



# Recall Service Bulletin



**DATE:** 8-1-16

**APPLIES TO:** This service bulletin applies to certain MM and K3 models of incomplete motor home chassis built by Spartan Motors USA, Inc. between September 21, 2006 and March 23, 2015.

***Bulletin # RSB15-290-001 is superseded by bulletin RSB15-290-001A due to a clarification of part numbers. Any vehicle repaired under bulletin RSB15-290-001 will not require any additional work.***

**NHTSA/TC Id:** 16V-313

**CONDITION:** Flexible exhaust tubes may tear

**CORRECTION:** Replace exhaust tube

**LABOR ALLOCATION:** 1.0 hrs. for alignment  
2.0 hrs. for replacement

**CLASSIFICATION:** E3

**PARTS NEEDED:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	S-2503-001B	4"X18" long 1712-LL2 replacement

**Kit # S-2503-001B Contains:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
2	1823-LL2-002	GASKET, EXHAUST, 4.63 OD
2	10028-6	V-CLAMP 4"
1	2924-LL2-001	BELLOWS-4" DIA 18" LONG
1	RSB15-290-001A	Instruction Document

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
1	S-2503-002B	5"X18" long 1701-LL2 replacement

**Kit # S-2503-002B Contains:**

<u>QTY</u>	<u>Part Number</u>	<u>Description</u>
2	1823-LL2-003	GASKET, EXHAUST, ISM/X DP
2	10028-3	V-CLAMP 5"
1	2922-LL2-001	BELLOWS-5" DIA 18" LONG
1	RSB15-290-001A	Instruction Document

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### GENERAL INSTRUCTIONS:

Thoroughly review entire service bulletin before starting work. If there are questions or concerns with steps defined in this service bulletin, contact Spartan Motors USA, Inc. Customer & Product Support Group.

All applicable industry safety standards must be followed when performing work identified in this procedure.

### STEP-BY-STEP INSTRUCTIONS:

1. If installed, remove heat shields that may limit access to bellows. Retain for reuse.
2. Inspect exhaust bellows for damage, if damage is found skip to step 13.
3. Take note of current shape of bellows, bellows **must** be straight. Refer to FIG. 2-1.

**FIG. 2-1**

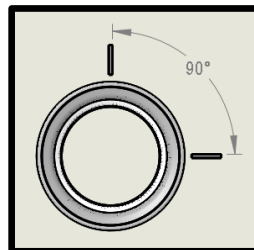


**Bellows are not straight**



**Bellows is straight**

4. Using a straight edge check for alignment of bellows.
  - a. Alignment should be checked in (2) two quadrants on bellows that are 90° from each other. Ex. Top and Side.

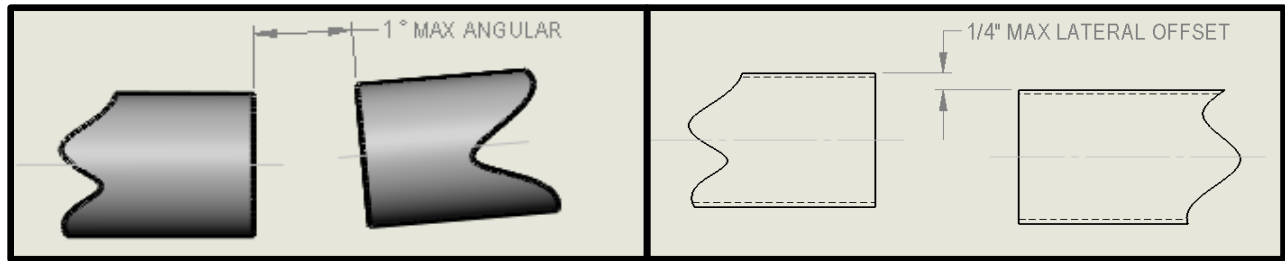


- b. Connecting tube alignment for bellows must meet the following requirements:

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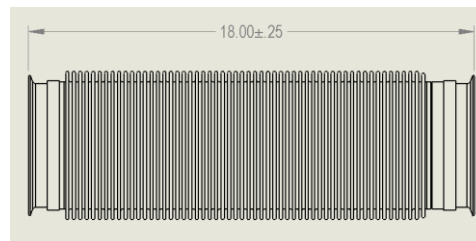


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**FIG. 3-1**

c. Installed length of bellows must be  $18.00 \pm 0.25$ "

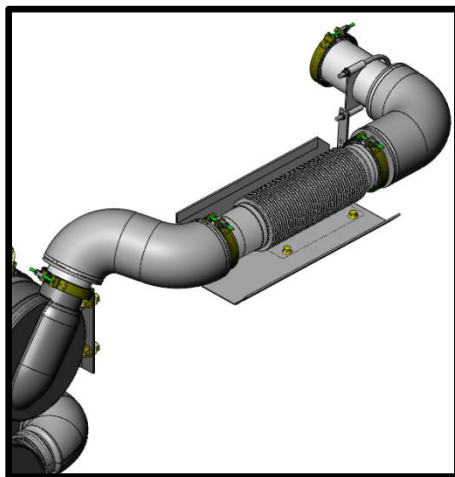


**FIG. 3-2**

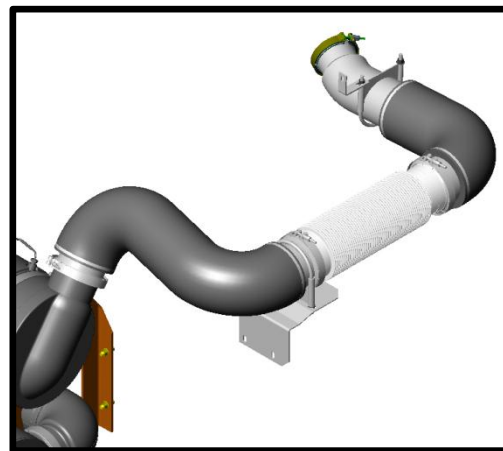
5. If no damage is found but misalignment is present proceed to the next steps.
6. Loosen clamps, support brackets, and v-band clamps that secure tubes to allow for adjustment of the tubes. Refer to 7<sup>th</sup> digit in VIN number for engine identification. If 7<sup>th</sup> digit is D, engine is an ISL: refer to FIG. 3-3. If 7<sup>th</sup> digit is E, engine is an ISX: refer to FIG. 3-4.

ISL installation (shown with bellows as reference)

ISX installation (shown with bellows as reference)



**FIG. 3-3**



**FIG. 3-4**

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- Using a straight edge, align tubes and exhaust bellows so they meet requirements for angularity, lateral offset and overall length. The alignment **must** be checked in (2) two quadrants that are 90° apart. Proper alignment **must** be achieved before proceeding, refer to Fig. 3-1 and 3-2.
- Once alignment requirements are met secure all clamps and brackets.

### CAUTION

Alignment of the tubes and bellows are critical.

- Torque (4) v-band clamps to 90 lbs. in.
- Ensure all other hardware has been tightened.
- Recheck alignment to ensure no shifting has occurred.
- Reinstall retained heat shields (if required). Process is complete.
- Remove clamps, gaskets, and bellows. Make note of shape of bellows that may indicate any misalignment. Refer to FIG. 2-1.
- Install supplied bellows using supplied v-band clamps and gaskets. Leave clamps loose enough to allow for adjustment if required.
- Using a straight edge, check alignment of exhaust bellows. Bellows **must** meet the requirements of angularity, lateral offset, and overall length. The alignment **must** be checked in (2) two quadrants that are 90° apart. Refer to FIG. 3-1 and 3-2.
- If proper alignment is not met go back to step, 6 if alignment requirements are met proceed to step 8.

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