



SERVICE BULLETIN

TITLE: G5 Ceiling skin repair procedure
TO: Micro Bird Inc. distributors
PRODUCT: G5 School bus, certain vehicles model year 2009 to 2012
FROM: Micro Bird inc. after sales and warranty dept.
Reference: recall 11-049-JSU

INFORMATION

Description

This document contains the directives needed to perform the repair which consists of installing glued and riveted junction plates on the ceiling's central joints inside school G5 vehicles.

Compliance

The claim under warranty must be sent to Micro Bird Inc. within 45 days after the repair has been performed.

Labor

The allowed time is of **20 minutes** per vehicle with a roof hatch option.
of **30 minutes** per vehicle without a roof hatch option.

Material availability

The required material will be provided by Micro Bird Inc. at no charge.

Note: It is highly recommended to read the entire procedure before starting the repairs.

ATTENTION: before proceeding with repairs, make sure the vehicle's ceiling skins and junction plates are at room temperature and exempt of condensation to ensure an optimal glue adhesion.

Required material to perform the repairs

- Hammer (1)
- Rigid paint scraper(1)
- Power drill (1)
- Drill bit (for steel) 13/64" (1)
- Manual riveter (1)
- White steel rivets
 - (16) Vehicle with roof hatch
 - (24) Vehicle without roof hatch
- Black panel fasteners 5/16 (2)
- Black fibre rivets (2)
- Loctite adhesive H8500 (50ml/junction)
- Adhesive applicator (1)
- Nozzles (3)
- G5 interior junction plates
 - (2) Vehicle with or without roof hatch
- G5 interior central junction plate
 - (1) Vehicle without roof hatch



INFORMATION CONCERNING THE MATERIALS

Product Number	Description	Qty 1 vehicle	NOTE
16D0314	G5 interior junction plates	2	Provided by Micro Bird
16D0313	G5 interior central junction plate	1 (if no roof hatch)	Provided by Micro Bird
996514	Loctite grey adhesive H8500	50 ml / junction plate	Provided by Micro Bird
CG50-10-1	Dual cartridge applicator	(reusable)	Provided by Micro Bird
9 # pink	Mixing nozzle	1 ea / junction plate	Provided by Micro Bird
BS01-0618-01	White steel rivets (stavex)	(16-24)	Provided by Micro Bird
BF41-0625-02	Black rivets 3/16 bulbex	2	Provided by Micro Bird
89L0004	Black panel fasteners 5/16	2	Provided by Micro Bird

ROOF SKIN REPAIR PROCEDURE - PREPARATION

Note: It is understood that the steps of this modification will be performed in a professional manner.

1- Find the central joints of the roof skin.

Roof skin with roof hatch

Position of the central joints

The middle joint does not need to be done as it is not glued the same way during production.



Roof skin without roof hatch

Position of the central joints



- 2- Remove the two (2) black plastic fasteners that hold the corner molding in front of the joints on each side of the bus in order to have the necessary space to insert the supplied junction plate.

If the corner molding is held by rivets, they must be removed by sliding a stiff spatula under the rivet head and hitting the spatula with a hammer. It is preferable to first sharpen the spatula to a 45 degree angle so it slides well under the rivet's head.

NOTE: The use of a power drill is not recommended as per it might make the rivet spin and damage the plastic molding.

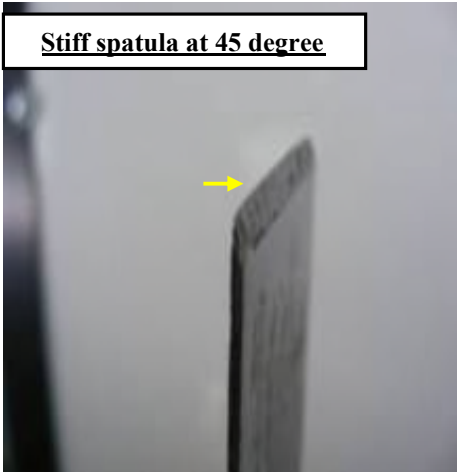


Figure 3



Figure 4



Figure 5

- 3- Determine the position of each of the junction plates. You will find the orientation to install the plate on the back of the part.



Figure 6

Arrow pointing towards the corner molding

If your vehicle has a roof hatch: Two (2) G5 interior junction plates of 21 3/16 " long are required. It is important to follow the identification arrow for good positioning (Figure 6).

If your vehicle does not have a roof hatch : In addition to the two (2) junction plates mentioned earlier, one (1) G5 interior middle junction plate, which is longer, will be required. The dimension of the middle junction plate is 27" long.

