

Tail Pipe Skid Plate Bracket Rework

Description:

This procedure outlines the steps to replace the welded bracket with the bolted-on brackets for the tailpipe skid plate.

This procedure applies to J4500 coaches of MY 2018/19 within the VIN range: 68801-69485 and D45CRT coaches of MY 2019 within the VIN range 81000-81027.

WARNING

Read this entire procedure before beginning work.

Use Safe Shop Practices at All Times.

To avoid personal injury:

- a. Proper Personal Protective Equipment (PPE) must be worn. Safety glasses and protective gloves are required for working with DEF Fluid.*
- b. Turn the main battery disconnect switch to the OFF position.*
- c. Ensure that both the front and the rear wheels are chocked.*
- d. Positioning the ENGINE RUN and ENGINE START switches on the engine compartment remote control box to the OFF position.*
- e. Allow enough time for components to cool down prior to working in the engine compartment.*

1.0 Material requirements:

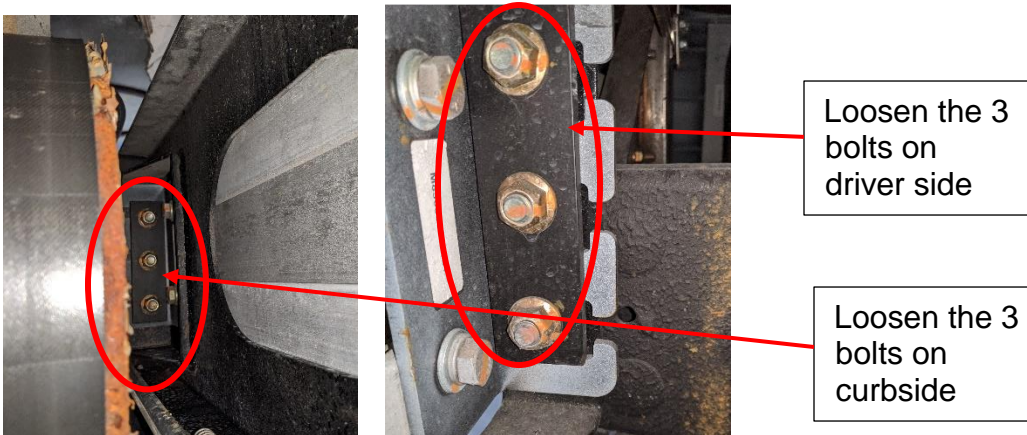
ITEM	PART NO	QTY	U/M	DESCRIPTION
1	T03-3076	1	EA	Bracket- Skid Plate, RH
2	T03-3077	1	EA	Bracket- Skid Plate, LH
3	T19-1170	4	EA	Bolt- Hex, 3/8-16, 3.25LG, SST
4	T19-1171	4	EA	Nut- Hex, 3/8-16, SST
5	19-2-63	4	EA	Washer-Flat, 3/8 ID, SST
6	T19-1172	4	EA	Washer- LK, 3/8ID, SST

2.0 Special Tools:

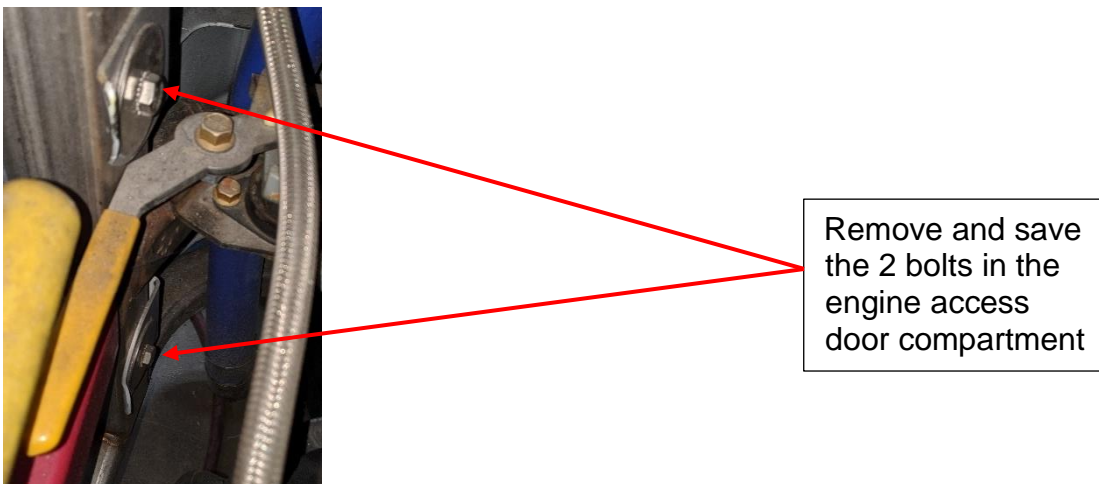
No special tools required.

