

SERVICE PROCEDURE

G-06511
February 2007

SUBJECT: SAFETY RECALL (U.S., EXPORT)
CAB ENTRY/EGRESS GRAB HANDLE on certain
CF500 and CF600 Models built 6/2/2004 thru
7/20/2006

DEFECT DESCRIPTION

Under normal usage, the a-pillar mounted entry/egress grab handle may loosen and possibly separate from the vehicle. This separation can occur without warning and may contribute to **personal injury**.

MODELS INVOLVED

This Safety Recall involves certain CF500 and CF600 models built 6/2/2004 thru 7/20/2006.

PARTS INFORMATION

Please read all of the information in this section before pre-ordering your parts. You may not require **all** of the parts below.

There are three (3) distinct levels of possible repair. Please see ***SERVICE PROCEDURE*** for specific details of each repair.

LEVEL 1

ALL vehicles involved in this recall require the following part:

Part Number	Part Description	Quantity
8900191R91	KIT,RECALL LCF GRAB HANDLES	1

LEVEL 2

Approximately **Half (50%)** of units that have been ***delivered to users*** will require the following parts:

Part Number	Part Description	Quantity
8900193R91	KIT,RECALL LCF A-PILLAR PATCH	1 per side, MAX 2 per vehicle as per <i>SERVICE PROCEDURE</i>

In order to properly install **8900193R91**, you will need to obtain the structural adhesive and application gun shown below (if necessary) ***DIRECTLY*** from Excelda.

This material is NOT available in International's PDC system:

Part Number	Part Description	Quantity
TA-1	MOTORCRAFT METAL BONDING ADHESIVE TA-1	1 per vehicle (1 tube will repair up to 2 cab sides)
501-040	ROTUNDA DISPENSER GUN 501-040	1 per dealer location (if necessary)

MSDS sheets and application gun information are attached to this letter. *Please review the application gun information to determine if your dealership already has an equivalent application tool before ordering.*

Please fill out the **[EXCELDA FAX ORDER FORM](#)** attached to this letter to place your order. This adhesive and application gun will be shipped to your location free of charge.

LEVEL 3

See 06511 SAFETY RECALL SUPPLEMENT for detailed instructions.

SERVICE PROCEDURE



WARNING:

TO PREVENT SERIOUS EYE INJURY, ALWAYS WEAR SAFE EYE PROTECTION WHEN YOU PERFORM VEHICLE MAINTENANCE OR SERVICE.



WARNING:

TO PREVENT UNEXPECTED MOVEMENT OF THE VEHICLE AND POSSIBLE SERIOUS PERSONAL INJURY OR DEATH, BLOCK THE WHEELS TO PREVENT THE VEHICLE FROM MOVING IN BOTH DIRECTIONS.

Each vehicle has two (2) cab entry/egress grab handles, one (1) on the driver's side and one on the passenger's side. **The following instructions will highlight ONE side. Please REPEAT instructions for other side of vehicle.**

A-PILLAR ATTACHMENT INSPECTION

1. Remove the cab entry/egress grab handle by removing two (2) bolts.



Figure 1

2. Remove a portion of the door frame wind lace for ease in trim panel removal.



Figure 2

3. Remove the driver's side interior a-pillar trim panel. First pry out upper attachment, then lift upward to release lower attachment.

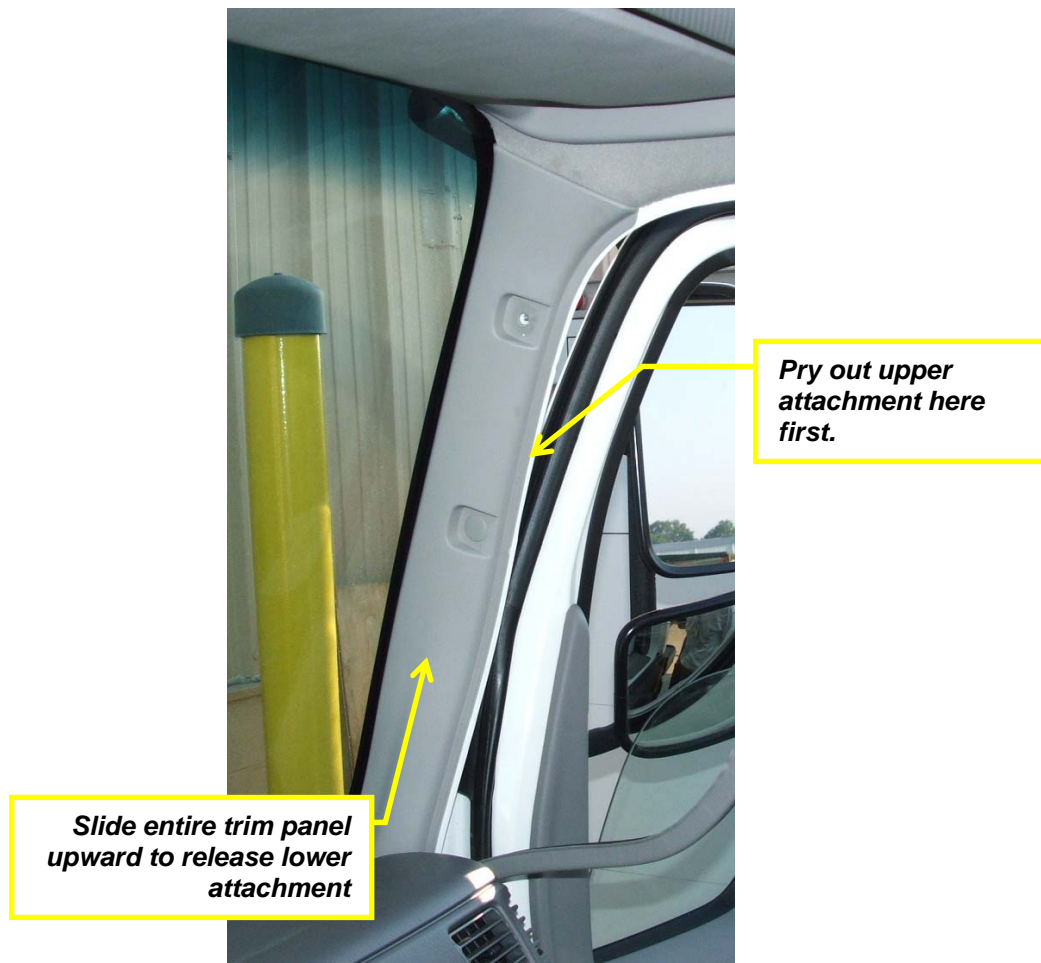


Figure 3

4. Discard removed grab handle and panel closeout.

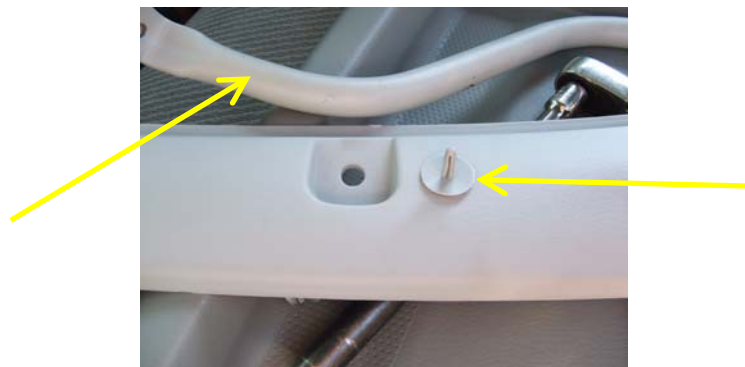


Figure 4

5. Inspect a-pillar grab handle attachment point and upper spot welds for evidence of base metal cracking, paint chipping, material distortion, etc.



