

REFERENCE :	Nova Bus Manuals
SECTION :	01 Stainless Steel Chassis
RS N°:	MQR 7621-386
EFFECTIVE IN PROD.:	L652-09 (2012JA19)

APPLICATION DEADLINE: -

SUBJECT:	Transverse beam located behind the front axle.
JUSTIFICATION:	Crack-repair procedure for the front transverse beam.

LEVEL	DESCRIPTION	DIRECT CHARGES		TIME
		LABOUR	MATERIALS	
1	Crack-repair procedure for the transverse beam behind the front axle.	Client	Client	8 h
2	-	-	-	-

MATERIAL

QTY	PART N°	REV.	DESCRIPTION	REPLACES PART N°
LEVEL 1				
		-		-
LEVEL 2				
-	-	-	-	-

DISPOSAL OF PARTS

REMOVED PARTS ARE:	DISCARDED	RETAINED

REVISION HISTORY

REV.	DATE	CHANGE DESCRIPTION	WRITTEN BY
NR	2014NO07	Translation of original French version.	M. Pasternak

**WARNING**

Your regular security standards apply.

PROCEDURE

1.1. Hoist the vehicle.

**NOTE**

For information on hoisting the vehicle, see section 18: Hoisting and Towing in the LFS maintenance manual. Follow all safety standards applicable at your establishment. For your own protection, use only equipment that is appropriate to the task.

