

REFERENCE:	Nova Bus Manuals
SECTION:	12: Interior furnishing
RS N°:	MQR 7621-695
EFFECTIVE IN PROD.:	L755-02 (2013MA)

APPLICATION DEADLINE: 2015AL01
CLAIM REFERENCE NUMBER: WB-3091

SUBJECT:	Floor covering weld bead lifting.
JUSTIFICATION:	The weld bead separates from the floor covering, causing degradation to the floor adhesive.

LEVEL	DESCRIPTION	DIRECT CHARGES		TIME
		LABOUR	MATERIAL	
1	Inspect and repair the three weld beads.	Nova Bus	Nova Bus	1.5 h
2	Replace the damaged section of floor covering.	Nova Bus	Client*	2 h / replacement

* The cost of the material will be reimbursed when claiming for this service document.

MATERIAL

QTY	PART N°	REV.	DESCRIPTION	REPLACES PART N°
LEVEL 1				
3	N47149-04	–	Bead weld rod	–
LEVEL 2 (only if required*)				
1	N47149-04	–	Bead weld rod	–

Materials will be available within 60 days. To order, please contact Prevost Parts by phone at 1-800-771-6682, by fax at 1-888-668-2555 or by email at prevostparts.commandes@volvo.com. Specify document number, quantity of parts required and shipping address.

* The material identified in Level 2 is to be ordered only for vehicles that respect the criteria defined in Level 1.

DISPOSAL OF PARTS

REMOVED PARTS ARE:	DISCARDED *	RETAINED	* Dispose of the unused parts and the defective parts in accordance with local environmental standards in effect.
	Yes	–	

REVISION HISTORY

REV.	DATE	CHANGE DESCRIPTION	WRITTEN BY
NR	2014FE04	Initial release	Bertrand Plouffe

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
New York City Transit - New York	L643	5895	5895	S92U1B4000143	S92U1B4000143	1
New York City Transit - New York	L670	5770	5894	S92U4C4500024	S92U3B4000242	125
New York City Transit - New York	L681	5896	5283	S92U2C4500023	S92U9C4500195	122
New York City Transit - New York	L692	5284	5363	S92U3C4500158	S92U3D4500274	80

**WARNING**

Follow your internal safety procedures.

PROCEDURE

LEVEL 1: INSPECT AND REPAIR THE THREE WELD BEADS.

- 1.1. Locate the first floor seam between the front wheelhouses.
- 1.2. Inspect the weld bead. See Figure 1. If you see serious damage to the floor covering such as water intrusion, go to Level 2: **REPLACE A DAMAGED SECTION OF FLOOR COVERING**.



Figure 1 - Left Picture: Damaged Weld Bead Section on an Undamaged Floor Covering (Level 1: Repair)
Right Picture: Damaged Floor Covering (Level 2: Replace)

- 1.3. Use a clean cloth to remove any dust along the seam.

**NOTE**

If you have never attempted to weld floor seams before, see Annex 1: FLOOR REPAIR INSTRUCTIONS.

- 1.4. Install the grooving tip on the hot air welder and wait until it reaches the right temperature. Slowly remove the damaged weld bead section(s) using a square as a cutting guide. See Figure 2.

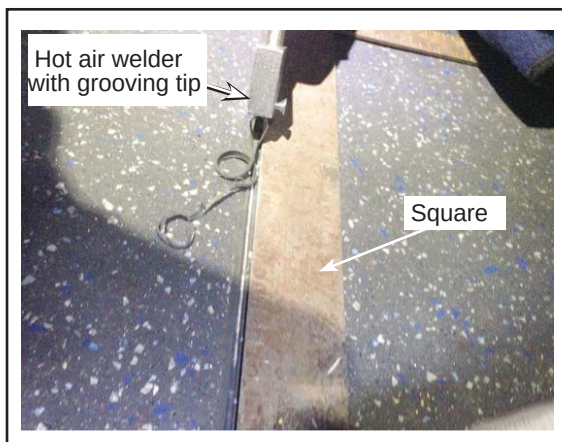


Figure 2 - Removal of Damaged Weld Bead with a Grooving Tip Installed on a Hot Air Welder

**CAUTION**

High risk of burns. Be very careful when removing and replacing the tip.

- 1.5. Use a dry clean cloth or paintbrush to remove any debris. See Figure 3.



Figure 3 - Damaged Weld Bead Removed

- 1.6. Install the rabbit tip on the hot air welder. Cut a length of N47149-04 bead weld rod four inches longer than the section to be repaired. With the hot air welder at approximately 400° F, carefully insert the rod in the rabbit tip. Weld at a slow and steady pace. See Figure 4.

**CAUTION**

High risk of burns. Be very careful when removing and replacing the tip.

Once you have finished, turn the hot air welder's heat switch to 0. Let the hot air welder cool down before turning it off to prevent damage to the tool.

**NOTE**

Make sure the surface is dry and clean before welding.

It is acceptable to overlap the rod while welding floor seams.

The weld bead must completely fill the seam.

