

# LA 45 COMPO: REAR RADIUS ROD MOUNTING BOLT

## INSPECTION



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**Property name and top bus number:** LA 45CLFW, 315000



**Issue:** Rear radius rod bolts torque verification procedure

**Reason/ cause:** This procedure should be used when checking the torque on the rear axle radius rods.

**Solution:** Re-torque bolts per this work instruction (SOI).

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**Number of affected buses:** As required

**Estimate repair hours/bus:** 15 min to inspect bolts. Up to 1 hour if all bolts need to be replaced.

#### **Necessary parts:**

Bolt, M18x65, 10.9 Hex. Head,	Part #: <b>01503-61865</b> ,	as required / bus,
WASHER, LOCK, M18,	Part #: <b>05020-60018</b> ,	as required,
LOCTITE 246, 1.69 FL OZ/50mL,	Part #: <b>5033332</b> ,	as required,

**Necessary tools:** 27 mm and 60 mm sockets, torque wrench capable for 150 lb-ft, 265 lb-ft and 557 lb-ft.

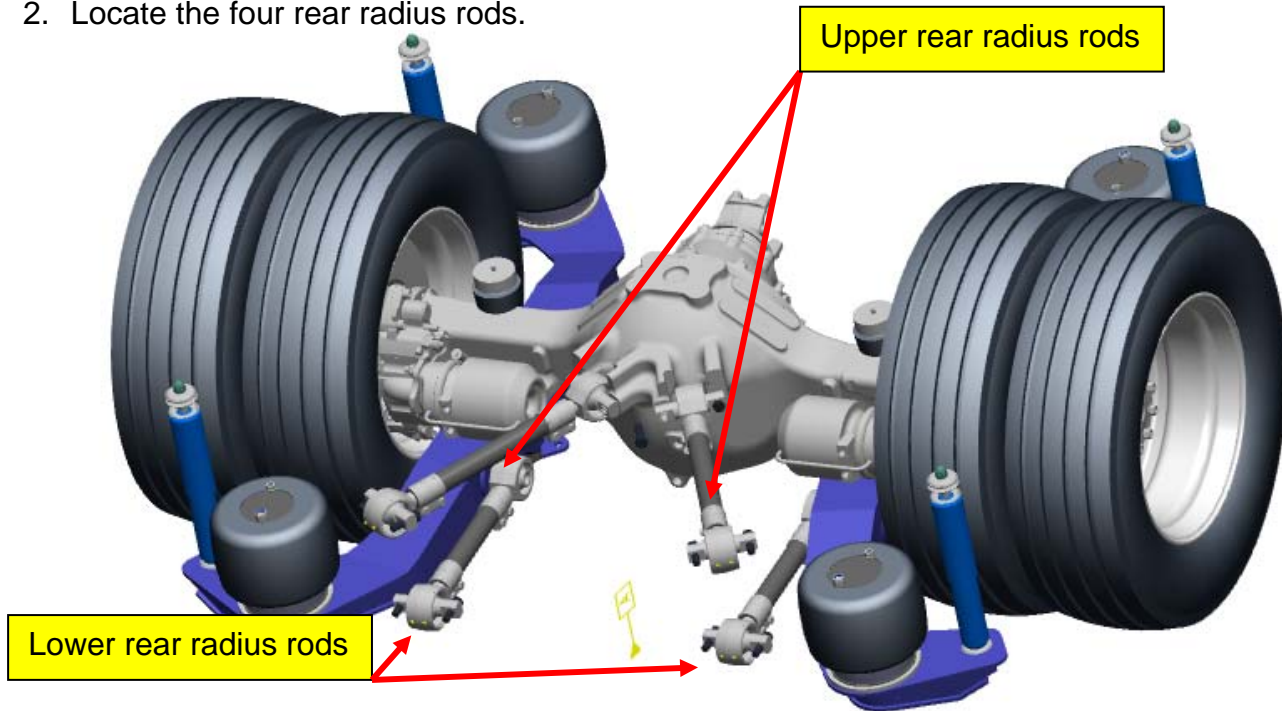
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**SAFETY PRECAUTIONS MUST BE FOLLOWED ACCORDING TO ACCEPTED INDUSTRY STANDARDS AND LOCAL/PROPERTY REQUIREMENTS.**

