

PREVOST

**WARRANTY
BULLETIN**

Wb98-12



DATE : May 1998	SECTION : 11
SUBJECT : INSTALLATION OF FOUR REINFORCEMENT CORNERS ON THE TAG AXLE	

APPLICATION

Model	VIN
H3 Series Coaches Model Year: 1990 - 1996	 From 2P9H33408L1001031 up to 2PCH33417T1011357 incl.

DESCRIPTION :

On the above-mentioned vehicles, the installation of four reinforcement corners on the tag axle ensures rigidity of joint between axle arch and sub-assembly.

MATERIAL

Part No.	Description	Qty
121503	Reinforcement corner	4

Note : Material can be obtained through regular channels.

PROCEDURE

Warning : Park vehicle safely over a repair pit, 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 an air-suspended vehicle, it is strongly recommended to securely support the body at the recommended jacking points.

1. Raise tag axle then remove the wheels or empty air springs then raise tag axle using a jack and remove the wheels.

Warning : Ensure to safely support the axle by its jacking points during repair. Only the recommended jacking points must be used as outlined in Section 18 of Maintenance Manual : "Body" under heading "Vehicle jacking points" or in Operator's Manual.

2. Welding must be done only by a qualified and experienced person.
3. Protective shields must be placed in order to protect components against heat, welding flash, welding arc and other elements associated with welding.
4. Always wear the appropriate safety equipment.

5. Weld in clean and well-ventilated area, and always have an appropriate fire extinguisher within your reach.
6. 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-Lock 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.
7. Before proceeding with welding, check if cracks are present on tag axle, gouge or grind cracked areas to bare metal and reweld. Install reinforcement corners referring to figure 1 welding specifications.

Caution : *If cracks are present on tag axle, rewelding may distort alignment. Check alignment after repair.*

Note : *For analysis purposes by Prévost Car's Engineering Department, please send us a picture of the crack along with the completed A.F.A. form.*

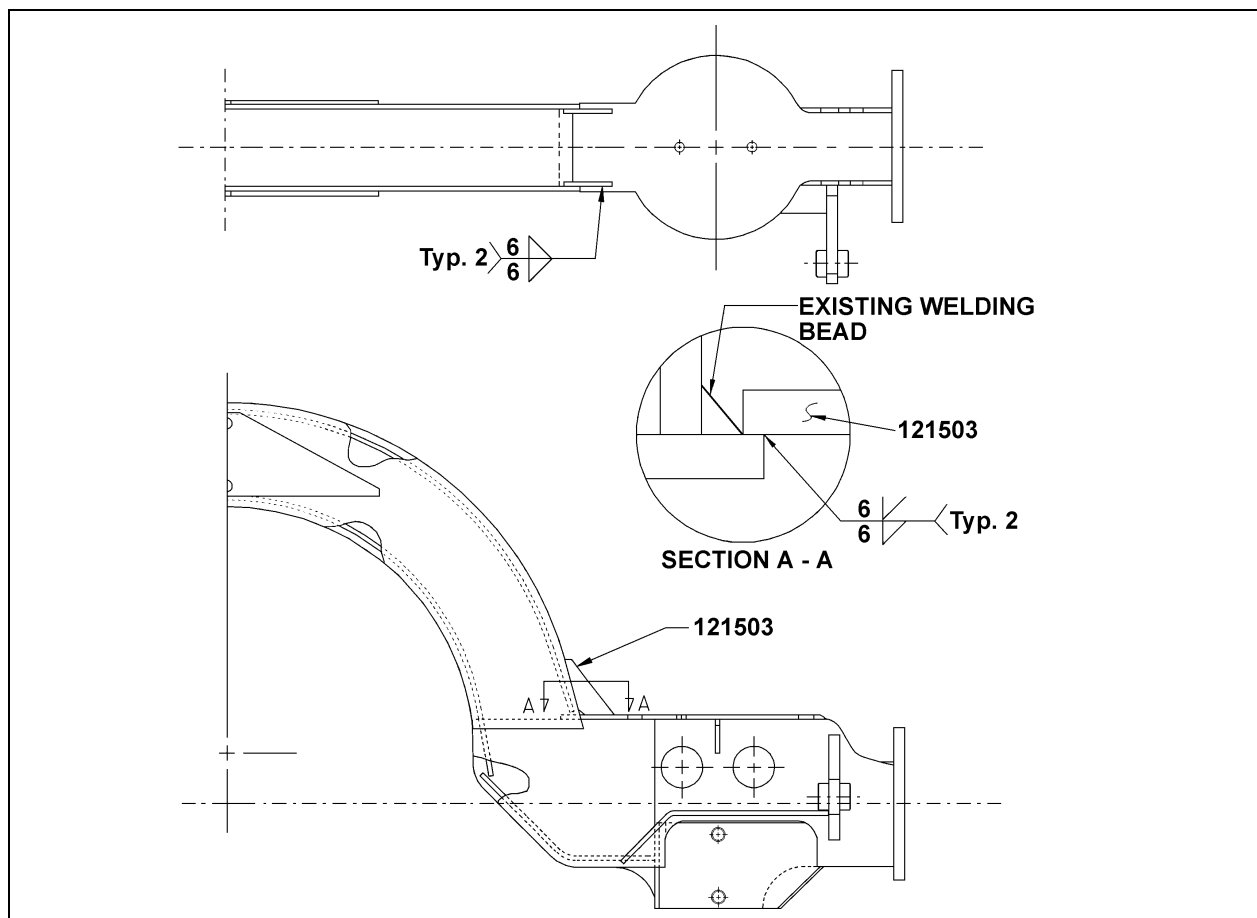


FIGURE 1 : TAG AXLE REINFORCEMENT CORNERS

8. Because of material thickness, it is recommended to use a semi-automatic electric arc welding machine in accordance with the following specifications :

STEEL - STEEL WELDING

Note : Welding must be done only by a qualified and experienced person.

- SMAW (Shield Metal-Arc Welding) process ;
 - welding rod conforms to CSA W48.3 - 93 specifications ;
 - E7018 type welding rod with 1/8" diameter (3,2 mm) or E48018 ;
 - current : flat - 90 amperes to 160 amperes
up - 90 amperes to 135 amperes
overhead - 90 amperes to 160 amperes.
 - FCAW (Flux Cored-Arc Welding) process ;
 - welding rod conforms to CSA W48.5 - M1990 specifications ;
 - E4801 - T9CH type welding rod with 0.045" diameter (1,2 mm) ;
 - voltage : 27 volts ;
 - current : 260 amperes ;
 - wire feed rate : 450 ipm ;
 - shielding gas : 75% argon and 25% CO² or 100% CO²
9. Allow welding to cool, then remove slag. Repaint reinforcement corners and axle.
10. Reconnect components mentioned at step 6.
11. Install wheels and lower tag axle.

WARRANTY

In the case of a cracked tag axle, send us a picture of the crack and the tag axle alignment will be reimbursed.

This modification is covered by the manufacturer's normal warranty. We will reimburse you the parts and one hour (1.0) of labor upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 98-12".

Parts disposition :

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

Expiration date : May 1999