



FMC Corporation
Motor Coach Division
333 Brokaw Road Box 864 Santa Clara California 95052

URGENT

ROUTINE

MANDATORY

INFORMATIONAL

Service Bulletin

DATE 10 February 1975

NUMBER 2907 10005

ATTENTION: SERVICE MANAGER				GROUP															
DESCRIPTION				7															
<p>This bulletin provides instructions for installation of a reinforcement kit on the steering gearbox mount bracket on the coaches listed herein.</p>				SUBJECT INSTALLATION OF REINFORCEMENT KIT FOR STEERING GEARBOX MOUNT BRACKET															
<p>COMPLIANCE</p> <p>Dealers must comply with this bulletin prior to delivery of coach to owner.</p>																			
<p>MANPOWER</p> <p>Estimated accomplishment time for one mechanic is approximately two and one-half hours.</p>				MODEL (S) AFFECTED S-5-08-J-00630 S-5-09-A-00654 S-5-09-A-00655 S-5-10-A-00656 S-5-10-J-00658 S-5-10-J-00659 S-5-10-J-00660 S-5-10-J-00663 S-5-10-E-00664 S-5-10-A-00665 S-5-10-A-00666 S-5-10-J-00667 S-5-10-J-00669 S-5-11-J-00680 S-5-11-J-00682 S-5-11-J-00684 S-5-11-J-00686 S-5-11-J-00688 S-5-12-J-00690 S-5-12-J-00692 S-5-12-J-00694 S-5-12-J-00696															
<p>WARRANTY REIMBURSEMENT</p> <p>FMC Motor Coach Division will allow a maximum of two and one-half labor hours and reimbursement for Kit 5100116-R006 on a properly submitted Warranty Claim (Form RVD 69) for this modification.</p>																			
<p>KIT CONTENTS (5100116-R006)</p>																			
<p>FIGURE 1</p> <table border="1"> <thead> <tr> <th>ITEM NO.</th> <th>TITLE</th> <th>MCD P/N</th> <th>QTY PER COACH</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Bracket, steer gear mount bracket reinforce</td> <td>5107644</td> <td>1</td> </tr> <tr> <td>2</td> <td>Bolt, reinforce bracket to mount bracket attach (5/8 in. - 11 x 4 1/4 in. long)</td> <td>M18194</td> <td>3</td> </tr> <tr> <td>3</td> <td>Washer, lock, bracket bolt (5/8 in. I.D.)</td> <td>M17008</td> <td>3</td> </tr> </tbody> </table>					ITEM NO.	TITLE	MCD P/N	QTY PER COACH	1	Bracket, steer gear mount bracket reinforce	5107644	1	2	Bolt, reinforce bracket to mount bracket attach (5/8 in. - 11 x 4 1/4 in. long)	M18194	3	3	Washer, lock, bracket bolt (5/8 in. I.D.)	M17008
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F.M.C., AS OF 10/20/75, HAS LONGER HONORS PARTS OR EQUIPMENT AVAILABLE AS OUTLINED IN THIS BULLETIN



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KIT CONTENTS (5100116-R006) (continued)				7	
FIGURE 1				SUBJECT	
ITEM NO.	TITLE	MCD P/N	QTY PER COACH	MODEL (S) AFFECTED	
4	Rod, stabilizer for reinforce kit	5107645	1		
5	Nut, castellated, rod-to-bracket attach (1 in. -8)	M17028	2		
6	Bolt, stabilizer-to-inboard bump spring bracket attach (1/2 in. - 13 X 2 1/2 in. lg.)	M18035	2		
7	Nut, lock, stabilizer rod bolt (1/2 in. -13)	M17049	2		
8	Bracket, outboard bump spring-to-frame attach	5107643	1		
9 (not shown)	Plate, backup, on frame behind item 4 rod attachment bracket	5107646	1		
ACCOMPLISHMENT INSTRUCTIONS					
<p>A. To accomplish installation of the reinforcement Kit, jack up coach front end and install jack stands at designated jack points per Owner's Manual. Obtain access from underneath the front through lower openings in front panel (panel removal not required).</p> <p>B. Position front wheels straight ahead.</p> <p>C. Prepare for kit installation by removal of certain parts and perform minor modifications to provide access as specified. Retain parts, when specified, for reuse during reassembly. Discard old parts not specified for retention. Suggest that retained parts be arranged on</p>					



