



**PREVOST**

# SAFETY RECALL

Sr00-37A

ENREGISTRÉ - REGISTERED  
**ISO 9001 & ISO 14001**



<b>DATE :</b> November 2000	<b>SECTION :</b> 11
<b>SUBJECT :</b> TAG AXLE INSPECTION AND INSTALLATION OF REINFORCEMENT PARTS	

**REVISION :** A

**A MISTAKE OCCURED IN THE APPLICATION OF THE 2<sup>ND</sup> PART. THE APPLICATION SHOULD HAVE LISTED FROM 2P9H33495R1001012 UP TO 2PCH3349711014181 INCL.**

## APPLICATION

Model	VIN
H3-40, H3-41 & H3-45 Coaches Model Year: 1990 - 1996	From 2P9H33408L1001031 up to 2PCH33417T1011357 incl.
H3-41 & H3-45 Coaches Model Year: 1994 - 2001	From 2P9H33495R1001012 up to 2PCH3349711014181 incl.
XL-40 and XL-45 Coaches Model Year: 1994 - 1995	From 2P9L33408R1001775 up to 2P9L33402S1001647 incl.
MTH-45E Model Year: 1994 - 1995	From 2P9E33492R1001777 up to 2P9E33492S1001638 incl.

## DESCRIPTION

It has come to the attention of Prévost Car Inc. that on the above-mentioned vehicles having a high mileage or submitted to severe working conditions, the tag axle may develop fatigue cracks and eventually a tag axle failure. This could have adverse effects on the handling of the vehicle. If you are the owner or operator of such vehicle, it is of the utmost importance to have the tag axle inspected right away. Reinforcement parts must be installed and cracks repaired if necessary in order to strengthen the tag axle. For more information or help on how to perform this safety recall, contact your service manager or the nearest service center.

## 1<sup>st</sup> PART

Model	VIN
H3 Series Coaches Model Year: 1990 - 1996	From 2P9H33408L1001031 up to 2PCH33417T1011357 incl.
XL-40 and XL-45 Coaches Model Year: 1994 - 1995	From 2P9L33408R1001775 up to 2P9L33402S1001647 incl.
MTH-45E Model Year: 1994 - 1995	From 2P9E33492R1001777 up to 2P9E33492S1001638 incl.

## MATERIAL

Part No	Description	Qty
121503	Reinforcement part	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.

## INSPECTION

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. Remove asphalt base undercoating (Gravel Guard 3M) and any rust present near the risk or affected area, the risk areas are the joints between axle arch and sub-assemblies (refer to figure 1).
3. Check if tag axle is cracked, check if cracks are superficial by grinding the affected area to make the cracks disappear. If cracks are only superficial, chip off or grind to bare metal then reweld crack referring to paragraph: **Steel – Steel Welding**. Weld reinforcement parts referring to figure 1 welding specifications

**Caution:** If cracks are not superficial and go trough material, replace tag axle with new axle. Contact your nearest Prévost service center or your regional service manager for the authorization.