3.0 Remove the existing skid plate brackets:

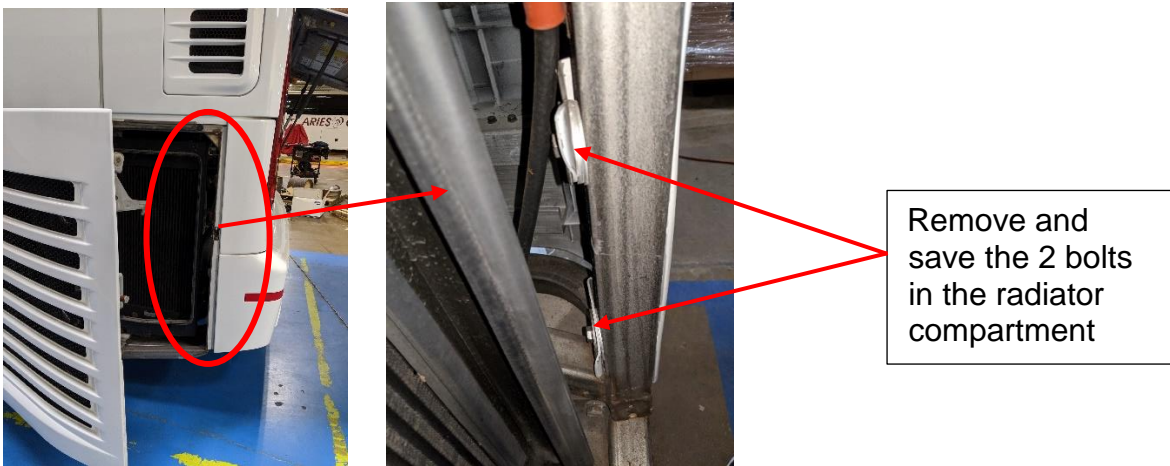
Loosen the 6 bolts securing the rear bumper to the coach.



Remove and save the 2 bolts securing the rear bumper to the coach frame in the engine access door compartment.

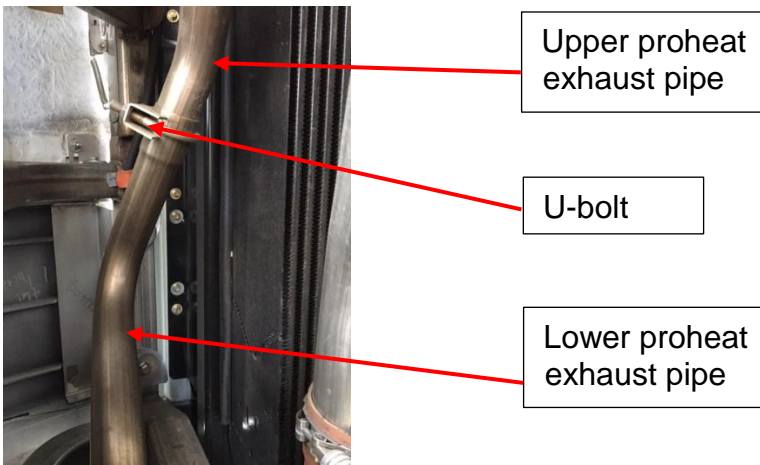


Remove and save the 2 bolts securing the rear bumper to the coach frame in the radiator compartment.

