



INSTRUCTION TO SERVICE

ITS: 5927

SECTION:	284 Electrical Panels
WRITTEN BY:	Troy Stutsky
SUBJECT:	Add two bonded and riveted brackets the front and rear of the side console

ITS5927

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PROCEDURE:

1. Turn the main battery disconnect switch to the “OFF” position.
2. Open the side console from the interior of the bus and inspect it to find out what revision number the console is by reading the revision letter sticker.
3. If the console is revision level “G” or higher, only the cup holder hardware will need to be changed.
4. To change the cup holder hardware, follow these steps:
 - a. Remove and discard the cup holder hardware. Retain the cup holder for re-installation.
 - b. Re-install the cup holder using the four new screws (NF PN 14S00010BK) and four new acorn nuts (NF PN 60N00000BK). Please install hardware as shown in Figure 8 below.
 - c. Skip to Step 11 of this ITS.
5. If the revision level is “F” or under, please continue with the instruction steps below.
6. To install the new front bracket (NF PN 571812) on the front end of the side console, follow these steps:
 - a. Locate the front bracket (NF PN 571812) and hold it in place in the location shown in Figure 1.

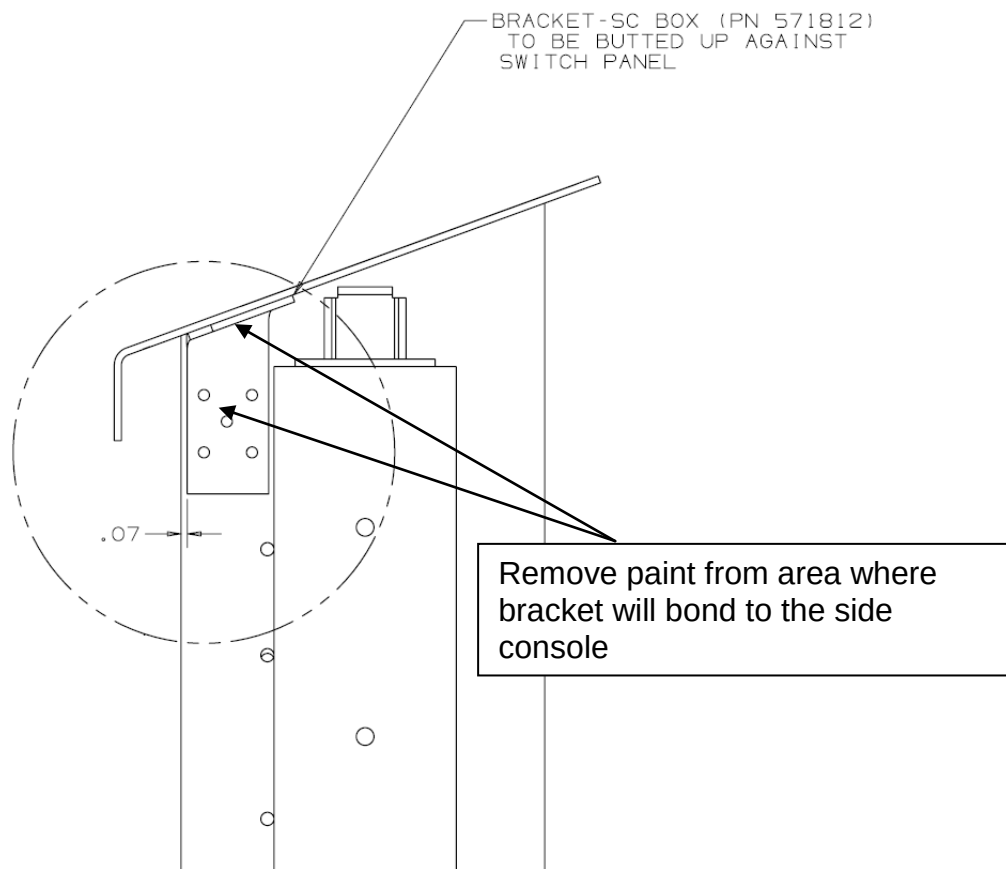


Figure 1: Front Bracket Location

- b. With the front bracket held in place, mark the location of the bracket on the side console box and on the underside of the side console top panel to indicate the area the bracket will be bonded to.