Figure 5

6. If **NO** evidence of base metal cracks, or spot weld damage exist, skip to **NEW GRAB HANDLE INSTALLATION SECTION**. Use **ONLY** parts indicated under **Level 1** in the **PARTS INFORMATION** section.

*The following figures represent what International considers **NO** evidence of base metal cracking or spot weld damage:*

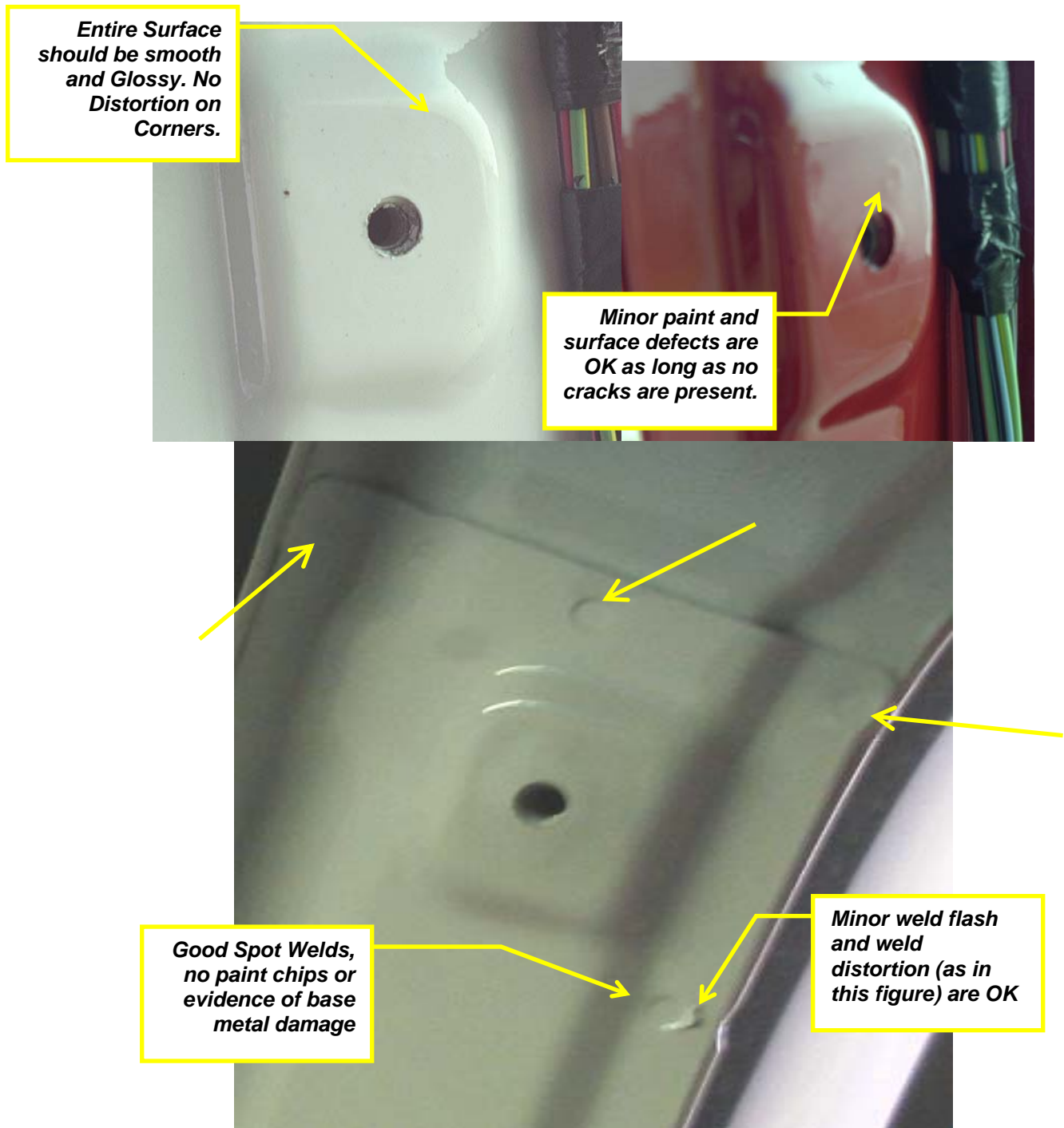
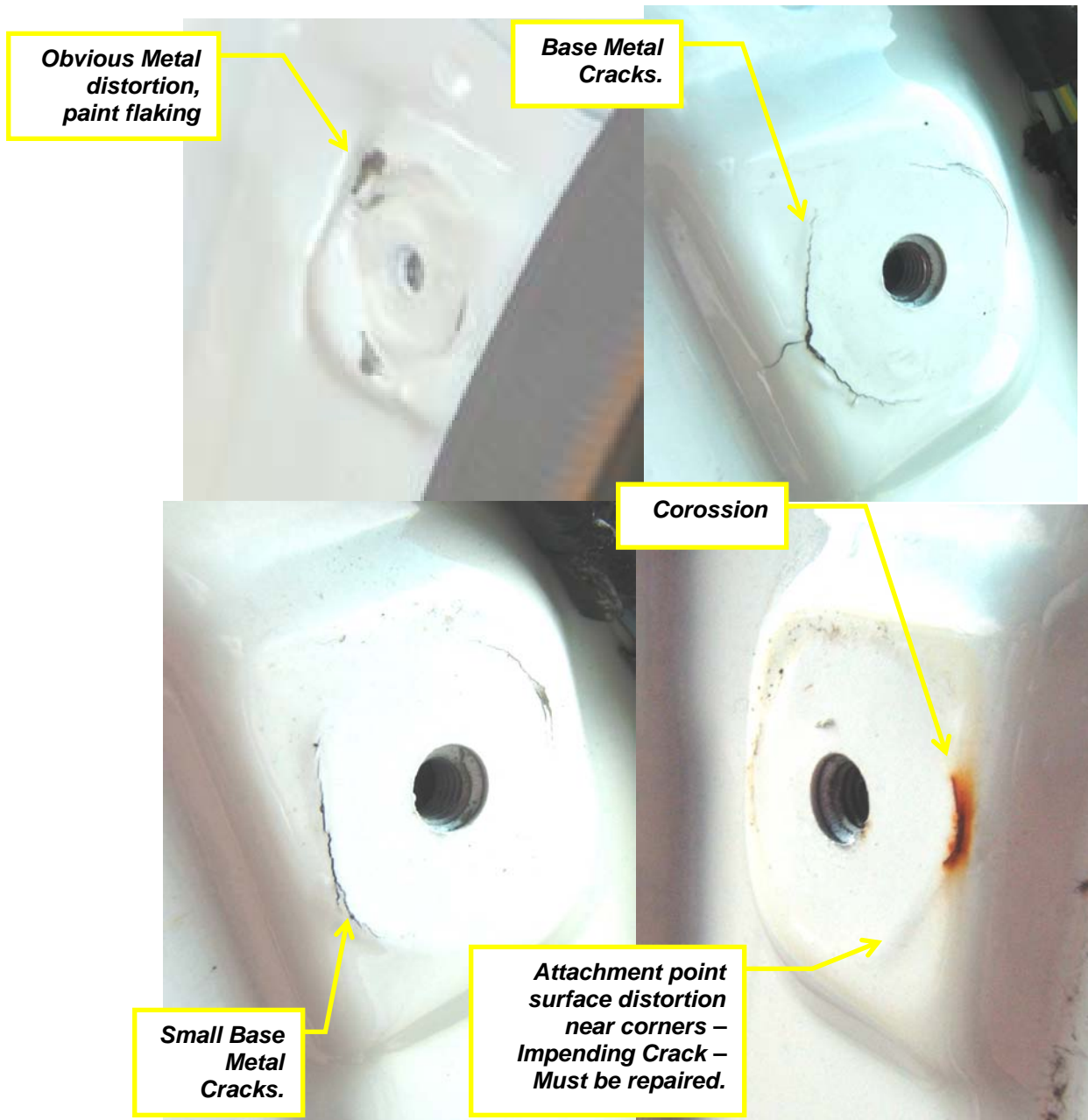


