

DART Field Repair: Removal of old rubber strips / Install of new rubber strips		
Work Instructions Initial Release: 3/21/2014	REVISION:	DOCUMENT: WI-081

1.0 PURPOSE

The purpose of this document is to provide instructions for field replacement of rubber strips on doors & frame assemblies for DART 40' and DART 31' buses. The original rubber strips (Neoprene rubber with rubber based adhesive) shall be replaced with new rubber strips (EPDM rubber with 3M acrylic adhesive).

2.0 SCOPE

2.1 This work instruction applies to the DART 40' and DART 31' installation effort.

2.2 Remove old rubber strips (Neoprene rubber) from doors & frame

2.2.1 Remove major residue of old adhesive from the metal surfaces (doors & frame)

2.2.2 Install new rubber strips (EPDM rubber)

2.3 Starting the week of 2/10/2014, buses were processed at Agility utilizing the new rubber.

2.3.1 The new rubber shall not be removed

2.3.2 Reference the following Information Sheets for buses processed using the new rubber

2.3.2.1 40' DART BUSES WITH NEW RUBBER ON FRAME & DOORS

2.3.2.2 31' DART BUSES WITH NEW RUBBER ON FRAME & DOORS

2.4 Starting the week of 2/24/2014, Rush Truck Center installed new rubber on doors

2.4.1 The new rubber shall not be removed

2.4.2 Reference the following Information Sheets for buses processed by Rush Truck Center

2.4.2.1 40' DART BUSES WITH NEW RUBBER ON DOORS ONLY

2.4.2.2 31' DART BUSES WITH NEW RUBBER ON DOORS ONLY

3.0 ASSOCIATED DOCUMENTS

4.0 TOOLS, GAUGES, FIXTURES

5.0 GENERAL INSTRUCTIONS

5.1 PERFORM REPLACEMENT OF RUBBER STRIPS ON DOORS (unless new rubber is already present)

5.1.1 Reference "LOCATION OF RUBBER STRIPS ON DOORS" included as part of this document

5.1.2 Remove existing rubber strips

5.1.3 If major adhesive residue remains on the door surface, perform the following:

5.1.3.1 Spray isopropyl alcohol on the old adhesive residue

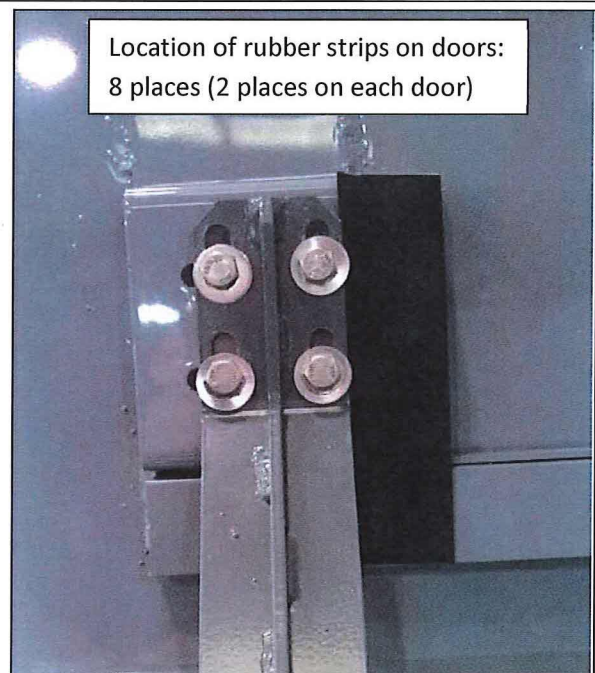
5.1.3.2 Allow 5-10 minutes for reaction time

5.1.3.3 Remove major residue using a plastic scraper tool

5.1.4 Attach new rubber strips as follows:

5.1.4.1 Apply *light thumb/hand pressure* over entire surface to achieve initial bond

5.1.4.2 Follow-up with *increased hand pressure* over entire surface to achieve final bond



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- 5.2 **PERFORM REPLACEMENT OF RUBBER STRIPS ON FRAMES (unless new rubber is already present)**
 - 5.2.1 Reference "LOCATION OF RUBBER STRIPS ON FRAMES" included as part of this document
 - 5.2.1.1 31' bus
 - 5.2.1.2 40' bus
 - 5.2.2 Remove existing rubber strips
 - 5.2.3 If major adhesive residue remains on the frame, perform the following:
 - 5.2.3.1 Spray isopropyl alcohol on the old adhesive residue
 - 5.2.3.2 Allow 5-10 minutes for reaction time
 - 5.2.3.3 Remove major residue using a plastic scraper tool
 - 5.2.4 Attach new rubber strips as follows:
 - 5.2.4.1 Apply light thumb/hand pressure over entire surface to achieve initial bond
 - 5.2.4.2 Follow-up with increased hand pressure over entire surface to achieve final bond

