

NJT: LOOSE UPPER SEAT TRACK ATTACHMENT



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Issue: The upper seat track may be loose on some buses.

Reason/ cause: This change is being made to enhance the durability of the seat track securement.

Solution: Install additional rivets per this work instruction.

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Number of affected buses: 5546 - 5673

Estimate repair time/bus: 1 hour if just rivets have to be added. 2 hours if seat has to be removed from the loose seat track section. 3 hours if a complete seat track section has to be replaced.

Necessary parts:

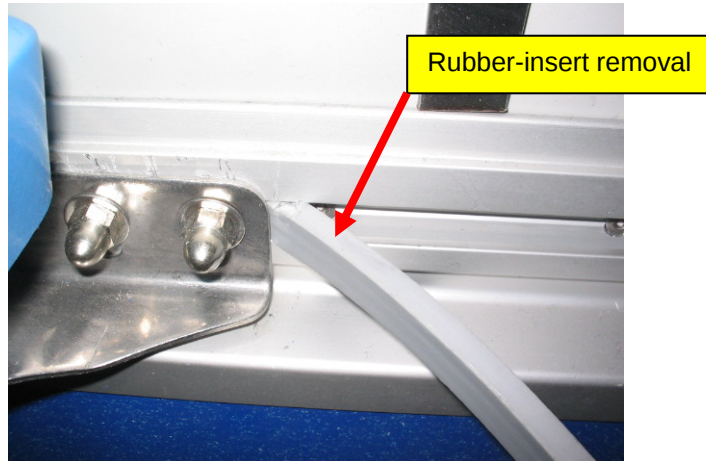
Seat track, (upper and lower),	part #: 416.02-7600-804	as required,
1/4", 0.350-0.625, SS PH SS rivet	part #: 700-8606-001	as required,
1/4x5/8, .160-.475 grip range SS CS rivet,	part #: 5029699	as required,
T-bolt, 3/8-24	part #: 5030480	as required,
Acorn nut 3/8-24	part #: 416.00.7600.905	as required,
Flat washer, 3/8	part #: 2606SS	as required,
221 Sikaflex, white	part #: 70003.01233	as required,
C5-A Copper based anti-seize	part #: 5024582	as required.

Necessary tools: Drill, rivet gun, F-size (0.2570") and 5/16 drill bits, flat head screwdriver, torque wrench (to 30 ft-lb), 90° countersink, 9/16 wrenches and sockets.

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

Adding rivets to the upper seat tracks (only if no damage on the seat track)

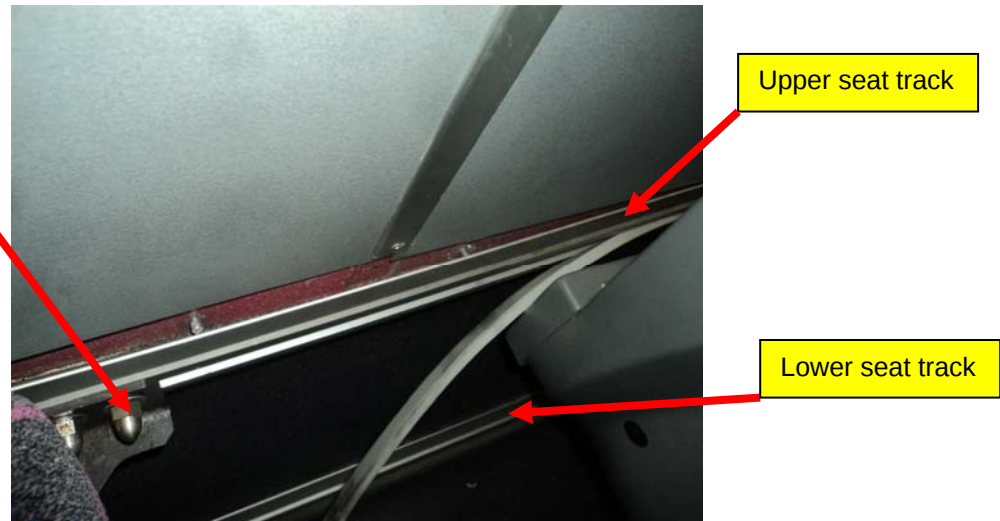
1. Remove the rubber inserts from the seat tracks by using a screwdriver or knife.