Figure 6 – Good Attachment Point Examples

7. If there is positive evidence of base metal cracks and minor damage, skip to **A-PILLAR PATCH PROCEDURE** for repair instructions.

*The following figures represent what International considers evidence of base metal cracking or distortion that requires **further repair BEFORE** installing new grab handles:*



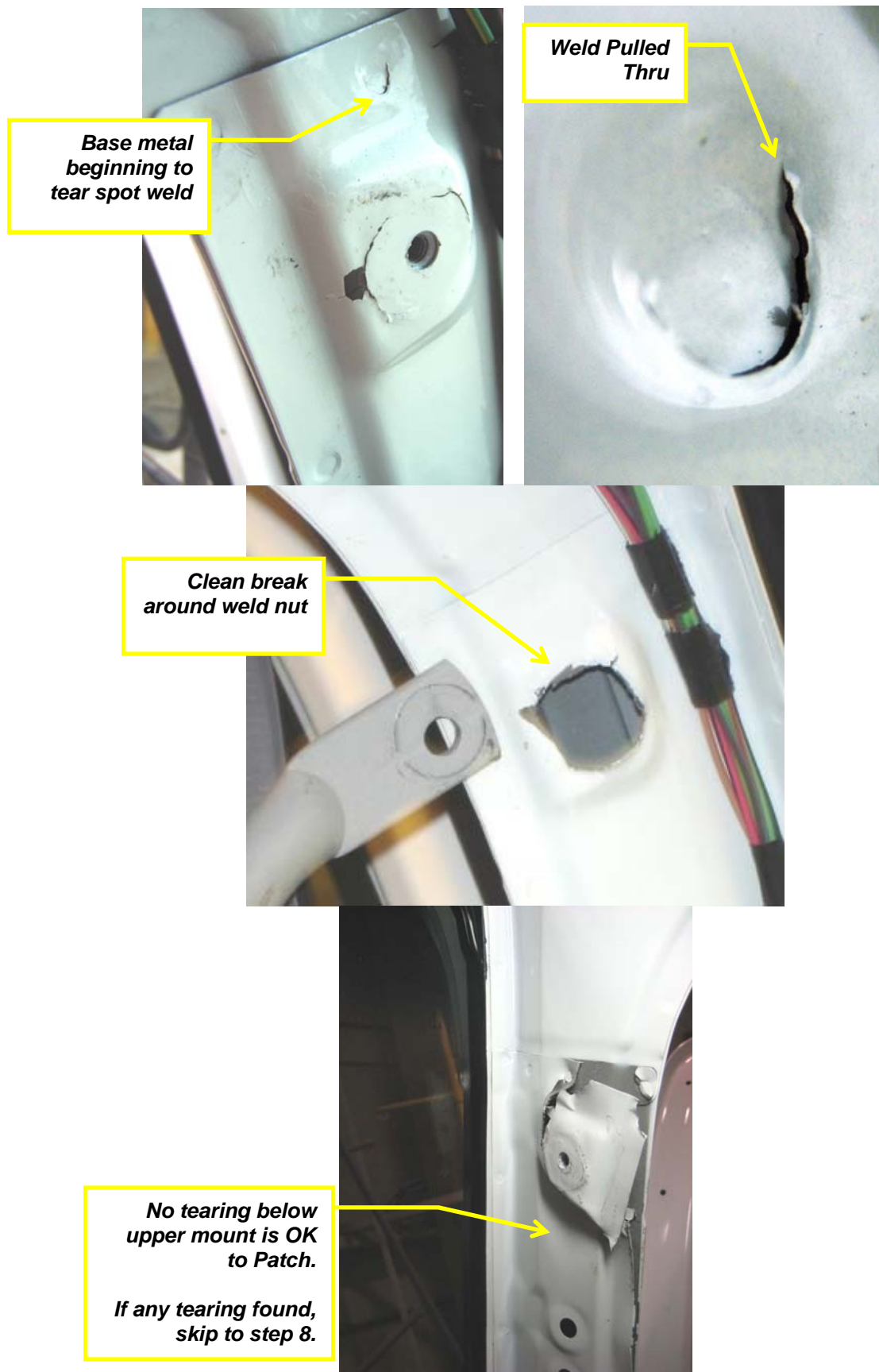


Figure 7

8. If **Severe Damage** to the a-pillar is found, contact **TECHNICAL SERVICES** for further instructions.

*The following figures represent what International considers evidence of extreme damage that requires a **complete a-pillar replacement** BEFORE installing new grab handles:*

