



URGENT

ROUTINE

MANDATORY

INFORMATIONAL

Service Bulletin

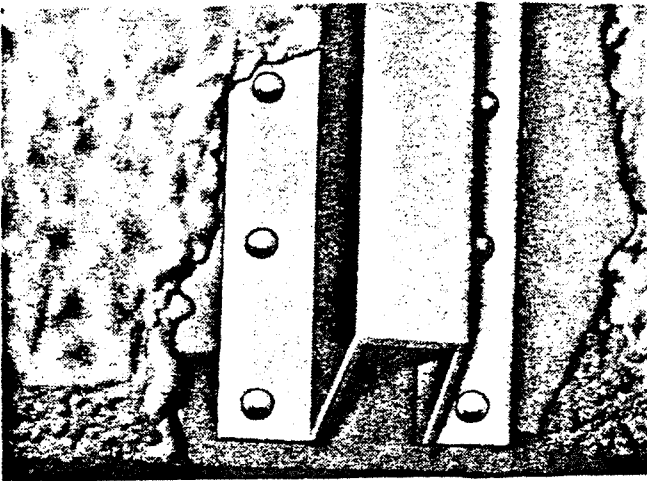
DATE December 1, 1976

NUMBER 2902-30001

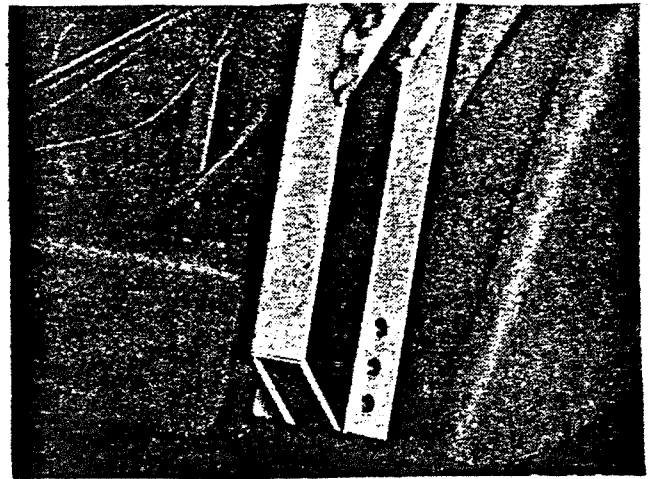
ATTENTION: SERVICE MANAGER		GROUP 2																																	
<p><u>DESCRIPTION</u></p> <p>This bulletin provides instructions for inspecting and reinforcing the upper body structure to lower frame mounting points. Inspection is to be accomplished on all motor homes within serial range as indicated.</p> <p><u>COMPLIANCE</u></p> <p>Owners should take their coach to one of the participating service centers listed as an attachment to the owners notification letter. FMC will reimburse for labor provided that this bulletin is accomplished no later than June 1, 1977.</p> <p><u>PARTS REQUIRED</u></p> <table border="1"> <thead> <tr> <th>Qty.</th> <th>Part Number</th> <th>Description</th> </tr> </thead> <tbody> <tr> <td>6</td> <td>5109097-01</td> <td>Angle</td> </tr> <tr> <td>16</td> <td>5109247-04</td> <td>Fastener (colored Red)</td> </tr> <tr> <td>24</td> <td>5109247-05</td> <td>Fastener (colored Yellow)</td> </tr> <tr> <td>8</td> <td>5109247-07</td> <td>Fastener (colored Brown)</td> </tr> <tr> <td>25</td> <td>M25029</td> <td>Rivet-Fiberglass to Frame</td> </tr> <tr> <td>35</td> <td>M25032</td> <td>Rivet-Shear Panels and Door Frame</td> </tr> <tr> <td>25</td> <td>M25044</td> <td>Rivet-Exterior Door Molding</td> </tr> <tr> <td>20</td> <td>M25090</td> <td>Rivet-Rub Rail Trim Molding</td> </tr> <tr> <td>50</td> <td>M25099</td> <td>Rivet-Fiberglass Panels Upper</td> </tr> <tr> <td>50</td> <td>M25104</td> <td>Rivet-Fiberglass Panels Lower</td> </tr> </tbody> </table> <p><u>TOOLS & EQUIPMENT</u></p> <p>One special "Huck" gun for fasteners</p> <p>Zinc Chromate primer for aluminum to steel interface</p> <p>Steel welding capacity and welding rod 3/32 O.D., alloy 7015, 7016, or 7018.</p> <p><u>MANPOWER</u></p> <p>Estimated accomplishment times per coach will depend upon coach condition as shown in Figures 1 and 2 and will vary from coach to coach. FMC/MCD will reimburse for labor per the following provided that WORK IS COMPLETED NO LATER THAN June 1, 1977.</p>		Qty.	Part Number	Description	6	5109097-01	Angle	16	5109247-04	Fastener (colored Red)	24	5109247-05	Fastener (colored Yellow)	8	5109247-07	Fastener (colored Brown)	25	M25029	Rivet-Fiberglass to Frame	35	M25032	Rivet-Shear Panels and Door Frame	25	M25044	Rivet-Exterior Door Molding	20	M25090	Rivet-Rub Rail Trim Molding	50	M25099	Rivet-Fiberglass Panels Upper	50	M25104	Rivet-Fiberglass Panels Lower	<p>SUBJECT</p> <p>Frame Reinforcement Instructions</p> <p>MODEL (S) AFFECTED</p> <p>All Motor Homes 00001 to 01050 Model 2900R</p>
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**F.M.C., AS OF 10/21/75, NO LONGER
ONERS LABOR AND REIMBURSEMENT**