2. Drill F-size (0.2570") holes through the seat track into the side wall between the existing rivets. Also drill a hole 1" from the end of the seat track; if there is an existing rivet already located there then drill a hole 1" from this rivet. *Do not remove the seats! It is not necessary to add rivet underneath the seat brackets if the track is not damaged.*
3. Apply anti-seize lubricant (part #: **5024582**) onto the 1/4" SS ph head rivets (part #: **700-8606-001**) and reinforce the upper seat track to the side wall by using a rivet gun. Ensure that the head of the rivet gun goes into the gap of the seat track (see picture on page 5th).
4. Reinstall the rubber cover trims. Cut the rubber trim above the pan head rivets to allowed the trim to fit flush (see pictures on the page 6th).

Separated or loose upper seat track repair

1. Remove the rubber inserts from the seat tracks by using a screwdriver or knife.
2. Mark (on the side wall, by using an erasable ink or pencil) the position of the seat brackets and the mounting bolts. It is important because underneath the mounting bolts (T-bolts) countersink rivets have to be used.
3. Remove the seat(s) from the loose section of the seat track by loosening the 3/8 size acorn nuts at the upper and at the lower seat tracks.



4. Remove the broken or loose rivets from the seat track and from the side wall.
5. Make sure that no dirt is underneath the seat track. Ensure that there is no gap between the side wall and the seat track. If the interior panel is over hanging underneath the contact surface of the seat track, then cut the interior panel (see picture below).



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6. Drill $\frac{1}{4}$ " holes through the seat track into the side wall between the existing rivets, and drill a F-size hole 1" from the existing hole where a broken or loose rivet was previously removed. Also drill a hole 1" from the end of the seat track; if there is an existing hole (or rivet) already located there then drill a hole 1" from this hole (or rivet).



7. Apply anti-seize lubricant (part #: **5024582**) onto the $\frac{1}{4}$ " SS ph head rivets (part #: **700-8606-001**) and secure the upper seat track to the side wall by using a rivet gun. Ensure that the head of the rivet gun goes into the gap of the seat track (see picture below). Install $\frac{1}{4}$ "-5/8 SS countersink rivets (part # **5029699**) only at the previously countersunk holes as needed for clearance of the seat mounting T-bolts.

Ensure that the head of the rivet gun fits the gap of the seat track.

$\frac{1}{4}$ " pan head SS rivet
(part #: **700-8606-001**)



8. Apply Sikaflex 221 white sealer (part #: **70003.01233**) into the existing holes of the seat track, where rivets could not be installed (damaged oversized holes).
9. Reinstall the seat(s) into the original position(s) as marked on the side wall (see paragraph 2 above) by using the original T-bolts and acorn nuts. Torque the nuts to 30 -5/+10 ftlb. Ensure that the T-bolts fully turned into the seat track. Use new T-bolt (part #: **5030480**) if the thread is damaged or the head of the original T-bolt can not be turned fully into the seat

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track. Use new 3/8 SS flat washer (part #: **2606SS**) and new acorn nut (part #: **416.00.7600.905**) if needed.

T-bolt (part #: **5030480**)



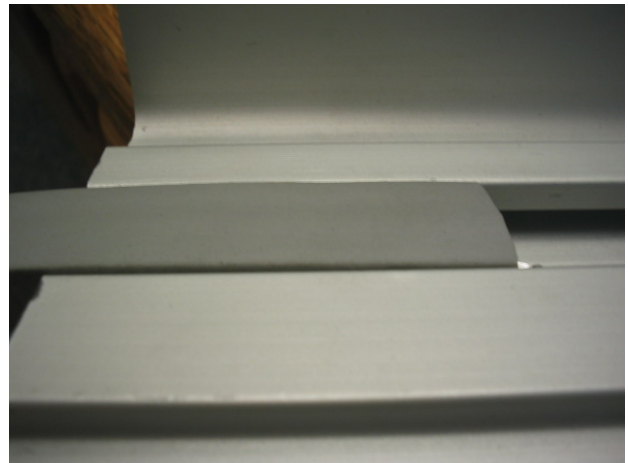
Not fully turned T-bolt; incorrect



Fully turned T-bolt; correct



10. Reinstall the rubber cover trims. Cut the rubber trim above the pan head rivets to allow the trim to fit flush (see below).