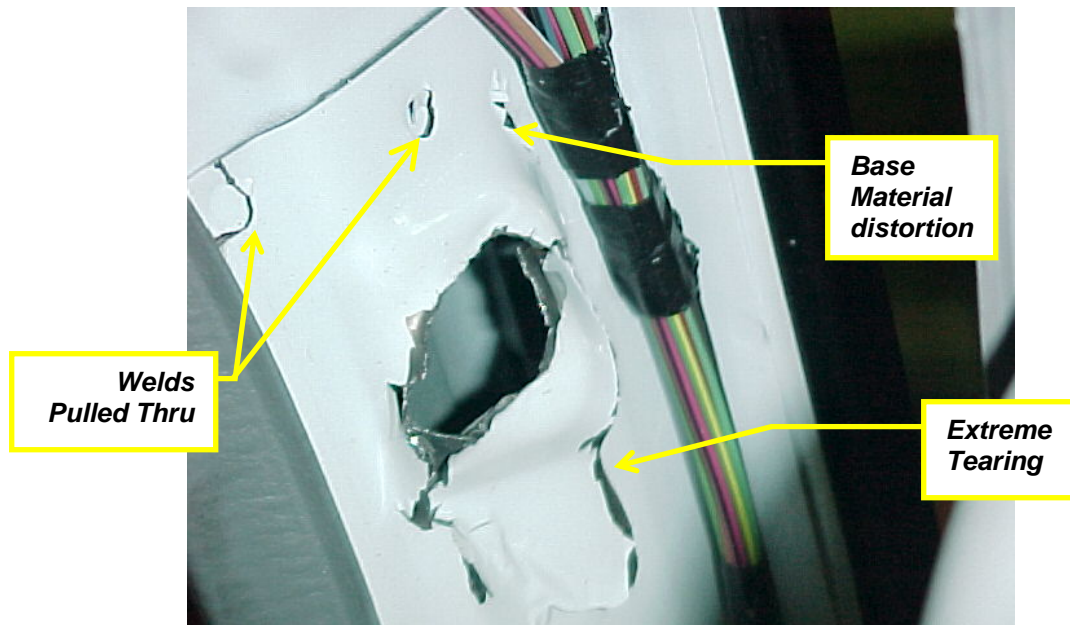


Figure 8

If there is any question regarding which level of repair is required, contact Technical Services at 1-800-366-4500 for review.

NEW GRAB HANDLE INSTALLATION (Level 1)

1. Ensure you have the necessary parts to complete this procedure. See Table 1.

Part Number	Part Description	Quantity
8900191R91	KIT,RECALL LCF GRAB HANDLES	1

Table 1 – Level 1 Repair Parts

2. Re-install both a-pillar interior trim panels. Re-attach wind lace.
3. Mount new grab handles using new hardware included in Recall Service Kit. Torque bolts to **7-9 LbF-Ft (10-11 Nm)**.

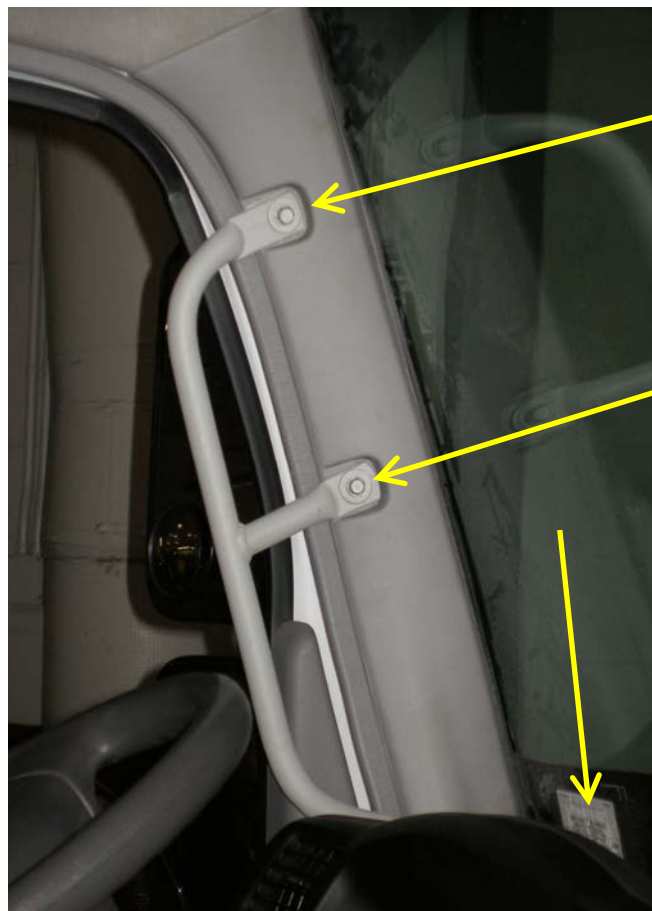


Figure 9

A-PILLAR PATCH (Level 2)

*You may need to perform this procedure on both a-pillars. Refer to **A-PILLAR ATTACHMENT INSPECTION**.*

1. Ensure you have the necessary parts to complete this procedure. See Table 2.

Part Number	Part Description	Quantity
8900193R91	KIT,RECALL LCF A-PILLAR PATCH	1 per side, MAX 2 per vehicle as per SERVICE PROCEDURE
TA-1	MOTORCRAFT BONDING ADHESIVE TA-1	1 per vehicle (1 tube will repair up to 2 cab sides)
501-040	ROTUNDA DISPENSER GUN 501-040	1 per dealer location (if necessary)

Table 2 – Level 2 Repair Parts

2. When performing this repair on the driver's side, first position the wiring harness on the a-pillar out of the way by disengaging the five (5) retainers and positioning the harness as far rearward as possible.

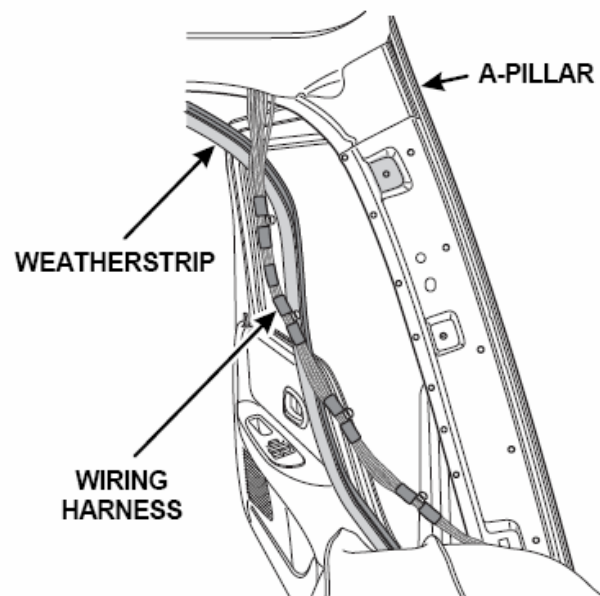


Figure 10

3. Remove the raised portion of the a-pillar where the weld nut was attached. This can be done by using a high speed cut-off wheel to remove the material, or by using a sheet metal hammer to flatten the material.

