

# Authorized Field Change

**INTERNATIONAL**

**AFC G-01901**

**Date:** April, 2001

**Subject File:** FRAME

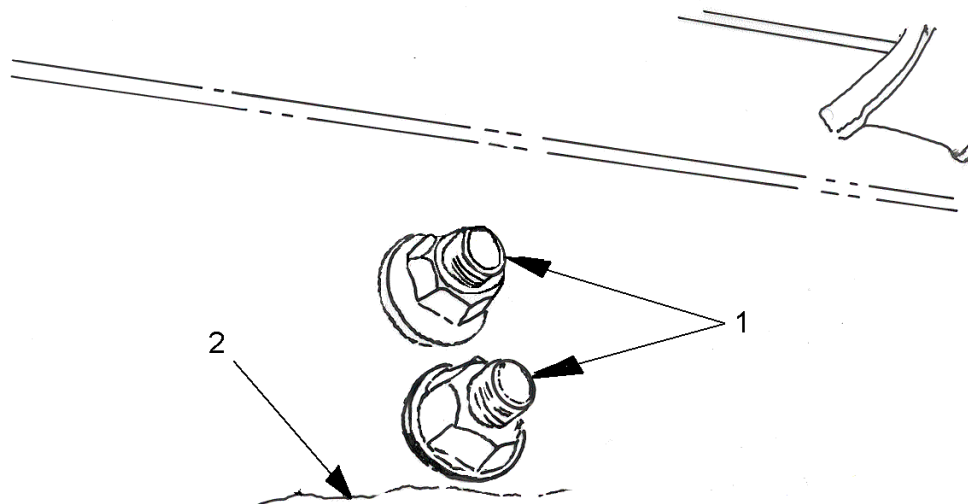
**Subject:** Frame Cracking at the Steer Axle Shock Absorber Bracket Mounting Bolts in the 3000RE Bus Model Built Before January 16, 2001

Model: 3000RE

End Date: 01/16/2001

## DESCRIPTION

Due to the dynamics of shock absorber forces, the stress levels in the frame web at the steer axle shock absorber bracket mounting bolt locations may exceed the frame material yield strength and may result in cracks as shown in Figure 1. Effective January 16, 2001, a frame reinforcement was implemented in production to address this issue.



**Figure 1 Front Shock Absorber Frame Rail Mounting Area Illustrating a Crack as Viewed from Inside the Frame Rail**

1. Shock Absorber Bracket Mounting Bolts
2. Area of Possible Cracking

# PARTS INFORMATION

Table 1 **Parts Information**

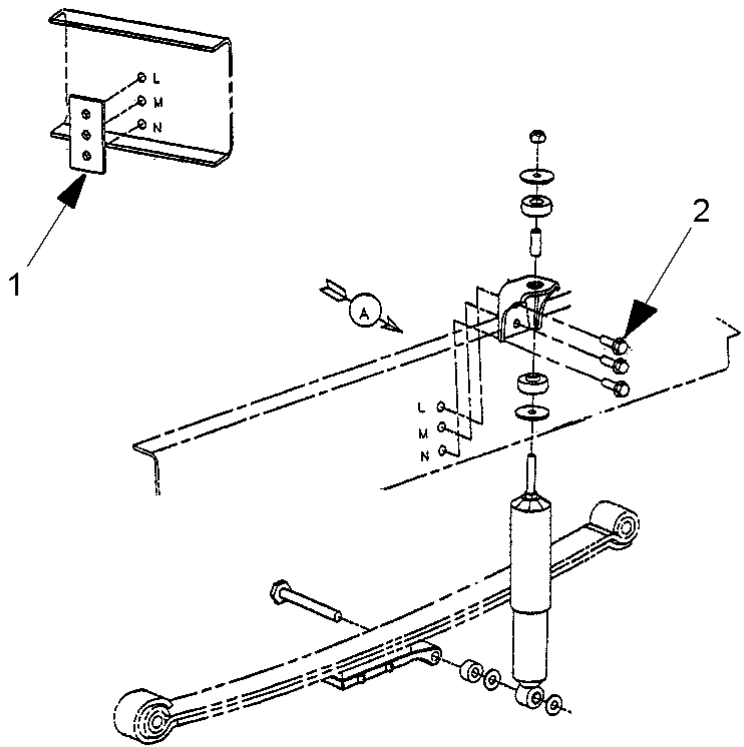
Part Number	Description	Quantity
3563097C1	Shock Mounting Reinforcement	2
414078C1	5/8-18UNF X 2 Inch Bolt	6
414089C1	5/8-18UNF Flange Locking Nut	6

