

PREVOST

Instruction Sheet

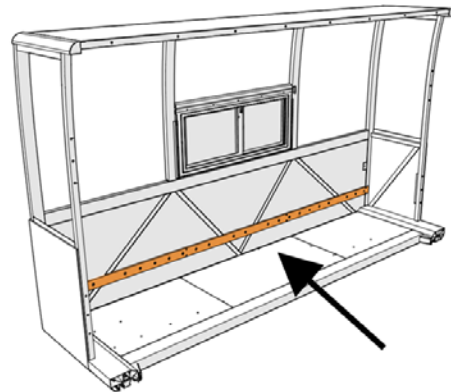
IS-18078

ENTERTAINER STRUCTURE REINFORCEMENT


This instruction sheet shows how to install reinforcement for seat belts in the front slide-out.

APPLICATION

Model	VIN
X3-45 Entertainer Model Year : 2019	From 2PCCS3490 <u>KC736367</u>



DISCONNECTION PROCEDURE PRIOR TO WELDING (NEA)

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

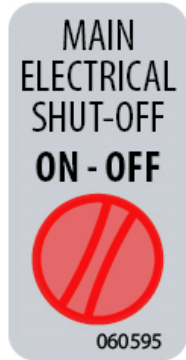
Disconnection prior to welding

PRECAUTIONS TO BE OBSERVED BEFORE ARC WELDING TO MINIMIZE THE RISK OF MAJOR AND COSTLY DAMAGES CAUSED TO THE VEHICLE ELECTRONIC COMPONENTS.

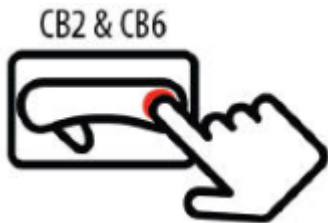


1. Turn the ignition switch to the OFF position.

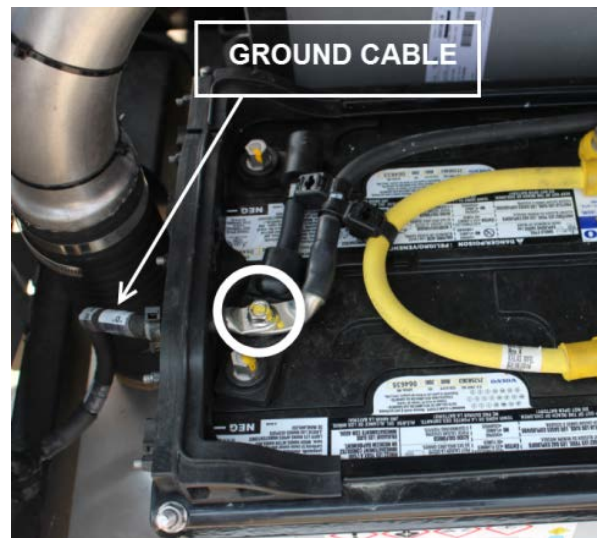
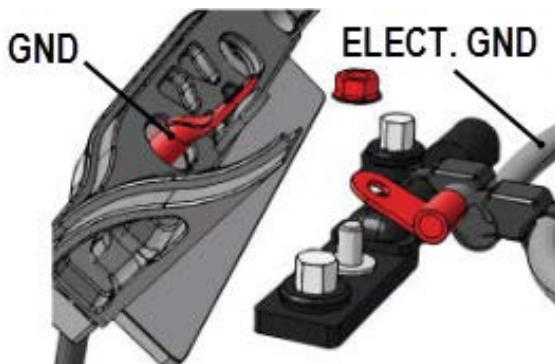
2. Set the main electrical shutoff switch to the OFF position.



3. Trip circuit breakers CB2 & CB6.



4. Disconnect the chassis ground cable "00" (GND) from the appropriate battery post (figure on your right).



CAUTION

Position welding machine ground clamp as close as possible to the work. Ensure that the welding machine ground return clamp is well secured and makes a good electrical contact with a large metallic area of the chassis located as close as possible to the welding point.

5. Once the welding works completed, perform the previous steps in reverse order. Torque the ground cable nut according to specifications found in Section 06 Electrical.

PROCEDURE



DANGER

Park vehicle safely, apply parking brake, stop the engine. Prior to working on the vehicle, set the ignition switch to the OFF position and trip the main circuit breakers equipped with a trip button.

