



Spartan Fire, LLC

Technical Service Bulletin
RSB21-250-001

DATE: 4/9/2021

APPLIES TO: This service bulletin applies 2019 through 2021 model year, Gladiator and Metro Star model emergency response chassis cabs built between January 14, 2020 and December 8, 2020.

CONDITION: Loose Reyco IFS Steering Gear Box Bolts

CORRECTION: Remove fasteners and reinstall with Nord-Lock washers in place of original flat washers.

LABOR ALLOCATION: 1.5 hours

CLASSIFICATION: V3

PARTS NEEDED:

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
2	K715597	Reyco Granning Hardware Kit <i>Reference: Engineering Print S-3757-001</i>

GENERAL INSTRUCTIONS:

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Fire LLC. Customer & Product Support Group. (1-800-867-6478)

All applicable industry safety standards must be followed when performing work identified in this procedure.

Please include the following information on the invoice when submitting for payment

1. Suspension Serial number: Located on tag at left front of suspension
2. In Service Date
3. Repair Date
4. Vehicle Mileage
5. Invoice #

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Service Bulletin

Service Bulletin SGM 0121

Date: 4/19/21

REV: D

Subject: Some IFS-FT units may have steering gears where the fasteners may loosen and lose clamp load between the cradle and steering gear.

Applies To: IFS for Fire Truck

VDM Range: 11/27/2019 thru 10/28/2020, excluding units contained at OEM.

Verify with OEM on specific affected units and applicable serial numbers.

Vocation: Fire Truck ER

Labor Allowance: 1.5 Hours for removal, cleaning, application of Nord-Lock washers and re-installation at specified torque.

Please Read the Entire Bulletin and Reference Manuals D710023 before Proceeding with Any Work. Follow industry standards regarding safety equipment and procedures.

This procedure should be done at latest on the Next Scheduled Service Interval.

Perform the below instructions one fastener on each gear at a time for each of the 14 bolts, using an alternating pattern.

Steering gear and steering gear clamp area to be cleaned with brake cleaner or similar solvent to remove oils, greases, and contaminants.

Female holes on steering gear to be cleaned with wire bottle brush or similar to remove contaminants such as, but not limited to, thread locker and oil.

While performing the TSB, inspect steering gear (threads and body), fittings and lines connected to the gear, and pitman arm for damage or leaks and replace or service as necessary.

Ensure proper steering fluid level before returning vehicle to service.

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Service Bulletin

Access to all of the bolts can be achieved by steering the suspension to limiting stops.

- Remove the single 7/8 in bolt from each steering gear
- Clean the threads inside the steering gear blind hole.
- Discard the 7/8 in fastener and flat washer and install the Nord-Lock washer on the new fastener.
- Install and torque to 500 lb ft.
- Remove the (10) 3/4 in fasteners from each steering gear one at a time and clean the threads and mating holes. See images on following pages.
 - o Access to all bolts may require steering the vehicle from one limit to the other.
 - o Discard the fasteners that directly thread into the steering gear and replace with new fasteners (6 fasteners directly around the output shaft of the gear)
 - o Reuse the 4 fasteners that thread into the mounting plates.
- Discard the flat washer and install the appropriate Nord-Lock washer on the fastener (new fastener if applicable).
- Install the 3/4 in fastener (new fastener if applicable) with Nord-Lock washer and torque to 300 lb ft.
- Repeat with the opposite steering gear.
- This procedure applies to both the master and slave gears.

- **Labor Allowance:** 1.5 hr. max recommended. Invoice Charge capped at \$195.00

Parts Required:

2 ea. Reyco Granning Hardware Kit #K715597

Tools Required:

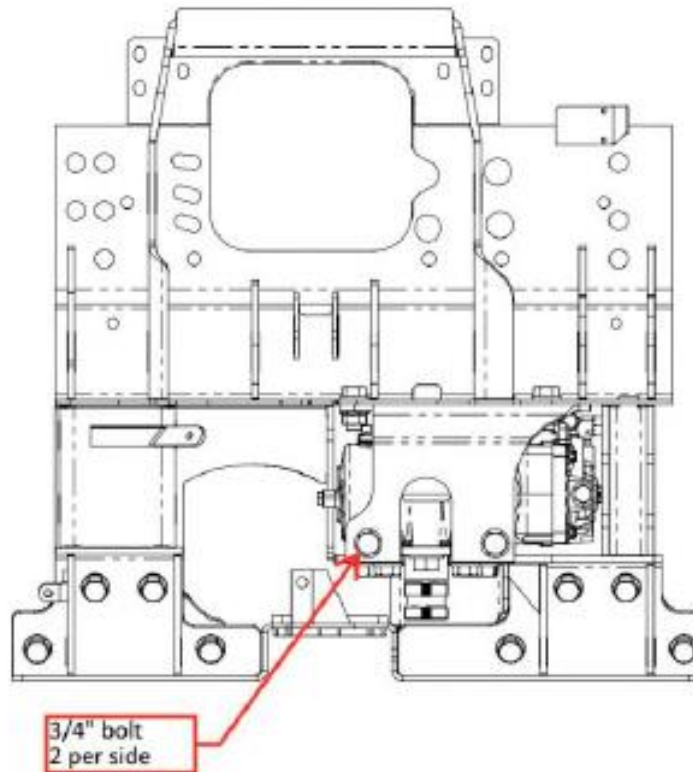
500 ft-lb Adjustable Torque Wrench
1 1/8" Socket
1 5/16" Socket

Reference:

Bolts Used in Steering Gear:

709388-03 3/4-16 X 1.25 GR 8 ZN (outside bottom plate, and side plate bolt)
8223752 3/4-16 X 2.00 GR 8 PO (bottom plate into steering gear) in K715597
709386-01 7/8-14 X 2, GR 8 ZN (bottom plate into steering gear) in K715597

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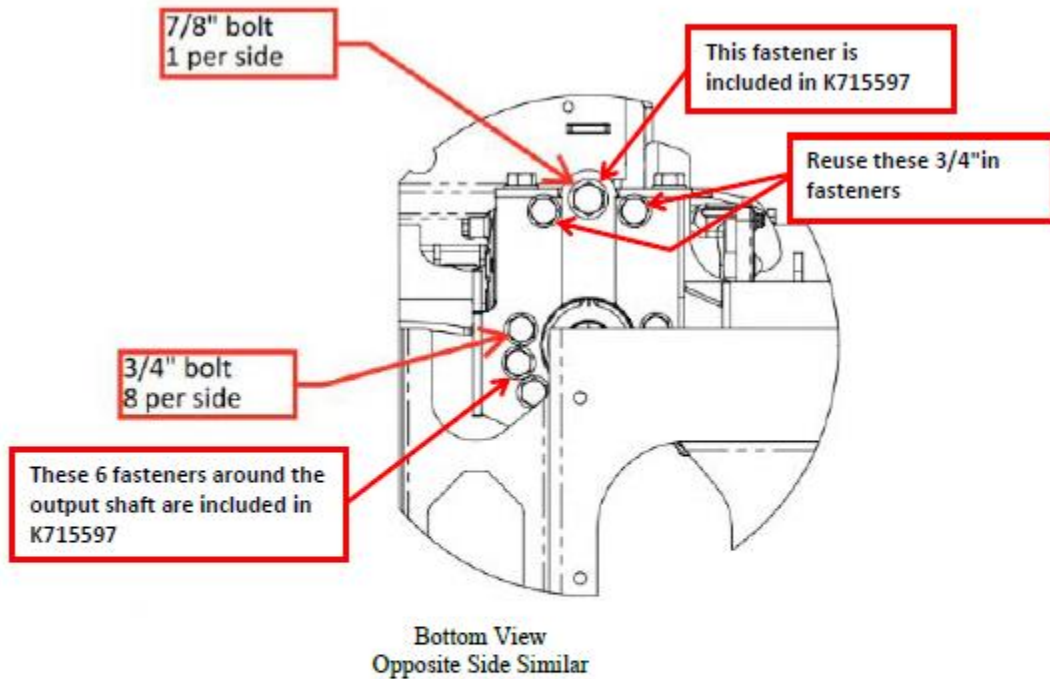


Cradle Side View (Suspension arms removed from view)

Opposite side similar

*****Reuse These Bolts*****

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⚠ WARNING Use jack stands or other safety devices to properly support vehicle

Failure to safely support the vehicle and follow the procedures in this bulletin can lead to property damage and/or personal injury.

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