NOTE: To protect against sparks or steel filings causing damage to the interior of the vehicle, install protective covers in the following locations:

- Over the instrument panel and steering wheel
- Seat cushions
- Area of windshield directly ahead of the a-pillar
- Headliner. *Do not use adhesive tape directly onto the headliner.*

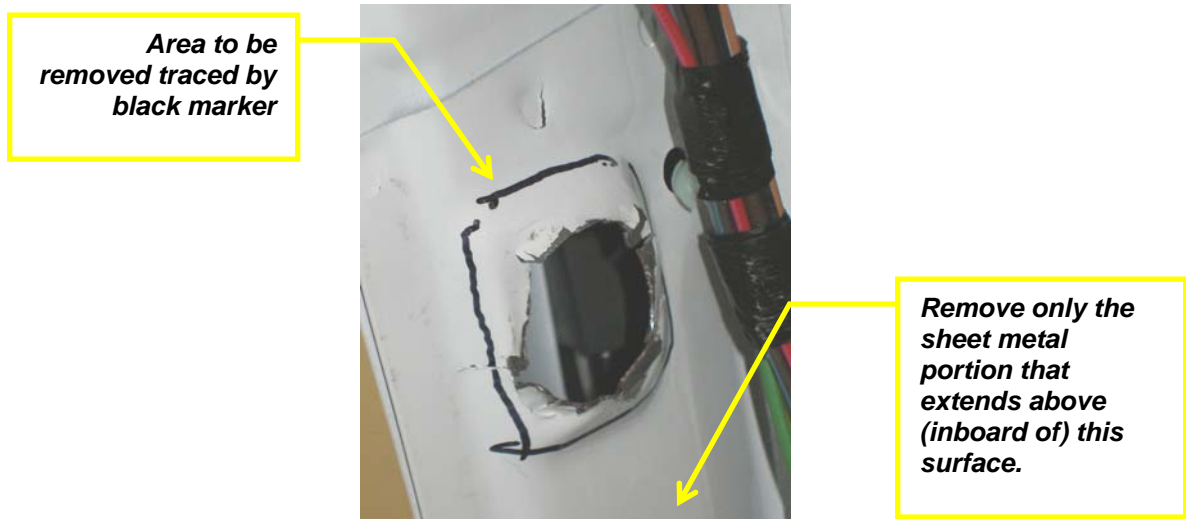


Figure 11a

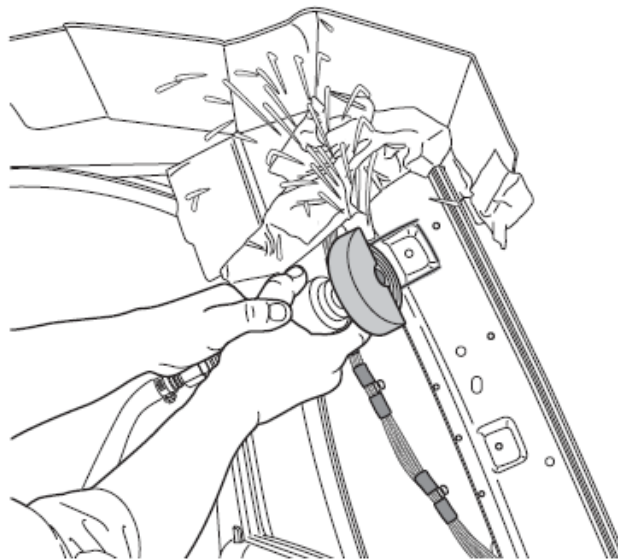


Figure 11b

4. Loosely attach **new grab handle** to patch, center mount and lower mount.

NOTE: Ensure grab handle's center mount is as far forward (toward the windshield) as possible before tightening

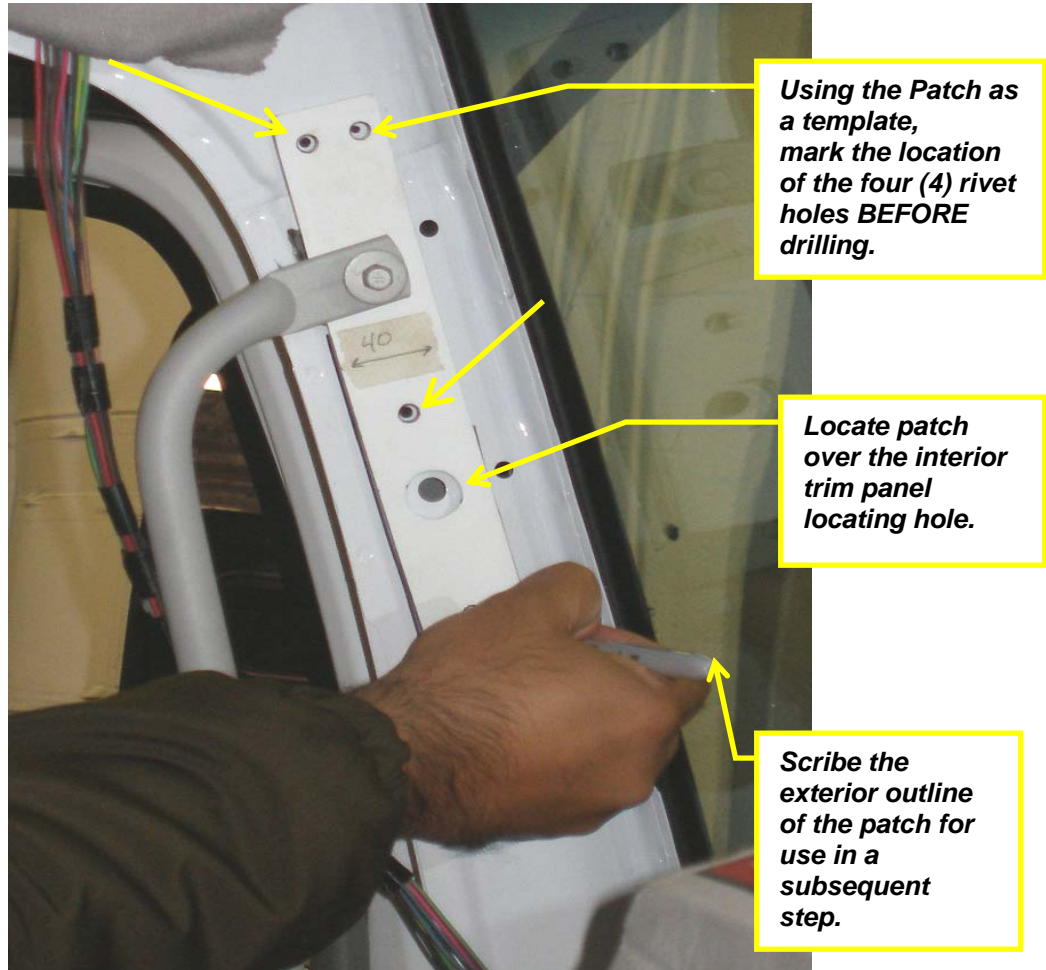


Figure 12

5. After rivet holes and patch outline are marked on the a-pillar, remove new handle from cab and patch.

6. Using a ¼" diameter drill bit, drill holes as marked and check rivet fit by pre-installing the patch.

NOTE: Patch and rivets should be able to be installed easily to minimize potential workability problems with the metal bonding adhesive.



