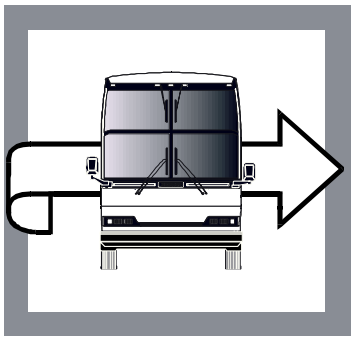

PREVOST

ENREGISTRÉ - REGISTERED
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PREVOST

WARRANTY BULLETIN

Wb04-03

DATE : FEBRUARY 2004	**SECTION : 16 - Suspension**
EXPIRATION: FEBRUARY 2006	
SUBJECT : ADDITION OF STOPS ON TAG AXLE	

APPLICATION

Model	VIN
H3-41, H3-45 Coaches Model Year: 1994 - 2001	From 2P9H33495R1001012 up to 2PCH33493110 14209 incl.
H3-45 VIP Model Year: 1995 - 2001	From 2P9V33494S1001057 up to 2PCV33496110 14207 incl.

DESCRIPTION

On the above-mentioned vehicles, it is necessary to install a stop on each tag axle side in order to prevent the shock absorber from being stuck between the air spring support plate and tire in case the shock absorber pin attachment suddenly fails.

MATERIAL

Part No.	Description	Qty
121637	Stop	2

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.*

PRECAUTIONS TO BE OBSERVED BEFORE WELDING

Caution: *Cut off battery power in main power compartment using battery safety switch.*

1. Disconnect *"Ground"* cables from battery terminals.

Note: *Disconnect "Ground" cables only.*

2. Disconnect all electronic control modules (radio & control head, HVAC, TTLT cluster Volvo). You must also disconnect alternator module located in front service compartment or in main power compartment on H3 vehicles.

3. Disconnect three wiring harness connectors from ECM (Electronic Control Module). The ECM is mounted on the starter side of the engine.

4. For vehicles equipped with an Allison or ZF-Astronic automatic transmission, disconnect three wiring harness connectors from ECU (Electronic Control Unit). The ECU is located in front service compartment or in main power compartment on H3 vehicles.

5. For vehicles equipped with WCL system, disconnect electronic controller connector.

6. 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 front service compartment.

7. Cover electronic control components and wiring to protect from hot sparks, etc.

8. Do not connect ground clamps to electronic control components.

Warning: *Ensure to safely support the vehicle 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.*

9. Support tag axle using two jack stands then open purge valve to remove the air from the system and in doing so lower the tag axle and spread the air springs.

10. Remove asphalt base undercoating (Gravel Guard 3M) and any rust present near the welding area.

Caution: *Position welding machine ground clamp as close as possible to the work.*

11. Install stops (121637) referring to welding specifications indicated in figure 1.

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.*

1. Do the appropriate welding on vehicle referring to figures 1 and 2 welding specifications.

- 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) ;

Material Thickness	Voltage	Current	Wire Feed Rate	Shielding Gas
1/8" to ½"	26 ± 2 volts	260 Amps	450 ipm. approx.	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).
- Current: 100 amperes to 150 amperes; optimum at 120 amps.

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

2. When welding is complete, reconnect ECM, automatic transmission and ABS electronic control units, etc.
3. Terminate by reconnecting *"Ground"* cables to battery terminals.
4. Once the welding beads are cold, sand blast or apply some lacquer thinner before applying a coat of primer onto the welding beads and onto both sides of parts.

