



**TEMSA**

# SERVICE BULLETIN

**Subject:** Assembly Improvement of the Floor Hatches

**Bulletin Type:** Field Fix Mandatory

**Bulletin No:** TS45-SR-1905

**PQR No:**

**Rev No:**

**Ref. No:** 700003771

**Vehicle Model:** TS45

**Flat Rate Time / Code:** 180 min

**Date of issue:** 12/23/2019

**Modify Before:** 12/23/2020

**What to do with off coming parts:**

- Scrap
- Return
- Use with additional parts
- On consignment
- No off coming parts

**What to do with outstanding parts of previous revision:**

- Scrap
- Return
- Use with additional parts
- On consignment
- No outstanding parts

**Description of the modification:**

This document describes the recommended steps for improvement the level of maintenance lids.

**Bulletin Responsible:** Beytullah Özdemir

**Published & Approved By:** Sibel Perçin

## SAFETY INSTRUCTIONS

### 1. Mechanical Requested Dress Code

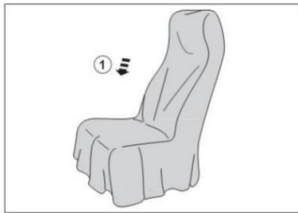


#### WARNING:

- Dress properly to avoid personal injury and damage to the vehicle

- ✓ Always wear protective clothing
- ✓ Do not wear any worn or loose-fitting clothing
- ✓ Remove jewelry before starting to work
- ✓ In case of long hair, use hairnet
- ✓ The illustration on the left shows some of the correct and incorrect clothing
- ✓ Sharp edged items should be avoided in order not to scratch vehicle (i.e. belts, watches, necklace)

### 2. Protect Seats when Mechanic Starts Working

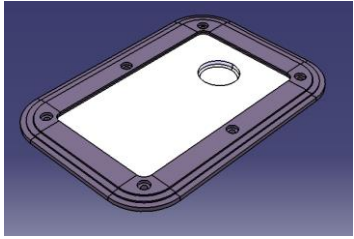
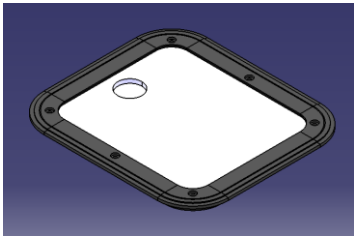


- ✓ Seats, trimming, upholstery stuff and carpeting should be protected with appropriate coverings.

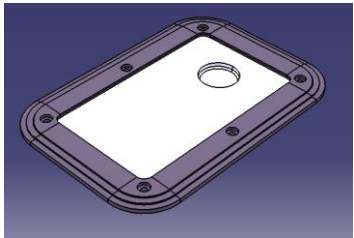
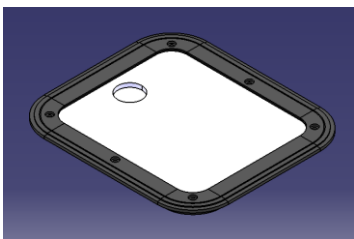
### 3. Welding on the Chassis

- Always disconnect the batteries (starting with the negative lead).
- Disconnect the connectors of electrical and electronic equipment (electronic control units, sensors and actuators) if they are less than 2 meters away from the chassis part to be welded or the earth terminal of the welding equipment.
- The earth terminal should never be attached to vehicle components such as engine, axles and springs. Arcing on these parts is not permitted, because of the risk of damage to bearings, springs, etc.
- The earth terminal must make good contact and be placed as close as possible to the part to be welded.
- Plastic pipes, rubber parts and parabolic springs should be well protected against welding spatter and temperatures higher than 70°.
- The contact switch must not be in the accessory or contact position. The contact key should be removed.
- Reconnect in reversed order of disconnecting. Ensure that a good earth connection is made between chassis, engine and cab.

