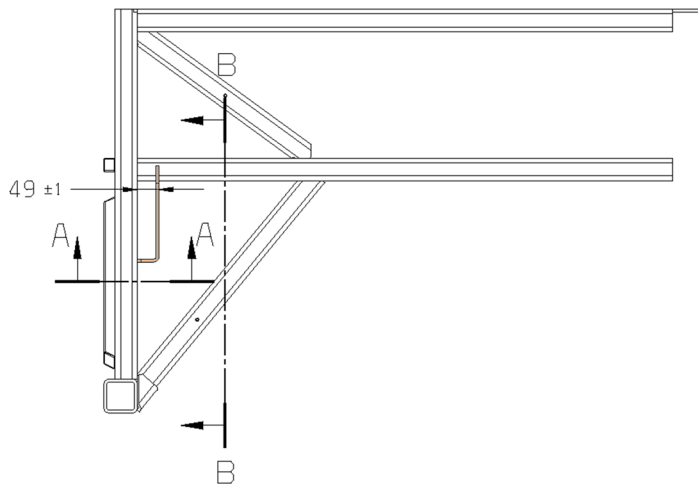
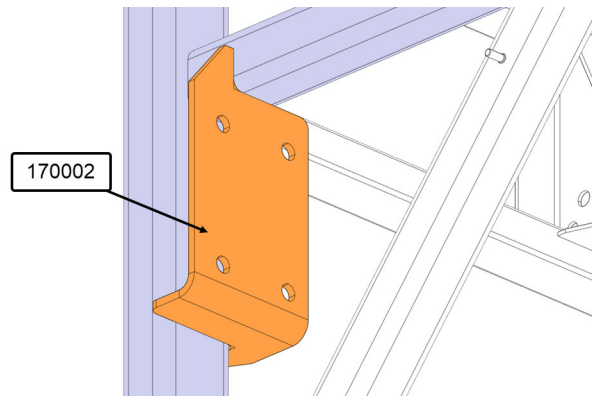
## FRONT SUSPENSION BRACE REPLACEMENT

1. Remove the old brace.

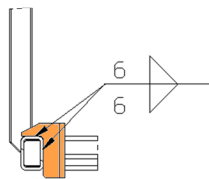


2. Weld the new brace 170002.

Note : For further details, refer to the drawing found in appendix A.



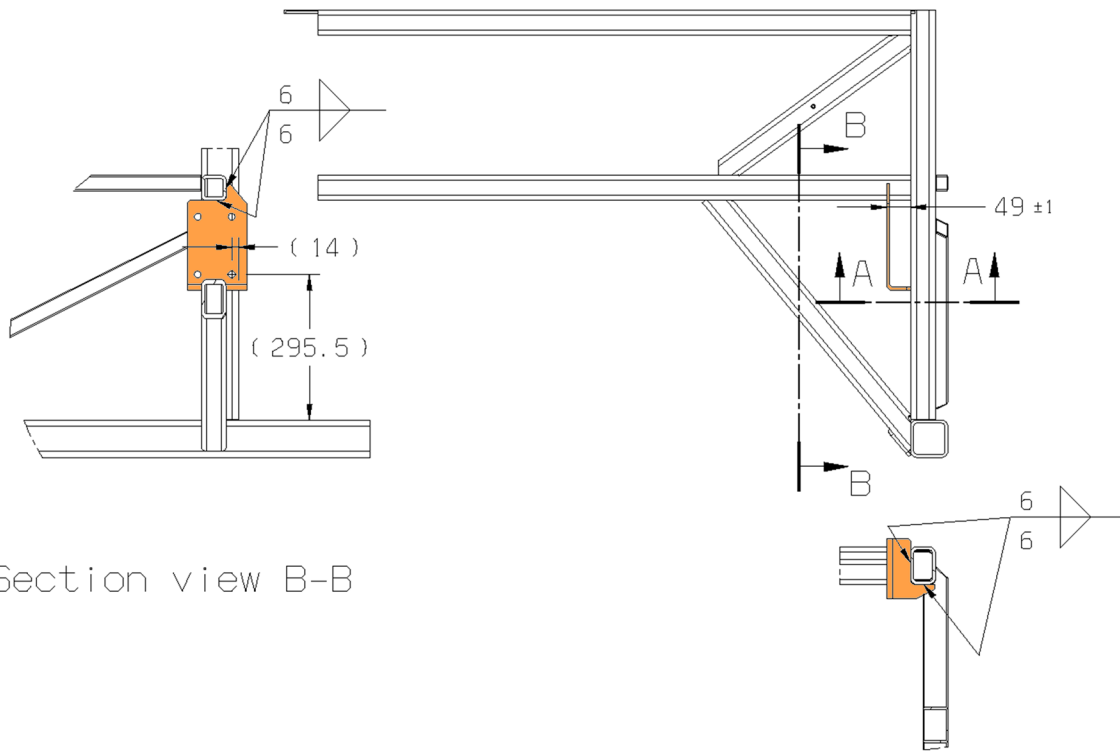
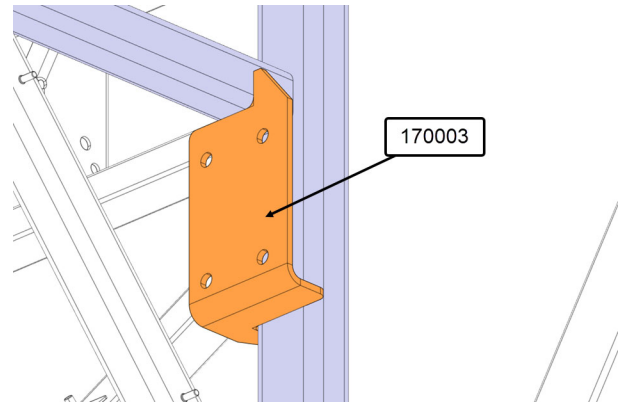
Section view B-B



Section view A-A

3. Weld the new brace 170003.

Note : For further details, refer to the drawing found in appendix A.



