



# INSTRUCTION TO SERVICE

ITS61434		September 3, 2025
<b>SECTION:</b>	460-Windows	
<b>SUBJECT:</b>	Swap Windows to meet Compliance	
<b>ISSUE:</b>	Compliance issues with the number and placement of emergency egress windows	
<b>SUMMARY:</b>	Rework affected buses to meet compliance	

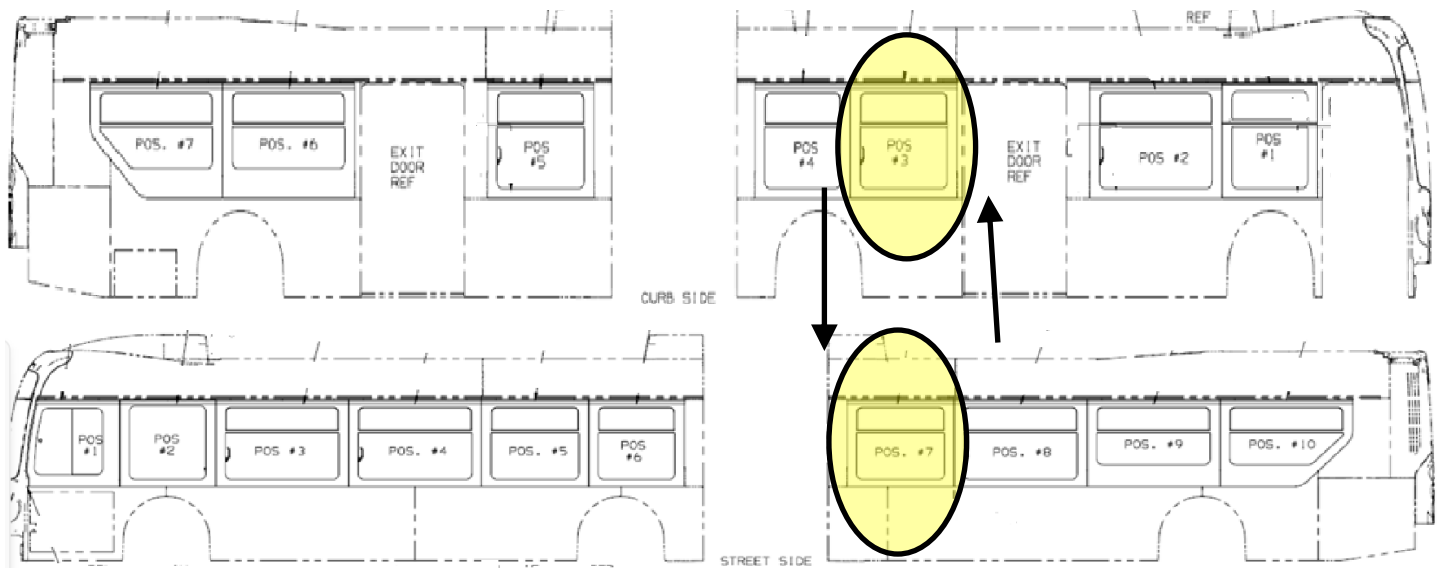
# ITS61434

Ref. NHTSA Recall No.	Ref. Transport Canada Recall No.
NHTSA 25V542	TC 2025-430

**THIS ITS DOCUMENT SHOULD BE RETAINED AND REFERRED TO FOR FUTURE MAINTENANCE UNTIL THE NEW FLYER PARTS AND/OR SERVICE MANUAL IS UPDATED TO REFLECT WORK DONE AS A RESULT OF THIS DOCUMENT. ENSURE THAT THIS DOCUMENT IS AVAILABLE FOR PARTS AND MAINTENANCE STAFF GOING FORWARD.**

**PROCEDURE:**

1. Set park brake and chock wheels.
2. Turn the main battery disconnect switch to the “OFF” position.
3. Locate the affected windows to remove and re-install in Figure 1.
4. Swap streetside window #7 with curbside window #3.