### Included Part List

No	Part Number	Part Name	Picture	Qty	Unit
1	HD201276Y	MAINTENANCE LID, FRONT CHASSIS		1	Piece
2	HD201291Y	MAINTENANCE LID, FUEL TANK		1	Piece
3	SM-07Y	SEALER, TEROSTAT 8599,BLACK,310 ML, GLASS		6	Pieces
4	SM-57Y	PRIMER, (Tst 8517 H 500 ml, HENKEL)		1	Piece

### Excluded Part List

No	Part Number	Part Name	Picture	Qty	Unit
1	HD201276Y	MAINTENANCE LID, FRONT CHASSIS		1	Piece
2	HD201291Y	MAINTENANCE LID, FUEL TANK		1	Piece

## TECHNICAL INSTRUCTIONS

1. Dismount the HD201276Y numbered maintenance lid which is located on the front chassis (See Figure-1)

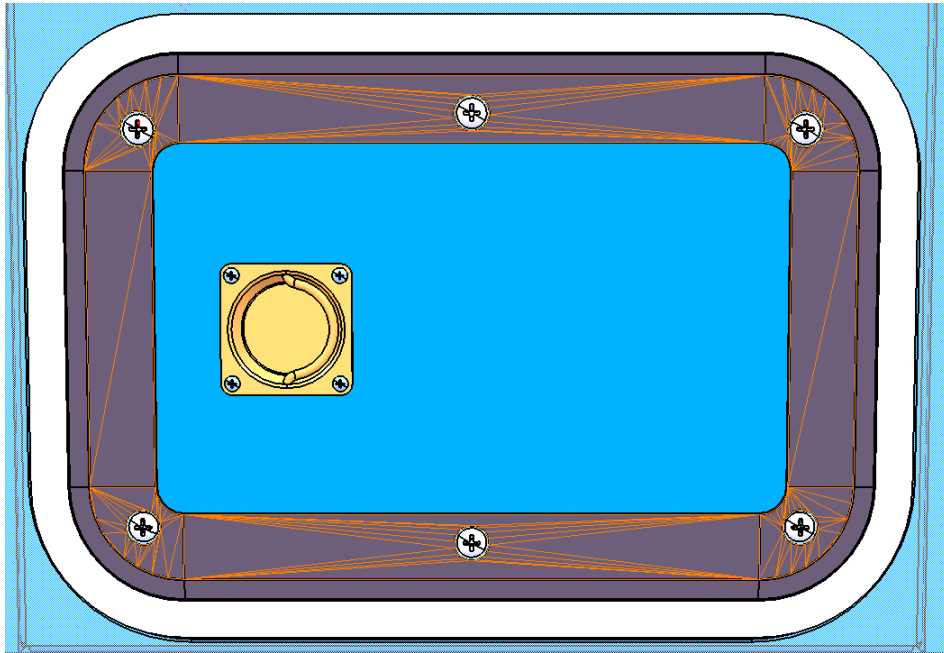


Figure-1

2. Cut the sealer which is under the frame (RP201139Y) as shown in the picture below by using utility knife and handle pry bar (See Figure-2).