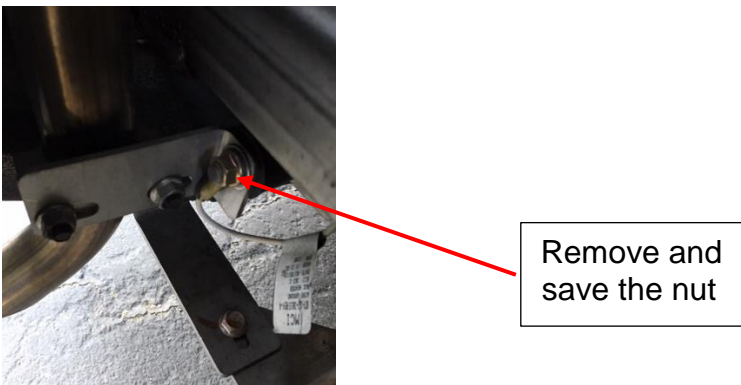


Remove and save the bumper.

Remove and save the two nuts on the U-bolt securing the upper proheat exhaust pipe to the lower proheat exhaust pipe. Save the clamp and U-bolt.



Remove and save the nut securing the lower proheat exhaust pipe to the bracket on the coach. Slide-out the lower proheat exhaust pipe and save it.

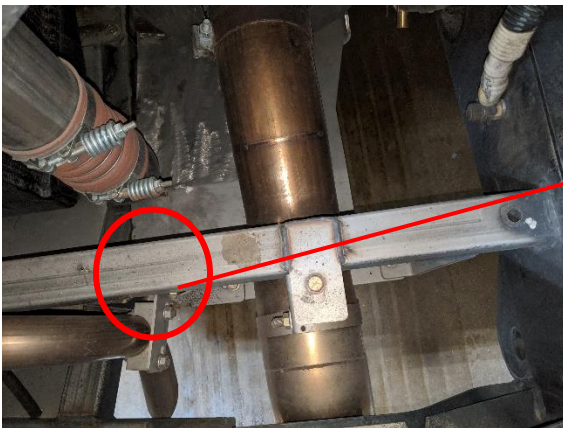


Remove and save the bolt securing the outboard skid plate bracket and skid plate.



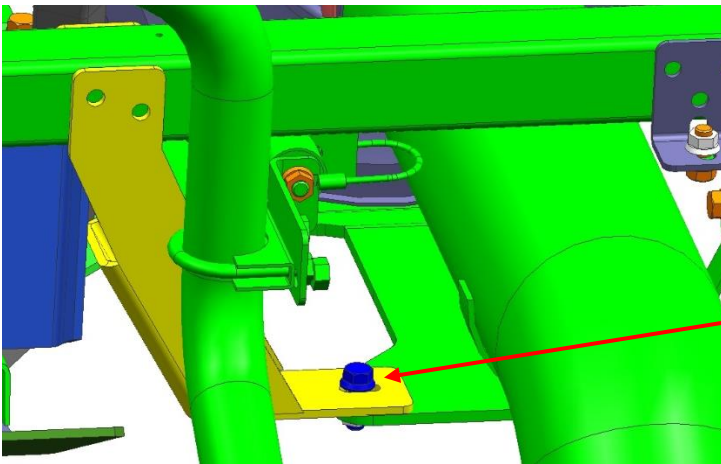
Remove and save the bolt

Grind the weld on the outboard skid plate bracket. Discard the bracket.



