



PREVOST

EN REGISTRÉ - REGISTERED
ISO 9001 & ISO

SAFETY RECALL

Sr03-07A




DATE : MARCH 2003	SECTION : STEERING
SUBJECT : STEERING GEAR BOX SUPPORT REINFORCEMENT	

REVISION : A

Information added stating that applicable to vehicles with independent front suspension only and VIN range updated

APPLICATION

Model	VIN
H3-45 VIP Bus Shell with <u>independent front suspension only</u> (since face lift) Model Year : 2003-2004	 <p>2PCV3349331014345 and also from 2PCV3349231014417 up to 2PCV3349731014722 incl. except 2PCV3349X31014620 2PCV3349631014713 2PCV3349541014641 2PCV3349531014721 2PCV3349031014710</p>

DESCRIPTION

Analysis have demonstrated possible failure of the steering gearbox support when under heavy load conditions or for vehicles with a mileage exceeding 155 000 miles (250 000km). Stress cracks may develop, as consequences the steering gearbox may become loose and thus affect steering maneuverability. To prevent this situation from happening, reinforcement parts must be installed on the above mentioned vehicles in order to strengthen the support.

MATERIAL

Part No.	Description	Qty
172833	Reinforcement part	1
172834	Reinforcement part	1
172835	Reinforcement part	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.

1. Inside the front service and electrical compartment, empty the windshield washer tank and remove it to gain access to the steering gearbox.
2. Open the reclining bumper compartment and remove the equipment in place in order to get to the steering gearbox support.
3. Remove the steering gearbox as described in section 14: STEERING in your Maintenance Manual. **You don't have to disconnect both the inlet and the outlet hoses from the steering gearbox.**