- c. Remove the bracket and with a sanding tool or equivalent tool, remove the paint from the inside of the marked out area on these surfaces. See Figure 1.
- d. Clean the two bonding surfaces with Isopropyl Alcohol (NF PN 134336) and allow alcohol to flash off until dry to the touch.
- e. Bond the bracket (NF PN 571812) in place. Follow the Plexus bonding instructions in Appendix A. Please ensure that there is plenty of Plexus squeeze out in order to provide a complete surface bond.

NOTE: Ensure the Plexus does not come into contact with the side console box sliders and the captive screw retainer.

- f. Using a drill and a #10 drill bit, drill four through holes in the front bracket in the four locations shown in Figure 2. Rivets will go through the side console top panel and through the side of the side console box.

NOTE: Please ensure wires are not damaged when drilling the through holes.

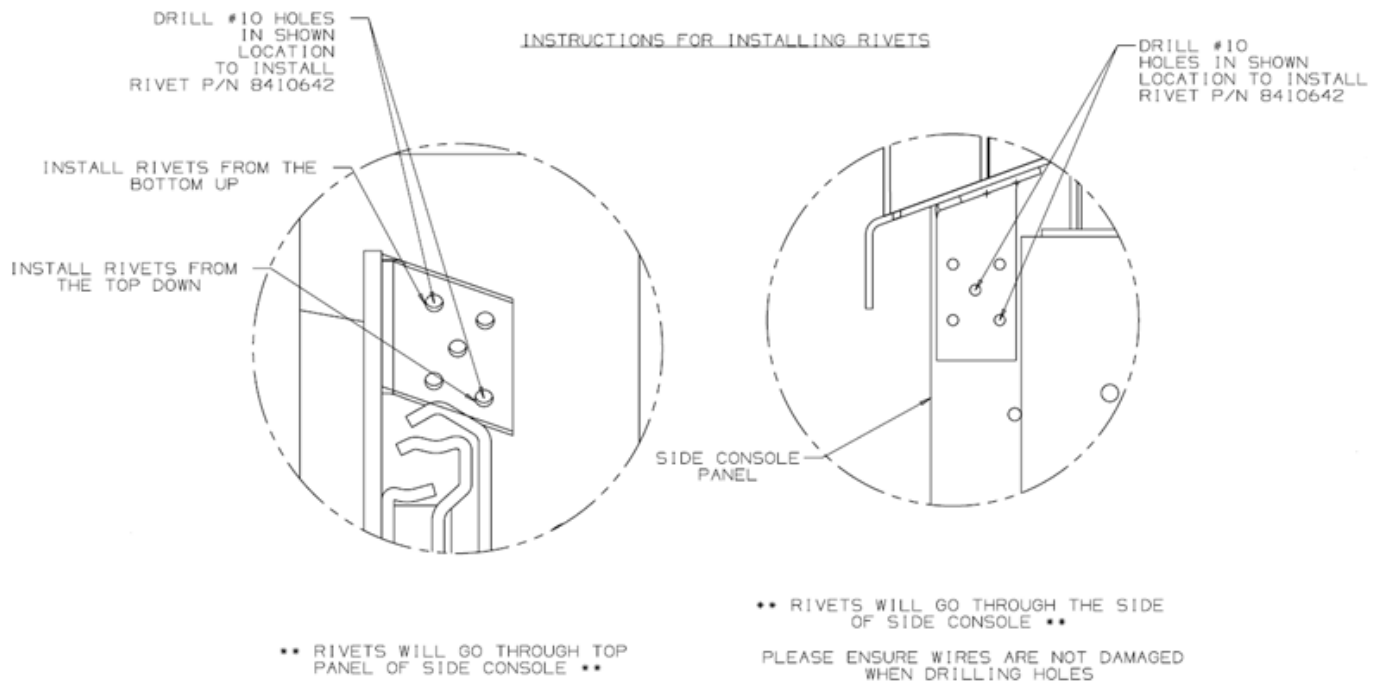


Figure 2: Rivet Hole Locations and Rivet Orientation Instructions

- g. Install two black rivets (NF PN 8410642) in the side console top panel in the correct orientation as shown in Figure 2.
- h. Install two black rivets (NF PN 8410642) in the side of the side console box in location shown in Figure 2.
- i. Apply a bead of black Sika (NF PN 055700) around the perimeter of the park brake riser box on the top of the side console panel and tool to a smooth finish. See Figure 3.