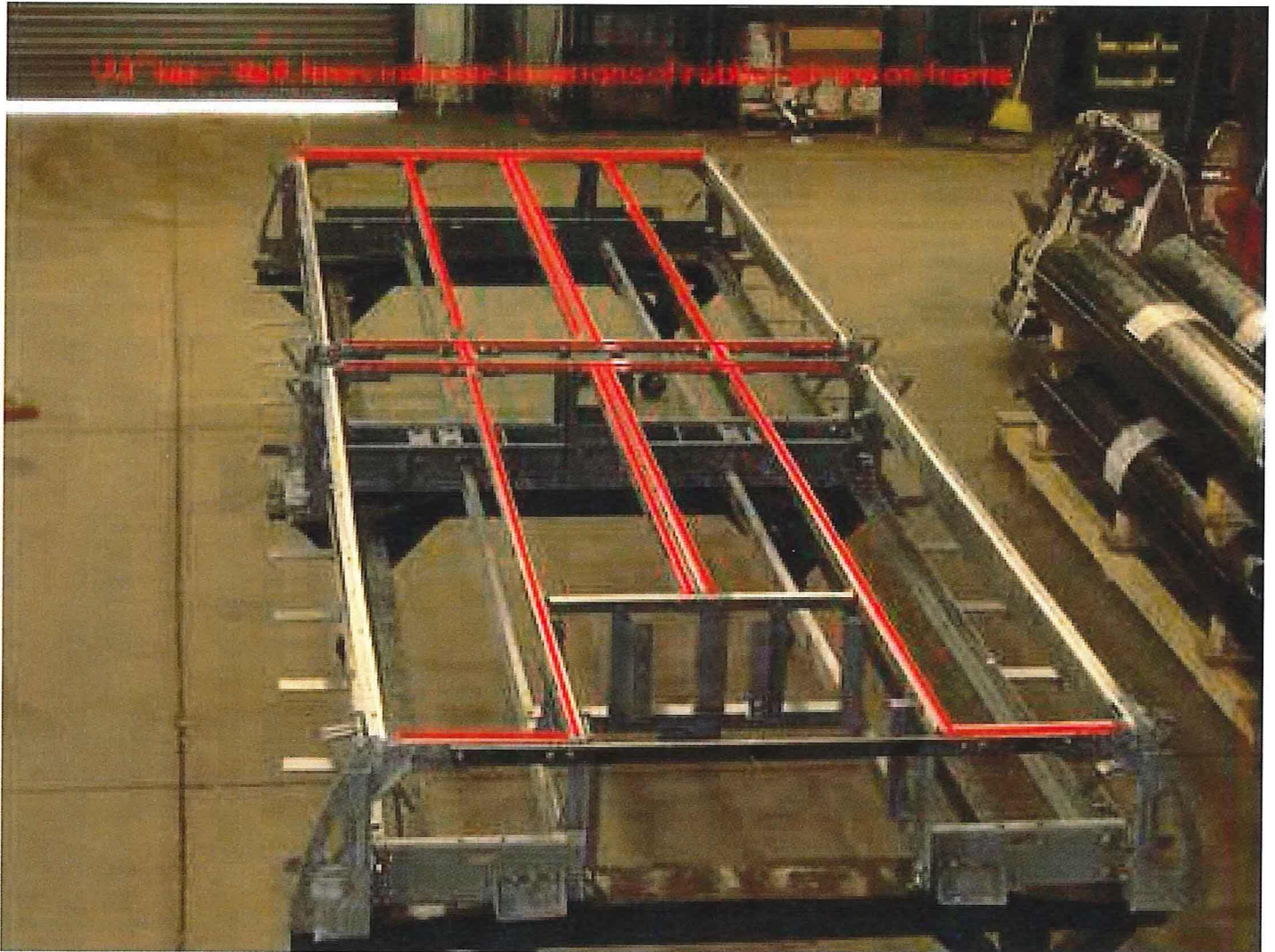


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LOCATION OF RUBBER STRIPS ON DOORS



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40' bus: Red lines indicate locations of rubber strips on frame