AS COVERED IN THIS BULLETIN



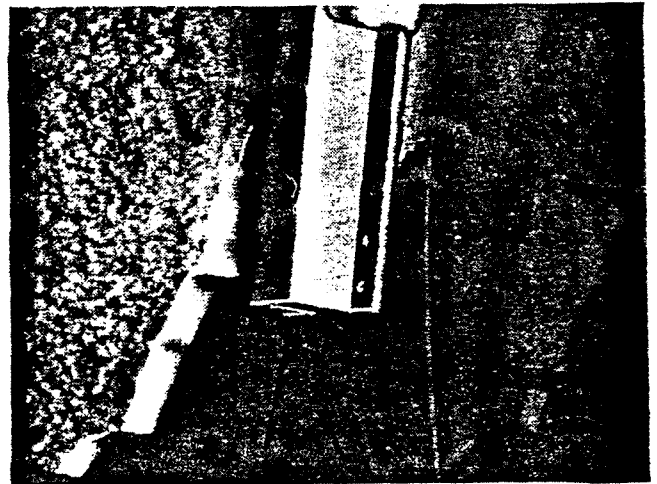
(A) Good section at frame proper cut-away of foam for rivet inspection



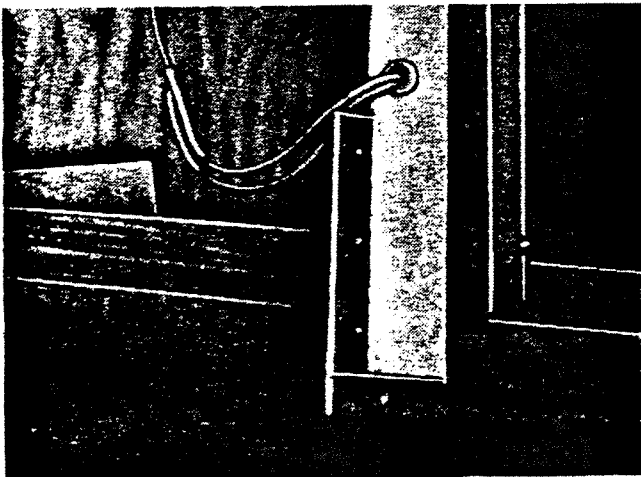
(B) Right front section with missing rivets



(C) Right rear support section pulled away from lower frame



(D) Left rear support section pulled away from lower frame



(E) Passenger door frame pulled away from lower frame



(F) Hairline crack lower aft corner of passenger frame

FIGURE 1. TYPICAL SECTION AND FRAME CONDITIONS.