4. If no cracks are present on tag axle, weld reinforcement parts referring to figure 1 welding specifications.

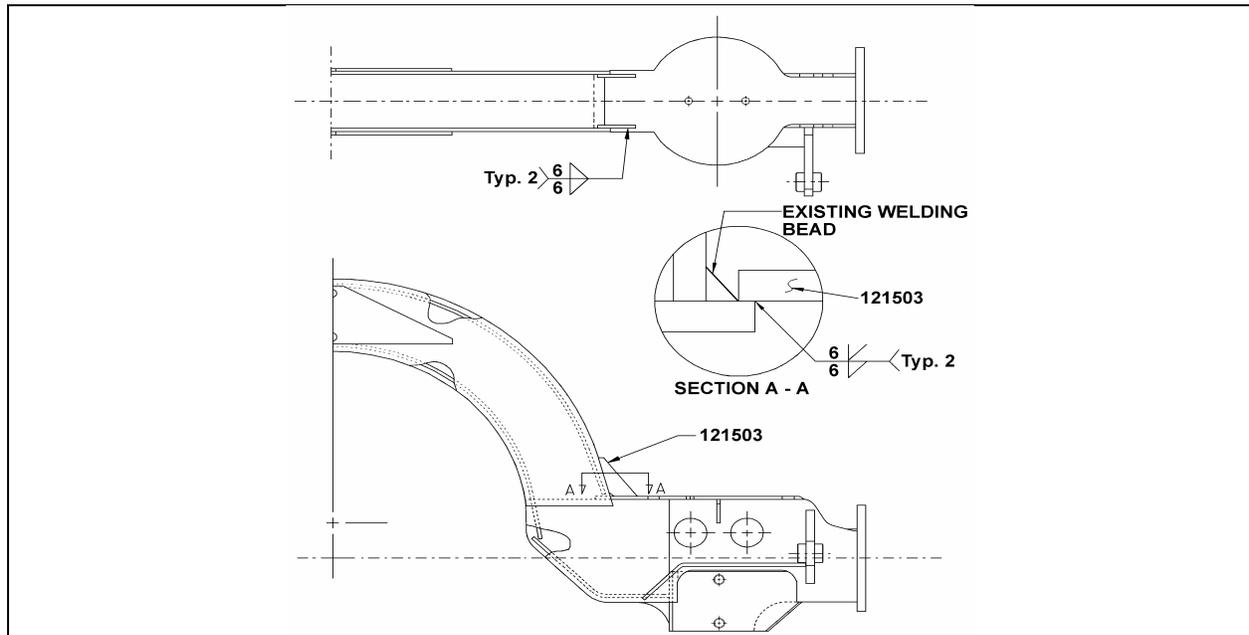


FIGURE 1

- When base metal temperature is below 32 °F (0 °C), base metal must be preheated to at least 50 °F (10 °C) and this temperature must be maintained for the whole welding process. It is therefore preferable to leave the vehicle to repair in a heated area for about half a day or heat tag axle until it reaches 50 °F (10 °C) minimum. You can also circulate warm air around tag axle using a fan.

**Caution:** Do not heat over 150 °F (100°C).

## REINFORCEMENT PARTS INSTALLATION

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

- Protective shields must be placed in order to protect components against heat, welding flash, welding arc and other elements associated with welding.
- Always wear the appropriate safety equipment.
- Weld in clean and well-ventilated area, and always have an appropriate fire extinguisher within your reach.
- 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.
- Weld reinforcement parts as per figure 1 and refer to welding specifications indicated in paragraph: **Steel – Steel Welding:**

## 2<sup>nd</sup> PART

Model	VIN
H3-41 & H3-45 Coaches Model Year: 1994 - 2001	From 2P9H33495R <u>1001012</u> up to 2PCH334971 <u>1014181</u> incl.

## MATERIAL

Part No	Description	Qty
121586	Reinforcement part	2
121587	Reinforcement part	2
121588	Reinforcement part	2

**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.*

## INSPECTION

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. Remove asphalt base undercoating (Gravel Guard 3M) and any rust present near the risk or affected area, the risk areas are located on sub-assemblies and indicated in figure 2.
3. Check if tag axle is cracked, check if cracks are superficial by grinding the affected area to make the cracks disappear. If cracks are only superficial, chip off or grind to bare metal then reweld crack referring to paragraph: **Steel – Steel Welding**. Weld reinforcement parts referring to figure 3 welding specifications

**Caution:** *If crack on sub-assembly goes trough the reinforcement and reaches vertical zone, replace with new axle. Contact your nearest Prévost service center or your regional service manager for the authorization. If crack does not go trough the reinforcement, install extra reinforcement parts after having rewelded the crack according to procedure hereafter.*

4. If no cracks are present on tag axle, weld reinforcement parts referring to figure 3 welding specifications.
5. When base metal temperature is below 32 ?F (0 ?C), base metal must be preheated to at least 50 ?F (10 ?C) and this temperature must be maintained for the whole welding process. It is therefore preferable to leave the vehicle to repair in a heated area for about half a day or heat tag axle until it reaches 50 ?F (10 ?C) minimum. You can also circulate warm air around tag axle using a fan.