**Figure 1: Window Locations**

**WINDOW R&R PROCEDURE:**

5. Remove the existing window assembly. To remove the window, follow these steps:

**⚠ WARNING:** Always use appropriate lifting equipment designed specifically for the task or use assistance of additional personal when replacing the window.

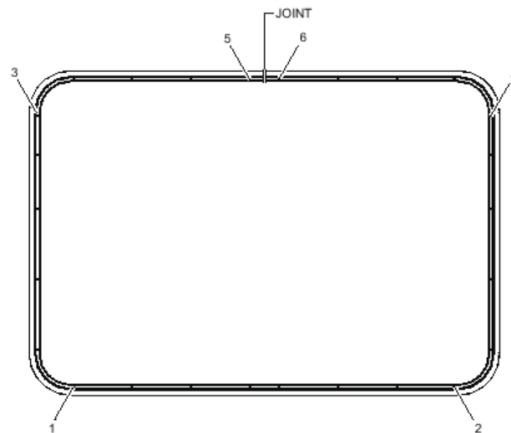
- a. Support the window assembly from outside the vehicle.
- b. Remove the clamp ring screw cover seal and remove all the screws from the interior clamp ring.
- c. Remove the clamp ring.
- d. Apply pressure to the interior side of the window assembly and force the window assembly outward from the vehicle window opening.

6. Install the new window assembly in the same location the existing window assembly was removed from. To install the new window assembly, follow these steps:

**👉 NOTE:** Before you install the window, inspect the window opening. It should not have damaged surfaces or lack of sealant at the joints. If required, clean out the existing sealant at the

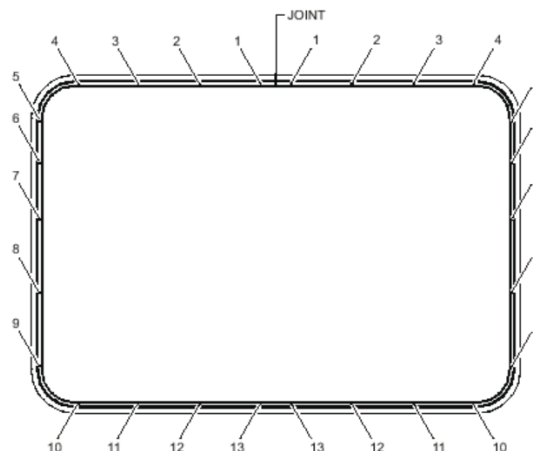
**joints and apply a small bead of new sealant (NF PN 560838) at all the joints around the window. Inspect the window assembly perimeter and the clamp ring seals as well.**

- a. Install the new window assembly from the exterior of the vehicle and push it into place taking care to center the window assembly into the opening. You may need to add shims (NF PN 106466) under the two contact surfaces of the window frame as required for leveling purposes.
- b. Support the window assembly from outside the vehicle.
- c. Install the clamp ring from the inside of the vehicle. Ensure the joint is at the top of the window.
- d. Install the first six screws (NF PN 358571) in the locations and sequence shown in Figure 1 and torque them to 20 in/lbs initially.