1.2. Install safety jacks under the vehicle. See Figure 1 for jack locations at the front of the vehicle.

1.3. Remove mud guards. Set units and retaining hardware aside for later reuse.

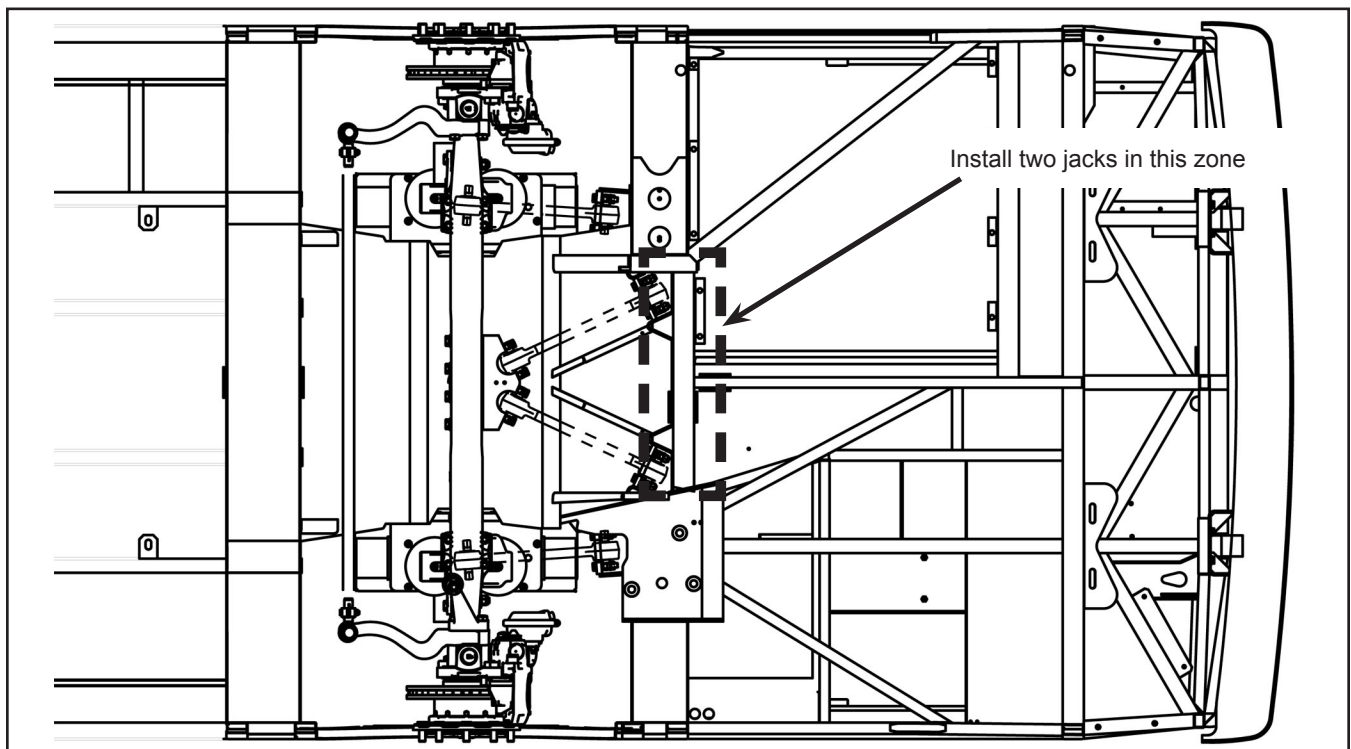


Figure 1 - Jack Locations at the front-end of the vehicle

- 1.4. Clean the areas around the cracks.
- 1.5. Drill a 1/8 in. (3 mm) stop-hole at each the end of the crack. If the crack ends at an edge of the support, do not drill a stop-hole at that end. See Figure 2.
- 1.6. Grind the crack down to half the thickness of the beam plates.

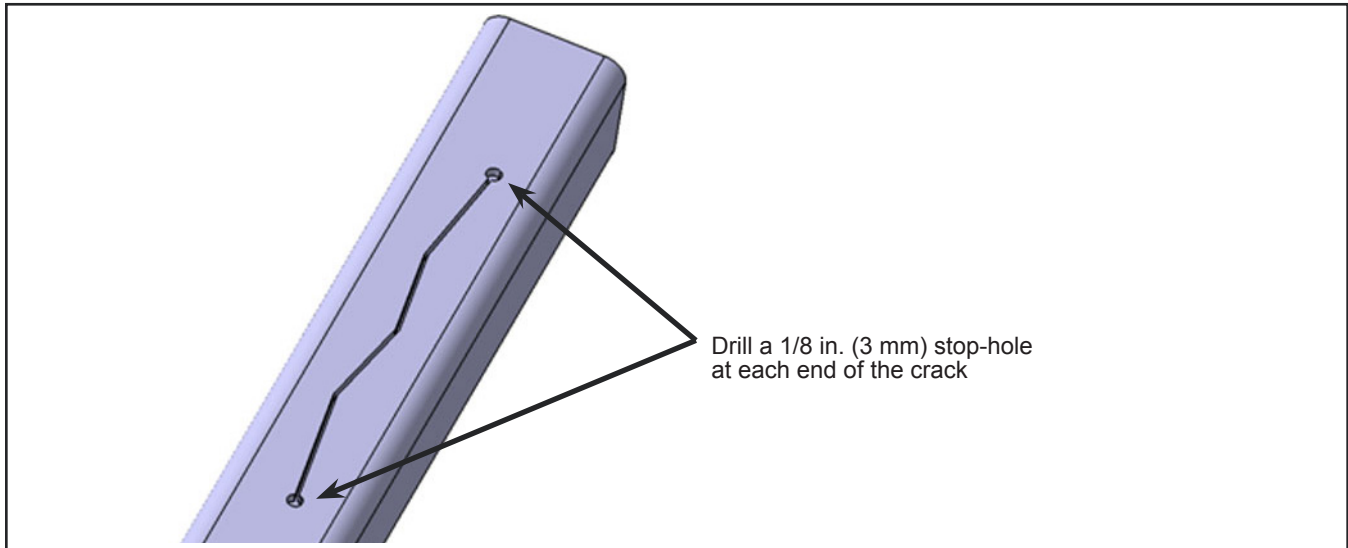


Figure 2 - Typical crack with a stop-hole drilled at each end

- 1.7. Begin welding the crack at one of the stop-holes up to the mid-point of the crack. Begin a new welding bead at the other stop-hole. Meet up with the previous bead.
- 1.8. If the crack is in one of the jack-support zones, grind the welded area flat and smooth.
- 1.9. Clean 11 in. (275 mm) on each side of the left and right gussets, on all faces of the beam. See Figure 3.

