



Instructions Sheet

IS-92097

REPLACEMENT OF ENGINE BELT GUARD #01-1512 BY #01-1611

MATERIAL

Part no	Description	Qty
01-1611	Engine belt guard	1
21-2192	Bracket	1
IS-92097	Instruction sheet	1
FI-92097	Feuille d'instructions	1

PROCEDURE

Warning: Park vehicle safely, apply parking brake, stop engine and set battery master switches to the "OFF" position prior to working on the vehicle.

1. Open engine compartment rear door.
2. Disconnect DDEC, ABS, electronically controlled transmission and preheater module connectors (if applicable) in order to protect these systems from voltage surges during welding procedure.
3. Remove the 2 wing nuts and washers retaining engine belt guard then lift and remove belt guard.
4. Remove and keep rubber washer mounted on the belt guard upper R.H. bracket (see fig.1).
5. Grind welding bead retaining belt guard upper R.H. bracket to vertical post, then remove and discard bracket.

Warning: Always wear safety goggles during grinding operations.

Caution: Protect nearby wiring, hoses and other accessories from intense heat and sparks prior to grinding and welding.

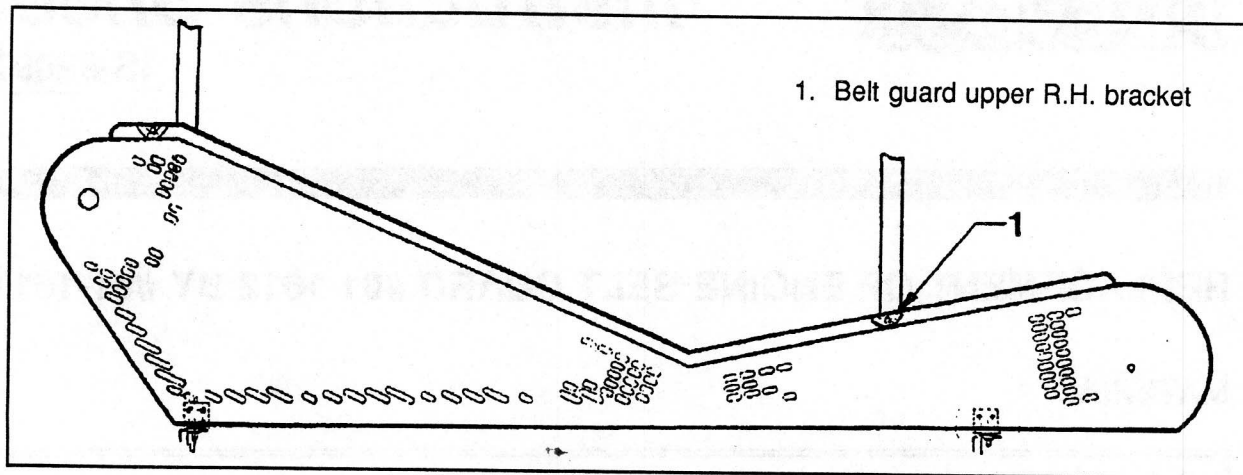


Fig. 1

01001

6. Using locking pliers, seat new bracket (#21-2192) on vertical post as illustrated in figure 2, then weld it with a "MIG" semi-automatic welding machine using the GMAW (gas metal arc welding) process set to the following parameters:

Wire: 308L 0.035" (0,9 mm)

Gas: T-90-H (90% He, 7.5% Ar, 2.5% CO₂)

Voltage: 20 ± 2 volts

Amps: 150

IPM: 260

↑
 Bon, mais équipement non disponible
 sans gauge
 Donc à l'avenir mettre ces paramètres
 ↓

Note: If such an equipment is not available, a conventional electric arc welding machine can be used according to the SMAW (shield metal arc welding) process. In this case, use a 308L-16 1/8" (3,2 mm) diameter welding rod which conforms to AWS (American welding standards) A5.9 specification. Set machine to 90-125 amps.

Warning: Always wear an appropriate safety equipment to perform welding. Remember that welding must be performed by trained personnel only.

