

NABI BRT: Battery Disconnect Switch Compartment Repair



Prepared By: Kalman Takacs
Field Service Engineer
Phone (256) 241-1243
Fax (256) 832-0930

Approved By: Dan Allen
Chief Engineer

Property Name: NABI 42 and 60BRT-s

Top Bus Number: NA

Issue: Corrosion at battery disconnect compartment.

Reason / cause: The compartment has been updated to enhance the corrosion resistance.
Missing mud flaps may have accelerated the corrosion.

Solution: Repair compartment per this work instruction. Check mud flaps and replace as necessary.

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Number of Affected Buses: 22

Estimate Repair Time: 8 hours.

Necessary parts:

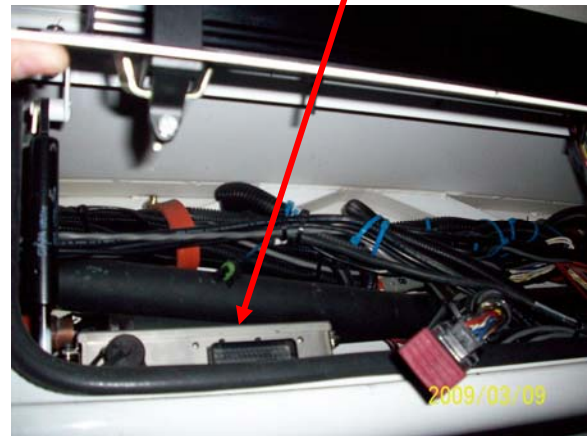
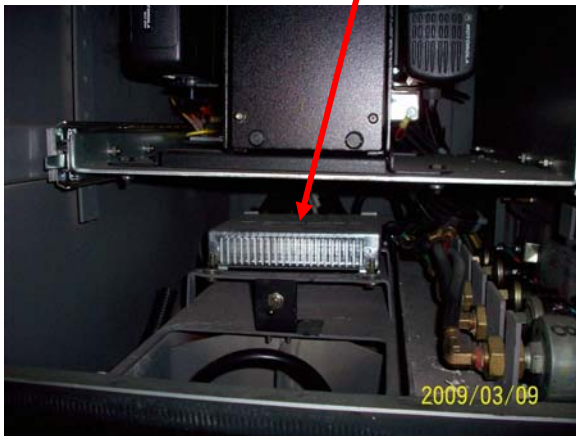
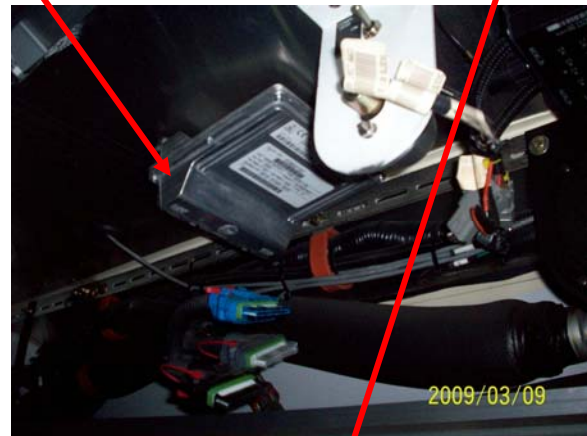
Gas spring cover, stainless steel,	NABI P/N: 61A-7189-001 ,	1/bus,
Plate, cover stainless steel,	NABI P/N: 61A-7189-003 ,	1/bus,
Close out panel stainless steel,	NABI P/N: 61A-7189-005 ,	1/bus,
Sikaflex, 221 white, sealer,	NABI P/N: 70003.01233 ,	1/ 2 buses,
Industrial primer,	NPN,	1 / 2 buses
Rubberized undercoating,	NPN,	1/ 2 buses,

Necessary Tools: Usual hand tools (wrenches, sockets, screwdrivers, hammer, etc.), grinder with thin cutting wheel, 36G, 120G abrasive discs, wire wheel, drill, 1/8" drill bits C-clamps, GMAW welding equipment, 309LSi .030/.035 welding wire and 98%Argon-2%Oxigen shielding gas.



SAFETY PRECAUTIONS MUST BE FOLLOWED ACCORDING TO ACCEPTED INDUSTRY STANDARDS AND LOCAL/PROPERTY REQUIREMENTS.

1. Park the bus on a leveled surface and apply the parking brake.
2. Turn off the battery disconnect switches.
3. Tag and disconnect the batteries cables.
4. Disconnect the ECU of engine, ABS, transmission, and the Hubner (anti knife system).



5. Disconnect the destination signs.
6. Turn off and disconnect the PA system.

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7. Remove battery disconnect switch compartment door with gas spring.



8. Cut and remove corroded sheet metal parts. Cut only as needed in order to remove the corroded area. See pictures below.





9. Clean and prime/paint any parts (as required) that will cover by the new sheet metal parts.
10. Install new parts per pictures below. Use rivets and clamps to temporary secure parts in place.

Note: according to the size of the corroded area, maybe not all of the new sheet metal parts are required. Cut new sheet metal parts if only the section of it required. Weld parts according to the followings:

- Use GMAW (MIG) welding process with 309LSi .030/.035 welding wire and 98%Argon 2%Oxigen shielding gas (or Trimix) with 8-10 liter/min gas flow.
- Tack and stitch weld sheet metal parts together and to the existing sheet metals.



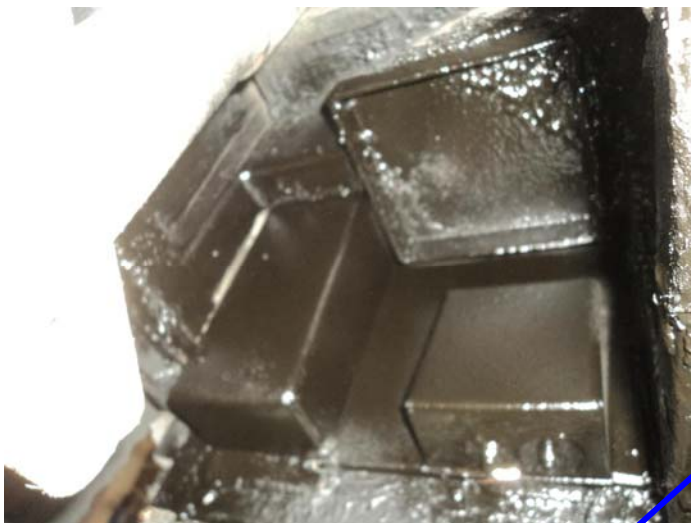
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11. Prime and seal the connections of new and original sheet metal parts.



12. Apply rubberized undercoating both sides of the repaired area.



- 13. Check for completeness of work.
- 14. Reinstall door with gas spring.
- 15. Remove unused parts and tools from work area.
- 16. Record Bus Number, Date of repair and Mileage.