



INSTRUCTION TO SERVICE

ITS: 61536		DATE 1/21/2026
SECTION:	490 – Entrance Door	
SUBJECT:	Rework- replacing D-Legacy entrance door lower window	
ISSUE:	The entrance door lower glass is non-compliant with FMVSS/CMVSS 205	
SUMMARY:	Replace the existing glass with AS2 glazing	

ITS-61544

Ref. NHTSA Recall No.	Ref. Transport Canada Recall No.
25V853	2026-007

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) Ensure to apply the parking brake.
- 2) Turn the master run switch to the off position and wait 5 minutes before proceeding.
- 3) Ensure to wear proper PPE.
- 4) Personnel must work in a well-ventilated area and must wear a rubber glove when handling alcohol, cleaner and degreaser.

Removing the existing glass:

- 5) Mask the outside perimeter of the lower window with masking tape to prevent scratching the door.

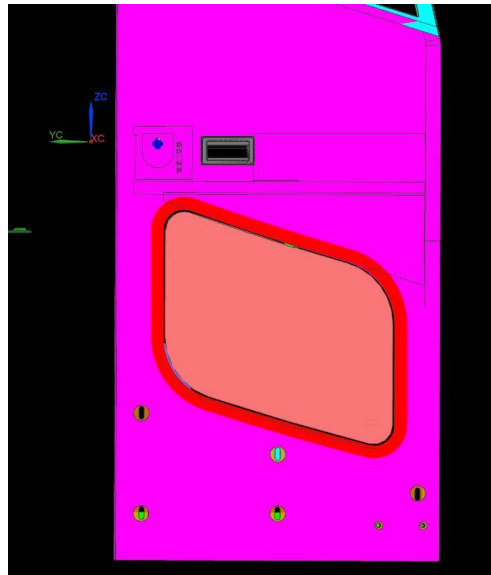


Figure 1: Outside Perimeter of Entrance Door Lower Window

- 6) Mask the inside panel on entrance door, surrounding the lower glass window, with masking tape (Highlighted red).

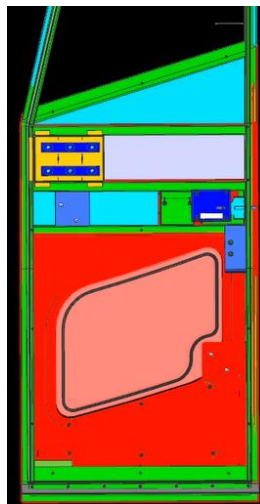


Figure 2: Panels Installed Around Inside Lower Glass Window

- 7) Hold the knife between window and entrance door and carefully begin removing the sika from one corner, working your way around the window.

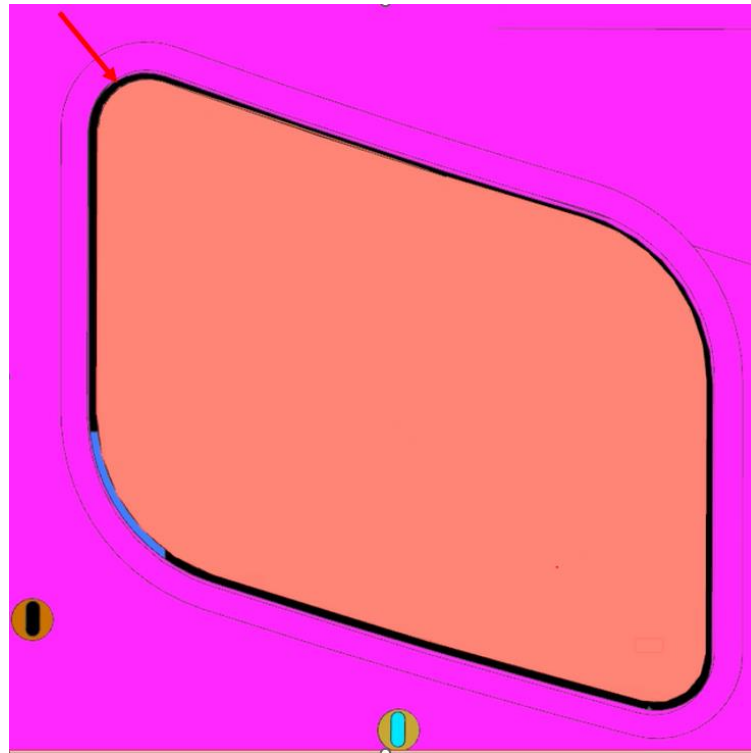


Figure 3: Cutting off the Sika from V-groove with Knife

- 8) Use putty knife to remove any remaining sika that is difficult to remove with a knife.
- 9) Once the sika is removed all around, carefully push the glass from inside of entrance door with mallet to remove it.
 - **NOTE: Please be careful to prevent damaging the weather strip as it will be reused.**

FIBREGLASS DOOR PREP:

- 10) Wipe down the bond area of weather-stripping (bond line) **P/N 3C-25-77** using clean cloth with isopropyl alcohol. Allow **5 minutes** until cleaner is dry.
 - **NOTE:** Avoid using a swirling motion when cleaning surfaces with a lint free cloth. The preferred method is to use a constant movement, for example, in either a straight horizontal and or vertical line, avoiding a back-and-forth motion.
- 11) Apply sika cleaner **P/N 237955** with white lint free cloth on weather-stripping. Allow **5 minutes** for flash off time.
- 12) Apply sika activator **P/N 230535** to bond line area by using wipe on, wipe dry method and allow **10 minutes** for flash off time.
- 13) Apply sika primer **P/N 065297** to bond line area, allow **20 minutes** for flash off time.

PROCEDURES TO PREP & INSTALL THE WINDOW:



- 14) Apply sika hard/glass surface cleaner **P/N 237955** on the inside and outside of the glass surface with white lint cloth on glass to ensure all the debris are removed, allow **1 minute** for the flash off time. Wipe with IP alcohol and wait for **5 minutes**.
- 15) Dry fit the glass **P/N 956989** on entrance door by leaving the equal spaces all around.
 - Lower Acrylic Window must sit flush on the entrance door window frame opening. It should not be over flush and may be no more than 1/8" under flash.
 - Lower Acrylic Window should be centered along the lower window frame opening.
- 16) When proper alignment has been achieved:
 - Reinstall existing filler **P/N 3C-27-319** to finish lacing.
 - Apply at least 1/4" diameter bead of Sealant Sikaflex **P/N 21-7112-31** along the bond line of weather strip.
 - Ensure to bond the lower window within **10 minutes** of laying down the bead of sealant.
- 17) Let the window clamped for **24 hours** in place and clean the sika with sika cleaner.

LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Remove the entrance door lower window and replace with AS2 glass	1	1.5	1.5

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	956989	WINDOW-GLASS, 6MM AS2 LAMINATED, GREY	1	EA	
2	21-7112-31	SEALANT-SIKAFLEX 221 GREY	1	EA	
3	230535	ACTIVATOR-SIKA	1	LT	
4	237955	CLEANER-GLASS/HARD SURF	1	EA	
5	065297	PRIMER-SIKA 206 G+P 1 LITER	1	EA	

SPECIAL TOOLS REQUIRED					
Item	Part Number	Description	Qty.	Units	Notes
1	N/A	Clamp	2	Each	