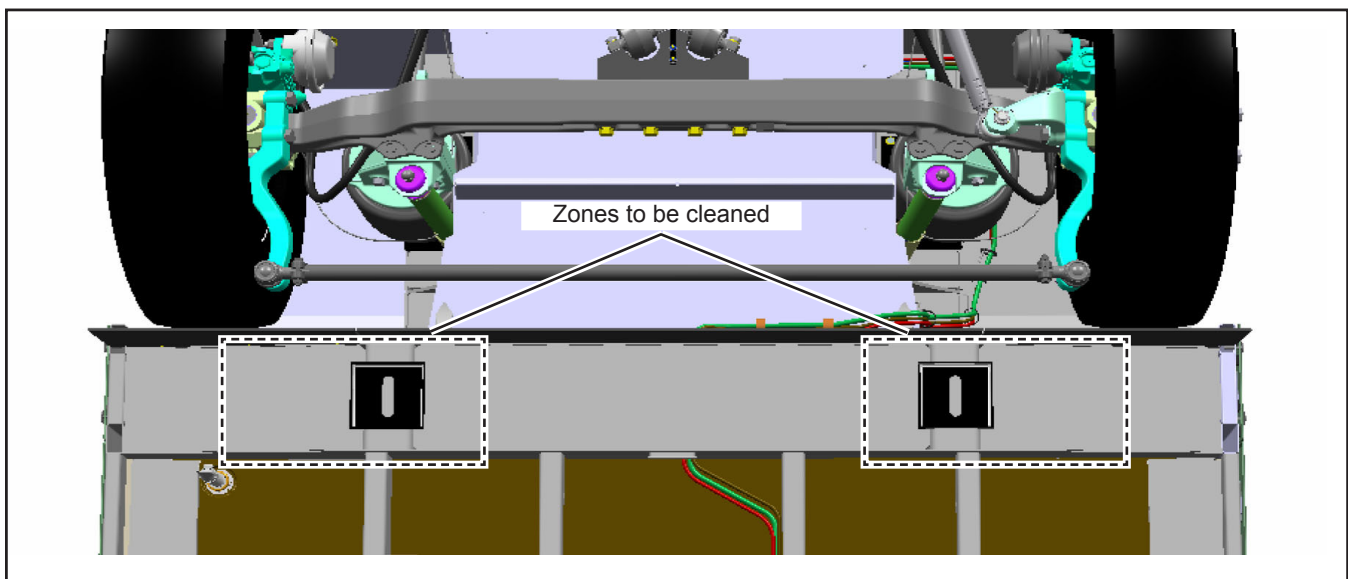


Figure 3 - Beam surfaces to be cleaned

- 1.10. Manually smooth out any bulging surfaces on the face of the beam.
- 1.11. Weld the open spaces between each stitch weld on the beam. Do this at all cleaned locations. See Figure 4 for the welding sequence.

