

# CNG CRADLE BOLT REWORK



Prepared by:

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Property name and Top bus number: **DART 304000 39001**  
**304500 39002 – 39155**  
**306000 38001**  
**306500 38002 – 38030**

Issue: CNG cradle studs have surface rust

Reason/ cause: not coated for the weather

Solution: add galvax cold galvanizing paint to studs

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Number of buses affected:    **DART**                    **304000**    **39001**  
   **304500**    **39002 – 39155**  
   **306000**    **38001**  
   **306500**    **38002 – 38030**

Estimate repair hours/bus:    2 hours

Engineering Documentation:    **DEV 13-200**  
   **ECN 13-34798**

Necessary parts:	<b>525-1584-005</b>	<b>nut, m12-1.75, disc lock</b>	<b>as needed per bus</b>
	<b>700-8627-001</b>	<b>zn paint, cold galvanizing,galvax</b>	<b>.1 gal per bus</b>
	<b>5024582</b>	<b>lubricant, anti-seize</b>	<b>.125 per bus</b>

Necessary tools:    usual hand tools, brake cleaner, wire brush, screw gun with #2 Philips tip, and torque wrench and socket (55 ft. lbs.), torque seal

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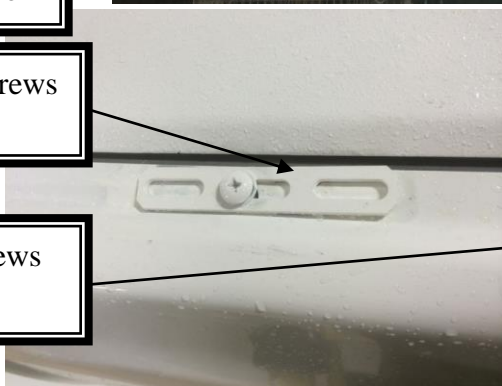
**SAFETY PRECAUTIONS MUST BE FOLLOWED ACCORDING TO ACCEPTED INDUSTRY STANDARDS AND LOCAL/PROPERTY REQUIREMENTS.**

1. Remove panels on both sides of bus to gain access to bolts

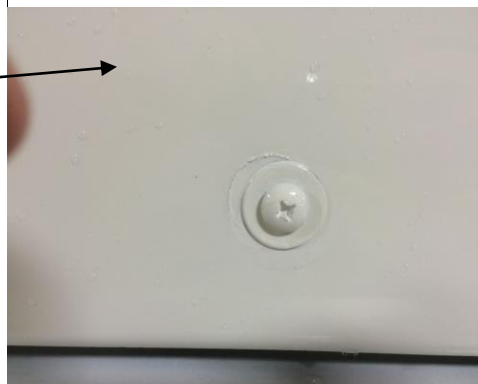
Remove hardware from side and top of cng panels on the roof



Top screws (X24)



Side screws (X24)



2. Open top doors and use proper fall protection per shop safety procedures
3. Remove existing hardware from cradle studs (X28)

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4. Clean existing studs with brake cleaner and wire brush to remove all corrosion and paint



5. Apply (700-8627-001) galvax coating to studs; apply ant seize inside of the nut before reinstalling. **Replace nut if any sign of corrosion.** Reinstall washers and disc lock nuts (525-1584-005). Torque hardware to 55 ft. lbs.

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6. Apply (700-8627-001) galvax coating to final assembled nut and stud. Completely cover stud, nut, and washer with generous coating of galvax.



7. Apply torque seal to nut after applying galvax

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8. Reinstall side covers
9. Check for completeness of work.
10. Remove all tools from working area.