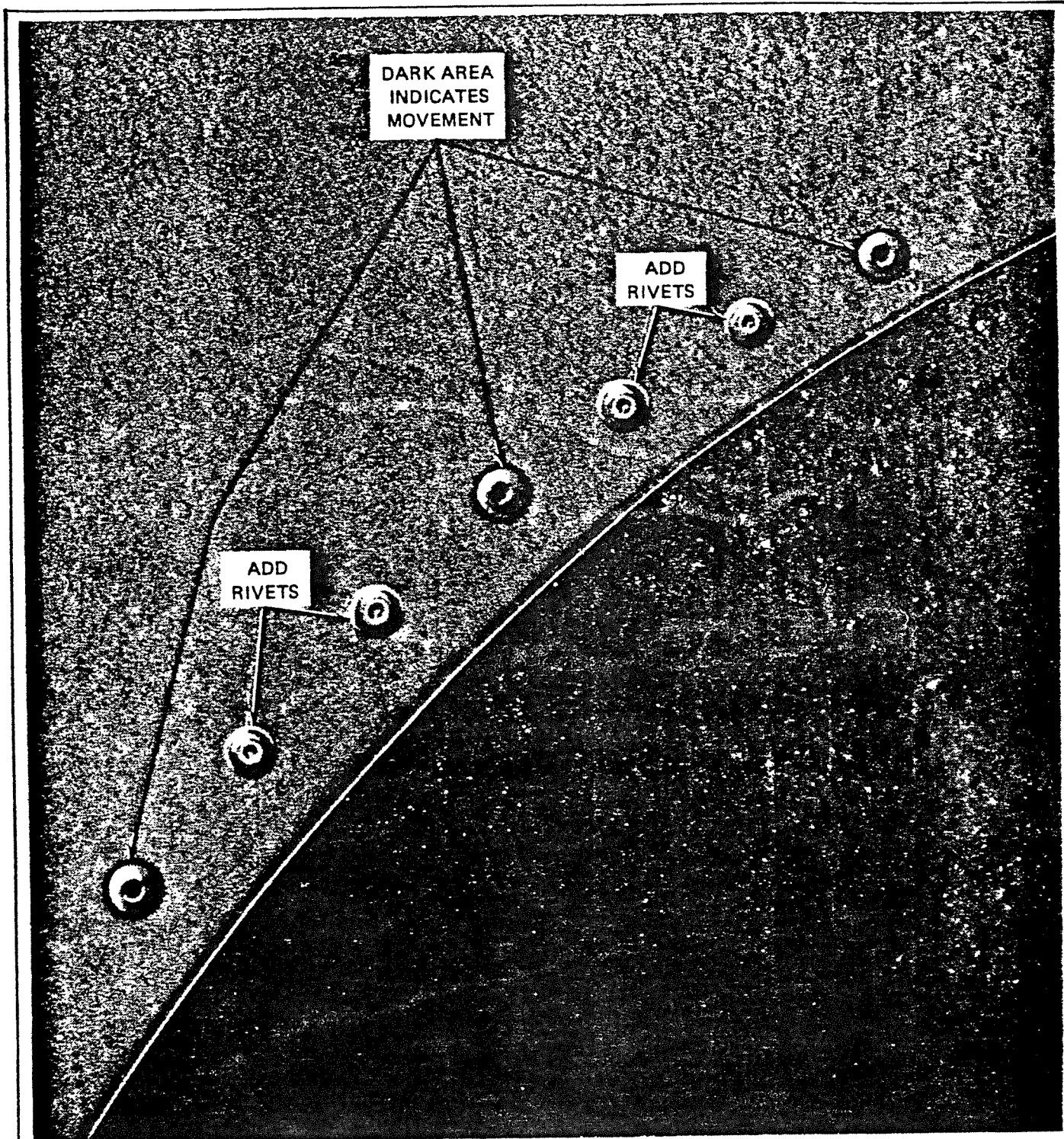


FIGURE 2. SHEAR PANEL TO WHEEL WELL CONNECTION.