MATERIAL

Part No.	Description	Qty
478687	REINFORCEMENT TUBING ASSEMBLY	1
360064	SIDE WALL RAIL	1
850090	MEMBRANE MBT WE (ROLL)	1
5000347	SCR CAP HEXS G500 M12X1.75X25 CL12.9	22
500967	WSH BEL SPR N500 .512X1.142X.098(M12,1/2	22
685126	SIMSON 70-03 SEALANT 600 ML	2

Other parts that may be required:

Part No.	Description	Qty
684196	RED GLUE FOR MEMBRANE	AS REQ.
680257	ALUMINUM TAPE	AS REQ.

NOTE

Material can be obtained through regular channels.

1. Park the vehicle with truck wheel blocks.

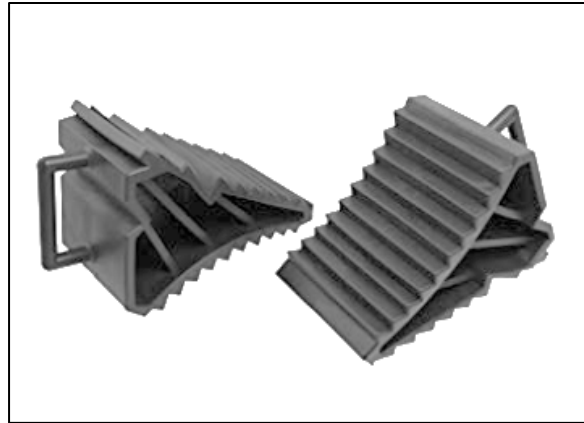


FIGURE 1

2. Apply the disconnection procedure shown at the beginning of this instruction sheet prior welding.
3. Extend the slide-out completely.
4. Gently remove the membrane covering the lower side walls and the lower center wall and avoid breaking the insulation panels behind.

IMPORTANT NOTE

There are isolation panels and aluminum structure behind the membrane. The panels are to be removed and preserved for reinstallation. The membrane as a sticky side in contact with the isolation panels and glue was applied for the contact with the aluminum structure. Remove the membrane gently to avoid breaking the panels.