1. Park the bus above a service pit and apply the parking brake.
2. Locate the four rear radius rods.



#### **Upper radius rod to axle housing mounting bolt inspection:**

3. Set torque wrench to 190 lb-ft and check the radius rod mounting bolts at the axle housing by using a 27 mm socket. If torque is correct (wrench clicks) then no further action is required. If bolt turns more than 45 degree (1/8 of a full turn) then proceed with the instructions written below.



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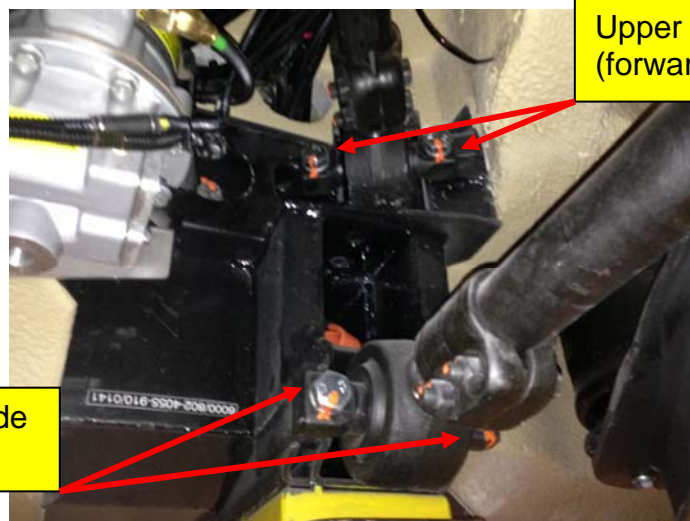
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4. If bolt was found loose, remove the bolt. Remove only one at a time if both bolts were loose. Discard bolt(s).
5. Clean threaded hole of the axle housing. Use small wire brush first then spray brake cleaner into the hole. **Wear safety glasses!** Use compressed air to remove debris and cleaner from the threaded hole.
6. Have a new M18x1.5 x65 mm bolt (P/N: 01503-61865) and ensure the threads are clean. Apply Loctite 246 thread locker onto the bolt: start applying Loctite ¼” from the head of the bolt all the way back to the first thread.
7. Install bolt with new M18 size lock washer (P/N: 05020-60018) through the radius rod into the axle housing. Turn bolt by hand to ensure it is not cross threaded. Do not use air tool! Turn bolt all the way in with a manual ratchet.
8. Torque bolt to 190 lb-ft and apply torque seal onto the head of the bolt.
9. Repeat this procedure on other radius rod to axle housing mounting bolts that turned more than 1/8 turn during torque check.

#### Upper and lower radius rod bus side (forward) mounting bolt inspection:

10. Set torque wrench to 265 lb-ft and check the radius rod bus side (forward) mounting bolts by using a 27 mm socket. If torque is correct (wrench clicks) then no further action is required. If bolt turns more than 45 degree (1/8 of a full turn) then proceed with the instructions written between #4 and #7.
11. Torque bolt to 265 lb-ft and apply torque seal onto the head of the bolt.
12. Repeat this procedure on other bus side (forward) radius rod to bus frame mounting bolts that turned more than 1/8 turn during torque check.



Upper rear radius rods bus side (forward) mounting bolts

Lower rear radius rods bus side (forward) mounting bolts

#### Lower radius rod mounting nut (large nut holding radius rod to C-frame) inspection:

13. Set torque wrench to 557 lb-ft and check the lower radius rod mounting nut by using a 60 mm size socket. If torque is correct (wrench clicks) then no further action is required. If nut turns then torque nut to 557 lb-ft (keep turning torque wrench until it clicks).

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14. Please contact to **James Shropshire** NABI West Regional Manager at 256-453-7586 if you have any questions.
15. Check for completeness of work.
16. Record fleet # and mileages.
17. Inspection interval of these bolts is per NABI Maintenance Manual.