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<p>ATTENTION: SERVICE MANAGER</p>	<p>GROUP 2</p>
<p>Condition 1 - Right and left sections forward of rear wheels (positions L4 and R4 in Figure 3) need reinforcement ---4 man hours. Please note that it is not necessary to completely remove coach panels to reinforce for this condition (see Joint Reinforcement Figure 5).</p> <p>Condition 2 - Right and left sections forward of rear wheels (L4 and R4) and all right side sections between rear wheel and front wheel (R3, R2 and R1) plus shear panels in front and rear right side wheel wells (see Figure 3) need reinforcement---8 man hours.</p> <p>Condition 3 - Right and left sections forward of rear wheels (L4 and R4), all right side sections between rear wheel and front wheel (R3, R2 and R1) plus shear panels in front and rear right side wheel wells and left side sections rear of front wheel (L1, L2 and L3), plus shear panels in front and rear left side wheel wells (see Figure 3) need reinforcement. Call factory service representative 408-289-3665 regarding warranty reimbursement <u>before</u> proceeding with the work.</p> <p>Condition 4 - Right and left sections forward of rear wheels (L4 and R4), all right side sections between rear wheel and front wheel (R3, R2 and R1) plus shear panels in front and rear right side wheel wells and left side sections rear of front wheel (L1, L2 and L3), plus shear panels in front and rear left side wheel wells, and all four corners of passenger door frame (see Figure 3) need reinforcement. Call factory service representative 408-289-3665 regarding warranty reimbursement <u>before</u> proceeding with the work.</p> <p><u>INSPECTION</u></p> <p>A thorough inspection of each coach is essential before proceeding with the work to determine if all parts and equipment are in stock and to determine extent of frame reinforcement required.</p> <ol style="list-style-type: none"> 1. Release lower edge of fiberglass side panels on left and right sides of coach (see Figure 5). 2. Cut away foam insulation just enough to inspect all rivets on body sections and shear panels (Figure 1A). 	<p>SUBJECT Frame Reinforcement Instructions</p> <p>MODEL (S) AFFECTED All Motor Homes 00001 to 01050 Model 2900R</p>