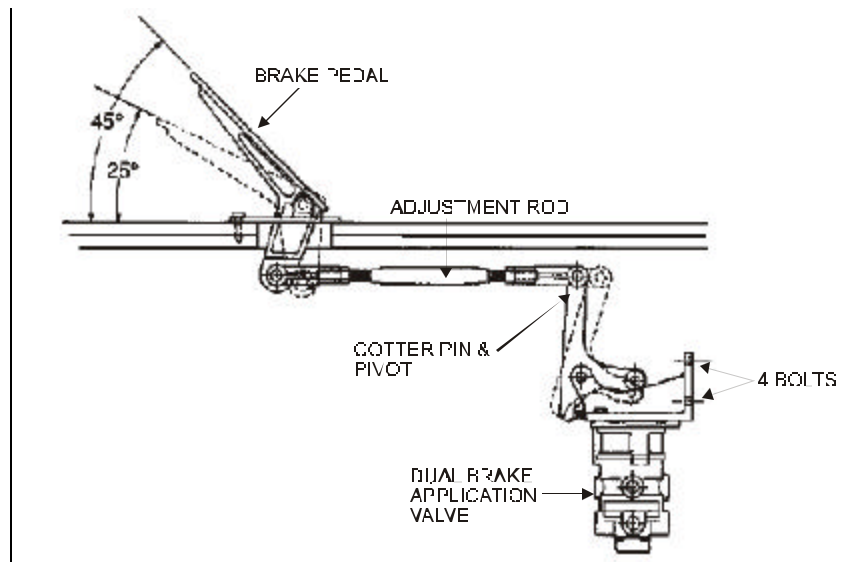


FIGURE 1: BRAKE APPLICATION VALVE

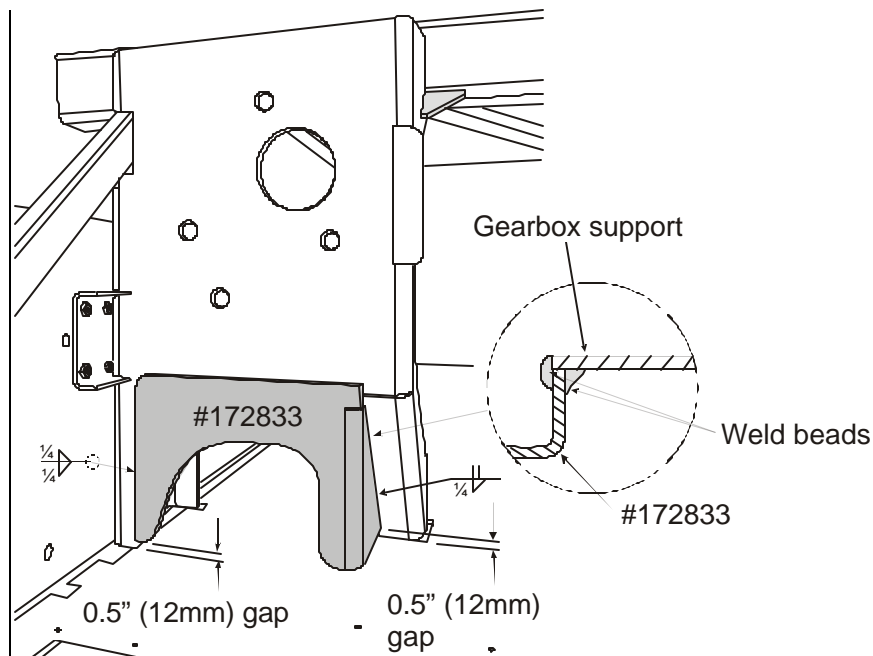


FIGURE 2: WELDING OF #172833

4. Remove the cotter pin and pivot from the adjustment rod and the brake application valve linkage (figure 1).
5. Unscrew the 4 bolts fixing the bracket and remove the brake application valve assembly (figure 1). Put aside and cover it to protect against welding splatter.
6. Position reinforcement part #172833 as shown in figure 2. Keep a gap of $\frac{1}{2}$ " (12mm) between the bottom of reinforcement part and the floor. Weld all around the reinforcement part, front side and back side with a weld bead section equal to or greater than the part thickness. To perform welding, refer to WELDING PROCEDURE and welding specifications indicated in paragraph: **Steel – Steel Welding**.