Figure 13

7. Once patch and rivets can be installed easily, remove patch and rivets.

8. Using an angle grinder with a sanding wheel, clean the paint and primer from the surface of the a-pillar.

CAUTION: To avoid possible structural rigidity problems, **ONLY REMOVE PAINT COATING FROM A-PILLAR. DO NOT REMOVE ANY BASE METAL.**

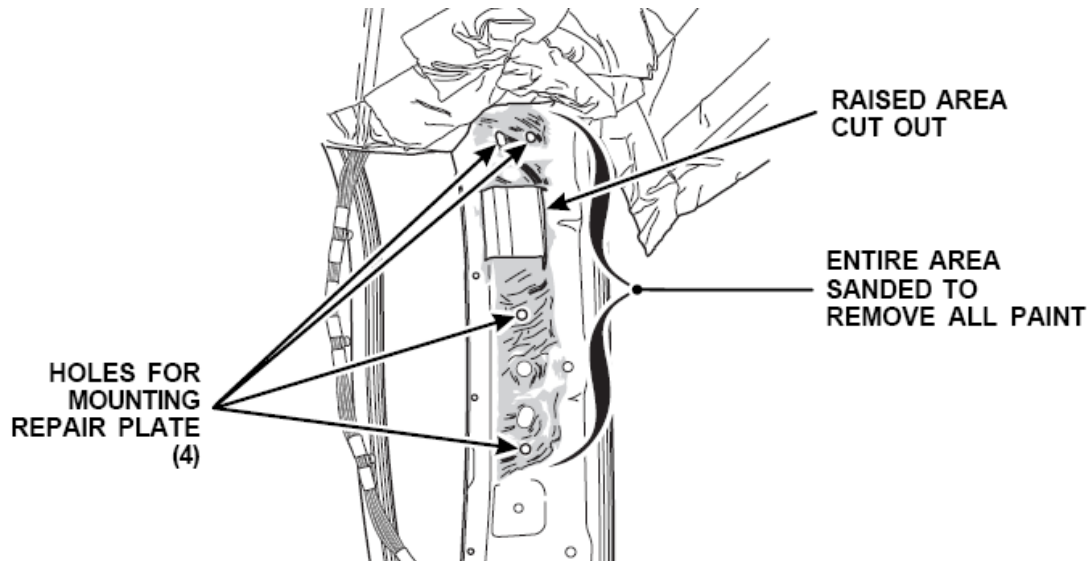


Figure 14

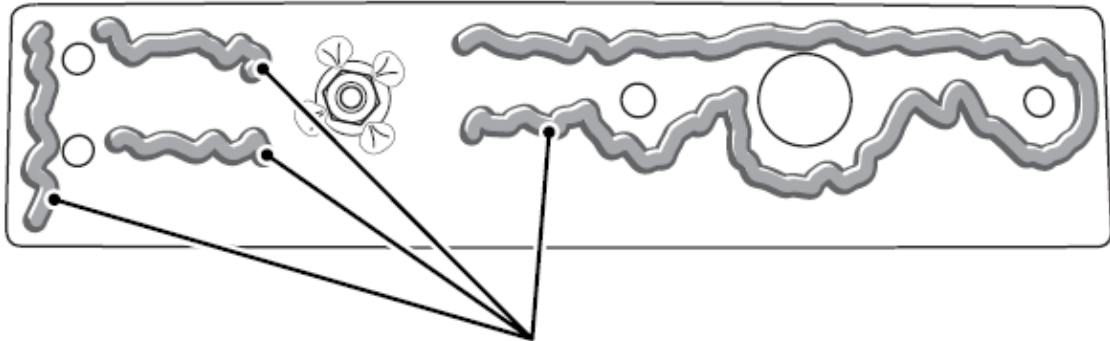
9. Using the sanding disc, clean the mating surface of the patch (side with weld nut).

NOTE: The a-pillar and mating surface of repair patch must be free of all paint, dirt, solvents and oil.

10. Prepare the tube of Motorcraft Metal Bonding Adhesive TA-1 as follows:

- Be sure the 2:1 plunger is installed in the Rotunda Dispenser Gun 501-040.
- Remove the protective cover off the back of the TA-1 cartridge, insert the cartridge into the dispenser gun and lock the enclosure.
- Cut the tip of the mixing tube down to the **second** largest ring.
- Remove the cap from the cartridge and install a mixing tip.
- Dispense a **2"-3"** (50-75 mm) long bead of adhesive onto a piece of scrap cardboard to ensure the product is properly mixed.

11. Apply the adhesive to the back of the patch in $\frac{1}{4}$ " (6mm) beads.



APPLY 6 mm (1/4 in) BEAD OF
TA-1 ADHESIVE TO PLATE AS SHOWN

Figure 15

12. Position the patch onto the a-pillar and secure with the rivets.

NOTE: Small amounts of adhesive squeezed out from under the plate should be left to dry. Remove only excessive amounts that may drip or contact the trip panel or wiring harness after the rivets are set.

13. Reattach the wiring harness (driver's side only).

14. Install new grab handles as per **NEW GRAB HANDLE INSTALLATION** procedure.

END OF SERVICE PROCEDURE

LABOR INFORMATION

<u>Operation No.</u>	<u>Description</u>	<u>Time</u>
A40-06511-1	<i>Inspect, R&R Grab Handle, no Patch</i>	0.5 hr
A40-06511-2	<i>ADD ON, for one (1) Patch Installation</i>	0.4 hr
A40-06511-3	<i>ADD ON, for two (2) Patch Installations</i>	0.8 hr

All vehicles require the Labor Op -1. Add on other labor operation as necessary.

CAMPAIGN IDENTIFICATION LABEL

*Each vehicle corrected in accordance with this campaign **must be** marked with a CTS-1075 Campaign Identification Label.*

Complete the label and attach on a clean surface next to the vehicle identification number (VIN) plate.

A rectangular label with a black border. At the top and bottom, it says "DO NOT REMOVE" in white capital letters. In the center, there is a white rectangular area with black text. The text includes "INTERNATIONAL" in bold, "Campaign No." followed by a line, "VIN" followed by a line, "Eng.#" followed by a line, "COMPLETED" in bold, and "Service Location Code #" followed by a line.