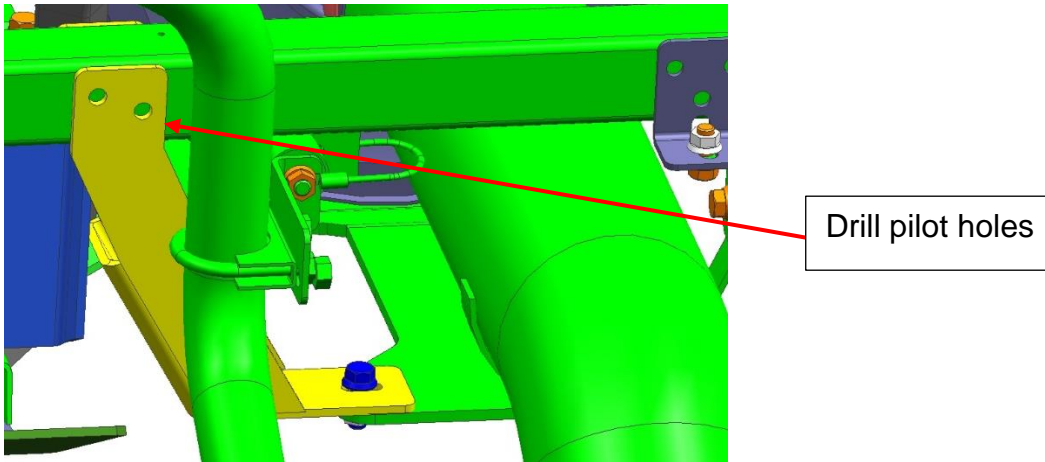
Grind the weld

Install the new LH skid plate bracket, MCI P/N: T03-3077, using the hardware removed in the previous step.

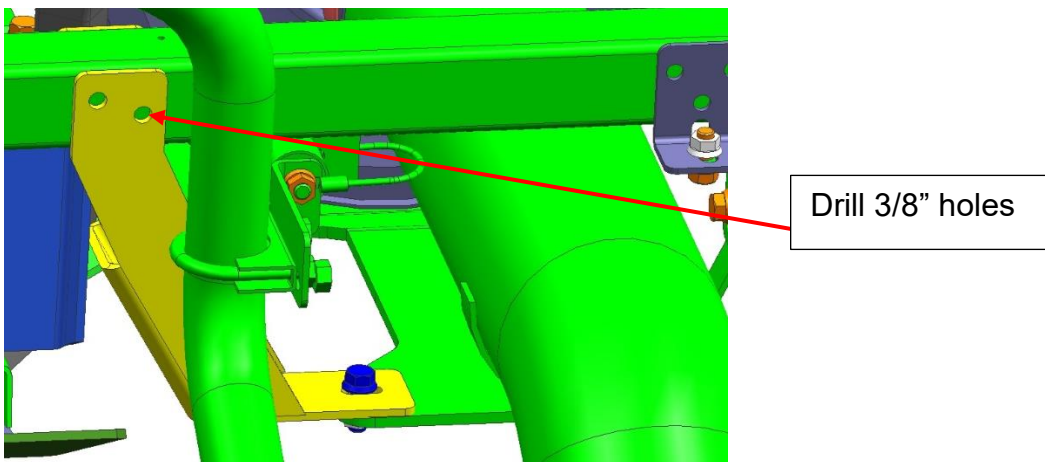


Existing hardware

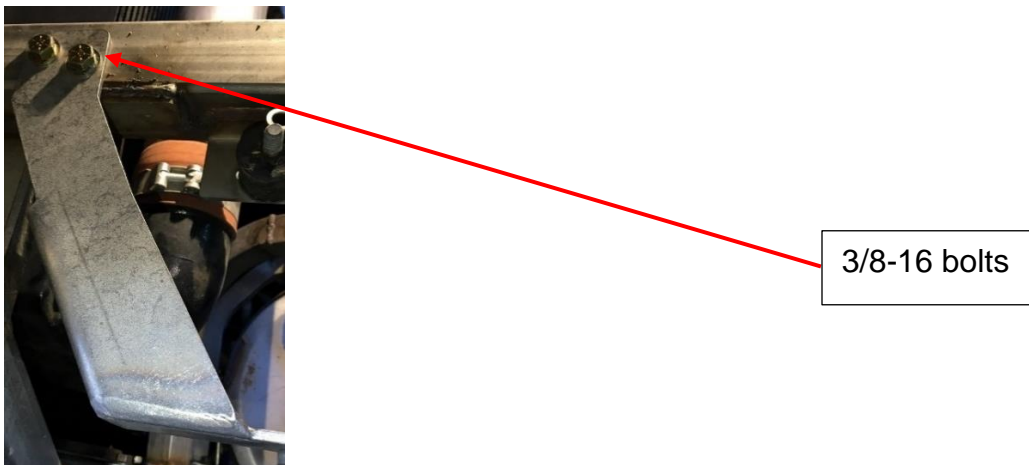
With the holes on the new bracket as template drill pilot holes in the frame using a 1/4" drill bit.



