



INSTRUCTION TO SERVICE

ITS: 6348

SECTION:	405-005 Artic Joint
WRITTEN BY:	Dwayne Peters
SUBJECT:	Hubner bellow interference

ITS6348

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PROCEDURE:

1. Turn the main battery disconnect switch to the “OFF” position.
2. **Inspect.** Remove the forward false ceiling bellow and inspect the gap between the top of the fabric to the bottom of the spider clamp bolt protruding outside of the nut face on the rear false ceiling bellow. If this gap is $\frac{1}{2}$ " or greater reinstall the false ceiling bellow. No further action is required.
3. If the gap is less than $\frac{1}{2}$ ", proceed with the following steps;
1. Remove the false ceiling bellows as followed;
 - a. Remove the rubber cover lock from the channel that attaches the false ceiling bellow to the center hoop frame and to the front and rear structure. Figure 1.

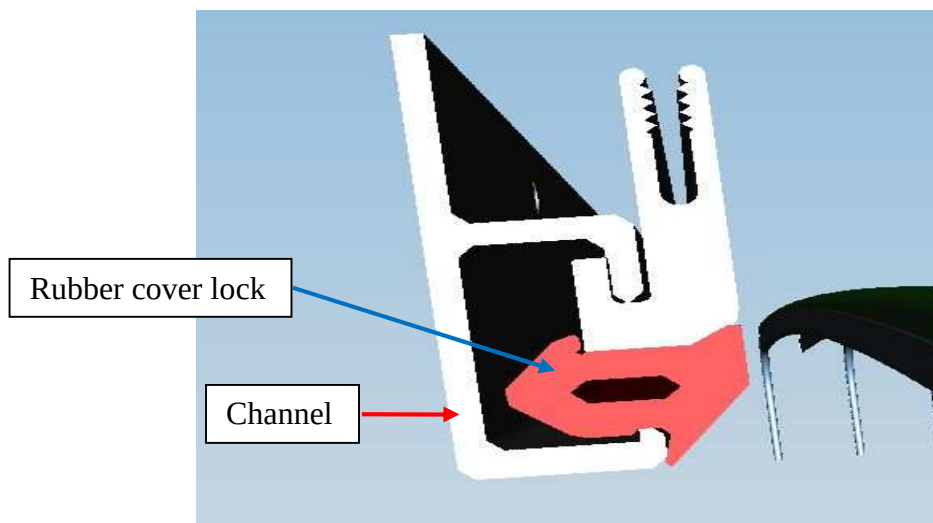


Figure 1: Rubber cover lock.

- b. Remove and discard the screws from the end caps that attach the legs of the false ceiling bellow to the outer bellows.
 - c. Remove the false ceiling bellow from the vehicle.
2. Trim 1.00" off all the end legs as shown in figure 2. Remove burrs.