ADMINISTRATIVE/DEALER RESPONSIBILITIES (U.S. & POSSESSIONS)

Proceed immediately to make necessary correction to units in inventory. **All inventory vehicles subject to this recall campaign must be corrected prior to sale, transfer or delivery.** If vehicles have been sold or transferred and you are in receipt of Customer Notification Letters and Authorization for Recall Service cards for those vehicles, the transfer location or customer must be notified **IMMEDIATELY** from your dealer location.

Dealers must correct all vehicles subject to this campaign at no charge to the owner, regardless of mileage, age of vehicle, or ownership, from this time forward.

The National Traffic and Motor Vehicle Safety Act, as amended, provides that each vehicle that is subject to a vehicle recall campaign must be adequately **repaired** within a reasonable time after the owner has tendered it for repair. A failure to adequately repair within **60 days** after a tender of a vehicle is prima facie evidence of failure to repair within a reasonable time. If the condition is not adequately repaired within 60 days, the owner may be entitled to **replacement**

with an identical or reasonable equivalent vehicle at no charge, or to a **refund** of the purchase price less a reasonable allowance for depreciation.

However, consistent with the customer notification, dealers are expected to complete the repairs on the mutually agreed upon service date.

To avoid having to replace an owner vehicle or refund the purchase price, every effort must be made to promptly schedule an appointment with each owner to repair his or her vehicle as soon as possible.

During the recall process, a listing of owner names and addresses will be furnished to the involved dealers to enable dealers to follow up with owners and have the vehicles corrected. You must limit the use of this listing to this campaign because the list may contain information obtained from state motor vehicle registration records and the use of such motor vehicle registration data for purposes other than this campaign is a violation of law in several states.

WARRANTY CLAIMS

Refer to Dealer Warranty Manual for procedures to conduct Recall Campaigns.

It is important that the Recall 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:

	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						

ADMINISTRATIVE/DISTRIBUTOR RESPONSIBILITY (EXPORT)

Proceed immediately to make necessary correction to units in inventory. All inventory vehicles subject to this recall campaign must be corrected prior to sale, transfer or delivery. If vehicles have been sold or transferred and you are in receipt of Customer Notification Letters and Authorization for Recall Service cards for those vehicles, the transfer location or customer must be notified from your distributor location.

Export locations are to submit warranty claims in the usual manner making reference to this recall number.

We ask for your full cooperation and follow-up to this important subject matter. If you have any questions or need further assistance, please contact the Regional Service Manager at your regional office.

INTERNATIONAL TRUCK AND ENGINE CORPORATION

INTERNATIONAL SAFETY RECALL 06511

EXCELDA FAX ORDER FORM

Please indicate the quantity you require below:

Part Number	Part Description	Quantity per Vehicle	Quantity Requested
TA-1	MOTORCRAFT METAL BONDING ADHESIVE TA-1	1 per vehicle (1 tube will repair up to 2 cab sides)	
501-040	ROTUNDA DISPENSER GUN 501-040	1 per dealer location (if necessary)	

Please indicate your shipping address and contact information below:

Dealership Name	
Contact Name	
Street	
City	
State	
Zip	
Phone/Fax Number	
Email	

Your order will be shipped at no charge to address indicated above.

FAX OR EMAIL THIS ORDER FORM TO THE FOLLOWING:

EMAIL: service@excelda.com

Fax : (248) 486-6874 Attn: SERVICE

If you have difficulty submitting this form, please contact International TECH SERVICE at 1-800-366-4500.



LINCOLN



Mercury

Motorcraft

Rotunda

Material Safety Data Sheet

FIR No.: 156626
Version Number: US-US-3

Level: 3
Release Date: 2006-09-15

1. Product and Company Identification

Product Name: Metal Bonding Adhesive
Product Code: See Attachment
Application: Metal bonding adhesive
Supplier: Ford Motor Company
 Attention: MSDS Information, P.O. Box 1899
 Dearborn, Michigan 48121
 1-800-392-3673

Emergency Telephone: Poison Control Center: 1-800-959-3673
 CHEMTREC: U.S. and Canada: 1-800-424-9300
 CHEMTREC: International: 1-703-527-3887

2. Composition/Information on Ingredients

This chemical product is a preparation.

Chemical Name	CAS Number	Percent Concentration	Hazard Classification
METHYL METHACRYLATE	80-62-6	>30-60	CAA-HAP HAZCOM RQ RSMSREST WHMIS 1 SARA 313
METHACRYLIC ACID	79-41-4	1-5	HAZCOM WHMIS 1

3. Hazards Identification

Flammable liquid and vapor.

Health: This product may be harmful if it is absorbed through the skin.
 This product is irritating to the eyes, respiratory system and skin.
 This product may cause sensitization by skin contact.
 This product is harmful if swallowed.

Environment: Material contains a chemical which is a Hazardous Air Pollutant (HAP), regulated by the United States Clean Air Act.

4. First-Aid Measures

Inhalation: If gas/fume/vapor/dust/mist from the material is inhaled, remove the affected person immediately to fresh air.
 If irritation persists, get medical attention.

Skin Contact: Wash skin with soap and water.
 If irritation persists, get medical attention.



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Eye Contact:	In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
Ingestion:	If the material is swallowed, do not induce vomiting. Get immediate medical attention or advice -- give several glasses of water or milk. Do not give anything by mouth to an unconscious or convulsing person.
Notes to a Physician:	If the affected person's breathing is difficult, give oxygen.

5. Fire-Fighting Measures

Extinguishing Media:	Dry chemical, foam, carbon dioxide, water fog.
Specific Methods:	Water may be used to cool exposed containers to prevent pressure build-up and explosion when exposed to extreme heat.
Specific Hazards:	Due to pressure buildup, closed containers exposed to excess heat may explode. Empty containers may retain product residue including Flammable or Explosive vapors. Do not cut, drill, grind, or weld near full, partially full, or empty product containers.
Protection of Firefighters:	Fire fighters should be equipped with NIOSH-approved, self-contained breathing apparatus (SCBA) and full protective clothing.

6. Accidental Release Measures

Personal Precautions:	Avoid skin contact and inhalation of vapors during disposal of spills. Eliminate all sources of ignition or flammables that may come into contact with a spill of this material.
Environmental Precautions:	No available information.
Methods for Cleaning Up:	Absorb the spilled material with an inert absorbent (nonflammable) material.

7. Handling and Storage

Handling:	
Technical Measures:	Keep this product from heat, sparks, or open flame. Protect electric equipment against sparking in case of risk of explosion.
Precautions and Advice for Safe Handling:	Do not puncture the container. Use with adequate ventilation.
Storage: Technical Measures:	No special precautions necessary.



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Storage Conditions:

Ground all containers of this material.
 Keep the container tightly closed and in a cool, well-ventilated place.
 Keep this product from heat, sparks, or open flame.