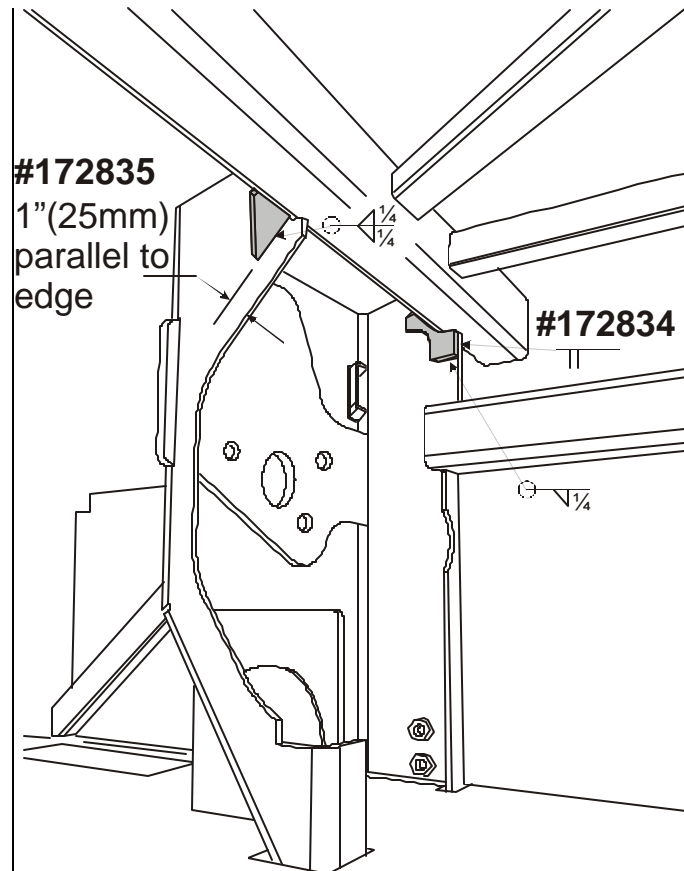


FIGURE 3: WELDING OF #172834 & #172834

7. Place reinforcement part #172835 as shown in figure 3. Assure that the 2 edges of the reinforcement part and the square tube are perfectly in contact. If needed, buff the corner of the reinforcement part to mate with an existing weld bead between the gearbox support and the square tube. Weld the reinforcement part, front side and back side with a weld bead section equal to or greater than the part thickness. To perform welding, refer to WELDING PROCEDURE and welding specifications indicated in paragraph: **Steel – Steel Welding**.
8. Place the reinforcement part #172834 flat on the gearbox support with the edge perfectly in contact with the square tube. Weld all around the reinforcement part with a weld bead section equal to or greater than the part thickness. To perform welding, refer to WELDING PROCEDURE and welding specifications indicated in paragraph: **Steel – Steel Welding**.
9. Reinstall the brake application valve.

10. Reinstall the steering gearbox as described in section 14: STEERING in your Maintenance Manual. Lubricate the steering gearbox fixing bolts with Loctite #242 blue and torque to 265 lbf•ft (310 N•m).

WARRANTY

This modification is covered by Prévost Car's normal warranty. We will reimburse you the parts and eight hours (8.0) of labor upon receipt of a completed A.F.A. form on which you must specify as per «Safety Recall 03-07». **You also have to fill the "Safety Recall Certification Sheet" provided with this bulletin and return it with your A.F.A. form to be reimbursed.**



WELDING PROCEDURE

- A. Remove anything that may be stored in the compartment to have clear access to the support.
- B. Protective shields must be placed in order to protect components against heat, welding flash, welding arc and other elements associated with welding.
- C. Always wear the appropriate safety equipment.
- D. Weld in clean and well-ventilated area, and always have an appropriate fire extinguisher within your reach.
- E. The following precautions are to be taken to protect the electronic control components :

Note: See "Precautions to be observed before welding" in section 00: GENERAL INFORMATION of your vehicle's Maintenance Manual.

- ◆ 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-Lock Brake System), disconnect wiring harness connectors from ABS Electronic Control Unit. The ABS Electronic Control Unit is located in the rear electrical compartment.
 - ◆ Do not connect welding cables to electronic control components.
- F. Using a grinder, clean the seating surfaces of the support to ensure adequate seating of the reinforcement part. Seat reinforcement part on support as per figure 2 and 3 and hold with a C-clamp "Vise-grip".

- G. To perform welding, refer to figure 2 and 3 and welding specifications indicated in paragraph: **Steel – Steel Welding**.
- H. Reconnect components mentioned at step E.

STEEL – STEEL WELDING

Caution: Before welding, disconnect electronic modules and battery terminals.

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

Warning: Only a qualified and experienced person must do welding.

- 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) ;
- Voltage : 26 ± 1 volts ;
- Current : 260 Amps ;
- Wire feed rate: 450 ipm. approx. ;
- Shielding gas: 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).

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



PREVOST

**Safety Recall
Certification Sheet
(Ref: Sr03-07)**

ENREGISTRÉ - REGISTERED
ISO 9001 & ISO 14001



SERIAL NUMBER: _____

PERFORMED BY		OWNER/OPERATOR	
We hereby certify that Safety Recall Instructions with regard to Safety Recall #03-07 have been performed.			
Name: _____		Name: _____	
Addr: _____		Addr: _____	
Phone: _____		Phone: _____	
Fax: _____		Fax: _____	
Signature :	_____	Signature :	_____
Date:	_____	Date:	_____

If the information mentioned above is incorrect or you are not the owner of this vehicle anymore, please fill this section and return to sender..

NEW OWNER: _____

BUSINESS: _____

ADDRESS (including County): _____

TELEPHONE: _____ **FAX:** _____

**Please return this completed document with your
A.F.A. form**