



INSTRUCTION TO SERVICE

ITS: 5673

SECTION:	405 Artic Joint
WRITTEN BY:	Jermie Marasigan
SUBJECT:	Modify Artic Joint Seat Pedestal Installation

ITS5673

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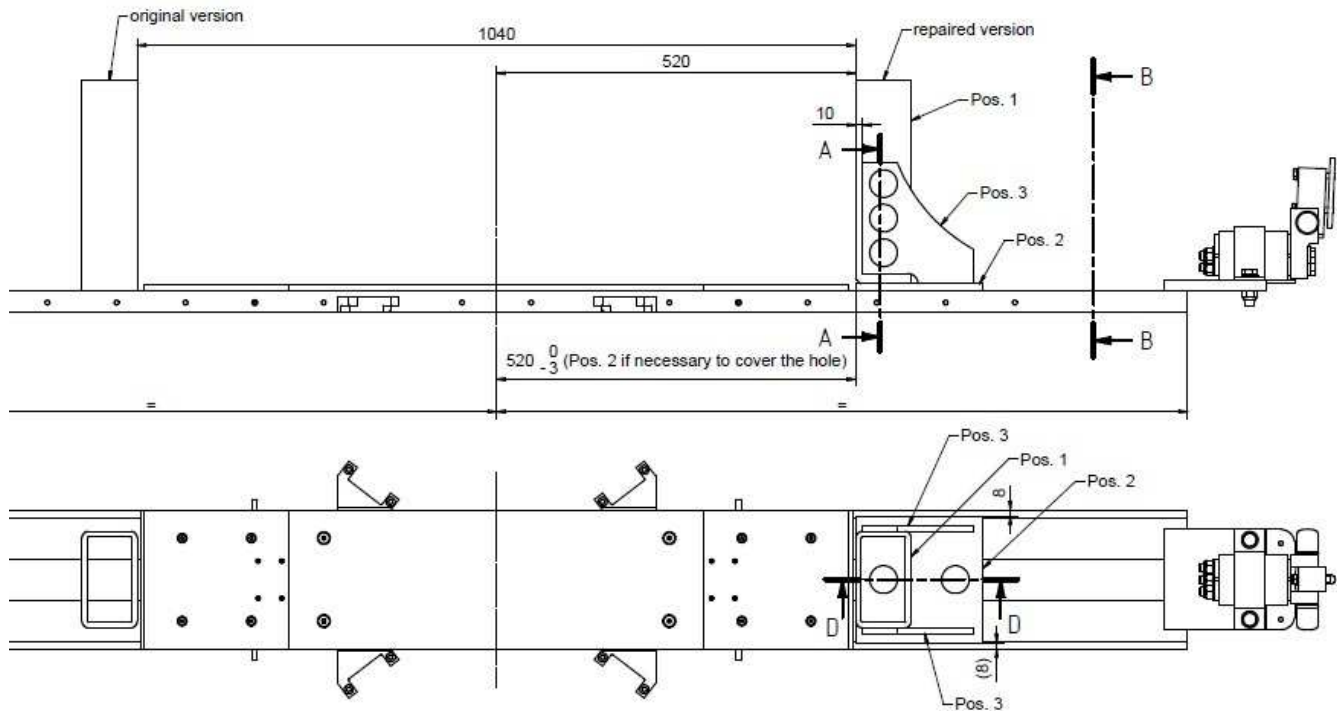


PROCEDURE:

1. Turn the main battery disconnect switch to the "OFF" position.
2. Remove the seats on both sides in the articulated joint area and set aside seat and hardware for re-installation.
3. Grind the weld around the base of the pedestal to remove the seat pedestals from the Artic Joint hoop beam.
4. Grind the bottom front side of the seat pedestals as shown (Z) in Figure 2.

 **NOTE: Grind away the zinc coating on the seat stem where it will be welded. All Welding must comply with New Flyer welding specification.**

5. Weld the bottom plates NF P/N: 6445430, existing pedestals and side gussets NF P/N: 6445431 onto the Artic Joint hoop beam on both sides as shown in Figure 1 and Figure 2. Follow welding procedure in Appendix A.
6. Once the welding is complete apply primer on the bottom plates and welded areas using primer mixture as per Appendix B.
7. Apply paint NF P/N: 102645 on repaired area and seat stem.
8. Re-install the seats using hardware removed from step 2.
9. Turn the main battery disconnect switch to the "ON" position.



NOTE:
Dimensions are in mm

1 mm = 0.03937 in
1 in = 25.4 mm

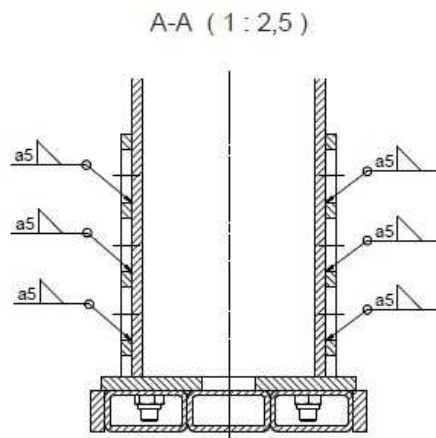
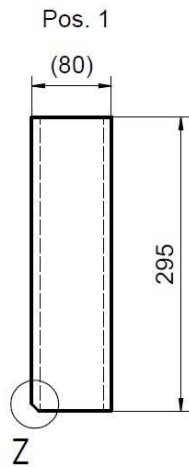
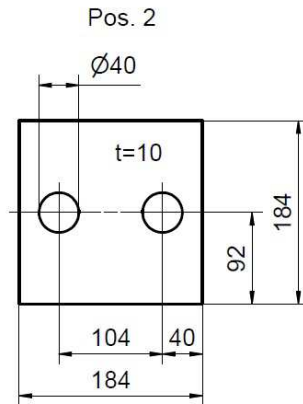