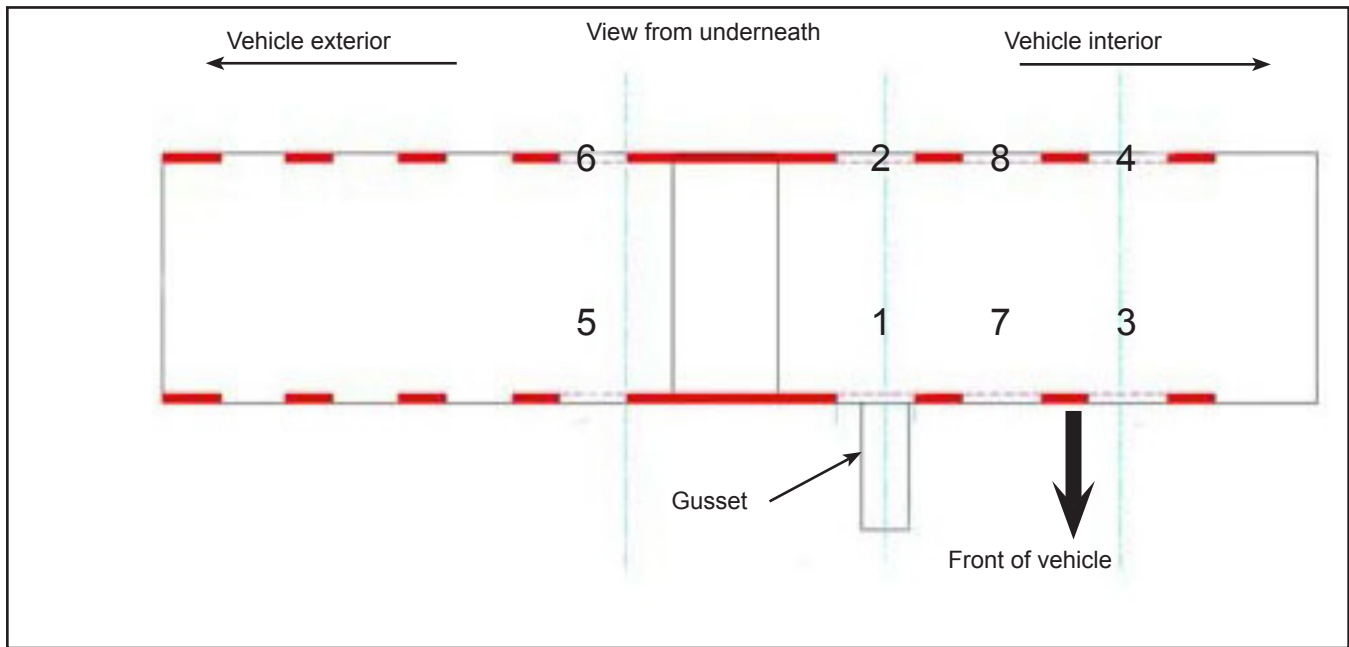


Figure 4 - Welding sequence

- 1.12. Apply an 8-to-12 Mil wet coat layer (203 to 305 microns) of N49247 anti-corrosion protective coating (Tectyl 3335) on the areas that have been cleaned. Use an airless sprayer designed for fluids.
- 1.13. Take a thickness reading on the freshly applied coating. If the reading indicates a thickness less than 8 Mil (203 microns), apply one or more fine coats of anticorrosion product until the correct thickness has been obtained.



NOTE

Thickness readings on the anti-corrosion coating must be done with a wet-film thickness gauge at multiple spots on the treated surface.

- 1.14. Wait for the anti-corrosive coating to develop a skin. When lightly touched, the product should not stick to the finger tips.
- 1.15. Apply a second 8-to-12 Mil coating (203 to 305 microns) (wet coat) N49247 anti-corrosion product (Tectyl 3335).
- 1.16. Wait for the anti-corrosive coating to develop a skin.
- 1.17. Apply a third 8-to-12 Mil coating (203 to 305 microns) (wet coat) N49247 anti-corrosion product (Tectyl 3335).

- 1.18. Let the anti-corrosion product dry for 150 minutes.
- 1.19. Take a thickness reading. Use a wet-film thickness gauge:
 - 1.19.1. If reading indicates a thickness of between 12 and 30 Mil (305 to 762 microns), proceed directly to step 1.20.
 - 1.19.2. If reading indicates a thickness greater than 30 Mil (762 microns), remove excess product. Use a scraper. Do not use a de-greaser.
 - 1.19.3. If reading indicates a thickness less than 12 Mil (305 microns), apply one or more fine coats of anticorrosion product until the correct thickness has been obtained.
- 1.20. Install the mud guards. Reuse previous hardware.
- 1.21. Remove safety jacks from under vehicle.
- 1.22. Lower the vehicle. ❖

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