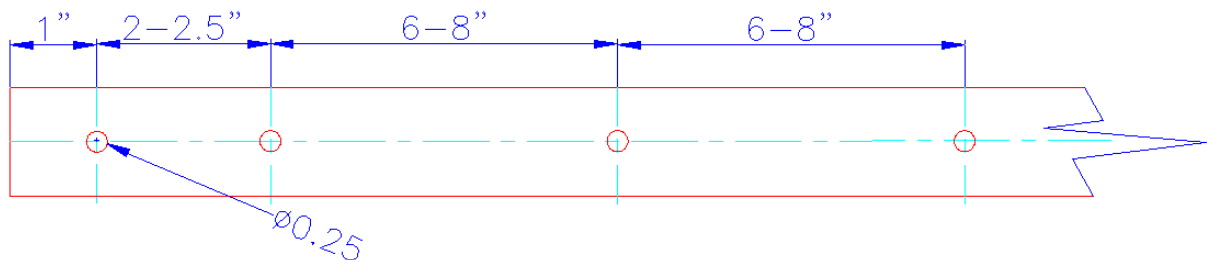
New upper seat track installation

1. If the seat track is bent or broken then remove the rubber insert from the upper seat tracks by using a flat head screwdriver. (Bent or broken seat tracks should be replaced.)
2. Mark (on the side wall, by using an erasable ink or pencil) the position of the seat brackets and the mounting bolts. It is important because underneath the mounting bolts (T-bolts) countersink rivets have to be used (see paragraph 8 below).
3. Remove the seats by loosening the 3/8 size acorn nuts at the upper and at the lower seat tracks (see pictures on the 4th page).
4. Drill out the existing rivets that are still holding the seat track by using a 5/16" size drill bit.
5. Mark the original hole-pattern onto the new upper seat track (part #: **416.02-7600-804**). This is necessary to prevent drilling the seat track at or close to that position, where a hole already exists in the side wall.

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6. Apply Sikaflex 221 white sealer (part #: **70003.01233**) into the existing holes of the side wall.
7. Place the new seat track to the side wall. Make sure that no dirt is underneath the seat track. Ensure that there is no gap between the side wall and the seat track. If the interior panel is over hanging underneath the contact surface of the seat track, then cut the interior panel (see picture on the 4th page).
8. Drill F-size holes through the seat track into the side wall: drill the first hole 1" from the end of the seat track and the 2nd hole is 2-2.5" from the first hole. The rest of the holes must be located 6-8" from each other (see the drawing below). Do not drill holes at or closer then 1" to the previously marked locations (see 5th paragraph); the minimum distance must be 1" between two holes. Countersink only those holes where the T-bolts (of the seat brackets) will be installed.



9. Apply anti-seize lubricant (part #: **5024582**) onto the 1/4" SS pan head rivets (part #: **700-8606-001**) and secure the upper seat track to the side wall by using a rivet gun. Install 1/4"-5/8 SS countersink rivets (part # **5029699**) only at the previously countersunk holes as needed for clearance of the seat mounting T-bolts.
10. Reinstall the seat(s) into the original position(s) as marked on the side wall (see paragraph 9 on the 5th page).
11. Reinstall the rubber cover trims. Cut the rubber trim above the pan head rivets to allowed the trim to fit flush (see pictures on the 6th page).

Make sure that all of the tools and dirt (metal shavings, rivets etc.) are removed from the bus. Record bus number, mileage, date of completing and the name of the person who performed the work.