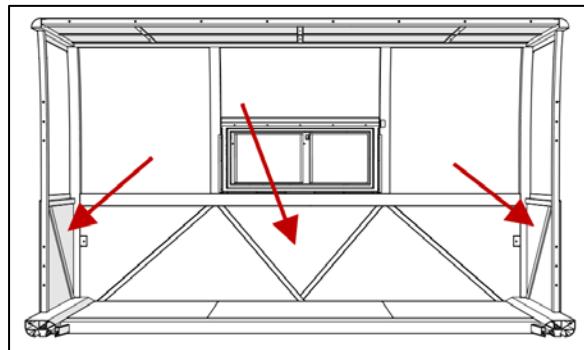


FIGURE 2

5. Discard the old membrane.

6. Remove gently both isolation panels on the right lower wall of the slide-out
7. Keep the panels in a safe place.

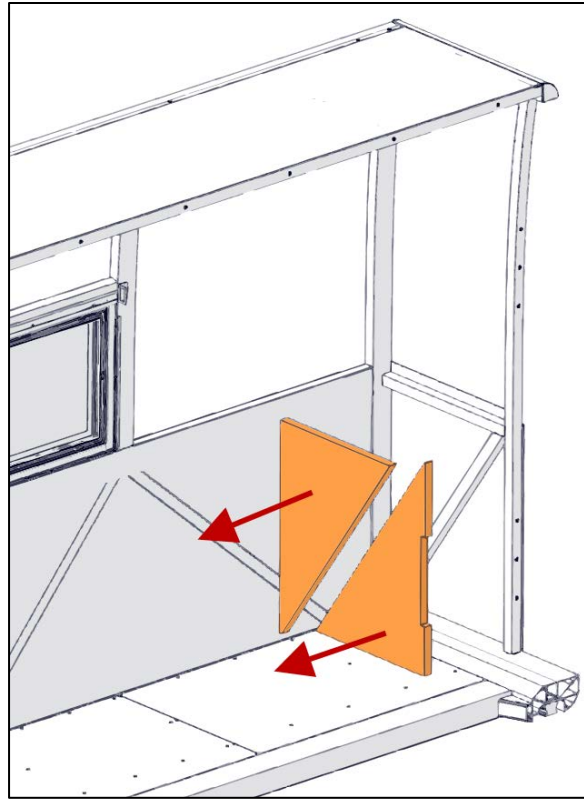


FIGURE 3

8. Remove gently both isolation panels on the left lower wall of the slide-out
9. Keep the panels in a safe place.

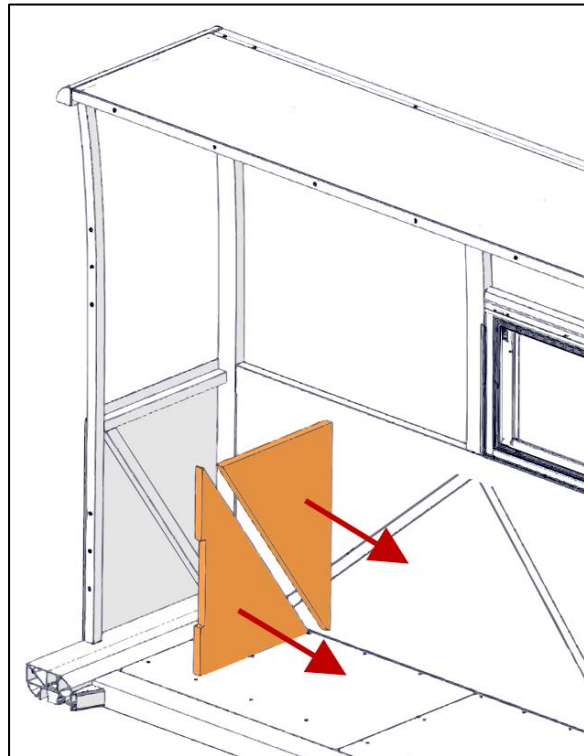


FIGURE 4

10. On the left side of the lower center wall, mark a horizontal line on the insulation panel of 310 mm high from the slide-out floor.
11. Extend this cutting line up to the last insulation panel on the right side of the lower center wall.

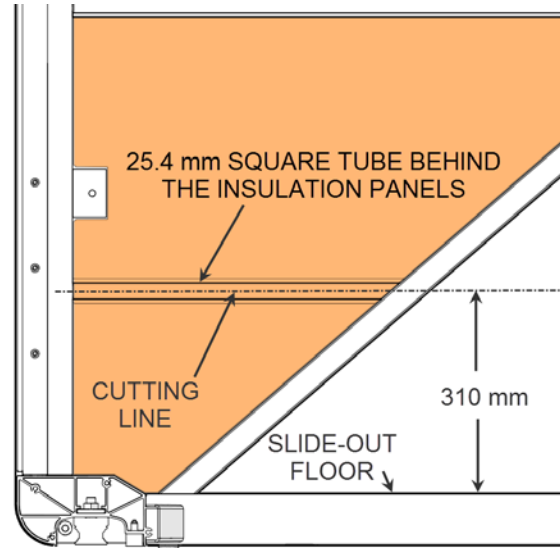


FIGURE 5

12. Make two spacer blocks at 135 mm high.

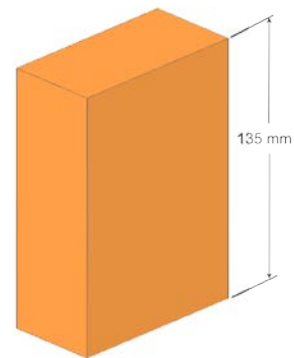


FIGURE 6

13. Make one spacer block at 163.4 mm high.

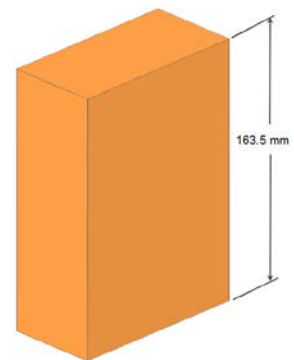


FIGURE 7

14. Install reinforcement tubing on the center wall structure. Adjust the vertical position of the tubing with a 135 mm high spacer block at both ends and a 163.4 mm high spacer block in the middle.
15. Make sure the 135 mm high spacer blocks stand on the aluminum slide-out structure and not on the wooden floor.

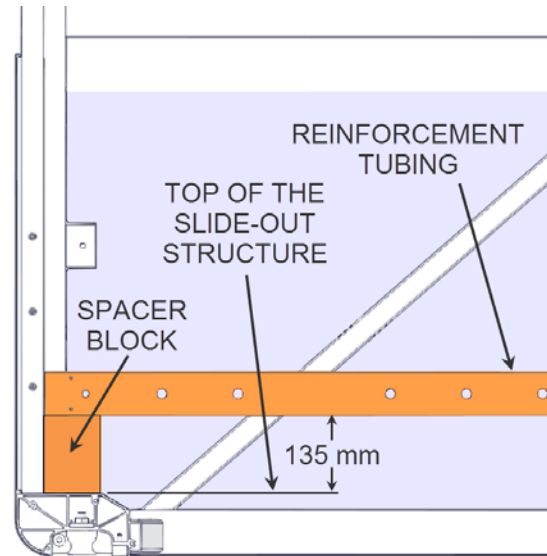


FIGURE 8

16. Mark a line on all insulation panels using the top of the reinforcement tubing as reference.
17. Mark a line on all insulation panels using the bottom of the reinforcement tubing as reference.