**Figure 1: Torque Clamp Ring screws in Sequence Shown**

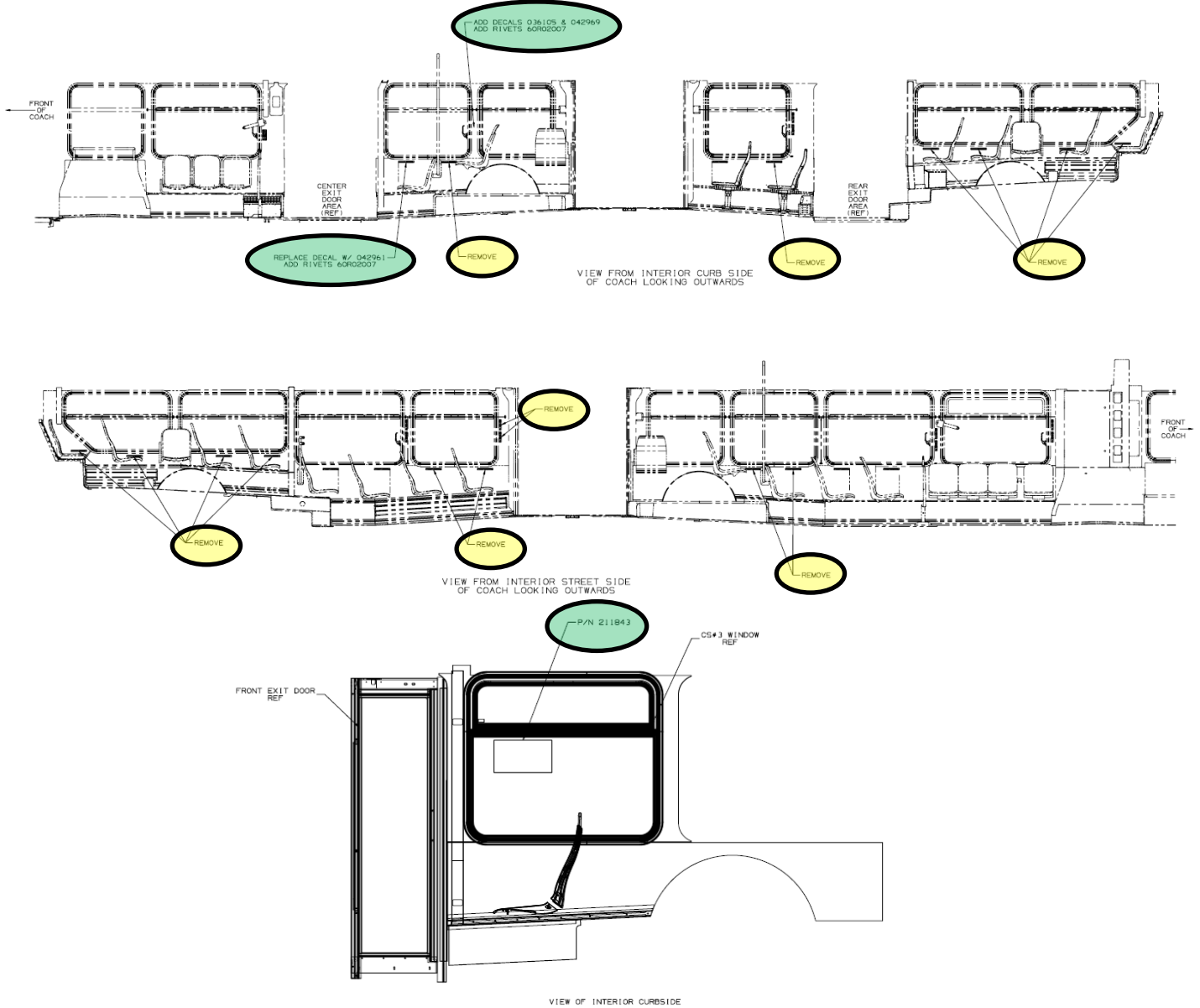
- e. Install the remaining screws (NF PN 358571) and torque them to 20 in/lbs initially in the order of installation.
- f. Apply a final torque of 45 in/lbs to all the screws in the sequence shown in Figure 2.