8. Exposure Controls/Personal Protection

Engineering Measures:

Use adequate ventilation to control airborne concentrations below the exposure limits/guidelines. If user operations generate a vapor, dust, and/or mist, use process enclosure, local exhaust ventilation, or other engineering controls to control airborne levels below the recommended exposure limits/guidelines.

Exposure Limits:

Chemical Name	TWA 8 hr	STEL/C	References
METHACRYLIC ACID	20(ppm)		ACGIH
			OSHA
METHYL METHACRYLATE	50(ppm)	100(ppm)	ACGIH
	100(ppm)	410(ppm)	OSHA

Personal Protective Equipment:

Respiratory Protection:

If engineering controls do not maintain airborne concentrations to a level which is adequate to protect worker health, an approved respirator must be worn. Respirator selection, use and maintenance should be in accordance with the requirements of OSHA Respiratory Protection Standard 29 CFR 1910.134 and/or Canadian Standard CSA Z94.4.

Hand Protection:

Use of impervious gloves is recommended, such as neoprene.

Eye Protection:

Wear chemical goggles.

Skin and Body Protection:

Remove contaminated clothing and wash before reuse.

Hygiene Measures:

When using this material, do not eat, drink or smoke.
 Wash thoroughly after handling.



Material Safety Data Sheet

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Level: 3
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9. Physical and Chemical Properties

Specific Gravity:	1.13
Physical State:	PASTE
Odor:	SWEET
Color:	OFF-WHITE
pH:	N.AV
Temperature Range During which Changes in Physical State Occur:	
Boiling Point:	>60 °C
Flash Point:	15.56 °C SETAFLASH
Auto-ignition Temperature:	N.AV
Explosion Properties:	
UEL:	8.8 %
LEL:	1.6 %
Vapor Density:	>1 (AIR = 1)
Solubility:	INSOLUBLE IN WATER
Viscosity:	N.AV
Evaporation Rate:	<1

10. Stability and Reactivity

Stability:	Hazardous polymerization will not occur. This is a stable material.
Conditions and Materials to Avoid:	Static discharge, friction, sparks, open flames, heat and other sources of ignition. This product reacts with acids.
Hazardous Decomposition Products:	Carbon monoxide, carbon dioxide. Decomposition of this product may yield oxides of nitrogen upon decomposition. Irritating and toxic gases or fumes may be released during a fire.



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11. Toxicological Information

80-62-6 METHYL METHACRYLATE
Inhalation, adult rat, LC50 = 3750 ppm
80-62-6 METHYL METHACRYLATE
Oral, adult rat, LD50 = 7872 mg/kg
79-41-4 METHACRYLIC ACID
Skin, adult rabbit, LD50 = 500 mg/kg

Inhalation:

Excessive inhalation of this material causes headache, dizziness, nausea and incoordination.

Skin Contact:

May cause allergic skin reaction.
Prolonged and/or repeated skin contact with this product may cause irritation/dermatitis.

12. Ecological Information

No specific aquatic data available for this product.

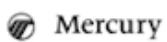
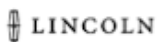
13. Disposal Considerations

Waste from Residues:

Dispose of waste material according to Local, State, Federal, and Provincial Environmental Regulation.

Contaminated Packaging:

No available information.



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14. Transport Information

U.S. Department of Transportation (DOT) 49 - CFR 172.101

Proper Shipping Name: Adhesives

UN Number: UN1133

Hazard Class / Division: 3

Packing Group: II

Reportable Quantity (per packaging):

CAS	RQ	Name
62-53-3	>100000	ANILINE
75-56-9	>100000	PROPYLENE OXIDE
80-62-6	2857	METHYL METHACRYLATE

Regulated Quantity:

Bulk	Non-Bulk	Limited Quantity
X	X	

Label: FLAMMABLE LIQUID

Canadian Transportation of Dangerous Goods (T.D.G.) - TDGR Schedule II

Proper Shipping Name: ADHESIVES

UN Number: UN1133

Hazard Class / Division: 3

Packing Group: II

Regulated Quantity:

Bulk	Non-Bulk	Limited Quantity
X	X	

Label: FLAMMABLE LIQUID



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Secretary of Communication and Transportation (SCT) - NOM-002-SCT2/1994 (Mexico)

Proper Shipping Name: ADHESIVOS

UN Number: UN1133

Hazard Class/Division: 3

Packing Group: II

Regulated Quantity:

Bulk

Non-Bulk

Limited Quantity

X

X

Label: FLAMMABLE LIQUID

International and Domestic Air Transportation - ICAO & IATA Section 4.2

Proper Shipping Name: ADHESIVES

UN Number: UN1133

Hazard Class/Division: 3

Packing Group: II

Label: FLAMMABLE LIQUID

International Water Transportation - IMDG Code Amendment 31-02

Proper Shipping Name: ADHESIVES

UN Number: UN1133

Hazard Class/Division: 3

Flashpoint: 15.56 °C Setaflash

Packing Group: II

Ems Number: 3-05

Regulated Quantity:

Bulk

Non-Bulk

Limited Quantity

X

X

Label: FLAMMABLE LIQUID

15. Regulatory Information

This product contains a toxic chemical or chemicals subject to the reporting requirements of Section 313 of Title III of the Superfund Amendments and Reauthorization Act of 1986 and 40 CFR Part 372.

This product contains an ingredient(s) considered to be an environmental hazardous substance(s) by the State of New Jersey.

This product contains an ingredients(s) considered to be a hazardous substance(s) by the State of New Jersey.

Material contains a chemical which is a Ford Motor Company Material of Concern. Use and release of this material should be minimized to the greatest extent possible.



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16. Other Information

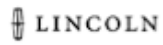
Key/Legend: N.AP = Not applicable; N.AV = Not available; ND = Not determined or No data; TLV = Threshold limit value; TWA = Time-weighted average; STEL = Short-term exposure limit; C = Ceiling limit

Preparation Information:

The chemical identification and properties for this material were provided by the manufacturer. For Canadian locations, a manufacturer's MSDS is available upon request. Health and safety information has been evaluated by the Occupational and Environmental Health Sciences Department, Ford Motor Company, National Parts General Office, MD74, 29500 Plymouth Road, Livonia, MI 48150, USA.

Disclaimer:

The information on this data sheet represents our current data and is accurate to the best of our knowledge as to the proper handling of this product under normal conditions and in accordance with the application specified on the packaging and/or technical guidance literature. Any other use of the product which involves using the product in combination with any other product or any other process is the responsibility of the user.



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Attachment

Product Code	Container Size	Part of Kit	Kit Product Code
TA-1	1.7 fl. oz. (50 mL)	Sheet Metal Bonding Kit	TA-7-A(Inactive)
TA-1-A (Obsolete)	1.7 fl. oz. (50 mL)		
TA-1-B	7.6 fl. oz. (225 mL)		