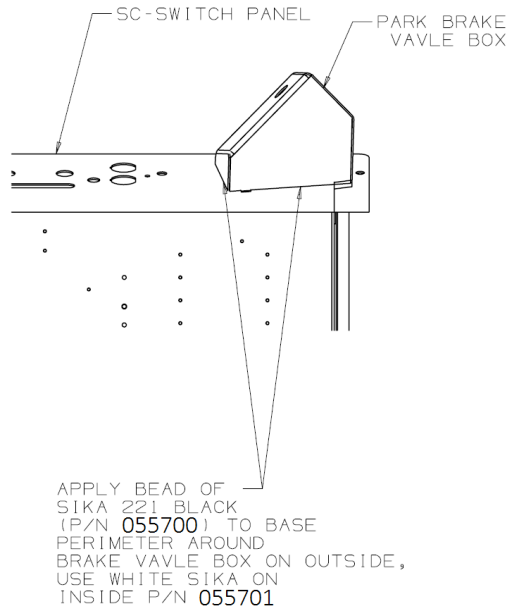


Figure 3: Apply Black Sika to Seal the Outside of the Brake Valve Box

- j. Apply a bead of white Sika (NF PN 055701) around the welded edges on the inside of the park brake valve riser box to seal any gaps and apply a bead of white Sika (NF PN 055701) on the underside of the park brake valve edges too. See Figure 4.