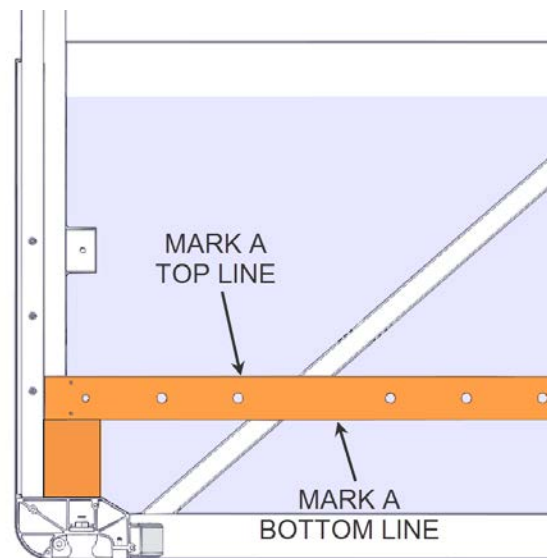


FIGURE 9

18. On each insulation panel, write down marks to each section (A to E) as shown in Figure 10.

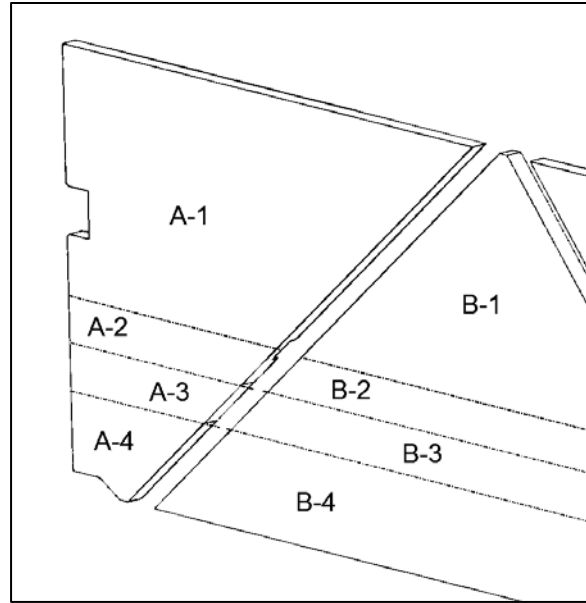


FIGURE 10

19. Use a professional cutter and cut all sections of the insulation panels following the cutting lines. Set the blade to 25 mm out of the blade holder.



20. Remove all insulation panel sections and keep in a safe place.

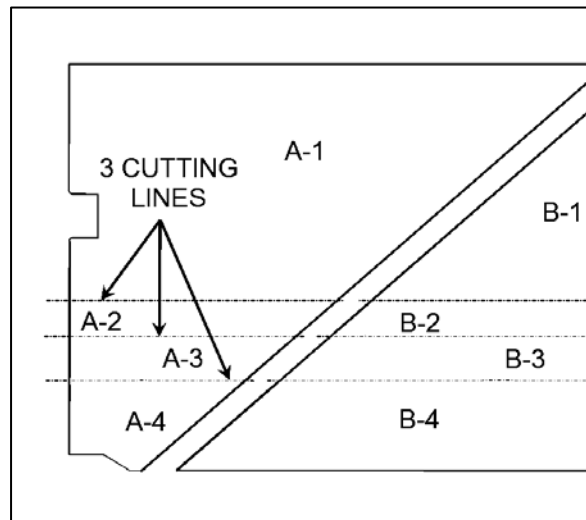


FIGURE 11

21. With the professional cutter, remove all the old membrane bottom sealant on the slide-out floor.



FIGURE 12

22. Prepare a mini air polisher with a new sand paper.

IMPORTANT NOTE

The polisher is to be used to clean the glue on the existing aluminum structure to prepare the welding areas. It is important to use a new sand paper to avoid contamination of the aluminum.