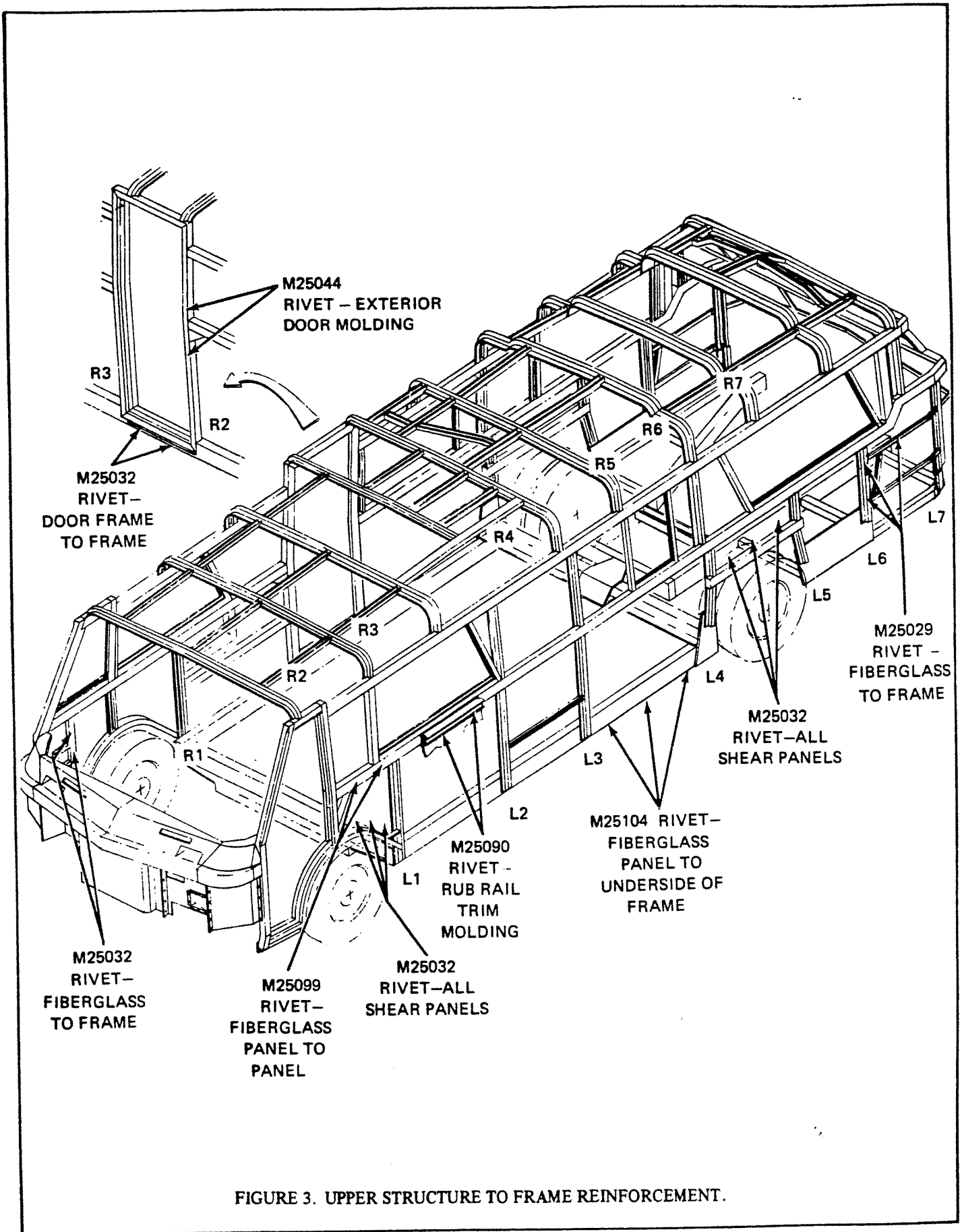


FIGURE 3. UPPER STRUCTURE TO FRAME REINFORCEMENT.



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<p>3. Inspect all body section to frame mounts and door for missing rivets, possible movement or disfiguration of rivets (Figure 2) or movement of body section or door frame away from lower frame (Figures 1 and 3).</p> <p>4. Inspect shear panels for missing rivets, possible movement or disfiguration of rivets (Figure 2) or movement of shear panel away from upper body sections. Note: If rivets show signs of movement, add two new rivets between each pair of existing rivets as shown in Figure 2.</p> <p>5. If all upper body section to lower frame rivets are in place and show no signs of deterioration, no reinforcement is necessary <u>except</u> at the right and left body sections (L4 and R4, Figure 3) forward of the rear wheels. New frame reinforcing angles will be added at these points regardless of the condition of the existing section and rivets.</p>	<p>SUBJECT Frame Reinforcement Instructions</p>
<p><u>ACCOMPLISHMENT INSTRUCTIONS</u></p> <p>A. <u>Hull Section to Frame Angles</u> (Figure 3, positions L4, R4, R2 and R3)</p> <ol style="list-style-type: none"> 1. Make certain coach is level at all four jacking points. Jack up body until distance from horizontal strut (just forward of right rear wheel) to bottom of frame is 39 1/4" as shown in Figure 4. 2. Realign rivet holes as close as possible. 3. Close gap between upper body section and lower frame with C clamp. 4. Cut out shear panel only as necessary to install reinforcing angles. 5. Grind or file off existing rivet heads to make angles flush with shear panel. 6. Apply zinc chromate primer to reinforcing angles in all areas that come in contact with aluminum. 7. Place reinforcing angles (5109097-01) against the body section and flush with lower frame. Secure with C clamps. 	<p>MODEL (S) AFFECTED</p> <p>All Motor Homes 00001 to 01050 Model 2900R</p>



FIGURE 4. BODY TO FRAME DIMENSION.