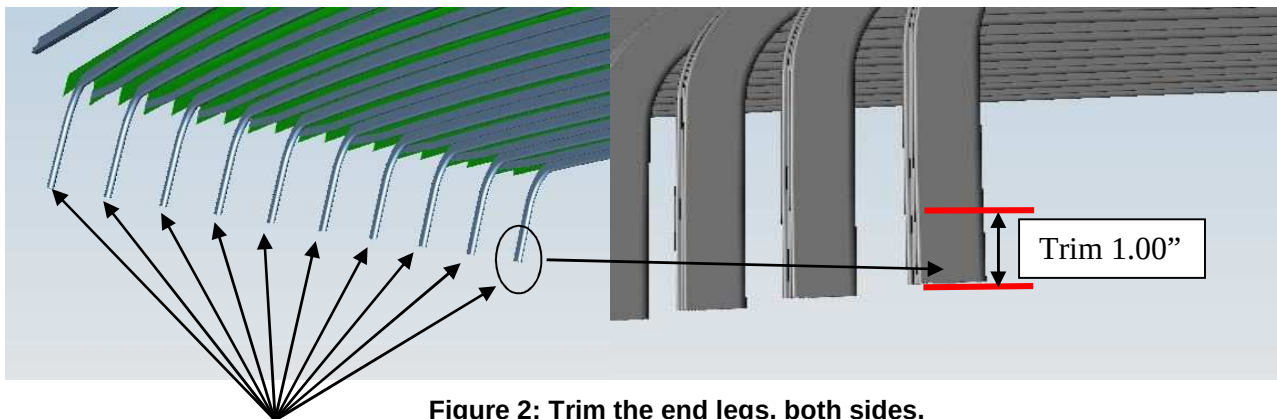


Figure 2: Trim the end legs, both sides.

3. Trim the 5 studs on the spider clamp to the dimension shown in figure 3. Ensure there's two threads remaining outside of the lock nut face. Remove any sharp burrs.

