



Date: February 28, 2020

Service Bulletin

Bulletin No.: 2020-0043

Product Models Affected:

World Trans E-series

FORM Rev 2020-0127

Purpose:

To install the shoulder anchorage L-track on a World Trans bus.

Warranty Status:

Standard warranty coverage for all product models.

Tool(s) / Equipment Required:

Chocks
Safety Glasses (PPE)
Hearing Protection (PPE)
Gloves, Cut Resistant (PPE)
Tape Measure
3/8-inch drill
"F" steel drill bit
Sunex Rivet Gun

Part(s) / Material Required:

<u>Description</u>	<u>Part Number</u>	<u>Quantity</u>
L-track, Omni Non-flanged, Rivets	WB-0070073	1
Rivet, 1/4 x 1.00 MBP-R8-M8, Shldr Res	WB-0070136	3

Note: Part(s)/Materials required allow for the installation of one position.

Estimate Time-To-Repair:

2 hours

General:

1. Park the vehicle on a flat level surface.
2. Chock wheels of the vehicle.
3. Ensure that the product use date is not greater than one (1) year from the expiration/manufacturing date of adhesives and sealants. Ensure product handling and storage processes meet manufacturer requirements.
4. Protect adjacent areas, from weld spatter and debris from grinding during hot work operations.
5. Protect adjacent areas, from overspray of paints and adhesives during assembly/finish operations.
6. Disconnect battery(ies), PCM/ECM/Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis.
7. Reconnect battery(ies), PCM/ECM/Modules, and other electrical device connections as described in the Ford Service Manual for welding on the chassis only after completing all weld process operations.
8. Wear appropriate PPE during rework process operations.
9. Ensure a fire extinguisher or other fire control apparatus are available during hot work operations.
10. Follow OEM instructions regarding the removal and re-installation, or protection of alternate fuel cells and/or components of the alternate fuel system installed on the vehicle when completing hot work operations.
11. Move any hoses, electrical harnesses or wire, or other components from the immediate work area where the hot work operations may be performed.
12. Follow appropriate industry standards and best practices for welding operations.
13. Follow manufacturer instructions for the handling and use of adhesives, sealants, and other materials used in sub-assembly and assembly processes.

Procedure:

1. Remove the Qstraint shoulder point seatbelt attachment from the L-track by removing the Qstraint plastic cover. Loosen the hardware. Put the seatbelt aside for re-installation. Reference Photo 1.



Photo #1

2. Drill out the rivets from the L-track.
3. Move the L-track rearward 1-inch from the existing holes drilled in the sidewall, ensuring the center lines of the L-track holes are in alignment. Reference Photo # 2.

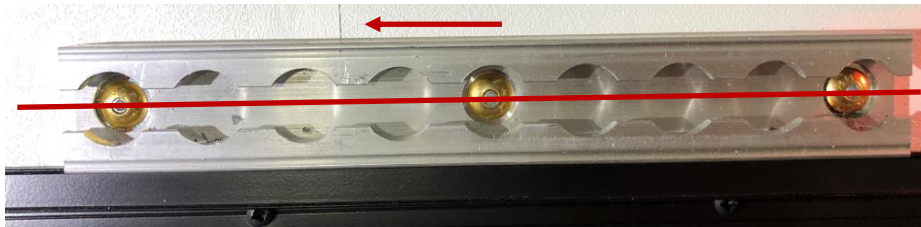


Photo #2

4. Mark and drill 3 new holes using an “F” size steel drill bit. Ensure the hole is through the interior fabric, the side wall panel, and the steel wall structure.
Note: Ensure that you do not drill the hole through the sidewall of the bus.
5. Place a rivet into the rivet gun.
6. Place the L-track onto the sidewall so that the holes of the L-track align with the newly drilled holes.
7. Insert the rivet through the L-track into the drilled hole in the sidewall, ensuring the rivet goes through the holes drilled in the steel tube of the wall structure. Reference Photo #3.
Note: Push on the L-track to ensure the sidewall material is flat against the steel cage structure.
8. Pull the trigger of the rivet gun.



Photo #3

9. Complete Steps 5 through 8 for the remaining 2 holes in the L-track.
10. Repair sidewall fabric where the hole remains visible.
11. Install the Qstraint shoulder point seatbelt attachment to the L-track reversing the steps completed in Step 1 and torque to the value specified by Qstraint. Reference Photo # 4.
Note: Ensure that the upper seatbelt shoulder point attachment is directly above the Qstraint seatbelt retractor, perpendicular to the floor.



Photo #4

Contact Information:

Contact Eldorado Customer Service, 1655 Wall Street, Salina, KS 67401; or by calling (785) 827-1033 / (800) 955-9086; or by Email: bussupport@eldorado-bus.com; or by Fax: (785) 823-9471.