FIGURE 13

23. Install the reinforcement tubing with the spacer blocks. Make sure the 135 mm high spacer blocks stand on the aluminum slide-out structure and not on the wooden floor.
24. On the left-hand side of the lower center wall, use air polisher to clean old glue on the existing aluminum structure (pole). Clear a minimum of 50 mm all around the reinforcement tubing future welding area.

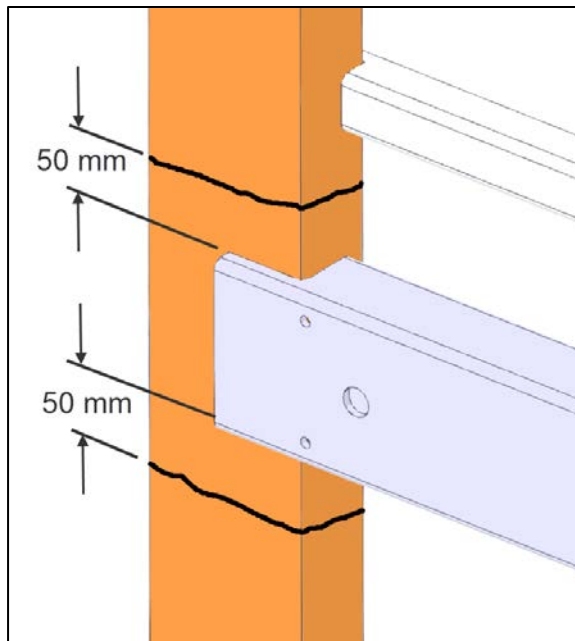


FIGURE 14

25. Repeat previous steps for all the diagonal square existing tubing and the existing pole on the right hand.

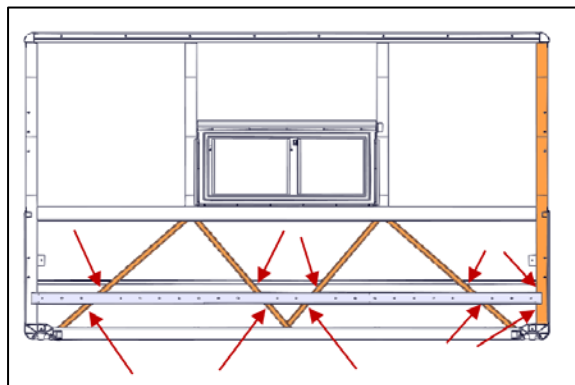


FIGURE 15

26. With a new sand paper grind the reinforcement tubing at each weld location over and under to remove the natural aluminum oxide layer protector.

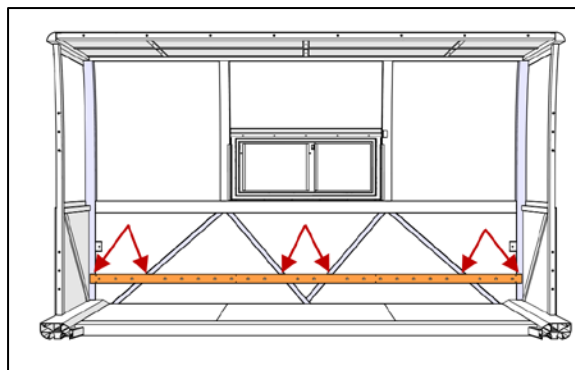


FIGURE 16

27. Prepare the material for TIG process welding.
28. Because of a lack of clearance when welding under the reinforcement tubing, make the back cap of the welding handle shorter as shown in Figure 18. Use a rubber cap and black tape to close the back cap. If available, use specific equipment according to your TIG torch.



FIGURE 17



FIGURE 18

29. Prepare twelve aluminum ER 5356 filler rods with a diameter of 3/32".



FIGURE 19

30. Install an extra 5-pound fire extinguisher ready to use, inside the vehicle. Do not use fire extinguishers supplied with the vehicle.



FIGURE 20

31. Cover the whole slide-out wooden floor with a fire retardant blanket.

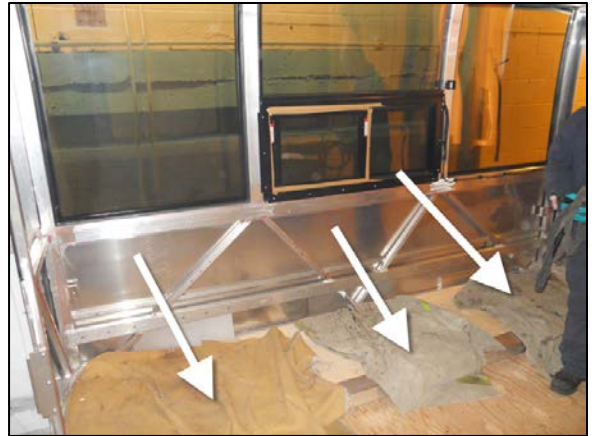


FIGURE 21

32. Fit and install sheet metal parts behind all the future welding areas to protect the external panel of the slide-out from overheating.