**Figure 2: Torque Clamp Ring screws in Sequence Shown**

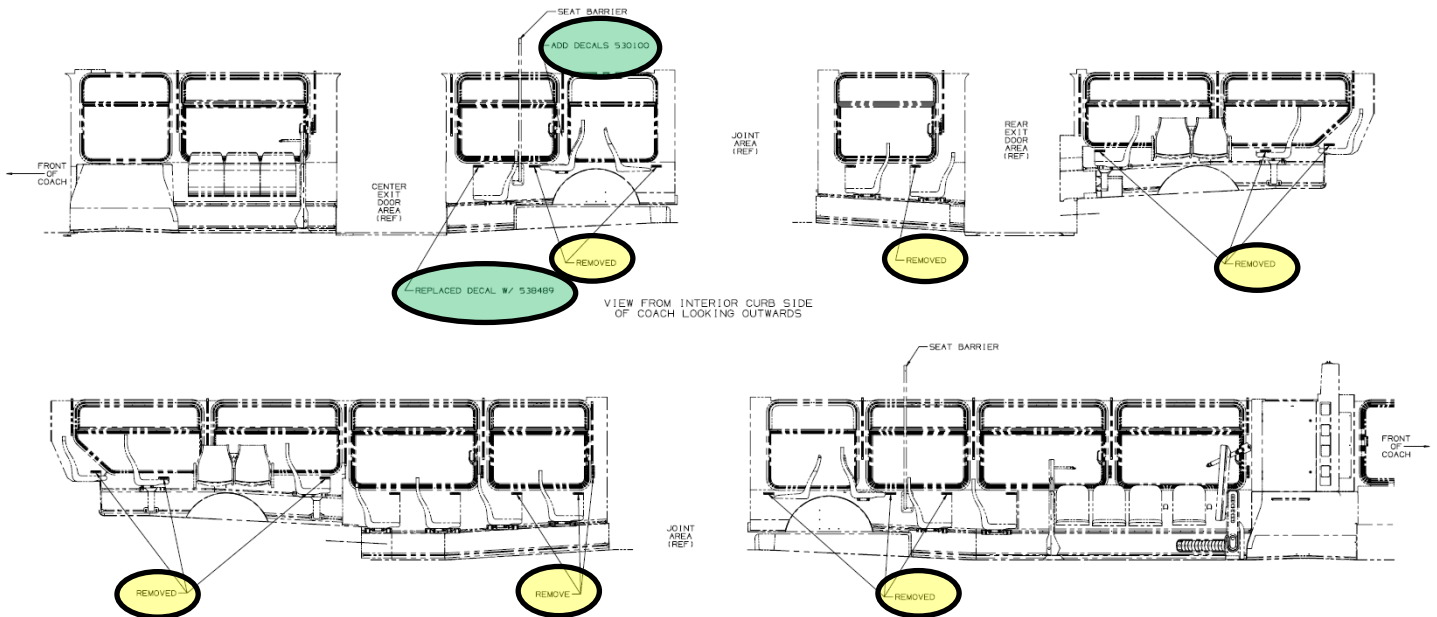


9. For SR-2927 affected window locations please remove and discard decals shown in figure 4.
10. For SR-2927, Install emergency decal plates (NF PN 036105, 042969, 042961) on the recently installed curbside #3 window location. See Figure 4 for plate locations. Secure using rivet (PN 60R02007).