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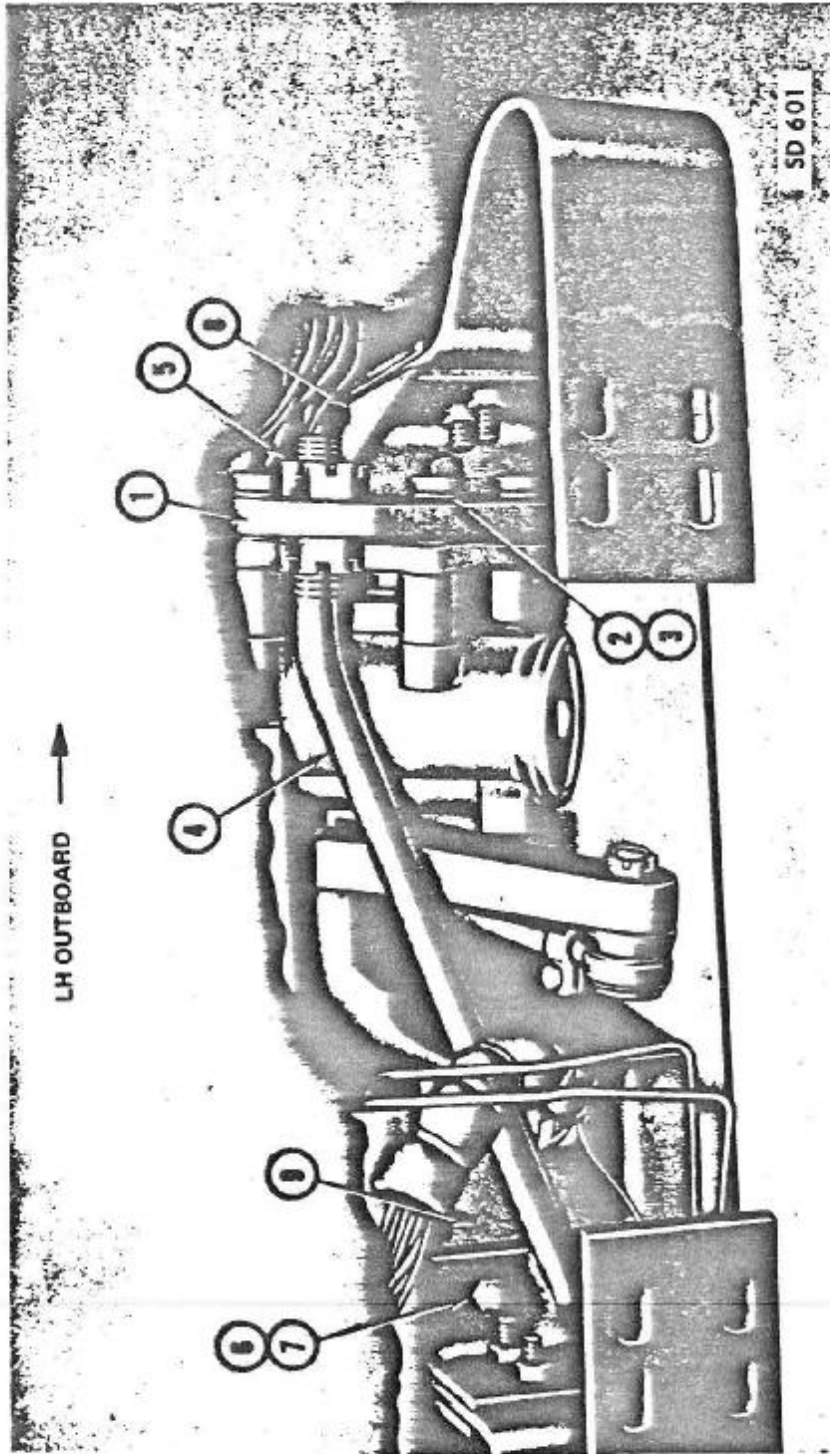


FIGURE 1. STEERING GEAR REINFORCEMENT KIT INSTALLATION

NOTE: THIS FIGURE SHOWS FRONT NOSE PANEL REMOVED FOR CLARITY. KIT INSTALLATION DOES NOT REQUIRE REMOVAL OF PANEL.