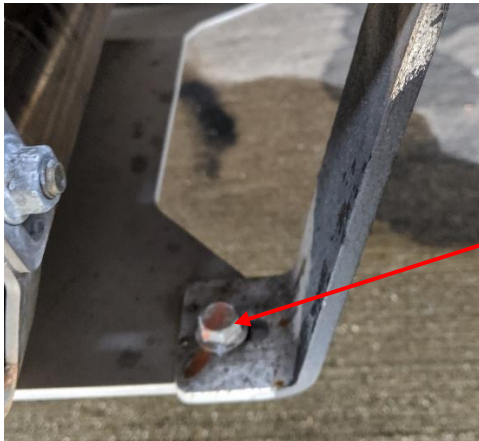
Match drill the holes in the bracket using a 25/64 drill bit.



Using the 3/8-16 bolt (MCI P/N: T19-1170, 3/8-16 nut (MCI P/N: T19-1171), 3/8 washer (MCI P/N: 19-2-63), and 3/8 lock washer (MCI P/N: T19-1172) secure the LH skid plate bracket to the coach frame. Torque the bolts to 20 Ft-Lbs.

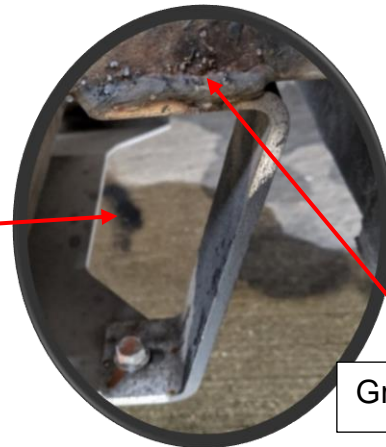


Remove and save the bolt securing the inboard skid plate bracket and skid plate.



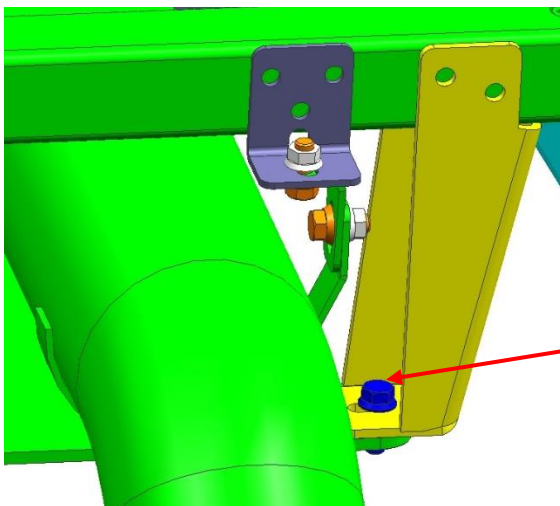
Remove and save the bolt

Grind the weld on the inboard skid plate bracket. Discard the bracket.