FIGURE 22

33. Prepare a garden hose with a gun to supply fresh water for the cooling of the slide-out wall from the outside when welding.

 **CAUTION**

Slide-out external panel may curve if overheated. Make sure to always keep the temperature of the external panel down.

Keep spraying fresh water on the external wall of the slide-out for all welding steps.



FIGURE 23

 **CAUTION**

When welding, touch the external panel with a hand to check the temperature. If the temperature increases ask the welder to stop welding a while and keep spraying fresh water.



FIGURE 24

 **CAUTION**

Apply the disconnection procedure shown at the beginning of this instruction sheet prior welding.

34. Install the reinforcement tubing on the structure with the 135 mm high spacer blocks at both ends. Make sure the 135 mm high spacer blocks stand on the aluminum slide-out structure and not on the wooden floor.
35. Install a 163.4 mm high spacer block under the reinforcement tubing in the middle.

 **CAUTION**

Open the entrance door, roof hatches and all windows of the vehicle prior to start welding.

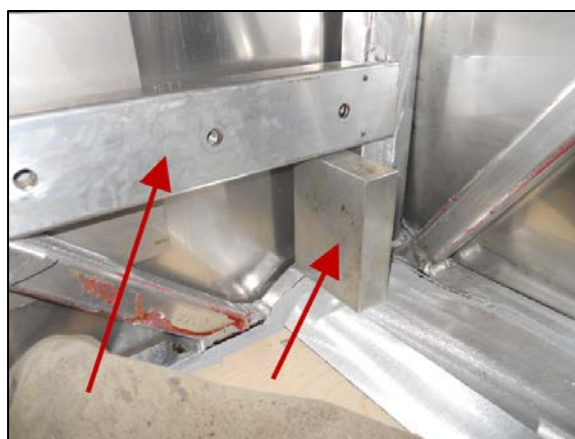


FIGURE 25

36. Prepare to tack weld the reinforcement tubing.
37. Before tacking, push the reinforcement tubing to ensure a good contact with the existing structure.