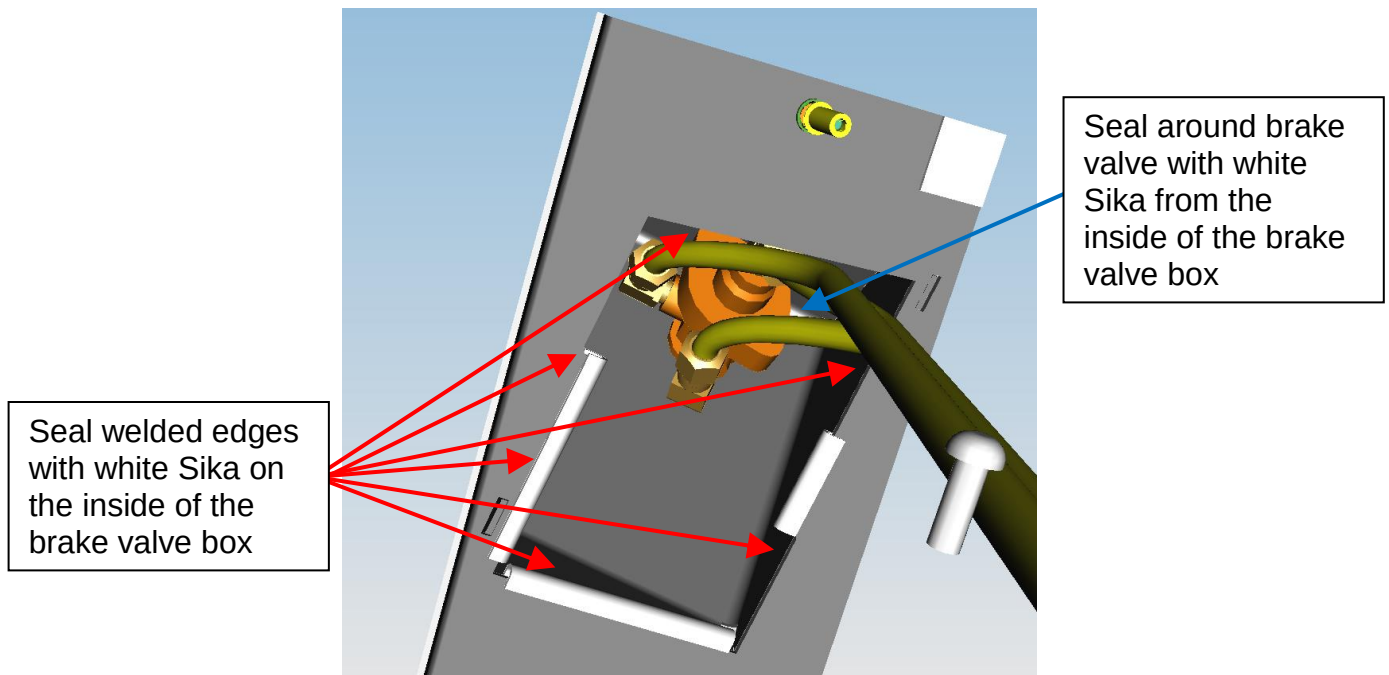


Figure 4: Seal the Brake Valve Box with White Sika

7. Inspect the rear end of the side console closest to the rear of the bus. If **there is not** a crack present, please follow these steps:

- a. Remove and discard the cup holder hardware. Retain the cup holder for re-installation.
 - b. Re-install the cup holder using the four new screws (NF PN 14S00010BK) and four new acorn nuts (NF PN 60N00000BK). Please install hardware as shown in Figure 8 below.
 - c. Skip to Step 11 of this ITS.
8. If **there is** a crack found while inspecting the rear end of the side console closest to the rear of the bus, please install the new rear bracket (NF PN 578711) on the rear end of the side console. Follow these steps:
- a. Remove and discard the cup holder hardware. Retain the cup holder for re-installation later.
 - b. Locate the rear bracket (NF PN 578711) and hold it in place in the location shown in Figure 5.