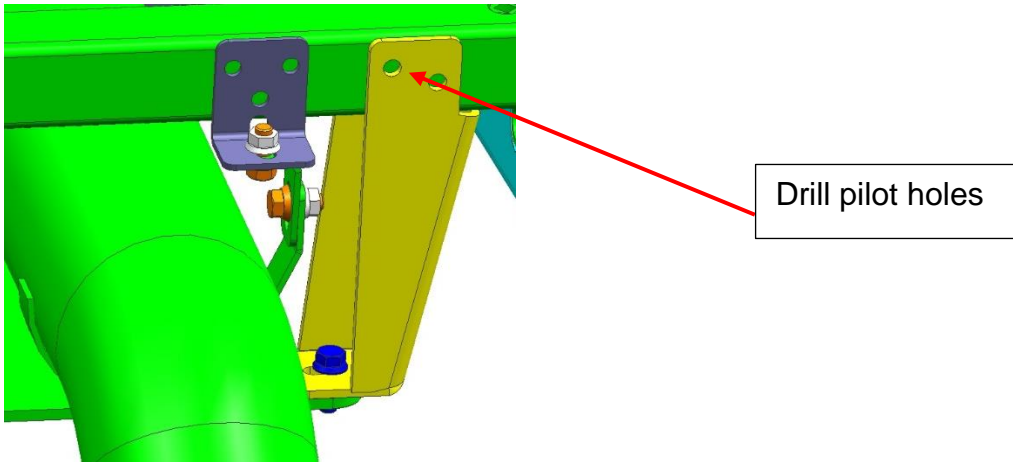
Grind the weld

Install the new RH skid plate bracket, MCI P/N: T03-3076, using the hardware removed in the previous step.

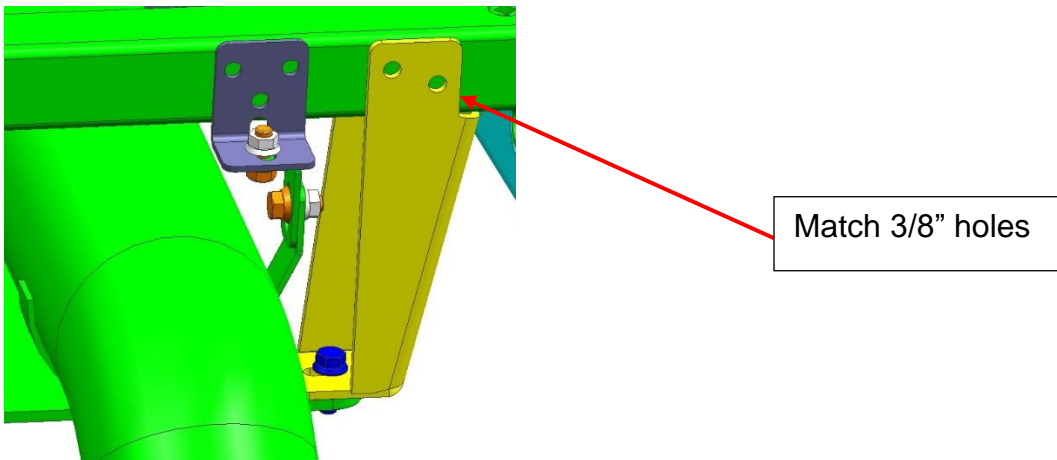


Existing hardware

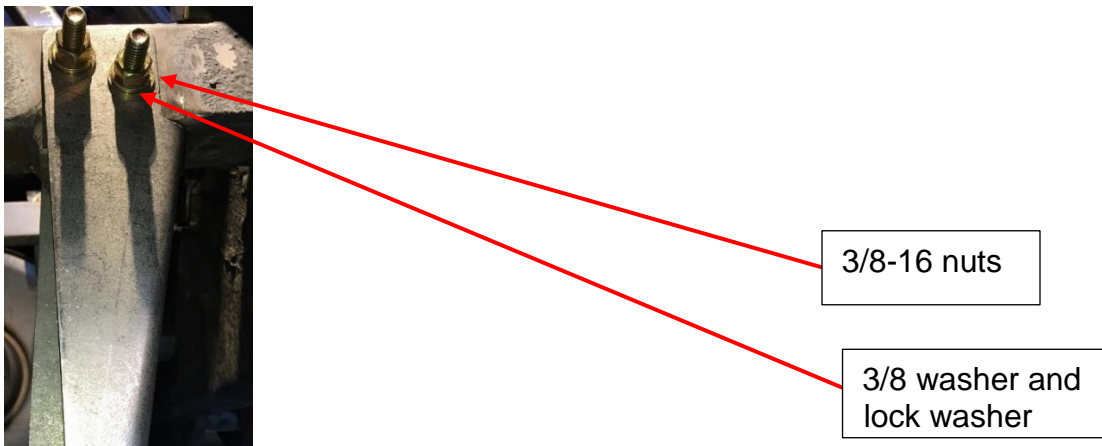
With the holes on the new bracket as template drill pilot holes in the frame using a 1/4" drill bit.