FIGURE 26

38. Tack weld the top of the reinforcement tubing with a diagonal existing tubing as shown in Figure 27.



FIGURE 27

39. Repeat previous steps with all the existing side poles and all diagonal tubes.

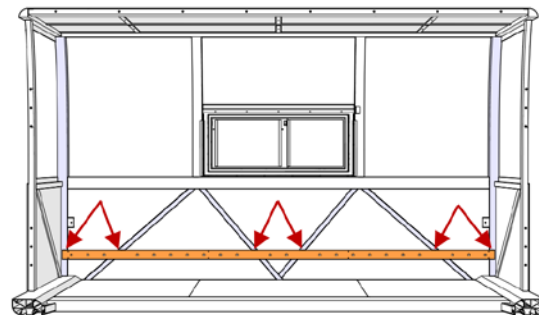


FIGURE 28

40. Start spraying fresh water on the slide-out external wall, both sides.

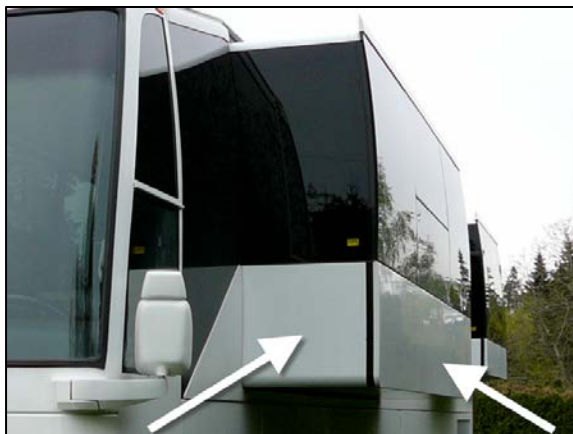


FIGURE 29

41. Follow the typical specification in Figure 30 for all welding.

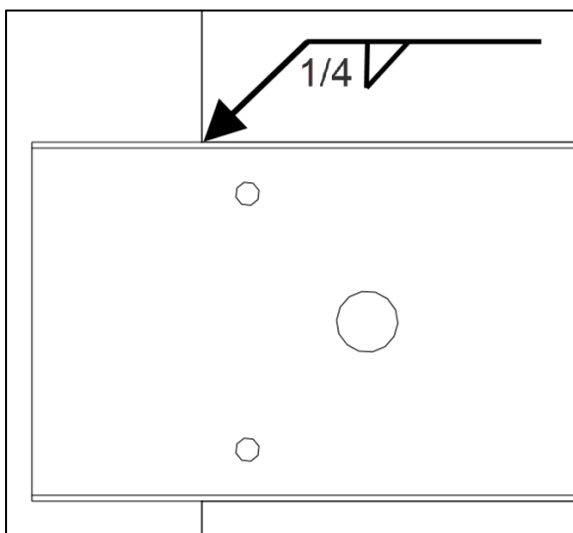


FIGURE 30

42. On the left-hand side of the slide-out, weld two corners at the top of the reinforcement tubing and one corner at the bottom (Figure 31).
43. Stop welding and keep spraying fresh water on the outside at least 2 minutes after the welding has stopped.

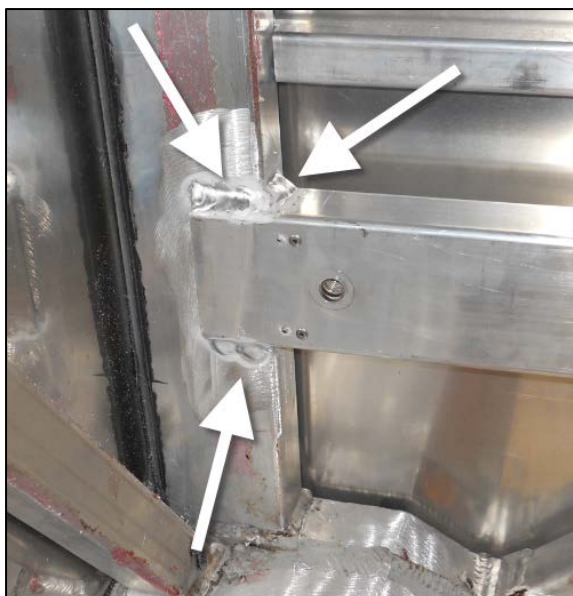


FIGURE 31

44. On the right-hand side of the slide-out, weld two corners at the top of the reinforcement tubing and one corner at the bottom (Figure 32Figure 31).
45. Stop welding and keep spraying fresh water on the outside at least 2 minutes after the welding has stopped.

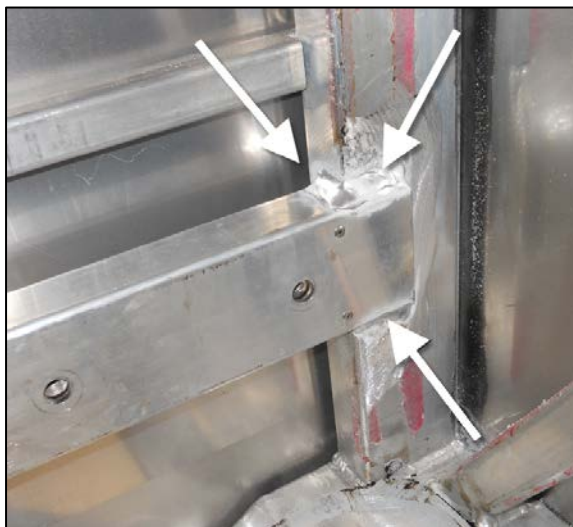


FIGURE 32

46. On a first diagonal tubing, weld three corners at the top of the reinforcement tubing and one corner at the bottom (Figure 33Figure 31).
47. Stop welding and keep spraying fresh water on the outside at least 2 minutes after the welding has stopped.
48. Repeat step 46 and step 47 for all diagonal tubings.



FIGURE 33

49. Make sure that all gaps are completely filled when welding.



FIGURE 34

50. Install all pieces of insulation panels (24) on side walls and center wall.
51. Use aluminum tape to keep the panels in place.

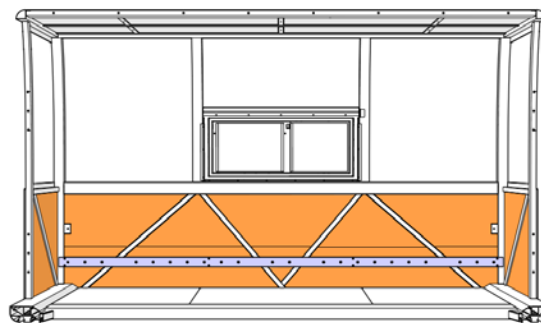


FIGURE 35

52. On both side walls of the slide-out, apply red glue #684196 as shown in Figure 36
53. Apply glue with a small painting roll .