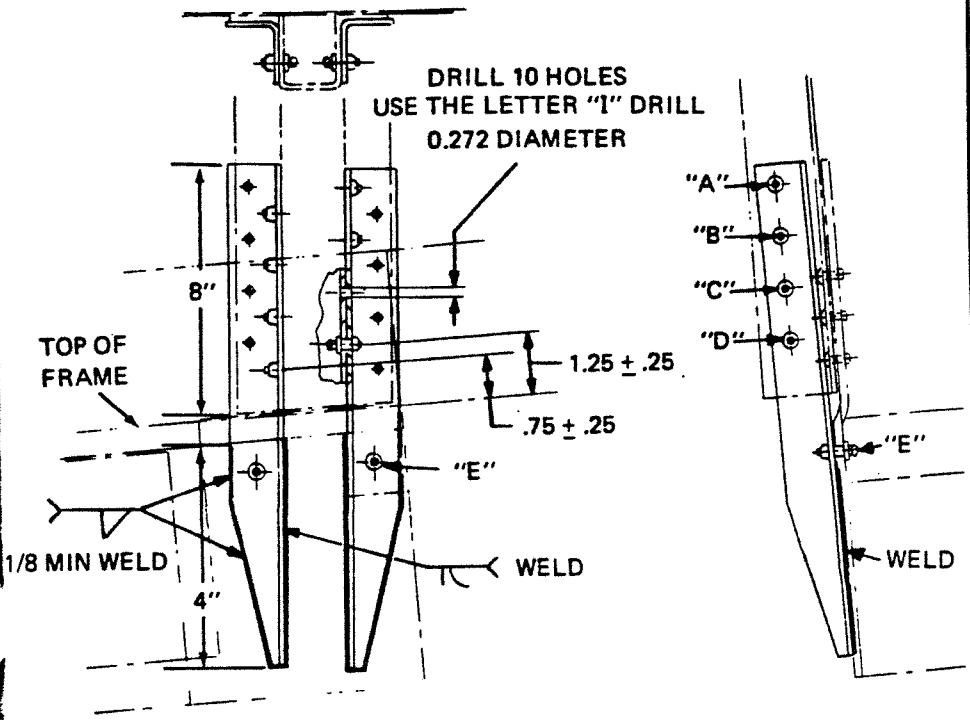


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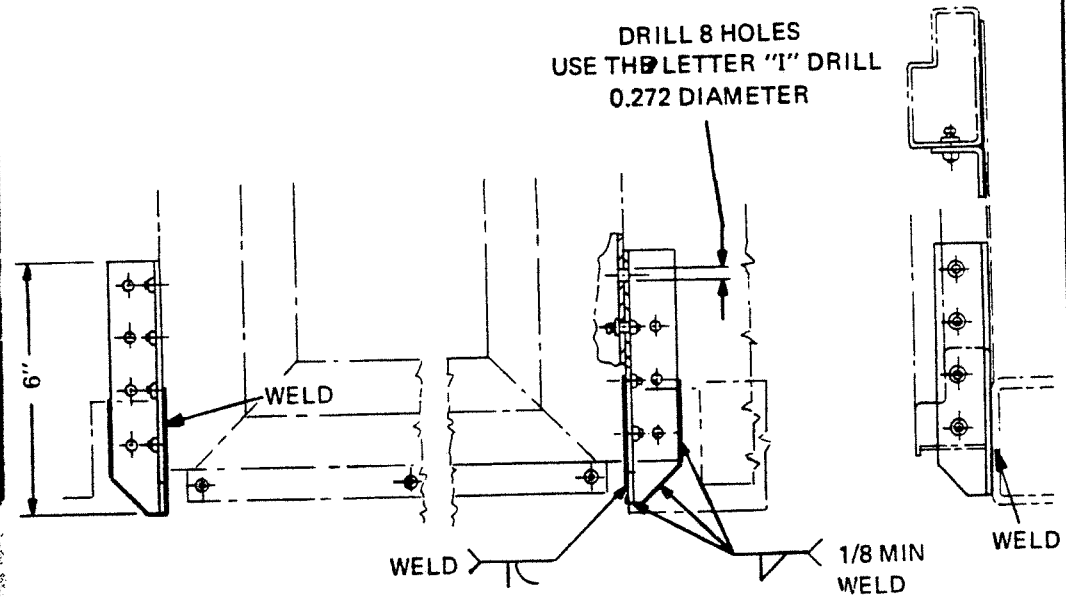
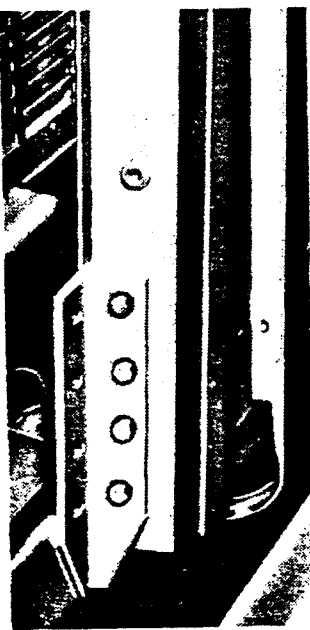
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<p>8. Drill two holes through each angle, one into body section and one onto the lower frame at points "D" and "E" in Figure 5. Use an "I" size drill.</p> <p>9. Install one fastener (5109247-04, colored red) through body section and lower hole of angle ("D" in Figure 5) to secure each angle. Use special "Huck" gun on fastener.</p> <p>10. Install one fastener (5109247-05, colored yellow) through frame and lower hole of angle ("E" in Figure 5) to secure angle at position L4 only (see Figure 3).</p> <p>11. Install one fastener (5109247-05, colored yellow) through frame and lower hole of angle ("E" in figure 5) to secure angle at position R4 only (see Figure 3). Use special "Huck" gun on fastener.</p> <p>12. Drill three holes through each angle into body sections for positions "A", "B" and "C" in Figure 5. Use an "I" size drill.</p> <p>13. Install fasteners (5109247-04, colored red) through body section to secure each angle. Use special "Huck" gun on fastener.</p> <p>14. Remove paint and scale in areas to be welded. Degrease using small disc sander or wire brush prior to welding.</p> <p>15. Weld angle to lower frame as indicated in Figure 5. A metal to metal fit is desirable. If gap exists, make two welding passes.</p> <p>B. <u>Hull Section to Frame</u> (Figure 3, positions L1, L2, L3, L5, L6, L7 and R1, R5, R6 and R7)</p> <p>1. Drill out old rivets and replace with "Huck" fasteners per table listed below:</p> <table border="1" data-bbox="287 1545 1149 1702"> <thead> <tr> <th><u>Position</u></th> <th><u>Fastener</u></th> </tr> </thead> <tbody> <tr> <td>L1, L2, L3, L5, L6, L7</td> <td>5109247-05, colored yellow</td> </tr> <tr> <td>R1, R5, R6, R7</td> <td>5109247-07, colored brown</td> </tr> </tbody> </table> <p>2. Realign rivet holes as close as possible.</p> <p>3. Close gap between body section and lower frame with C clamp.</p>	<u>Position</u>	<u>Fastener</u>	L1, L2, L3, L5, L6, L7	5109247-05, colored yellow	R1, R5, R6, R7	5109247-07, colored brown	<p>SUBJECT</p> <p>Frame Reinforcement Instructions</p> <p>MODEL (S) AFFECTED</p> <p>All Motor Homes 00001 to 01050 Model 2900R</p>
<u>Position</u>	<u>Fastener</u>						
L1, L2, L3, L5, L6, L7	5109247-05, colored yellow						
R1, R5, R6, R7	5109247-07, colored brown						



