

Subject: Improvement of the fender carcass  
for the material corrosion

Bulletin type: FM

Bulletin Nu: TS45-FM-2202

PQR Nu: 500000007095

Rev Nu:

Ref. Nu: 700004174

Araç Modeli: **TS45 EPA21**

Labor time: **1 hour**

Release date:

Expiration Of Validity :

**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 off coming parts

**Description of the modification:** Operations  
to prevent the corrosion onto the fender carcass

Liabile: **Tuğçe Aydil Dalkıran**

Confirmation &Release:

## 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



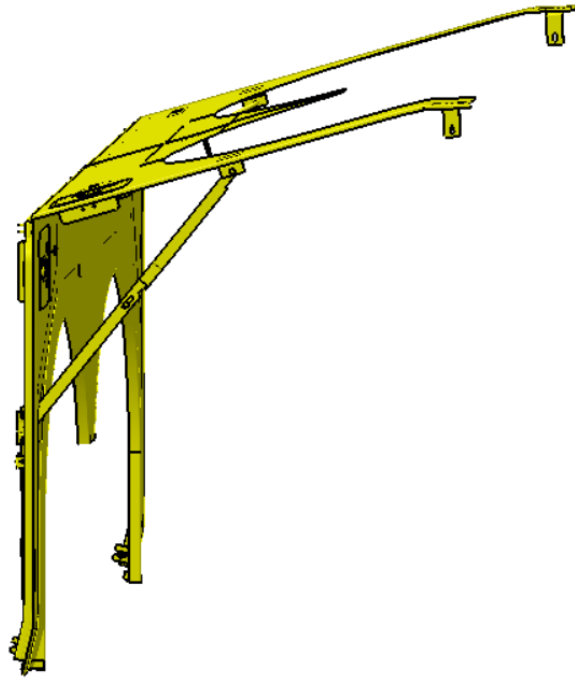
- ✓ Seats, trimming, upholstery stuff and carpeting should be protected with appropriate coverings.

### 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.

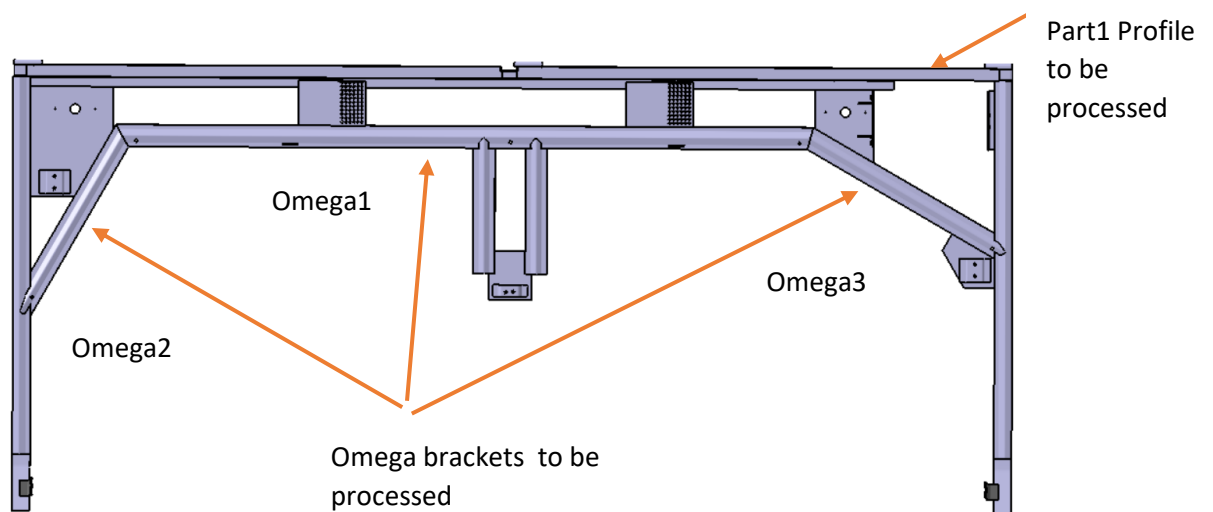
This service bulletin describes the operations to be carried out to prevent the corrosion onto the fender carcass.