Figure 1: ARTIC JOINT SEAT PEDESTAL INSTALLATION

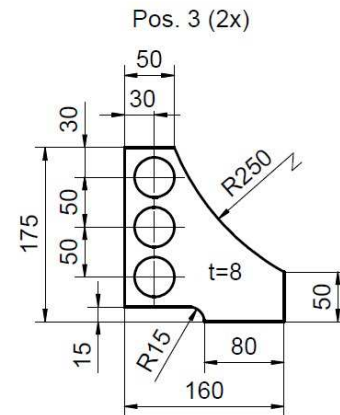
Existing Pedestal



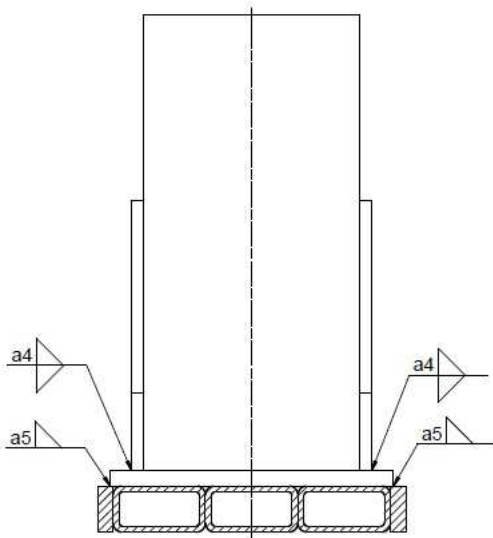
Bottom Plate
NF P/N: 6445430



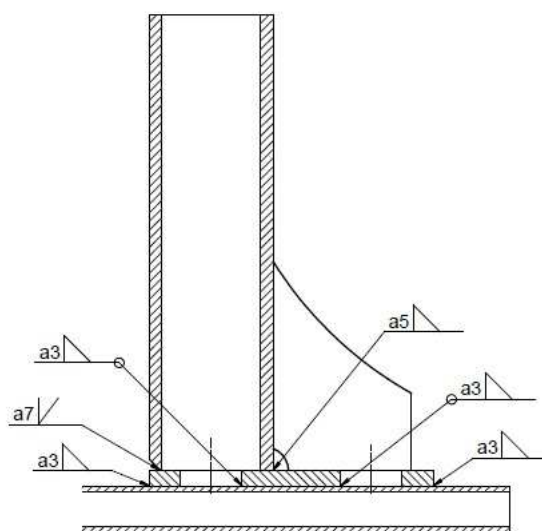
Gusset Plate
NF P/N: 6445431



B-B (1:2,5)



D-D (1:2,5)



Z (1:1)

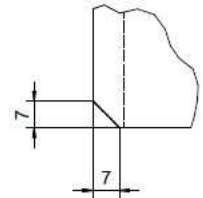


Figure 2: ARTIC JOINT SEAT PEDESTAL INSTALLATION

APPENDIX A

Welding Procedure

- I. Remove old weld by grinding as required. Oxy-acetylene torches must not be used.
- II. Area enclosed by welded zone plus 2" either side to be cleaned to base metal by wire brush, removing all grease, zinc, oil, rust and scale from surfaces to be joined.
- III. Disconnect battery cables when welding. Also disconnect ECUs for engine, transmission, electronic destination signs, ABS, articulated joint (black box and pressure sensors) and VCM.
- IV. Temperature of steel parts to be welded must be at or above 50°F (10°C) before welding.
- V. All welds to be made with E7018, low hydrogen welding rods. Gas metal arc welding (semi-automatic) may be used where practicable, provided AWS A5.18 standard E70S-3 or E70S-6 wire is used, with argon-carbon dioxide shielding gases.
- VI. Welder shall meet qualifications for "all position" welding as per AWS D1.1 or CSA W59 standard qualification for metal arc welding.

APPENDIX B

Primer Mixing Instruction

- I. Clean area to be primed per painting and priming procedures in New Flyer Service manual under section: Chassis and Structure.
- II. Mix DuPont 2570S with DuPont 2505S, to
 - 2 Parts DuPont 2570S (NF PN: 380254)
 - 1 Part DuPont 2505S (NF PN: 380255)

Tips for Success:

Apply one medium wet coat. Film build dry should be 0.8-1.0 mils as a non sanding primer/sealer over metal material. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 40-60 minutes. Up to 2 coats can be applied (2.0-2.0 mils) as non-sanding primer/sealer over steel.

LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Modify Artic Joint Seat Pedestal Installation	1	4.0	4.0

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6445430	PLATE, BOTTOM	2	EA	
2	6445431	PLATE, GUSSET	4	EA	
3	380254	PRIMER-DUPONT 2570S	0.05	EA	
4	380255	ACTIVATOR-DUPONT 2505S	0.025	EA	
5	102645	PAINT-LOW GL BLK 848PN5636LG	0.05	EA	