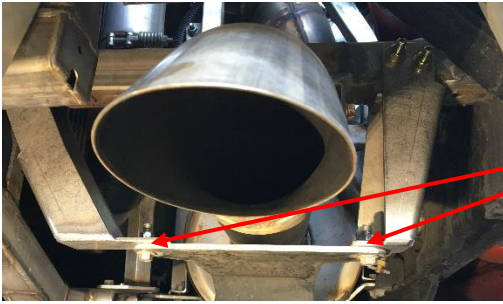
Match drill the holes in the bracket using a 25/64 drill bit.



Using the 3/8-16 bolt (MCI P/N: T19-1170, 3/8-16 nut (MCI P/N: T19-1171), 3/8 washer (MCI P/N: 19-2-63), and 3/8 lock washer (MCI P/N: T19-1172) secure the RH skid plate bracket to the coach frame. Torque the bolts to 20 Ft-Lbs.

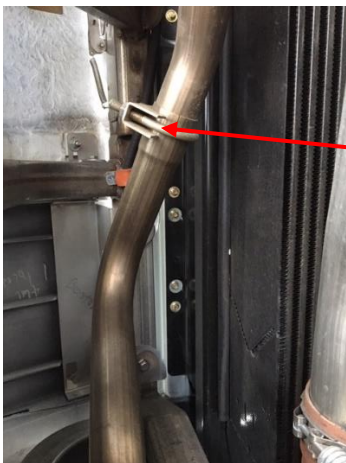


Torque the bolts securing skid plate brackets and skid plate to 33-37 Ft-Lbs.



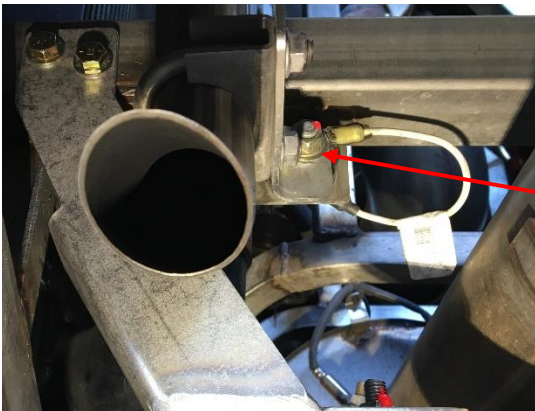
Torque the bolts to 33-37Ft-Lbs

Slide the lower upper exhaust pipe in the lower proheat exhaust pipe and secure them with the existing clamp, U bolt, and nuts.



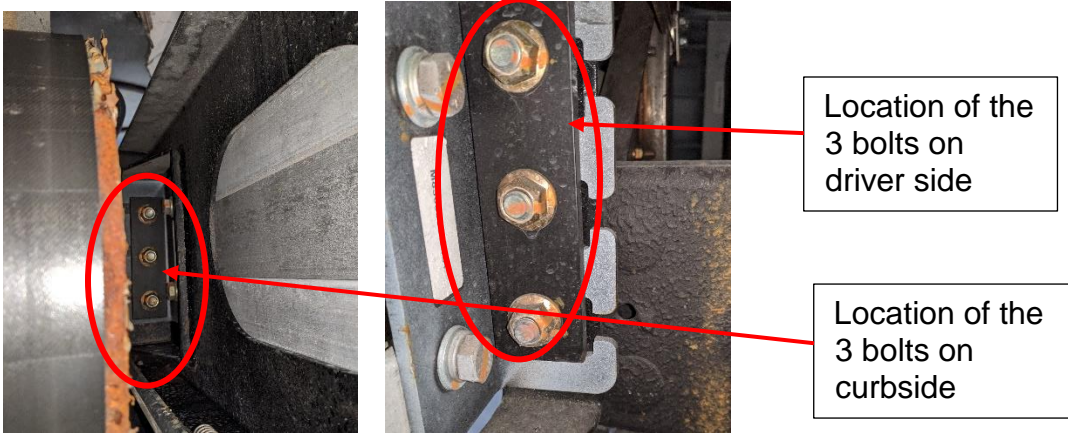
Clamp, U-bolt and nuts

Secure the lower proheat exhaust pipe to the bracket on the coach using the existing nut.