Figure-2

3. Cut the sealer residues by using utility knife (See Figure-3).



Figure-3

4. Remove the maintenance lid frame which is shown with blue color (See Figure-4).

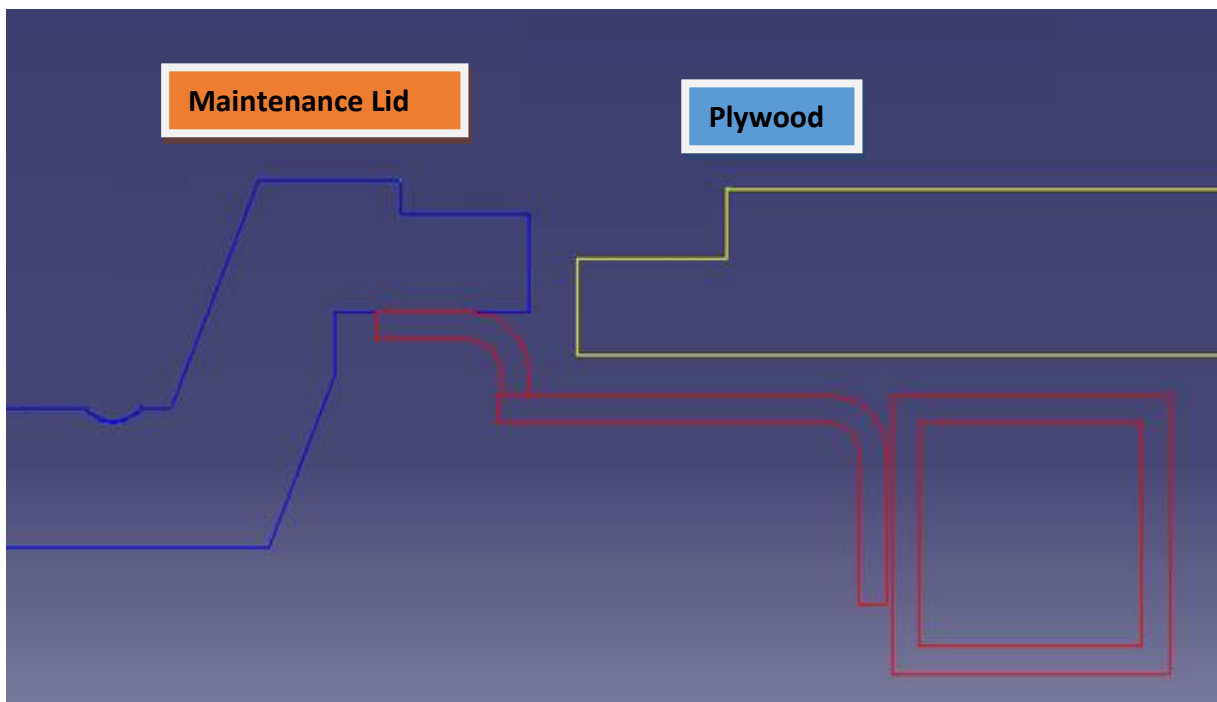


Figure-4

5. After dismantling of the maintenance lid frame, the sealer on the maintenance lid is cutted with utility knife. (See Figure-5).



Figure-5

6. To be able to apply the primer properly, make sure that the linearity of the adherence surface of the maintenance lid and apply the primer to adhesion surface of maintenance lid and maintenance lid structure.
7. Apply the sealer on maintenance lid structure. The maintenance lid frame is adhered by hand. Check the level of the maintenance lid and plywood with the gauge. Flatten with your hands. (See Figure-6).



Figure-6

8. Apply the primer under the frame(RP201139Y) and between maintenance lid and plywood. (See Figure-7 and Figure-8).

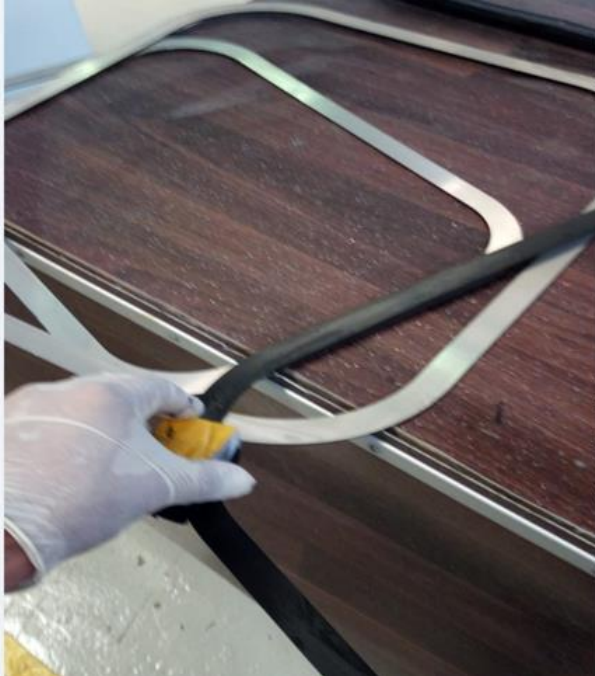


Figure-7



Figure-8

9. Apply the sealer on between the maintenance lid and plywood. And the frame (RP201139Y) is adhered to center the maintenance lid overthrow. (See Figure-9 and Figure-10).



Figure-9



Figure-10

**NOTE1:** All this steps are expressed for the front chassis maintenance lid(HD201276Y). Apply the same steps to the fuel tank maintenance lids(HD201291Y).

### FLAT RATE BREAK DOWN

Application	Time
Tool preparations	15 min
Mounting the maintenance lids and adjusting the level of maintenance lids	165 min
<b>Total</b>	<b>180 min</b>

Safety recall " TS45-SR-1905 " is applicable to following units:

<b>To whom that will carry out this bulletin</b>	
Verify vehicle eligibility by checking warranty bulletin status via TEMSA ONLINE SYSTEM	
Model	VIN
TS-45	Begin: NLTEJXM89L1000294    End: NLTEJXM82L1000315
<b>This Safety Recall does not necessarily apply to all the above-mentioned vehicles, some vehicles may have been modified before delivery.</b>	