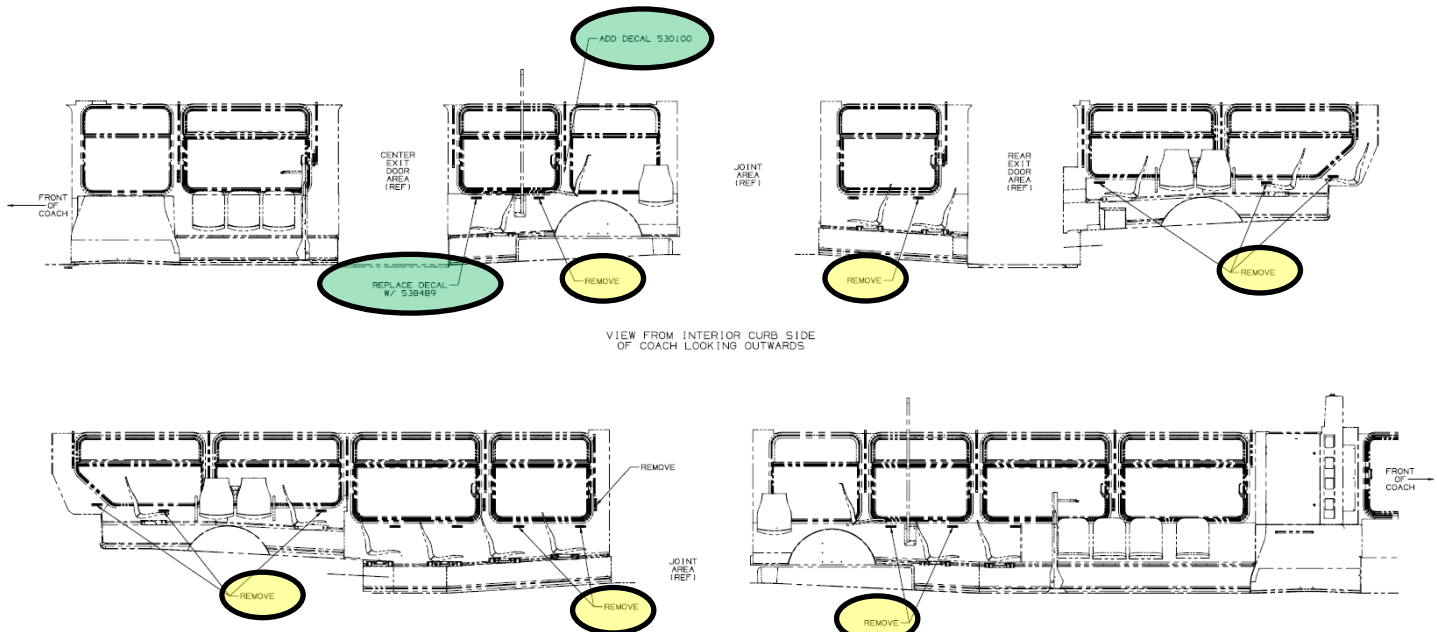
**Figure 4: Emergency Decal Plates Locations**

11. For SR-2887 affected window locations please remove and discard decals shown in figure 5.
12. For SR-2887, Install emergency decals (NF PN 530100, 538489) on the recently installed curbside #3 window location. See Figure 5 for decal locations.



**Figure 5: Emergency Decal Location**

13. For SR-2945 affected window locations please remove and discard decals shown in figure 6.
14. For SR-2945, Install emergency decals (NF PN 530100, 538489) on the recently swapped window locations.  
See Figure 6 for decal locations.



**Figure 6: Emergency Decal Locations**

15. Remove all tools and debris from work area to return coach to service.
16. Turn the main battery disconnect switch to the "ON" position.



<b>LABOUR ESTIMATE</b>				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Swap Windows to meet Compliance	1	2.0	2.0

<b>PARTS REQUIRED</b>					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	357552	SEAL-CLAMPRING SCREW COVER	1	EA	If Required
2	358571	SCREW-TORX 10-16 X 1.375 #8 PAN	30	EA	If Required
3	106466	SPACER WINDOW	5	EA	If Required
4	536464	DECAL-EMER INSTN E/S	1	EA	If Required
5	036105	PLATE-EMER INSTN ENG	1	EA	If Required
6	042969	PLATE-EMER INSTN SPN	1	EA	If Required
7	042961	PLATE-EMER INSTN E/S	1	EA	If Required
8	530100	DECAL-EMER INSTN ENG	3	EA	If Required
9	538489	DECAL-EMER INSTN ENG	2	EA	If Required
10	60R02007	RIVET AL 1/8 GRP 12-.31	10	EA	If Required
11	536471	DECAL-EMER INSTN ENG	1	EA	If Required
12	024082	DECAL-HANDICAP SYMBOL	1	EA	If Required
13	211843	DECAL-NOTICE	1	EA	If Required