## SERVICE PROCEDURE

**NOTE** – The following service procedure applies to both the right and left frame rails.



**WARNING** – To prevent personal injury, park the vehicle on a flat level surface and chock the wheels.



**Figure 2** Installing the Shock Mounting Reinforcement to Repair or Prevent Frame Rail Cracks

1. Shock Mounting Reinforcement Part Number 3563097C1
2. Fastener Part Numbers 414078C1 Bolt and 414089C1 Nut

## SERVICE PROCEDURE (CONT.)

1. Remove the mounting bolts from the frame shock absorber bracket and pivot the shock absorber out of the way.



**WARNING** – Wear a welder's helmet with dark colored filter lenses of the proper density and protective clothing when welding to prevent personal injury.

**CAUTION** – Disconnect the positive and negative cables from the battery before welding on the vehicle. Attach the welder ground cable as close as possible to the part being welded.

2. Clean and inspect the area around the shock absorber mounting holes for evidence of cracking. If cracks are not found, proceed to Step 3. If cracks are found, repair by welding before proceeding to Step 3. Refer to Service Section S01001Y, Frame, in Group 01 of the Master Service Manual for welding information that applies to 50,000 PSI yield strength frame material.
3. Install two new bolts, part number 414078C1, into the shock absorber mounting bracket, pivot the shock absorber into position inserting the bolts into the frame mounting holes.
4. Position the shock mounting reinforcement, part number 3563097C1, top two holes onto the two bolts.
5. Install two nuts, part number 414089C1 and tighten to 200 to 240 Lbf-Ft (271 to 325 Nm).

**CAUTION** – Use a piece of wood or other suitable material between the frame and shock absorber to protect the shock absorber from damage when drilling in Step 6.

6. Drilling from inside the frame rail, use the bottom hole in the shock mounting reinforcement as a template and drill a 5/8 inch diameter thru hole in the frame.
7. Left frame rail (driver's side): Install bolt part number 414078C1 through the frame, shock mounting reinforcement and hose clip, install nut part number 414089C1 and tighten to 200 to 240 Lbf-Ft (271 to 325 Nm).

Right frame rail: Install bolt part number 414078C1 through the frame, shock mounting reinforcement, install nut part number 414089C1 and tighten to 200 to 240 Lbf-Ft (271 to 325 Nm).

8. Re-install the shock absorber.

Operation number must appear on all claims.

**Table 2 Labor Information**

Operation No.	Description	Time
A40-01901-1	Inspect and Install Shock Mounting Reinforcement (Right and Left Frame Rail)	1.0 Hr.
A40-01901-2	Inspect, Weld Repair and Install Shock Mounting Reinforcement (Right and Left Frame Rail) Note: Only to be used if the frame rail is cracked and a repair weld is performed.	2.5 Hr.

### ADMINISTRATIVE PROCEDURE

Expense is to be charged to Warranty. Claims are to be submitted in the normal manner, making reference to Authorized Field Change Number G-01901.

It is important that the coding be completed properly to assist in processing the warranty claim. Complete instructions will be found in the Warranty Manual, Section 7-1. Special attention should be given to Items 39 through 44.

To assure this important improvement is made in a timely manner, all claims for G-01901 activity must be submitted by April 30, 2002 or within the normal warranty period for the vehicle, if after April 30, 2002.

	GROUP	NOUN	C	WARR.	TP	PAD
GROUP Enter number G—						
NOUN Leave blank						
C (CAUSE) Enter either 1, 2, 3. (see below)						
1. Inspected (No repair required).						
2. Inspected and repaired.						
3. Defective part from parts stock.						
WARRANTY (Warranty Code) Enter 40.						
TYPE PART Enter P for type part causing failure.						
PAD Enter 100						

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