**Caution:** *Do not heat over 150 ?F (100?C).*

## REINFORCEMENT PARTS INSTALLATION

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

1. Protective shields must be placed in order to protect components against heat, welding flash, welding arc and other elements associated with welding.
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-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.
5. Weld reinforcement parts as per figure 3 and refer to following welding specifications:

## WELDING SEQUENCE

In order to allow better heat dispersion and to control deformation due to welding, it is important to follow the following steps :

- ? Install and spot weld reinforcement parts # 121586, 121587 and 121588 as per figure 3;
- ? (1) Weld top of reinforcement part #121588 (horizontal);
- ? (2) Weld under reinforcement parts # 121586 and 121587 (overhead);
- ? (3) Weld under reinforcement part #121588 (overhead);
- ? (4) Weld top of reinforcement parts #121586 and 121587 (horizontal);
- ? Allow welding to cool, then remove slag and grind arc spots. Check quality of welding. Repaint reinforcement parts and axle. Apply asphalt base undercoating (Gravel Guard 3M).

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

- ✘ FCAW (Flux Core Arc Welding) process ;
- ✘ Electrode wire conforms to A5.20 AWS (American Welding Standards) specifications ;
- ✘ E4801T-9-CH, E71T-1 or E71T-9 type electrode wire with 0,045" diameter (1,14 mm) ;
- ✘ Current : 260 amperes ;
- ✘ Voltage :  $26 \pm 1$  volts ;
- ✘ Wire feed rate : 430 ipm. (approximately) ;
- ✘ Feed speed : 12 ipm ;
- ✘ Shielding gas : 75% argon - 25% CO<sub>2</sub> or 100% CO<sub>2</sub>.

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 (Shield Metal-Arc Welding) process ;
- ✘ Welding rod conforms to A5.1 of AWS (American Welding Standards) specifications ;
- ✘ E 7018 type welding rod with 3/32" diameter (2,4 mm) ;
- ✘ Current: horizontal - 50 amperes to 100 amperes (optimized at 85 amperes).
  - up - 50 amperes to 100 amperes (optimized at 85 amperes).
  - overhead - 50 amperes to 100 amperes (optimized at 85 amperes).