- 4- Remove the protective film from each of the junction plates. Once the protection film is removed, it is important to handle the parts with care in order to prevent any possible damage. (Figure 7).

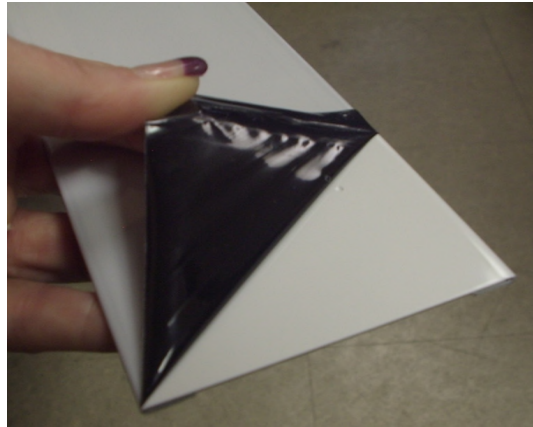


Figure 7

CEILING SKIN REPAIR PROCEDURE - INSTALLATION

- 1- Make sure to have the correct position of the junction plates.



Figure 8 Interior part (side which will be glued) arrow pointing the corner molding.

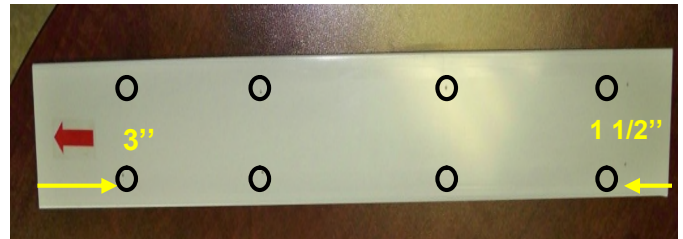


Figure 9 Exterior part with marked holes (First punch mark at 3" towards the corner molding side.) (First punch mark at 1 1/2" on the extrusion side)

- 2- It is really important to make the installation of the junction plates one at a time in order to avoid the premature drying of the adhesive. Make sure never to install a junction plate on which the adhesive has been applied for more than 15 minutes.
- 3- On the back of the junction plate, using the supplied dual cartridge applicator and the mixing nozzle, apply a 3/8" wide bead of grey loctite H8500 along the two (2) hems (Figure 10).

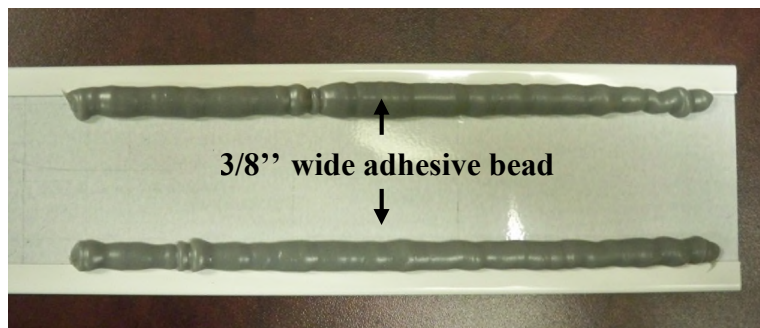


Figure 10

- 4- Position the adhesive coated junction plate on the ceiling joints making sure it is properly centered.

(First punch mark of junction plate 3" from the corner molding and first punch of junction plate 1 1/2" from the ceiling extrusion (Figure 11).

- 5- Insert the junction plate between the ceiling skin and the corner molding (Figure 11) making sure the junction plate is facing the right way. Arrow pointing towards the corner molding which will ensure an adequate fixation and, slightly curve the plate to insert it between the extrusion and the roof skin (Figure 12).

