



INSTRUCTION TO SERVICE

ITS: 5817

SECTION:	410 Tapping Plates
WRITTEN BY:	Kevin Robinson
SUBJECT:	MIDI - Add a tapping plate for the farebox.

ITS5817

HIS DOCUMENT AND THE CONTENTS DISCUSSED HEREIN ARE THE CONFIDENTIAL AND PROPRIETARY INFORMATION OF NEW FLYER INDUSTRIES CANADA ULC AND NEW FLYER OF AMERICA INC. AND ARE DISCLOSED BY NEW FLYER IN CONFIDENCE. THIS DOCUMENT AND THE CONTENTS HEREIN ARE NOT TO BE DISCLOSED BY THE INTENDED RECIPIENT WITHOUT THE PRIOR WRITTEN AUTHORIZATION OF NEW FLYER. ANY UNAUTHOIZED DISCLOSURE, REPRODUCTION OR OTHER DISTRIBUTION OF THIS DOCUMENT OR INFORMATION IS STRICTLY PROHIBITED AND MAY RESULT IN ACTION BEING TAKEN AGAINST THE PARTY MAKING THE UNAUTHORIZED DISCLOSURE. THIS DOCUMENT AND ALL COPIES HEREOF MUST BE RETURNED TO NEW FLYER UPON REQUEST.

PROCEDURE:

1. Turn the main battery disconnect switch to the “OFF” position.
2. Ensure that the fiberglass mating surfaces are thoroughly cleaned of any paint, corrosion protection or insulation. Refer to Figure 1 for placement. Area can be accessed from under the bus, behind the front bumper on.

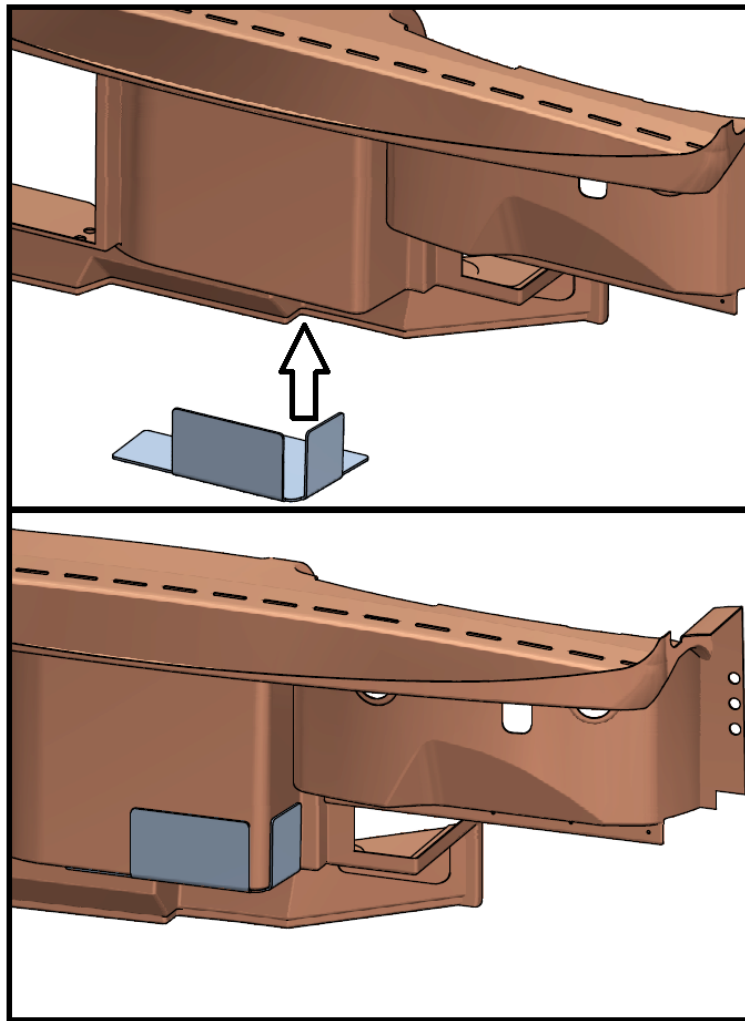


Figure 1: Plate Placement, as Seen From Front of the Bus Looking Rearward.

3. Lightly abrade fiberglass mating surfaces.
4. Prime all mating surfaces using Plexus PC120 (New Flyer PN 067196). Refer to Appendix A for Plexus application procedure.
5. Liberally apply adhesive to all surfaces using Plexus MA920 (New Flyer PN 067197).
6. Block or clamp the tapping plate (PN 34119392) into position. The clamps can be removed after 1 hour.
7. Re apply spray insulation to cleaned off parts.
8. Remove all tools and debris and return the bus to service condition.



9. Turn the main battery disconnect switch to the “ON” position.



Appendix A - Plexus Application Procedure

1. Wipe down all contact surfaces with clean lint free cloth. Ensure that the surface area is free of grease and debris.
2. Apply Plexus PC120 Primer along all surfaces which are to be bonded using clean cloth. Flash off time one minute.
3. Apply Plexus MA920 Adhesive to indicated surface. Dispense adhesive length of mix nozzle when using a new nozzle before applying to primed surface.
4. Place bonding surfaces together, pressing bonding surfaces firmly together and apply clamps.
5. Remove any excess squeezed-out adhesive and allow drying for 60 minutes before removing clamps.

**** SAFETY:** Applicator shall use rubber gloves and approved respirator when using Plexus Primer and Adhesive.



LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Add a tapping plate for the farebox.	1	1.5	1.5

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6335783	STATIC MIXER	1	EA	
2	067196	PRIMER-PLEXUS PC120	0.25	QT	
3	067197	ADHESIVE PLEXUS MA920	0.50	EA	
4	A-34119392	COIN VAULT SUPPORT PLATE	1	EA	

SPECIAL TOOLS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6341339	APPLICATOR GUN	1	EA	