

"DOCUMENT UNCONTROLLED IF PRINTED"

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
TSB1415	DS Transition Window Replacement	1 OF 4		SER	DBaker	12/3/2014

The purpose of TSB 1415 is to change it to a safety rated window.

Read process before beginning. If you do not understand any part please contact: Chris Ward, Director of Parts and Warranty at 1-866-953-5555 or by E-mail @ cward@ARBOCSV.com.

Good Mechanics safety practice must be followed on any repairs.

Safety practices should include but not be limited to properly supporting the chassis, axles, blocking tires, and a work area free of clutter.

Repair shops safety rules must be followed and safety equipment used. O.E.M. Battery and Auxiliary Battery MUST be disconnected.

Labor Operation Code: 026602.

Labor Time Allowance: 1.0 hour.

Pre-authorization required.

Tools Required

- 1- Flat screwdriver.
- 2- Short phillips screwdriver.
- 3- Screw gun.
- 4- Caulk gun.
- 5- Knife.
- 6- Two clean rags.
- 7- T-handles for window cut out wire.
- 8- Putty scraper.
- 9- Needle nose pliers.
- 10- Wire cutter.

Parts List

- 1- (1) ARBOC Part#1306567 Window, transition clear acrylic.
- 2- Auto glass window cut out wire.
- 3- Lacquer thinner. (Purchase locally)
- 4- Adhesive promoter. (Purchase locally)
- 5- Clear silicone. (Purchase locally)

Repair Instructions:

Note: Please make sure bus and window are warm before proceeding.

Step 1- Remove interior plastic trim around window.



Step 2- Cut a 12" piece of auto glass cut-out wire. Slide one end of the wire into T-Handle sleeve until it comes up and out of the slot, bend the wire to 90 deg and insert end into the hole in the end of the sleeve. Slide the handle over the hole in the end of the sleeve.



Step 3- Using a flat screwdriver and a piece of cardboard pry up on the window from outside breaking the seal.

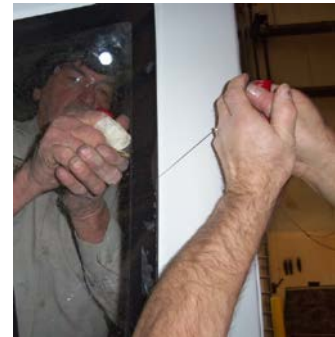


Step 4- Using pliers feed the other end of the wire from the inside of the window to the outside in the location that you loosened the window from the seal.



Step 5- Install other t-handle on wire that was passed under the window.

Step 6- Using two people work the wire back and forth moving it up and down breaking the seal on the window.



Step 7- Once you have broken the seal, push the window from the inside and remove it.



Step 8- Using lacquer thinner and a putty scraper remove the high spots of seal left around the entire window opening. Then wipe entire area with adhesive promoter.



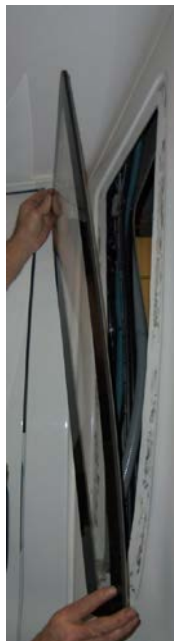
Step 9- Remove the backing from the seal tape.



Step 10- Apply a 3/8" bead of clear silicone around the inside edge of the tape.



Step 11- Starting at the bottom of the window, insert the window onto the fiberglass pillar making sure to center it in the opening.



Step 12- Press around the entire perimeter of the window to assist in adhesion.



Step 13- Hold top outside corner tight against bus with heel of hand for approximately 30 seconds.



Step 14- Re-install interior plastic trim ring around window.

Note: Let bus sit 1 hour to allow window seal to cure before moving.