

PREVOST

ENREGISTRÉ - REGISTERED
ISO 9001 & ISO 14001




**WARRANTY
BULLETIN**

Wb11-15A

DATE : MAY 2011	SECTION : 18 - Body
EXPIRATION: MAY 2013	
SUBJECT : DIESEL PARTICULATE FILTER (DPF) ACCESS DOOR AIR GRILLE BONDING VERIFICATION	

REVISION : A THIS WARRANTY BULLETIN SUPERSEDES PREVIOUS VERSION.
Text modified, SCR changed for DPF. The DPF access door is involved, not the SCR door.
Involved vehicles do not have SCR system.

APPLICATION

Model effected	Vehicle affected	
H3-45 Coaches Model Year : 2010	2PCH33492AC71 <u>1682</u>	2PCH33491AC71 <u>1687</u>
	2PCH33496AC71 <u>1684</u>	2PCH33495AC71 <u>1689</u>
	2PCH3349XAC71 <u>1686</u>	2PCH33495AC71 <u>1692</u>
X3-45 Coaches Model Year : 2010	2PCG33496AC72 <u>9968</u>	2PCG33493AC72 <u>9975</u>
	2PCG33498AC72 <u>9969</u>	2PCG33495AC72 <u>9976</u>
	2PCG33494AC72 <u>9970</u>	2PCG33497AC72 <u>9977</u>
	2PCG33491AC72 <u>9974</u>	
XLII-45 Entertainer's Model Year : 2011	2PCY33491BC72 <u>9978</u>	

DESCRIPTION

On the vehicles affected by this bulletin, it is necessary to check for proper bonding strength of the DPF access door air grille.

If the air grille bonding is not up to standard, a repair will be necessary.

You can proceed to the inspection of the air grille in order to determine if a repair is needed as described in Part 1. The gluing process, the required products and the adhesive application tooling are very specific, for this reason, you must make an appointment to a Prevost Service Center to have the air grille properly secured if required.

PROCEDURE



DANGER

Park vehicle safely, apply parking brake, stop engine and set battery master switch(es) to the OFF position prior to working on the vehicle.

PART 1 INSPECTION

1. Open the DPF access door.
2. Look for the apparent adhesive bead on the back of the air grille. Use the following criteria to validate for proper bond strength:
 - Validate that the adhesive bead color is gray. If the adhesive bead is black, the bonding is not acceptable.
 - Validate that the adhesive has hardened or cured. A soft adhesive bead indicates a lack of activator at time of assembly or the wrong type of adhesive was used. In this case, the bonding is not acceptable.
 - Check that the bonding between the parts is hard, rigid and strong. If the adhesive bead is flexible, deformable and weak, the bonding is not acceptable.



ON THE PICTURES ABOVE, INSERTING A SCREWDRIVER SHOWS WEAK BONDING (protect surrounding painted surface)

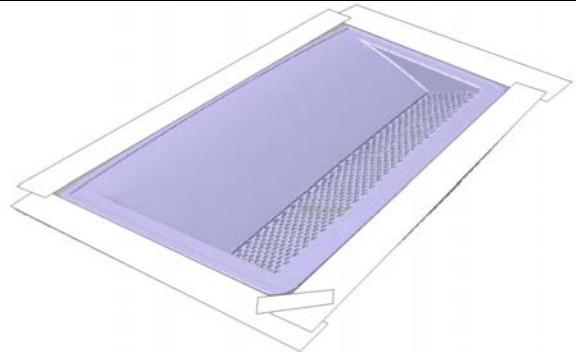
3. If the bonding is not acceptable, make an appointment in one of Prevost Service Centers in order to have the air grille corrected. If the air grille can easily be separated from the door, please do so. Otherwise, remove the entire access door.

PART 2 REPAIR - PREPARATION AND GLUING

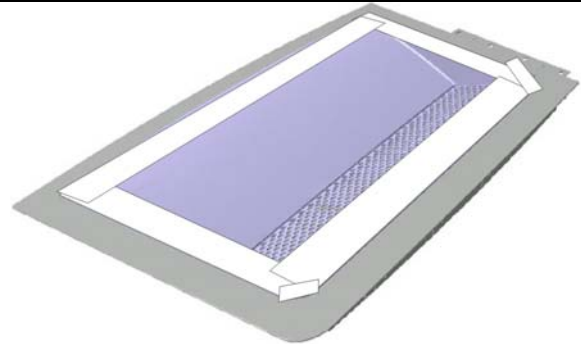
Adhesive and preparation products:

Part No	Description	Qty	
682989	SILICONE REMOVER 5L	bulk	
506769	DOUBLE-FACE ADHESIVE TAPE 1/8" x1/4" x 60'	10 ft	
680226	PAD, SCOTCH-BRITE 7446 6" x 9" GRAY	1	
683919	TWO-PART ADHESIVE MIXER	1	
687955	PRIMER, PC120 PLEXUS, 944 ML	In USA, please get supplies from: ITW Plexus USA 30 Endicott Street Danvers, MA 01923 tel. 978-777-1100 www.plexus.com	as required
687956	TWO-PART ADHESIVE, PLEXUS MA530, 400ml		as required

1. Before removal of the air grille, protect the surrounding painted area using masking tape. Place masking tape so it will help you, as a guide, to properly reposition the air grille at time of installation.