Note: *Sand blasting the welding beads and parts is preferable.*

5. Then, apply an asphalt base undercoating (Gravel Guard 3M) onto both sides of parts.

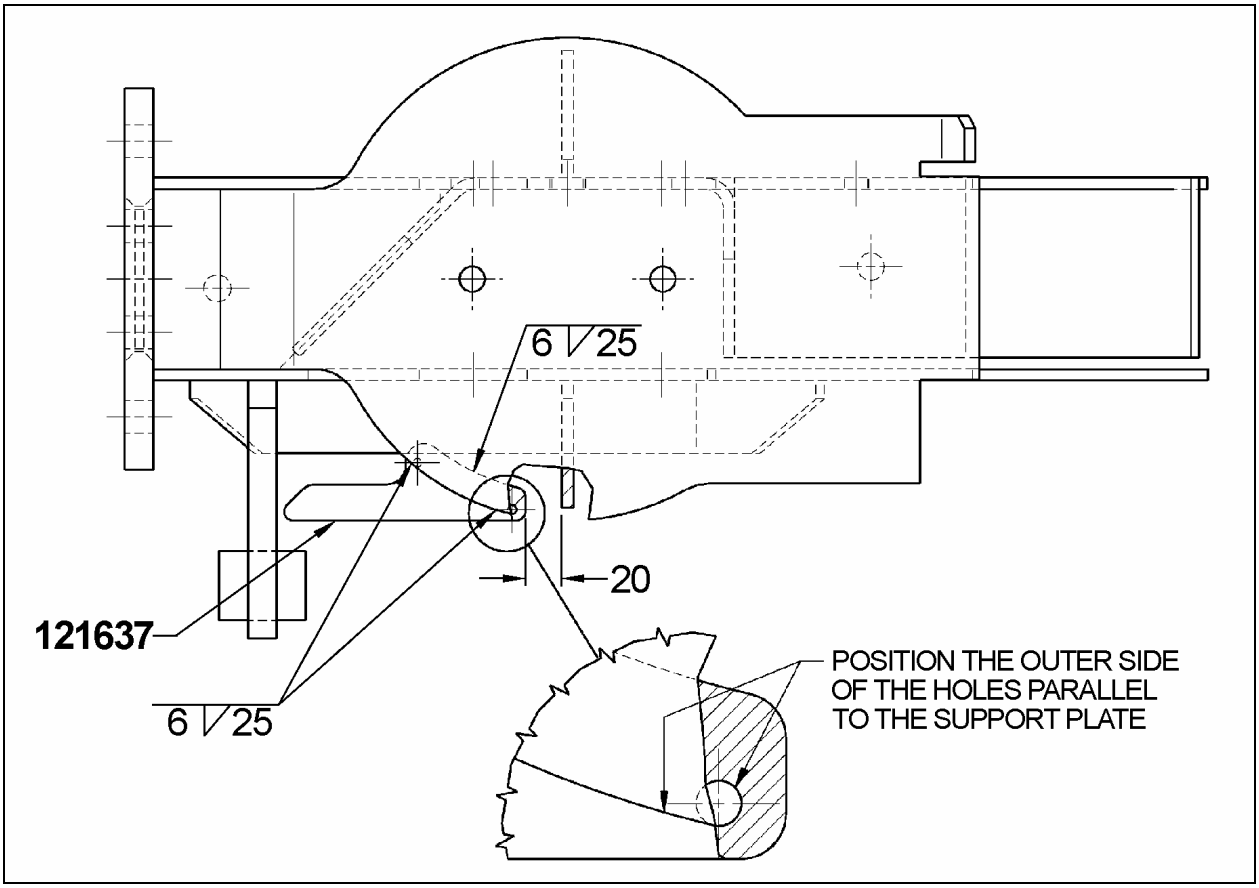

FIGURE 1

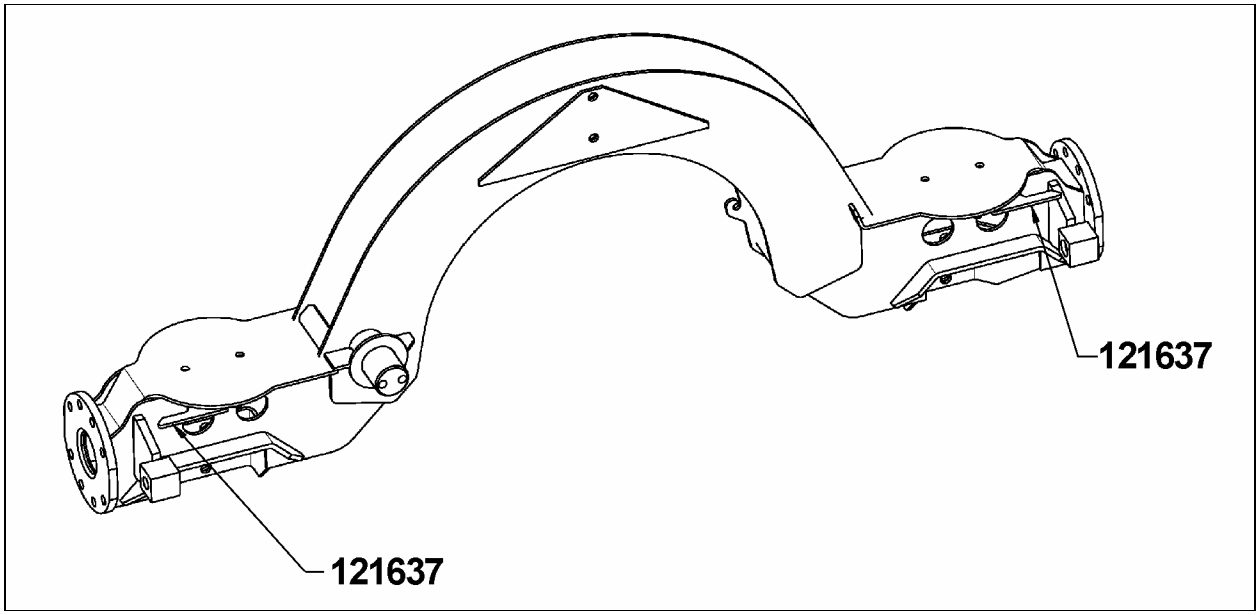

FIGURE 2

WARRANTY

This modification is covered by Prévost Car'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 04-03".

Parts / Waste disposal:

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