Firstly, the fender is opened as the following figure.



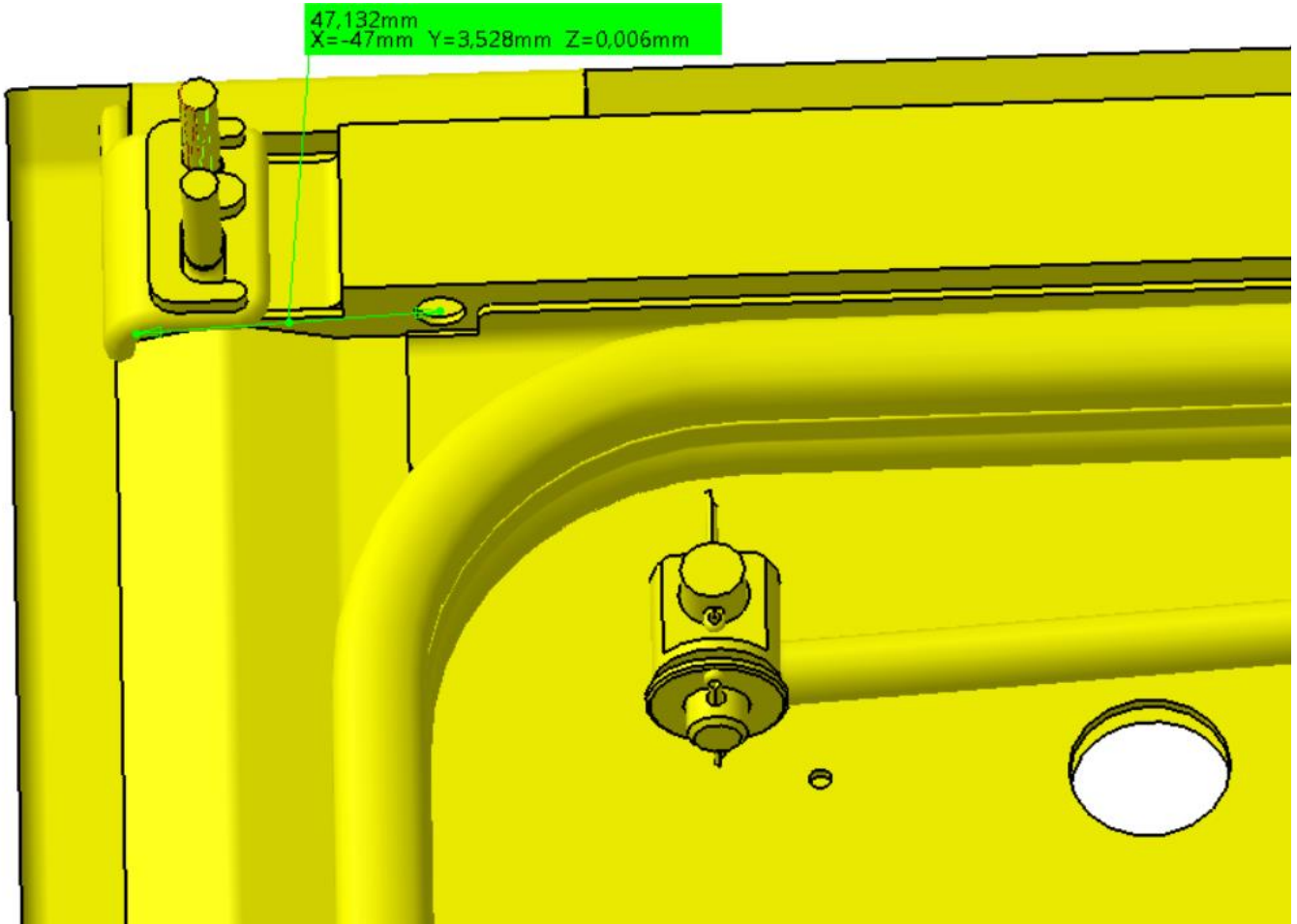
**Figure.1** Fender

The profile and omega brackets onto the fender to be processed are shown in the following figures