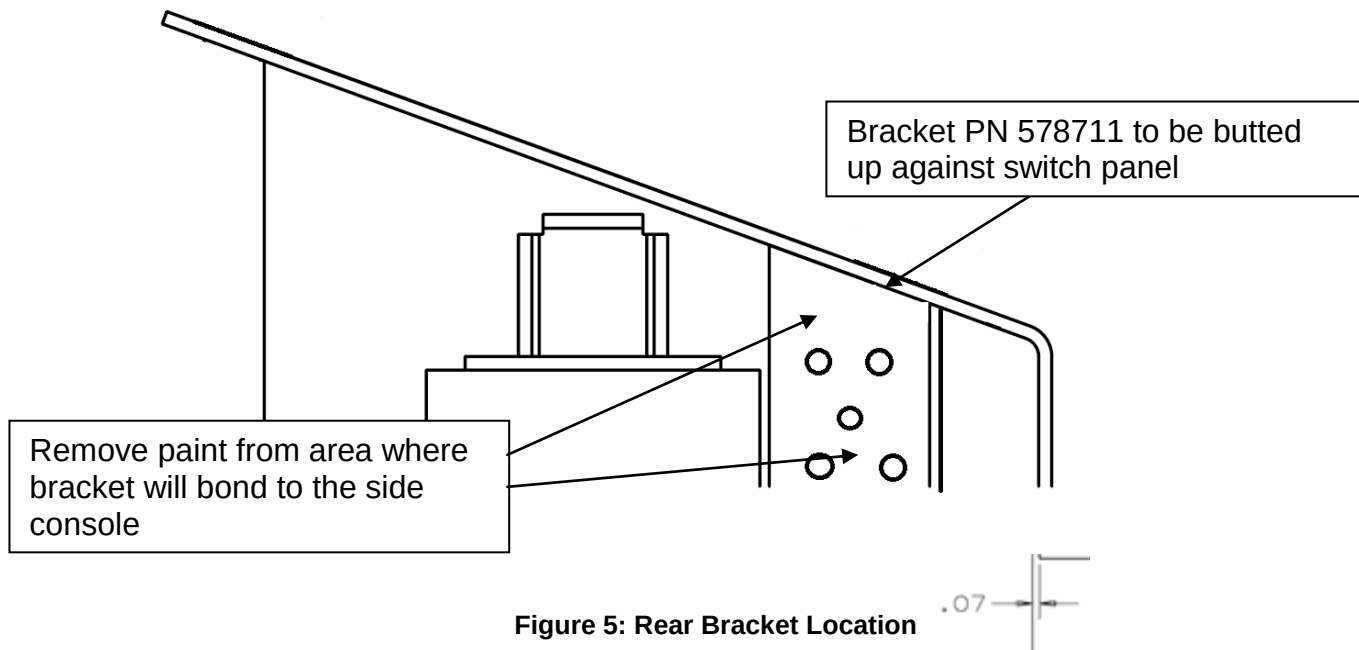


Figure 5: Rear Bracket Location

- c. With the rear bracket held in place, mark an outline around the bracket on the side console box and on the underside of the side console top panel to indicate the area the bracket will be bonded to.
- d. Remove the bracket and with a sanding tool or equivalent tool, remove the paint from the inside of the marked out area on these surfaces. See Figure 5.
- e. Clean the two bonding surfaces with Isopropyl Alcohol (NF PN 134336) and allow alcohol to flash off until dry to the touch.
- f. Bond the bracket (NF PN 578711) in place. Follow the Plexus bonding instructions in Appendix A. Please ensure that there is plenty of Plexus squeeze out in order to provide a complete surface bond.

NOTE: Ensure the Plexus does not come into contact with the side console box sliders and the captive screw retainer.

- g. Using a drill and a #10 drill bit, drill four through holes in the rear bracket in the four locations shown in Figure 6. Rivets will go through the side console top panel and through the side of the side console box.

NOTE: Please ensure wires are not damaged when drilling the through holes.

