

PROLO OUTER HANDLE REPLACEMENT

Control No: W-HAT-180

Content Revision: B

Dept: PROLO HATCH

Page

1

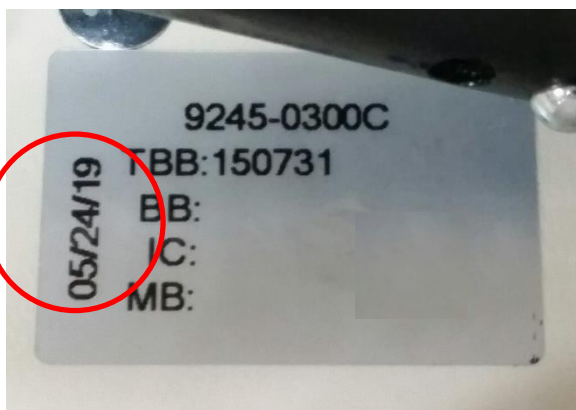
1. **PURPOSE:** How to replace the 009336 Outer Handle for a 924X Series Prolo Roof Hatch.
2. **SAFETY:** Wear safety glasses all the time on the production floor.
3. **WORK INSTRUCTION:**



Step 1: Gather the necessary components for the work. 009336 Handle, 009321-5 O-ring, 008798 Screw, 1/8" Allen wrench or driver w/ 1/8" bit



Step 2. Locate the silver "build date" sticker on the inside of the lid (located in red circle shown above)



Step 3: If the date is between 8-1-18 and 5-21-19, the hatch will need to be reworked. Dates before or after that timeframe do not need rework.



Step 4: REWORKING THE HATCH
Rotate the handle into the orientation shown

PROLO OUTER HANDLE REPLACEMENT

Control No: W-HAT-180	Content Revision: B	Dept: PROLO HATCH	Page 2
-----------------------	---------------------	-------------------	--------



Step 5: Set the torque setting to 4-5, or the minimum needed to set the screw.



Step 6: Insert the 1/8" Allen bit into the 008798 screw and remove screw from red handle.



Step 7: Pull down to remove the red handle



Step 8: Open the lid 5-6 inches, reach around and lift the black handle out of the bushing.

PROLO OUTER HANDLE REPLACEMENT

Control No: W-HAT-180

Content Revision: B

Dept: PROLO HATCH

Page

3

**Step 9: Remove outer handle****Step 10: Ensure that the 009321-5 O-ring is secured around the base of the handle stem. If it is not there, check to see if it is in the lid bushing. If it is not in either location, replace with a new o-ring.****Step 11: Insert the new handle into the bushing and orient as shown.****Step 12: From inside the lid, you will see the shaft of the outer handle**

PROLO OUTER HANDLE REPLACEMENT

Control No: W-HAT-180

Content Revision: B

Dept: PROLO HATCH

Page

4



Step 13: The inside of the red handle has ribs to self-orient the red handle on the outer handle.



Step 14: Place the handle onto the stem of the outer handle (oriented as shown).



Step 15: Insert the 008798 screw into the red handle and thread the screw into the outer handle stem. Approximately 10-12 in-lbs to secure. Setting of 4-5 on driver

Step 16 Close the lid from the vented position. The rework is complete. Move to the other hatch in the bus.

PROLO OUTER HANDLE REPLACEMENT

Control No: W-HAT-180

Content Revision: B

Dept: PROLO HATCH

Page

5

4. DOCUMENT HISTORY (UP TO 5 REVISIONS ONLY)

Revision Level	Section(s)	Summary of Significant Changes
-	NA	Initial Release
A	All	Added steps 3, 5, 19 and 20; updated image on current step 18
B	3	Removed Steps 17-20