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<p><u>ACCOMPLISHMENT INSTRUCTIONS (continued)</u></p>	<p>7</p>
<p>floor underneath coach in a general pattern resembling the installed configuration, to facilitate rapid location of reused attaching hardware during reinstallation. Proceed as follows:</p> <p>(1) Remove the nuts, washers and bolts attaching the front bumper to the two, bumper mount, leaf springs, located on LH side of coach; do not remove bumper.</p>	<p>SUBJECT</p>
<p>(2) Remove locknuts and bolts attaching the two LH inboard and outboard bumper leaf springs to the four frame mount brackets; remove springs and retain. Retain attaching nuts and bolts.</p> <p>(3) Remove the frame mount bracket, nearest to coach centerline, of the inboard mount bracket set, by removing lock nut and attachment bolts. Retain bracket, locknuts and bolts. Repeat removal procedure for adjacent bracket, but discard nuts and bolts and retain bracket only.</p>	<p>MODEL (S) AFFECTED</p>
<p style="text-align: center;"><u>NOTE</u></p> <p>To provide better access to the top bolt for the next step and for installing new parts, the lower corner edges of the panel and the aluminum angle in the vicinity of work area, may be bent back about 50 degrees, using vise grip pliers or similiar tool. Temporarily tie-back or tape all wiring back away from bracket mount areas during these procedures.</p>	
<p>(4) Repeat step (3) for the outboard bumper spring-leaf-to-frame attach bracket set but retain all attaching locknuts and bolts; discard only the two brackets.</p>	
<p>(5) Remove the three bolts and lockwashers attaching the steering gearbox to the mount bracket; discard bolts and washers.</p>	
<p>D. See figure 1 and install the reinforcement kit components and the parts retained during disassembly, in the following sequence:</p>	



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<p><u>ACCOMPLISHMENT INSTRUCTIONS (continued)</u></p> <p>(1) Loosely install the steering gearbox reinforcement bracket (item 1) where shown, using three lock-washers (item 3), three bolts (item 2) and two bolts and locknuts retained from step C (4). Do not tighten.</p> <p>(2) Insert the plate (non-threaded) end of the stabilizer rod (item 5) up and inboard through the coach front panel opening for the inboard bumper spring. Move rod inboard toward coach center line until threaded end clears opening. Feed rod (threaded end) behind harness and tubing (as shown). Just before inserting through the hole in the reinforcement bracket, install one castellated nut (item 5) all the way on threaded end of rod.</p> <p>(3) With stabilizer rod threaded end inserted in bracket hole, assemble the rod end plate on bracket retained from step C (3), with the back-up plate (9) behind the frame structure. Align holes and use two new bolts (item 6) and nuts (item 7) to loosely secure rod end, bracket and back-up plate in position.</p> <p>(4) Loosely install the inboard frame mount bracket section retained from step C (3) with the retained locknut and bolts.</p> <p>(5) Loosely install inboard bumper spring retained from step C (2) in brackets, using the retained lock-nuts and bolts.</p> <p>(6) Loosely connect bumper to inboard spring with nuts, bolts and washers retained from step C (1).</p> <p style="text-align: center;"><u>CAUTION</u></p> <p style="text-align: center;">Prior to accomplishing next step, check that no wiring has dropped in between the new reinforcement bracket and frame mount structure.</p> <p>(7) Tighten the reinforcement bracket attach bolts previously installed in step (1).</p>	<p>SUBJECT</p>
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<p><u>ACCOMPLISHMENT INSTRUCTIONS (continued)</u></p> <p style="text-align: center;"><u>NOTE</u></p> <p>Standard dry (non-lubricated) torque value for the three 5/8 inch size bolt attaching the reinforcement bracket-to-steering gearbox mount is approximately 110 foot pounds. The 1/2 inch size bolts require 55 foot pounds torque.</p> <p>(8) Tighten the inboard bumper spring-to-frame bracket attach bolts previously installed in step (3).</p> <p>(9) Turn the inboard castellated nut, installed on stabilizer rod in step (2), until it firmly contacts the reinforcement bracket.</p> <p>(10) Install and tighten the outboard castellated nut (item 5) on the stabilizer rod end. Torque 200 ft. lb.</p> <p>(11) Loosely install the new outboard spring-leaf-to frame attach bracket (item 8), using locknuts and bolts retained from step C (4).</p> <p>(12) Loosely install outboard bumper spring, retained from step C (2), in between the reinforcement and outer brackets, using the retained locknut and bolts.</p> <p>(13) Loosely connect bumper to spring with nuts, bolts and washers retained from step C (1).</p> <p>(14) Align (level) bumper and tighten all remaining attaching nuts/bolts for total installation; recheck previously tightened bolts to ensure tightness.</p> <p>E. Remove tape, installed to hold wiring out of the way, and remove jack stands.</p> <p style="text-align: right;"><i>Max Snavely</i> MAX SNAVELY Service Manager</p>	<p>SUBJECT</p> <p>MODEL (S) AFFECTED</p>