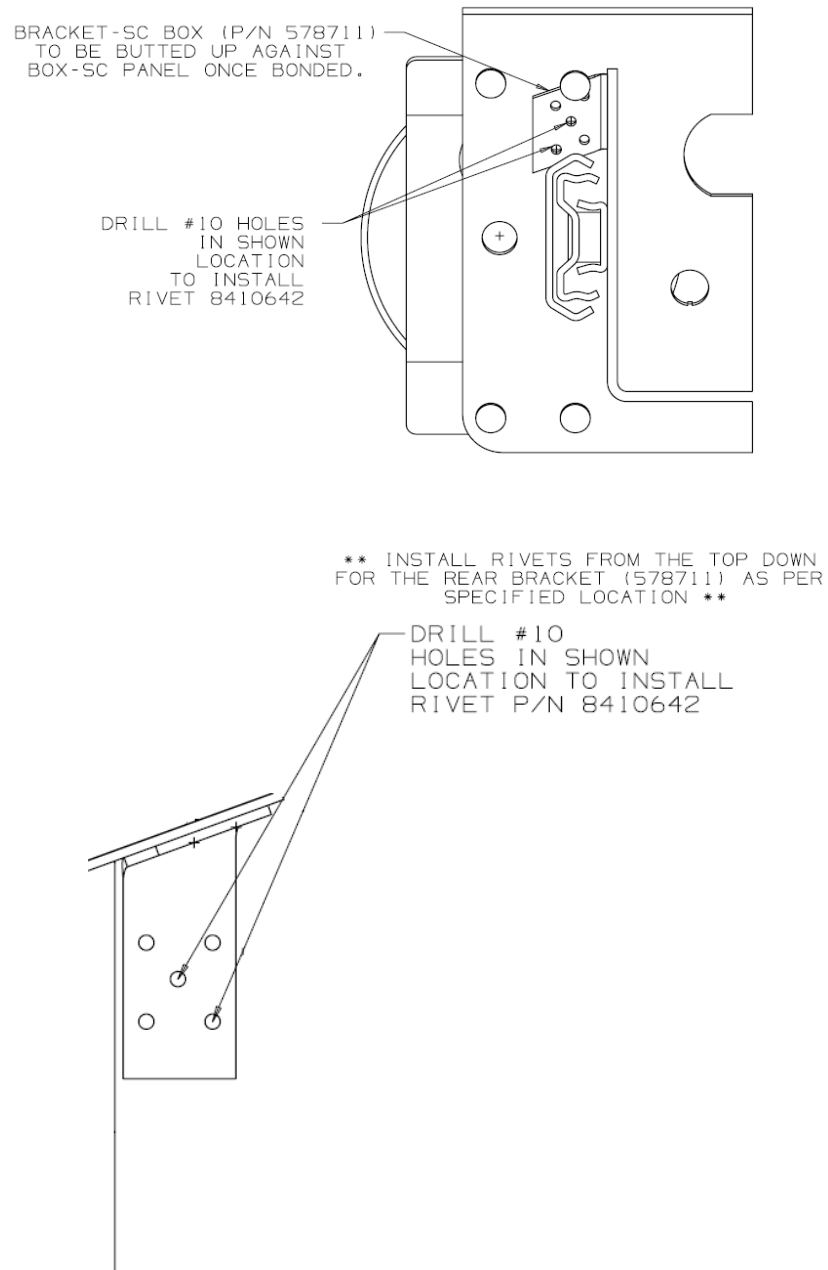


Figure 6: Rear Bracket Hole Locations

- h. Install two black rivets (NF PN 8410642) in the side console top panel in location shown in Figure 6.
- i. Install two black rivets (NF PN 8410642) in the side of the side console box in location shown in Figure 6.
9. Using the cup holder mounting hole as a template, drill a 0.201" diameter hole through the rear bracket that is covering the original cup holder mounting hole. See Figure 7.

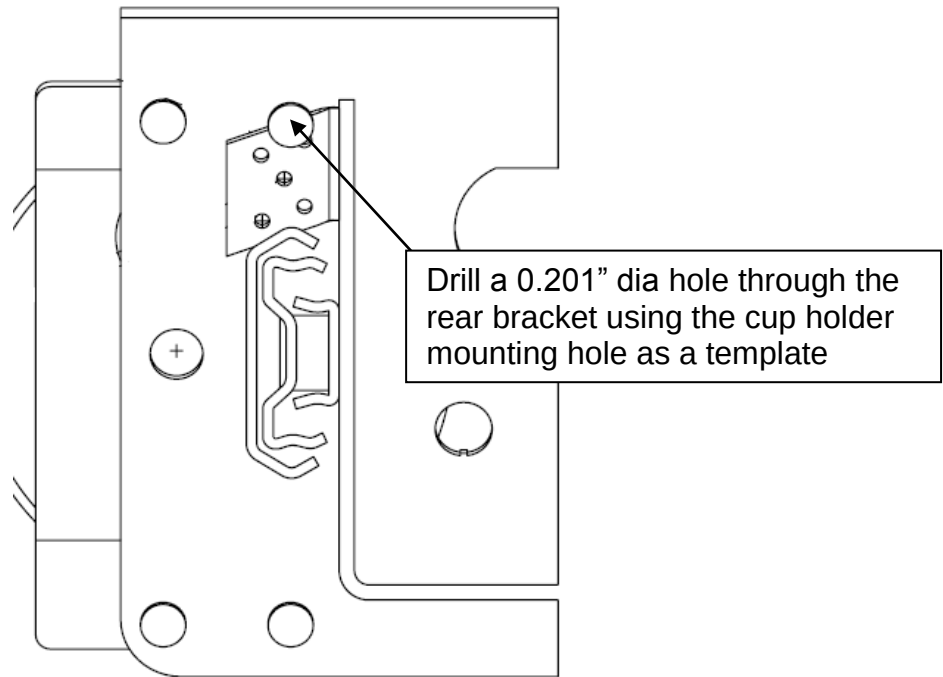


Figure 7: Cup Holder Mounting Hole Location

10. Re-install the cup holder using the four new screws (NF PN 14S00010BK) and four new acorn nuts (NF PN 60N00000BK). Please install hardware as shown in Figure 8.