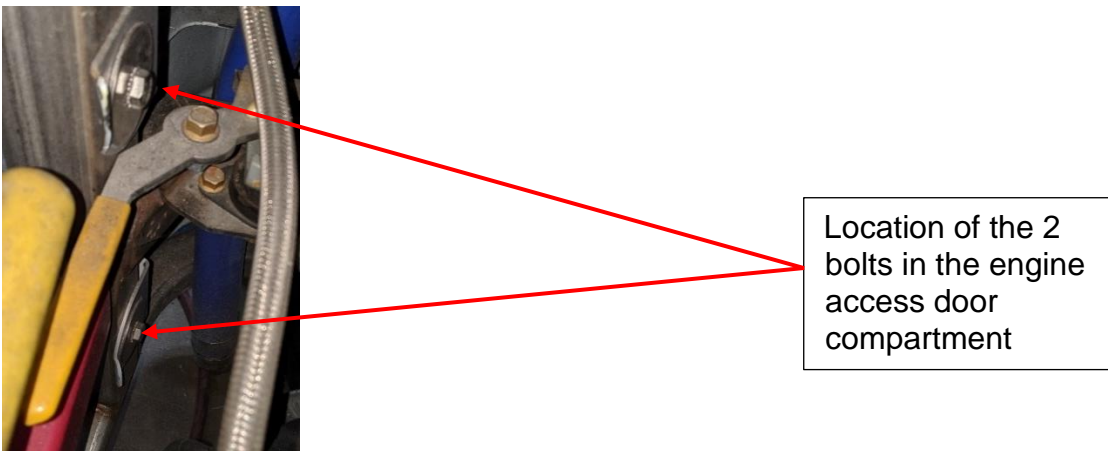


Existing hardware

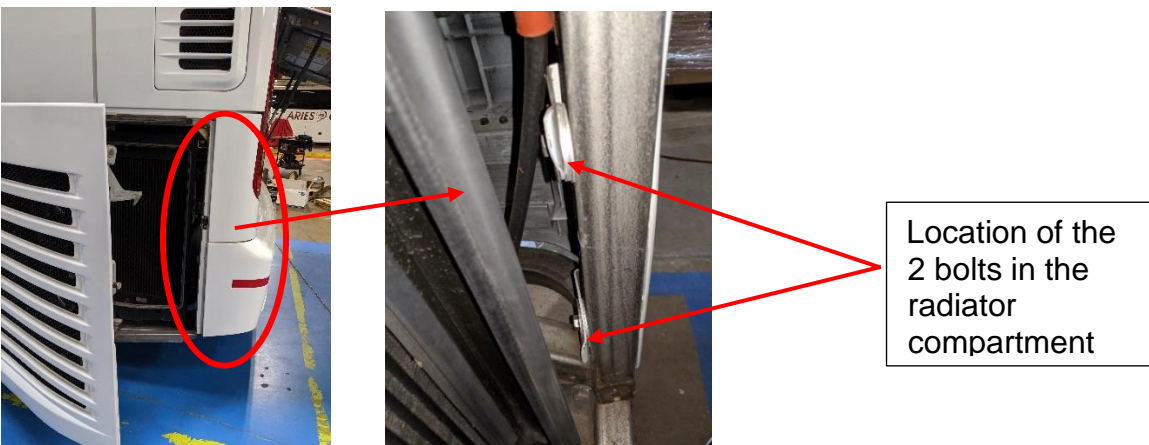
Install the bumper to the rear frame of the coach and tighten the 6 existing bolts to 65-75 Ft-Lbs.



Secure the bumper to the coach frame in the engine access door compartment using the existing bolts removed in Step2 and torque them to 18-22 Ft-Lbs.



Secure the bumper to the coach frame in the radiator compartment using the existing bolts removed in Step3 and torque them to 18-22 Ft-Lbs.



End of the procedure