6. Reconnect components mentioned at step 4.
7. Install wheels and lower tag axle.

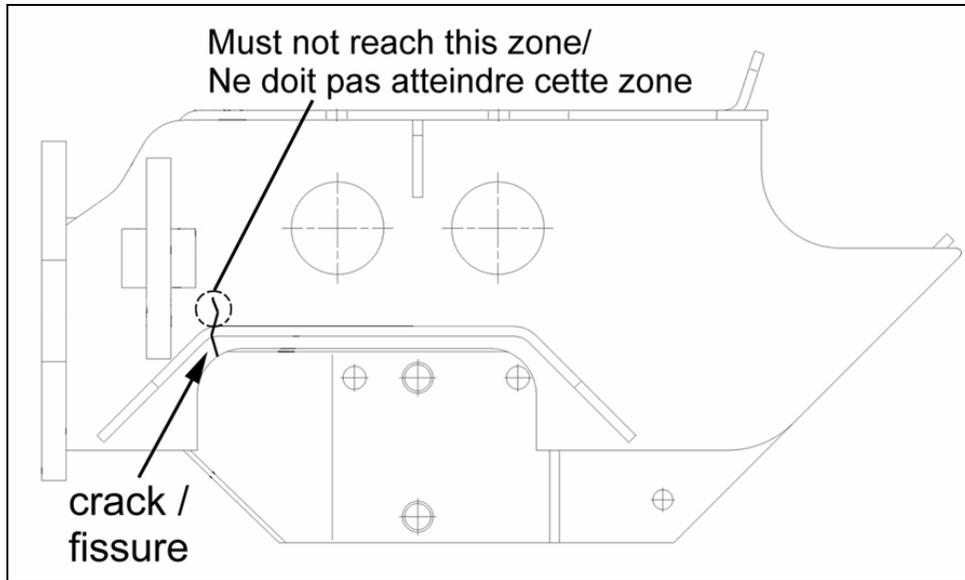


FIGURE 2

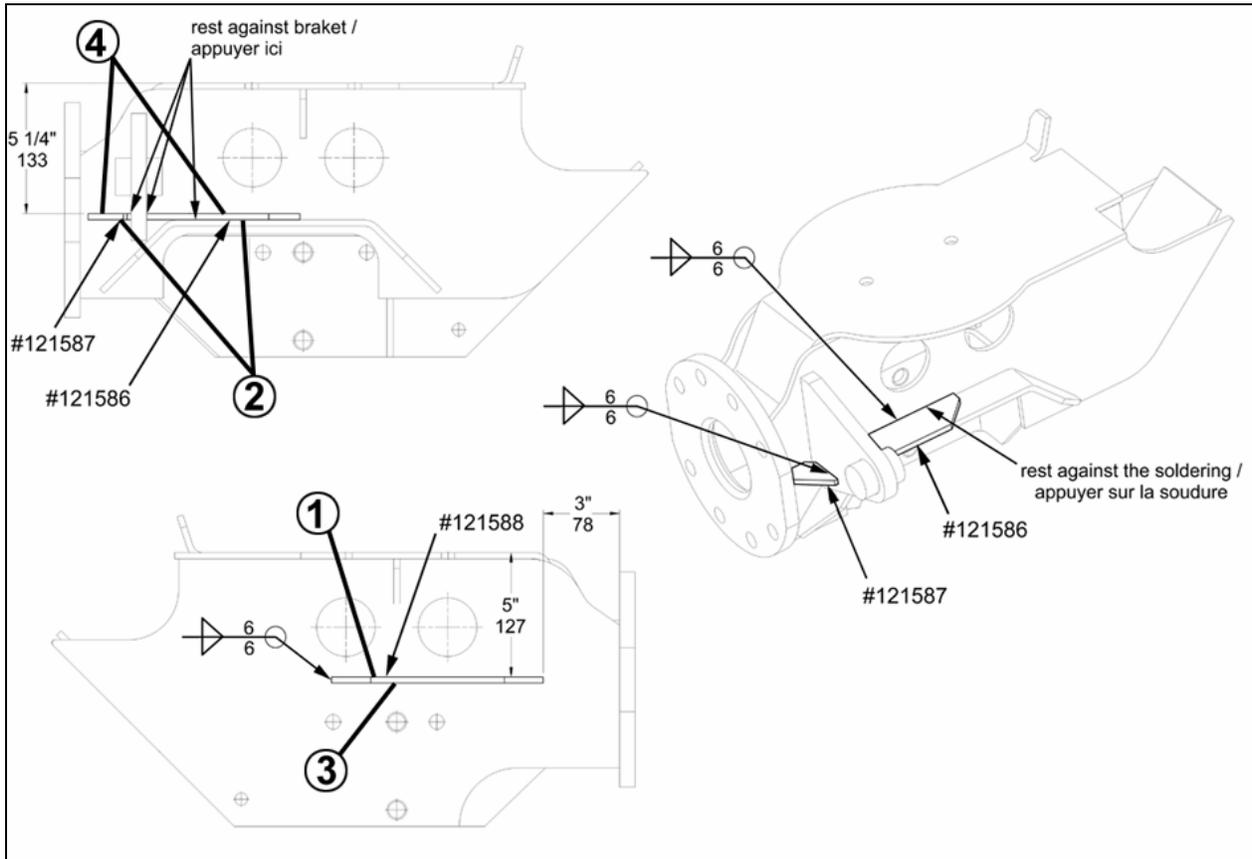


FIGURE 3

## WARRANTY

This modification is covered by Prévost Car's normal warranty. We will reimburse you the parts and two and one half hours (2.5) of labour upon receipt of a completed A.F.A. form on which you must specify as per "Safety Recall 00-37".



**PREVOST**

**Safety Recall  
Certification Sheet  
(Ref: Sr00-37A)**

ENREGISTRÉ - REGISTERED  
**ISO 9001 & ISO 14001**



**SERIAL NUMBER:** \_\_\_\_\_

PERFORMED BY		OWNER/OPERATOR	
We hereby certify that Safety Recall Instructions with regards to Safety Recall #00-37A 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:** \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

**TELEPHONE:** \_\_\_\_\_ **FAX:** \_\_\_\_\_

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