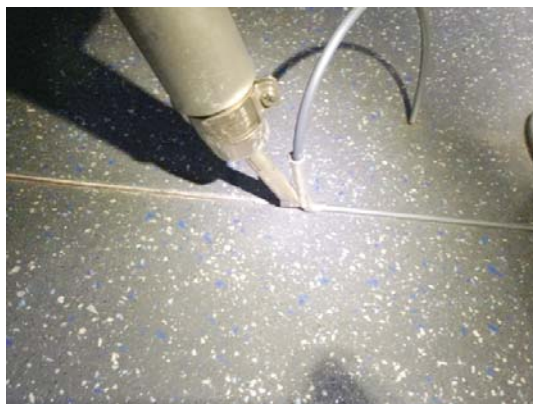


Figure 4 - Welding a Floor Seam

- 1.7. Remove excess material using a Mozart knife with the attached plate. See Figure 5.



Figure 5 - Removal of Extra Material Using the Mozart Knife with the Attached Plate

- 1.8. Allow 5 to 10 minutes to let the weld bead cool. Use the Mozart knife without the attached plate to trim the weld bead to a clean, flush finish. See Figure 6.

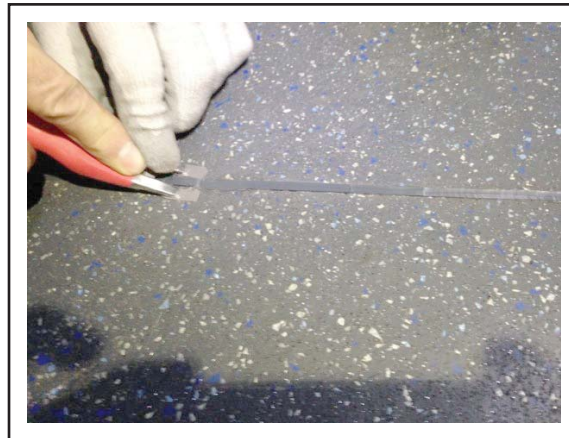


Figure 6 - Trimming Using the Mozart Knife without the Attached Plate

- 1.9. Carefully inspect and verify that the floor seam is sealed. Clean the area. See Figure 7.



Figure 7 - Good Floor Seam

- 1.10. Locate the second floor seam between the middle wheelhouses.
- 1.11. Repeat steps 1.2 to 1.9.
- 1.12. Locate the third floor seam between the rear wheelhouses.
- 1.13. Repeat steps 1.2 to 1.9.
- 1.14. Once all locations are done, the vehicle may be returned to service.

LEVEL 2: REPLACE A DAMAGED SECTION OF FLOOR COVERING.

- 2.1. Remove weld bead as per step 1.4 in **LEVEL 1: INSPECT AND REPAIR THE THREE WELD BEADS.**
- 2.2. Cut floor covering to desired width, depending on damage (normally from 2 to 24 inches).
- 2.3. Use a knife and ice pick to remove the damaged section. See Figure 8.



Figure 8 - Removal of Damaged Section

- 2.4. Pull with one hand and apply acetone or similar product to dilute adhesive. See Figure 9.



Figure 9 - Diluting Adhesive with Solvent

- 2.5. Remove remaining end sections with pliers. See Figure 10.



Figure 10 - Removal of Remaining End Sections

- 2.6. With acetone or similar product, remove remaining adhesive on the floor.
2.7. Apply masking tape around the surface to be repaired. See Figure 11.



Figure 11 - Applying Masking Tape to Protect Surrounding Areas

- 2.8. Apply N45500 adhesive on floor. See Figure 12.



Figure 12 - Applying Adhesive on Floor

- 2.9. Cut a piece of floor covering from the N47101-57 raw material. Apply N45500 adhesive on the piece of floor covering. See Figure 13.



Figure 13 - Applying Adhesive on Floor Covering

- 2.10. Bond the piece of floor covering to the floor.
- 2.11. Install the grooving tip on the hot air welder. Use a square as a guide and create a groove on both seams. See Figure 14.

**CAUTION**

High risk of burns. Be very careful when removing and replacing the tip.

Once you have finished, turn the hot air welder's heat switch to 0. Let the hot air welder cool down before turning it off to prevent damage to the tool.

**NOTE**

Make sure the surface is dry and clean before welding.

It is acceptable to overlap the rod while welding floor seams.

The weld bead must completely fill the seam.



Figure 14 - Creating a Groove on Both Sides of New Bonded Piece of Floor Covering

- 2.12. Follow steps 1.5 to 1.9 in **LEVEL 1: INSPECT AND REPAIR THE THREE WELD BEADS** for both seams.
- 2.13. Once you have inspected and repaired all floor seams, the vehicle may be returned to service. Otherwise, go to step 1.2 in **LEVEL 1: INSPECT AND REPAIR THE THREE WELD BEADS**.



Annex 1: FLOOR REPAIR INSTRUCTIONS

FLOOR REPAIR INSTRUCTIONS



NOTE

For a list of suggested tools listing, see Annex 2.