JOINT REINFORCEMENT – POSITION L4-R4 ONLY (FIGURE 3)



PASSENGER DOOR REINFORCEMENT – POSITION R2 AND R3 ONLY (FIGURE 3)

FIGURE 5. REINFORCING ANGLES.



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<p>4. Use an "I" size drill to drill out rivet heads.</p> <p>5. Install fasteners per table above.</p> <p>C. <u>Passenger Door Frame</u></p> <ol style="list-style-type: none"> 1. Realign rivet holes as close as possible. 2. Replace damaged or missing cherry rivets, bottom edge of door frame, with new rivets (M25032). 3. Apply zinc chromate primer to reinforcing angles in all areas that come in contact with aluminum. 4. Place angle (Modify 5109097-01, per Figure 5) flush against door frame and secure with "C" clamps. 5. Drill four holes into door frame. Use an "I" drill. 6. Install four fasteners (5109247-04), colored red) through door frame to secure each angle. Use special "Huck" gun on fastener. 7. Remove paint and scale in areas to be welded. Degrease using small disc sander or wire brush prior to welding. 8. Weld angle to lower frame as indicated in Figure 5. A metal to metal fit is desirable. If gap exists, make two welding passes. <p>D. <u>Passenger Door Frame Cracks</u></p> <p>Some coaches have developed hairline cracks in two or possible four corners of the aluminum door frame (Figure 1F). These cracks can be repaired by aluminum welding.</p>	<p>SUBJECT Frame Reinforcement Instructions</p> <p>MODEL (S) AFFECTED All Motor Homes 00001 to 01050 Model 2900R</p>