REWORK TO INSTALL CUP HOLDER

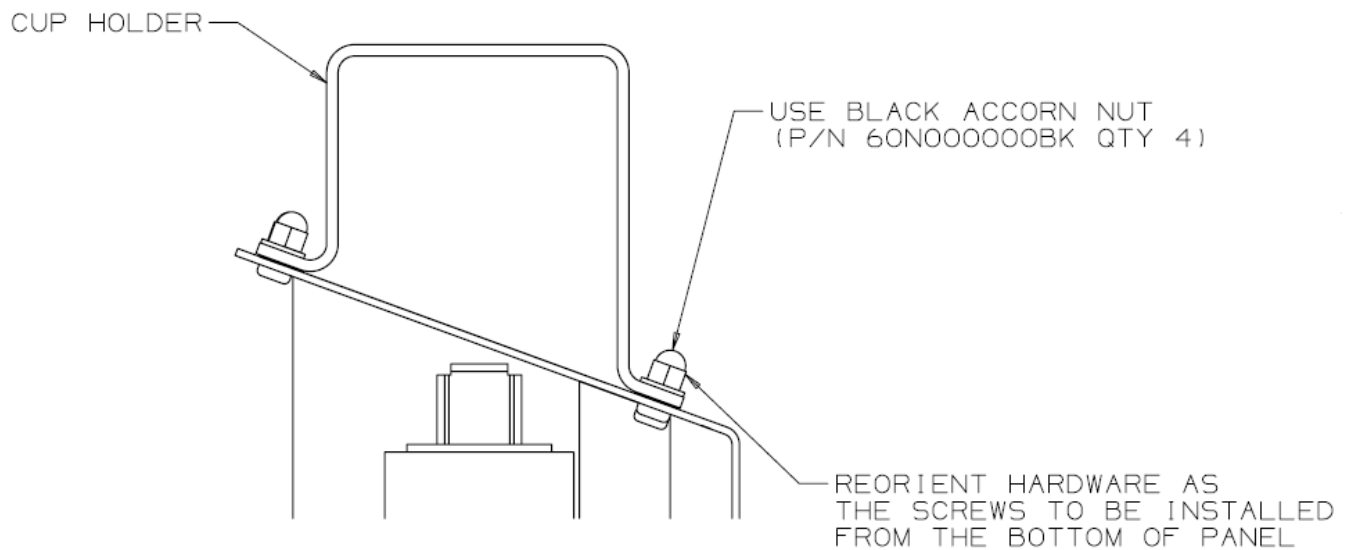


Figure 8: Re-install Cup Holder with New Hardware

11. Clean up all tools and debris and return the bus to service condition.
12. Turn the main battery disconnect switch to the "ON" position.

Appendix A

Plexus Bonding Procedure

1. CHECK THE EXPIRY DATE ON THE CONTAINER OF PRIMER AND ADHESIVE TO ENSURE THE PRODUCTS ARE NOT PAST SHELF LIFE.
2. APPLY THIN LAYER OF PLEXUS PC120 PRIMER (NF PN 067196) ALONG ALL SURFACES THAT ARE TO BE BONDED USING CLEAN CLOTH.
3. WHILE THE PRIMER IS STILL WET, WIPE DOWN ALL PRIMED SURFACES WITH CLEAN LINT FREE DRY CLOTH TO REMOVE ANY SURFACE CONTAMINANTS LIFTED OFF BY PRIMER PC120, AND LEAVE ONLY A THIN, QUICK DRYING FILM.
4. WHEN THE PRIMER PC120 IS COMPLETELY DRIED, APPLY PLEXUS MA1020 ADHESIVE (NF PN 526515) TO INDICATED SURFACES.
5. DISPENSE ADHESIVE LENGTH OF MIX NOZZLE (NF PN 6351374) WHEN USING A NEW NOZZLE BEFORE APPLYING TO PRIMED SURFACE.
6. PLACE BONDING SURFACES TOGETHER, PRESS THE SURFACES FIRMLY TOGETHER AND APPLY CLAMPS OR WEIGHTS.
7. REMOVE ANY EXCESS SQUEEZED-OUT ADHESIVE AND ALLOW TO DRY FOR 20 MINUTES BEFORE REMOVING CLAMPS.



LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Add two bonded and riveted brackets the front and rear of the side console.	1	1.5	1.5

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6449248	KIT- SIDE CONSOLE BRACKET INSTALLATION KIT	1	EA	
2	067196	PRIMER-PLEXUS PC120	0.01	QT	
3	526515	ADHESIVE-PLEXUS MA1020	0.1	EA	
4	134336	ISOPROPYL-ALCOHOL	0.01	EA	
5	055701	(OBS) SIKA 221 WHITE	0.1	EA	
6	055700	ADHESIVE SIKA 221 BLACK	0.1	EA	

PARTS KIT – P/N 6449248

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6361396	APPLICATOR TIPS	1	EA	
2	571812	BRACKET-SC BOX	1	EA	
3	8410642	RIVET BLIND BLACK PAINTED 3/16" X .187/.437	8	EA	
4	578711	BRACKET-SC BOX	1	EA	
5	14S00010BK	SCREW-PH CR BLK #10 24	4	EA	
6	60N00000BK	NUT-CRN #10UNC BLK	4	EA	

SPECIAL TOOLS REQUIRED

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