Annex 1.1. Use a scrap piece of floor covering to get familiar with hot air welder usage.

Annex 1.2. Install the grooving tip on the hot air welder. Once the temperature reaches approximately 400 °F, use a square or ruler as a guide to remove some material. See Figure 14.



CAUTION

High risk of burns. Be very careful when removing and replacing the tip.

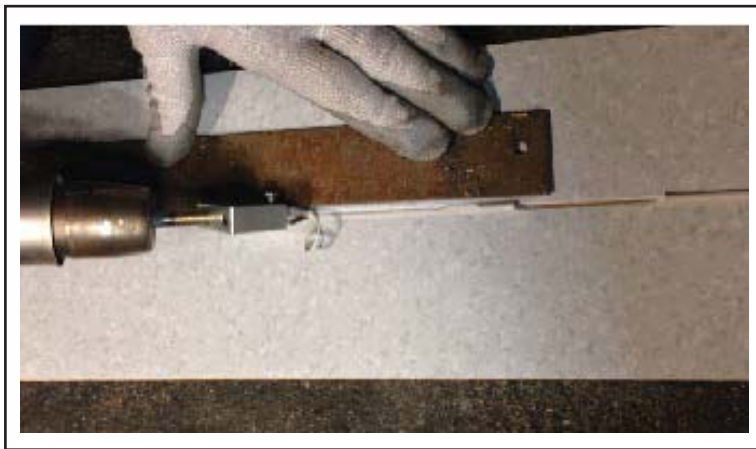


Figure 15 - Working with the Grooving Tip

Annex 1.3. Install the rabbit tip on the hot air welder. Insert the weld rod in the rabbit tip. Weld on the piece of floor covering at a slow and steady pace, applying enough pressure. See Figure 15.

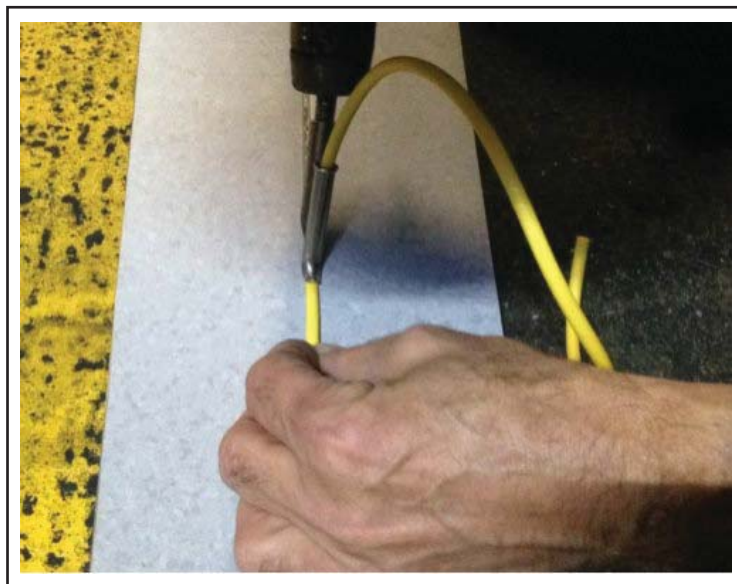


Figure 16 - Welding with the Rabbit Tip

Annex 1.4. Make sure to create a little bead on both sides of the seam, indicating a good weld. See Figure 16.



Figure 17 - A Good Weld Bead

Annex 1.5. Use a Mozart knife with the attached plate to remove excess material. Allow 5 to 10 minutes to let the seam cool. Apply enough pressure on the knife without the attached plate to trim to a clean, flush finish. See Figure 17.

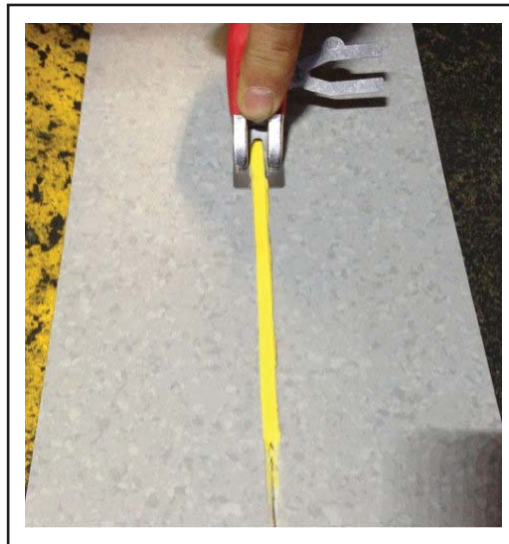


Figure 18 - Using the Mozart Knife

Annex 1.6. Repeat steps Annex 1.1 to Annex 1.5 as needed to gain more confidence in welding floor seams.



CAUTION

Once you have finished, turn the hot air welder's heat switch to 0. Let the hot air welder cool down before turning it off to prevent damage to the tool.

Annex 2: SUGGESTED TOOLS



N8885714 Electric hot air welding tool



N8885716 Speed welding nozzle (rabbit tip)



Grooving tip



Mozart knife