7. Allow welding to cool then put the rubber washer (previously removed) on new bracket.

8. Install new belt guard (#01-1611) then fix it using the 2 wing nuts and washers.

9. Reconnect DDEC, ABS, electronically controlled transmission and preheater module connectors (if applicable).

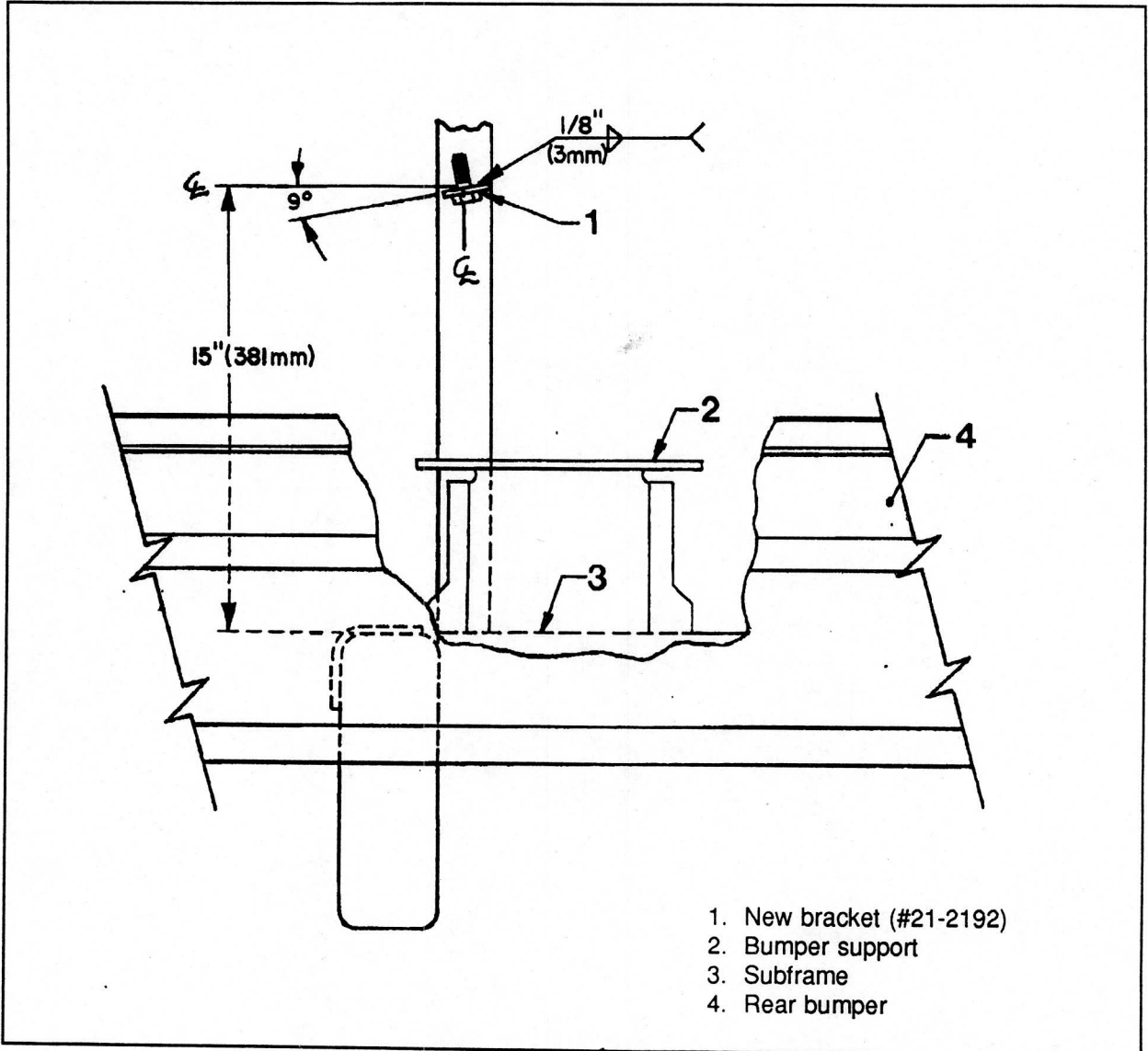


Fig. 2

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