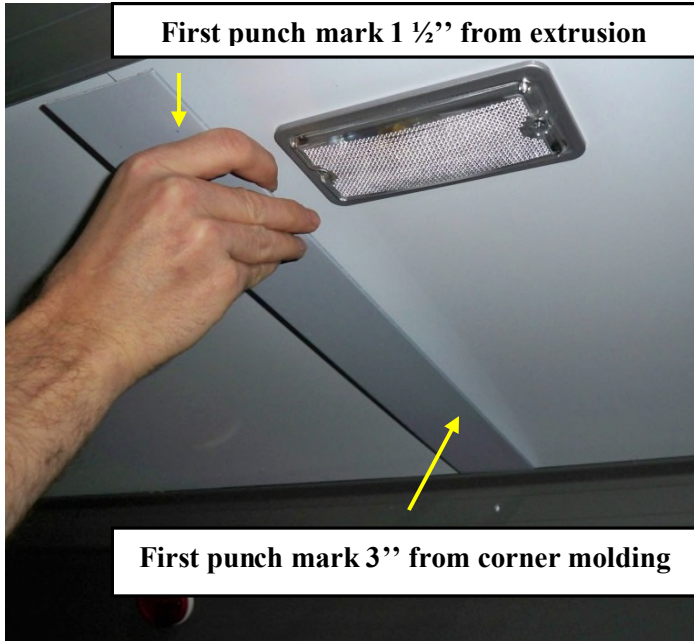


Figure 11

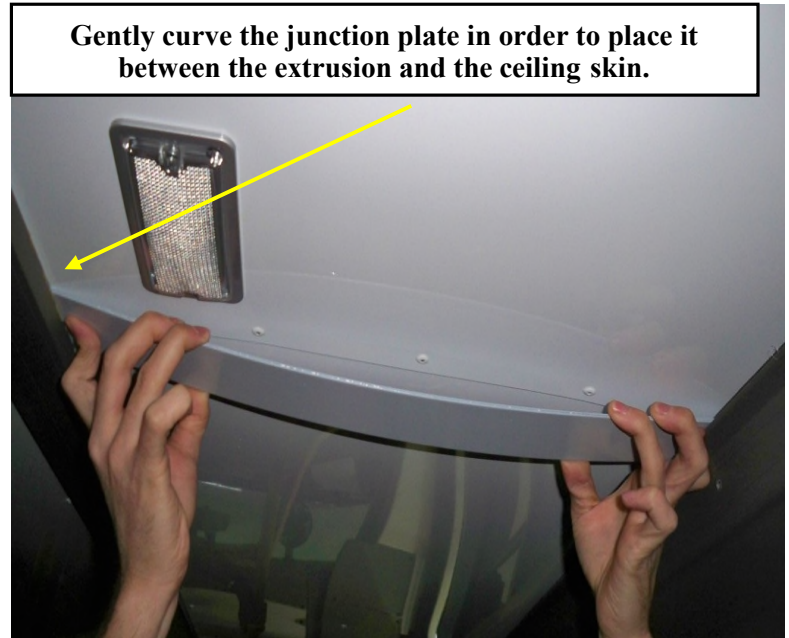


Figure 12

- 6- Fix the junction plate making sure it stays in place and it is centered.
- 7- Using a power drill and a 13/64" drill bit (for steel use), drill a hole in an existing punch mark in the center of the junction plate (Figure 13). Then, insert a rivet using a manual riveter (Figure 15) to hold the part in place.



Figure 13

It is important to use the rivets supplied by Micro Bird Inc.

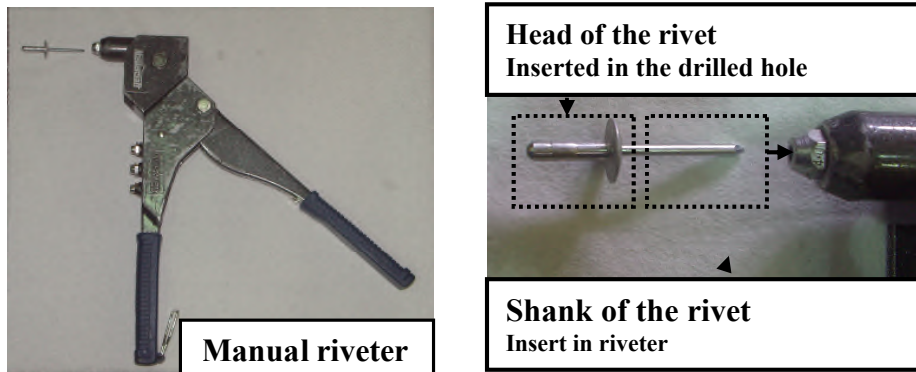


Figure 15

8- Install the junction plate making sure to drill and rivet all the identified punch marks as mentioned in step 7.



Figure 16

- 9- Remove the excess glue using a plastic spatula to avoid damage to the roof skin. If needed, clean up with a soft rag soaked in isopropyl alcohol.

- 10- Proceed with the installation of the other junction plates covering the central joints following the same procedure.

- 11- Finalize the repair by installing the two (2) black panel fasteners or the two (2) black fibre rivets (supplied) in each of the corner moldings (Figure 17 & 18).

Install the black panel fasteners manually (Insert fastener and push).
Install the black fibre rivets using the manual riveter.



Figure 17



Figure 18