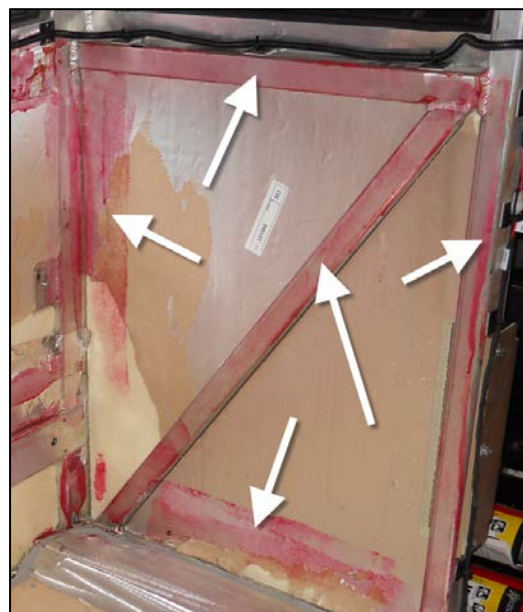


FIGURE 36

54. On center lower wall of the slide-out, apply red glue #684196 as shown in Figure 37.

IMPORTANT NOTE

Do not apply glue on the vertical face of the reinforcement tubing. This surface is a mounting face. Apply glue only on the top and on the bottom of the reinforcement tubing.

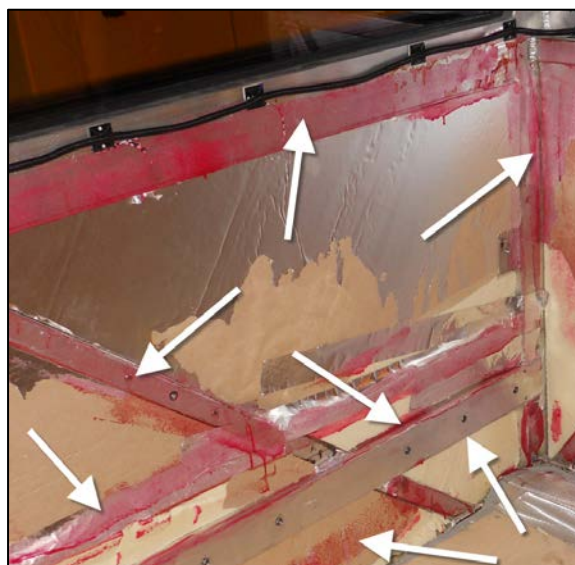


FIGURE 37

- 55. Remove 1000 mm long of the membrane sticky side protection.



FIGURE 38

- 56. Install the membrane on the right-hand side wall.
- 57. Make sure the top of the membrane is flush with the existing structure.



FIGURE 39

- 58. Cut to fit.



FIGURE 40

59. With a professional cutter, remove the excess length of the membrane at the bottom of the wall. A clean corner is necessary at the bottom to apply a sealant.



FIGURE 41

60. Apply 25 mm wide of red glue on the side wall membrane section as shown in Figure 42. The center wall new membrane section overlaps 25 mm on both side wall membrane sections.



FIGURE 42

61. Repeat steps 55 to 60 for the left-hand side wall.



FIGURE 43

62. Install the membrane on the center lower wall of the slide-out. Align the top of the center membrane section with the top of the side wall membrane section.



FIGURE 44

63. Cut the membrane as shown in Figure 45 to clear the whole vertical mounting face of the reinforcement tubing. Make the cutting 10 mm lower than the top of the reinforcement tubing and 10 mm higher the bottom.



FIGURE 45

64. Stick the extra length of the membrane with the top and the bottom of the reinforcement tubing.



FIGURE 46

65. Rub the whole membrane with a wooden block to ensure a good contact of the membrane with the glue.



FIGURE 47

66. Apply a bead of 25 mm wide of sealant #685126 at the bottom of all membrane sections (3).



FIGURE 48

67. Install the rail with the Belleville washers (22) and the socket head screws (22).
68. Torque the screws to a value of 96 lb-ft.
69. Installation is complete for this position.

Allow 6 hours of labor for this position.



FIGURE 49

PARTS / WASTE DISPOSAL

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