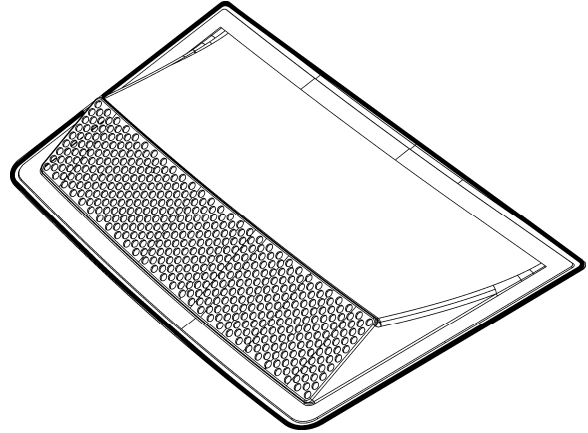
2. Using making tape, protect the painted surface of the air grille.



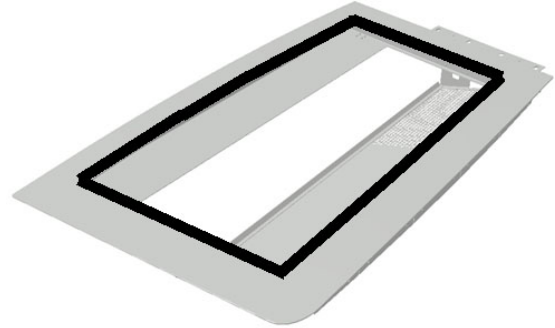
3. Carefully remove the air grille. Take care not to damage it as it will be reuse (suggested tools: air hammer chisel (zip), knife, wire saw).
4. Scrape old adhesive and remove all tape residue. For best results, prepare surface so the fiber glass will be exposed.
5. Clean off dirt, dust of grease from surface where adhesive will be applied using silicone remover (p/n 682989) or isopropyl alcohol. Do not clean with a back and forth movement. Allow enough time to dry.



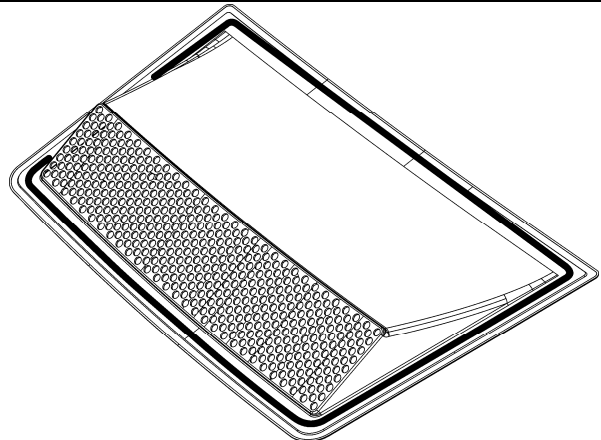
6. Apply 1/8X1/4 double-face adhesive tape around the air grille at about 1/8 inch from the edge.



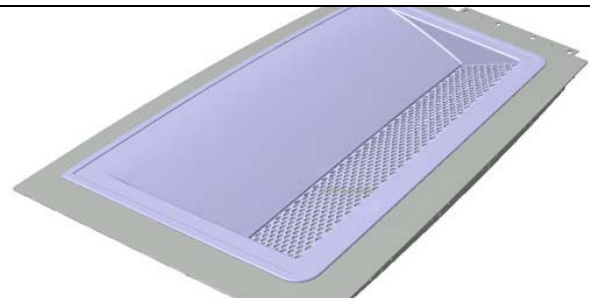
7. Remove all residue of old adhesive and tape on the door. Use sand paper if required.
8. Clean with silicone remover or isopropyl alcohol.
9. To assure best adhesion, rub door surface where adhesive will be applied using a gray Scotch-Brite pad (p/n 680226).
10. Clean with silicone remover or isopropyl alcohol once again
11. If the primer coat has peeled or chipped, apply Plexus PC120 (p/n 687955) primer locally.



12. Use only methacrylate Plexus MA530 adhesive (p/n 687956). Plexus MA530 is a 1:1 ratio, i.e. one part of adhesive for one part of activator.
13. In order to assure proper adhesive curing, it is mandatory to use mixer nuzzle #683919. **Do not use any other type of mixer.**
14. Apply adhesive bead at 1/2 inch from the tape. The bead size must be about 1/4"-5/16" (cut mixer nuzzle at 2nd mark).
15. Remove the double-face adhesive tape protective paper.



16. Place air grille on the door and press firmly. Allow at least one hour (1 hr) for curing time.
17. Reinstall DPF access door.



WARRANTY

The inspection and repair are covered by Prevest's normal warranty.

We will reimburse you 15 minutes (0.25h) of labor **for the inspection** upon receipt of a completed A.F.A. form on which you must specify as per "Warranty Bulletin 11-15".

The working time required to perform the repair is approximately 2 1/2 hours (plus 1 hour for curing time). As a matter of normal service process, your Prevest Service Center or Prevest Certified Service Providers will also check for other repair measures which might be applicable to your vehicle and this may increase the required working time.

Please contact your Prevest Service Center or your Prevest Certified Service Providers for additional information and to schedule an appointment at your earliest convenience. Please mention WB11-15.

Fail Code	18-05
Defect Code	84
System Condition	B
Causal Part	478288