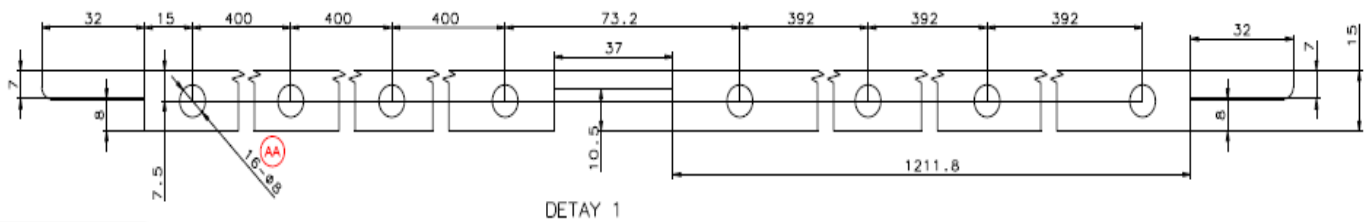


**Figure.2** The parts to be processed

The profile will be drilled with a diameter of 8 mm as a given distance of 47 mm to the beginning of the profile and then the other holes will be drilled as the intervals which is shown in the Figure.3

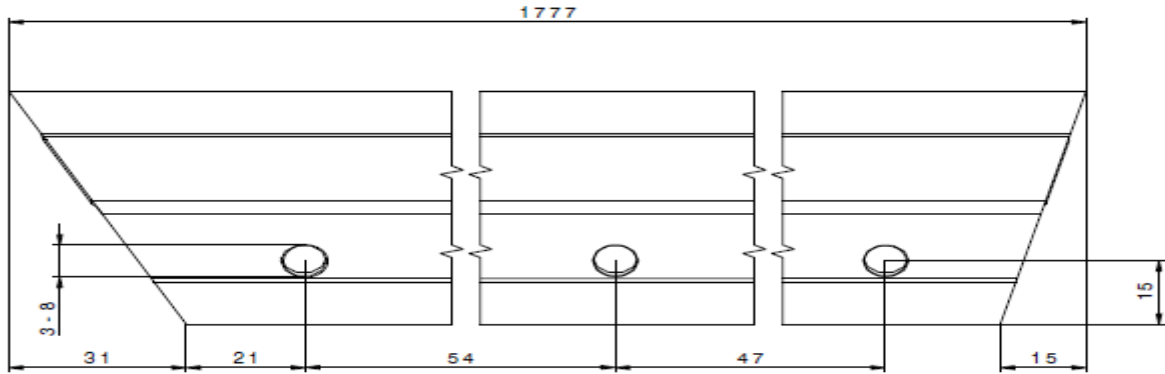


**Figure.3** The place of the first hole



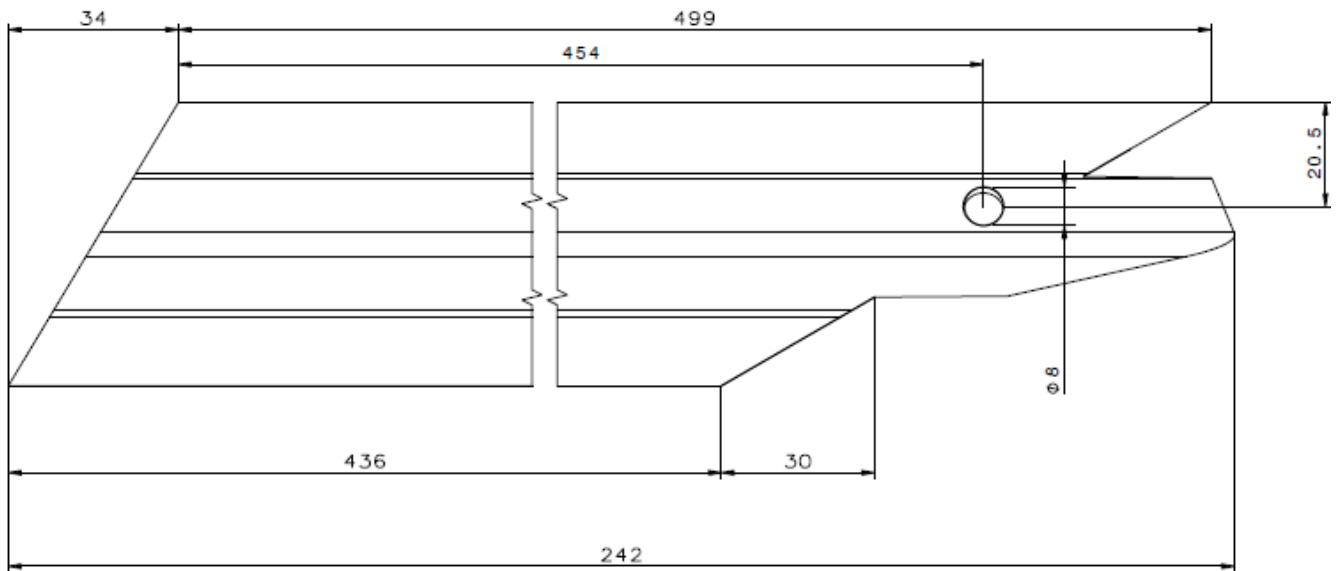
**Figure.4** The holes on the profile

The holes on the omega 1 bracket which is also shown in Figure.2 will be drilled as the following



**Figure.5** The holes on omega1 bracket

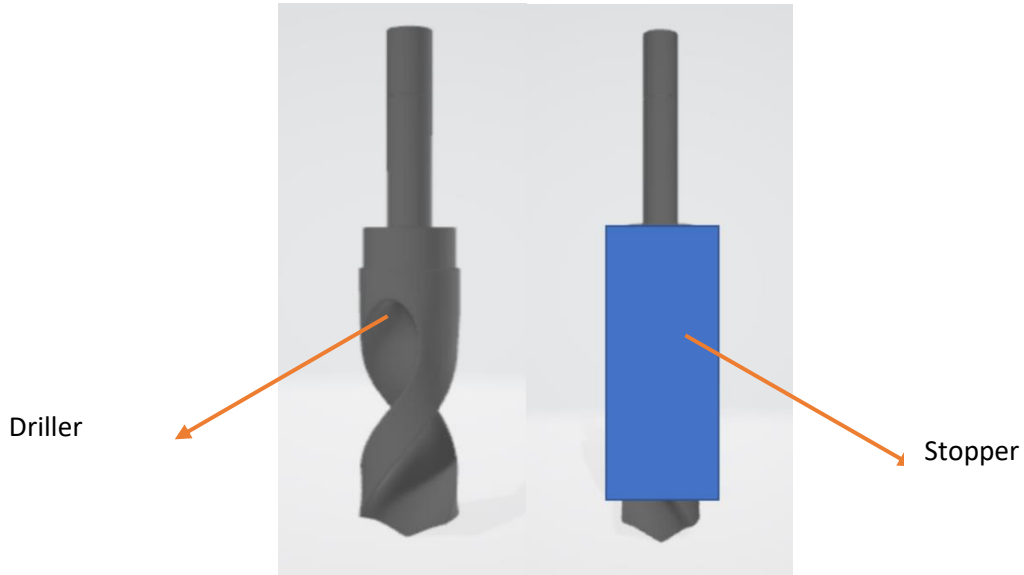
Omega2 and Omega3 will be drilled from the following place in the Figure.6



Front view  
Scale: 1:1

**Figure.6** The hole on the omega2 and omega3 brackets

Please note that all of drilling operations must be performed with a driller which has an stopper onto it as in the following figure to prevent any damage to the composite part.



**Figure.7** Driller

The vehicles that the operation will be performed are listed in the following Table.

<b>Chassis No</b>
NLTEJXA94M1000329
NLTEJXA96N1000334
NLTEJXA99N1000330
NLTEJXA90N1000331
NLTEJXA92N1000332