Section view B-B

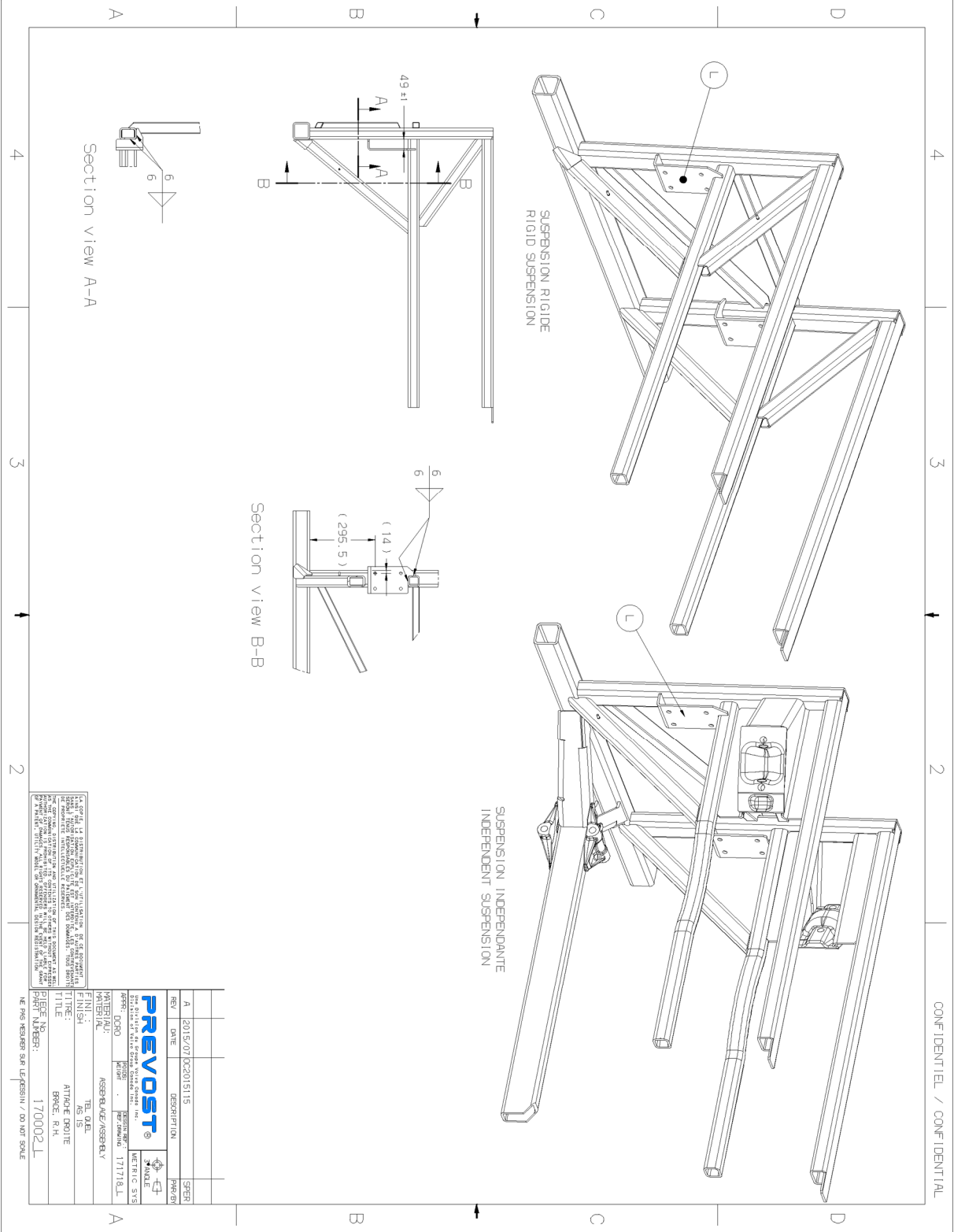
Section view A-A

### PARTS / WASTE DISPOSAL

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

# Appendix A

# REFERENCE DRAWINGS



CONFIDENTIAL / CONFIDENTIAL

REV	A	DATE	2015/07/02	DESCRIPTION	SEPER
<p><b>PREVOST</b>                  5110 Boulevard de la Grande Vallée, 10000 Laval, Québec                  511-850-0000 • www.prevost.com • 17718.L</p>					
MATERIAL	ALUMINUM				
FINISH	POUR ANODISÉ				
TITLE	ATTACHE DOOITE				
SCALE	1:1				
PART NUMBER	170002.L				

NE PAS MESURER SUR LE Dessin / DO NOT SCALE

Avertissement de sécurité : Ce produit est destiné à être utilisé en tant que siège de transport pour les personnes âgées et les personnes handicapées. Il ne doit pas être utilisé comme siège de transport pour les personnes âgées et les personnes handicapées. Le fabricant ne s'engage pas à garantir la sécurité de ce produit. Le fabricant ne s'engage pas à garantir la sécurité de ce produit. Le fabricant ne s'engage pas à garantir la sécurité de ce produit.