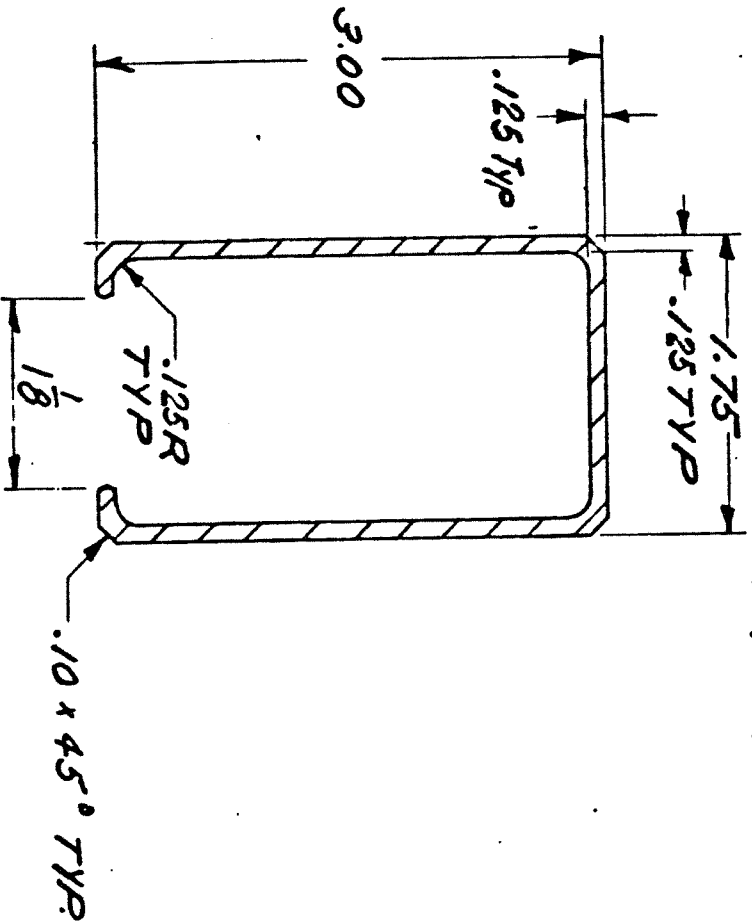
Center Beam Upper Case

REVISIONS

IT#	DESCRIPTION

TOLERANCES

45



QTY PICT	PART NO. OR IDENT. NO.	NAME	MATERIAL OR OR. NO.	DESCRIPTION OR MATL SPEC
				AI. 5083 H111

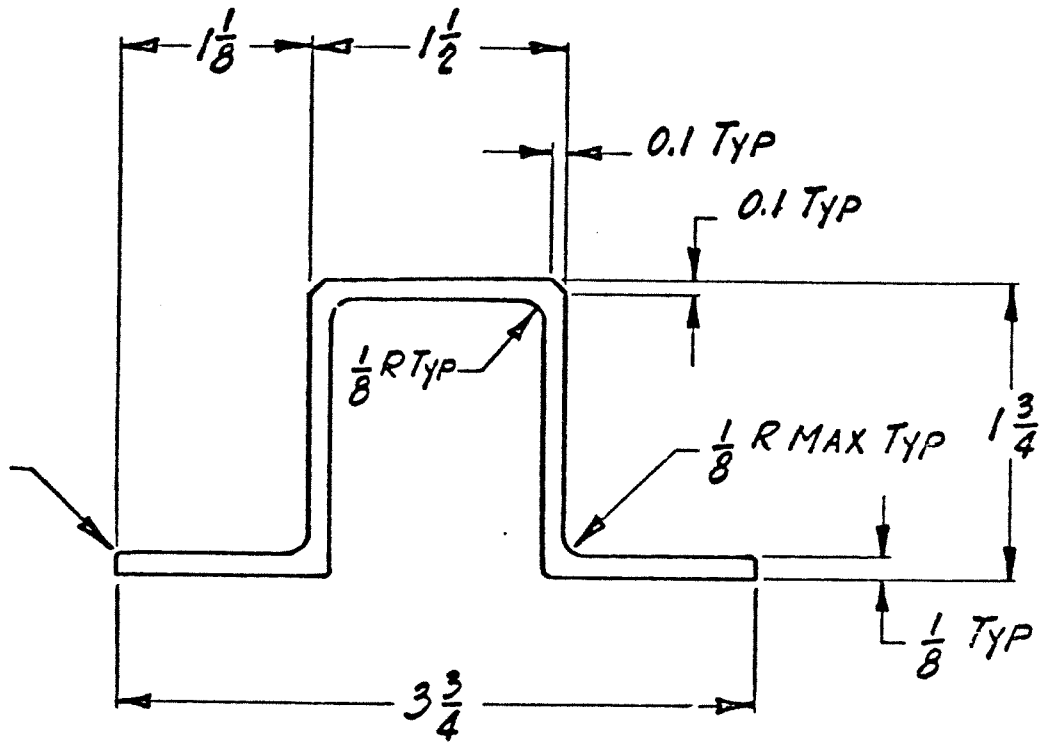
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NOTES

TOLERANCES PER
FED. STD. 245

Foot Dowel
VERTICAL Supports

$\frac{1}{32}$ R TYP



ITEM NO.	QTY REQ'D	PART NO. OR IDENT. NO.	NAME	MANUFACTURER C

[REDACTED] ON

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES DECIMALS * .XX* FRACTIONS XXXX	DATE	[REDACTED]	TITLE SHAPE SCALE
	DRAFTSMAN	[REDACTED]	
	ENGINEER	[REDACTED]	
	CKG MFG	[REDACTED]	