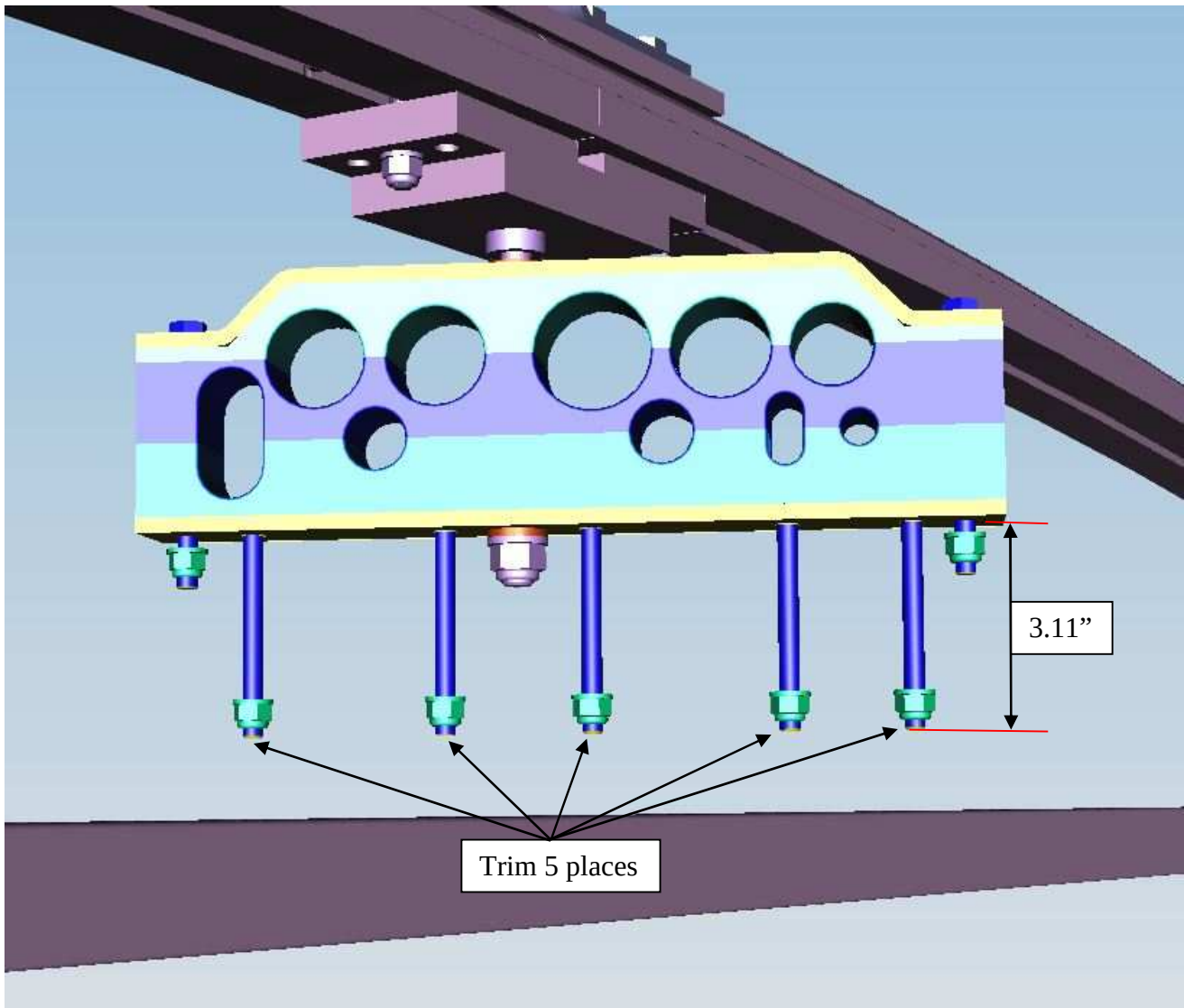


Figure 3: Trim the 5 studs

4. If the bus is equipped with stanchions in the center of the artic joint remove the stanchions.

5. Measure the space between the hoop profile and false ceiling strut in the center as shown in figure 5. Lower the false ceiling strut to 10.50" by loosening the 8 retaining screws ensuring the strut is level when complete by measuring to the floor in two places while maintaining the 10.50" dimension. Figure 4 and 5. Torque the screws to 177 in-lbs.

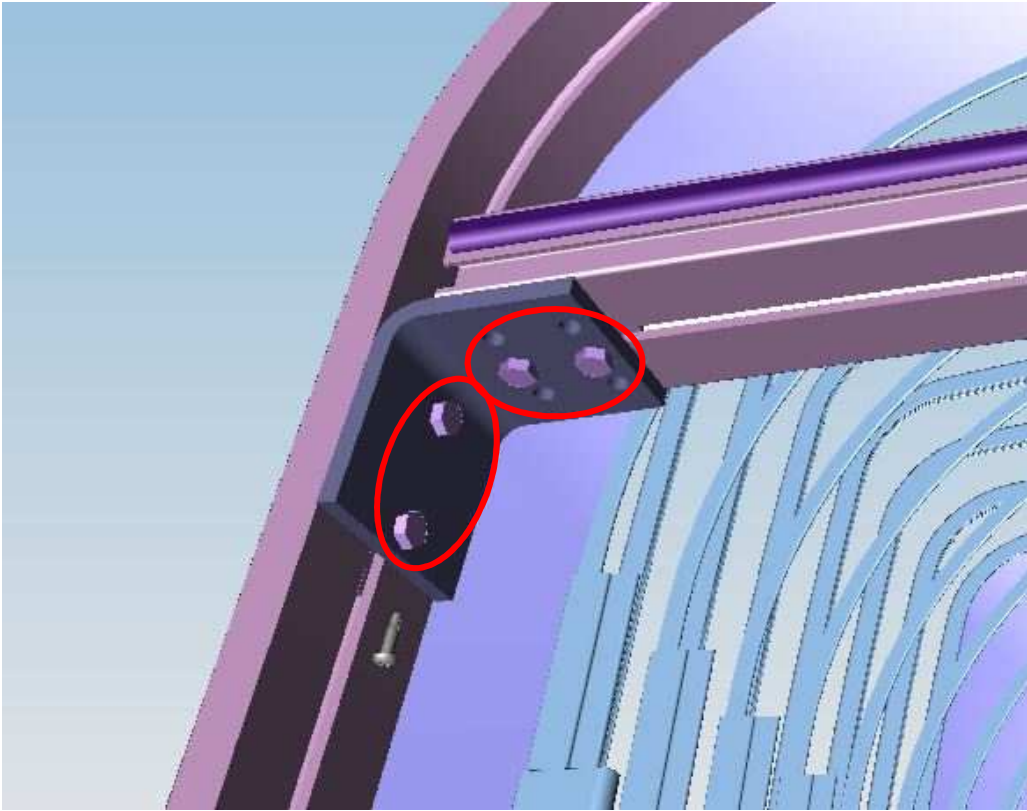


Figure 4: Loosen the screws, both sides

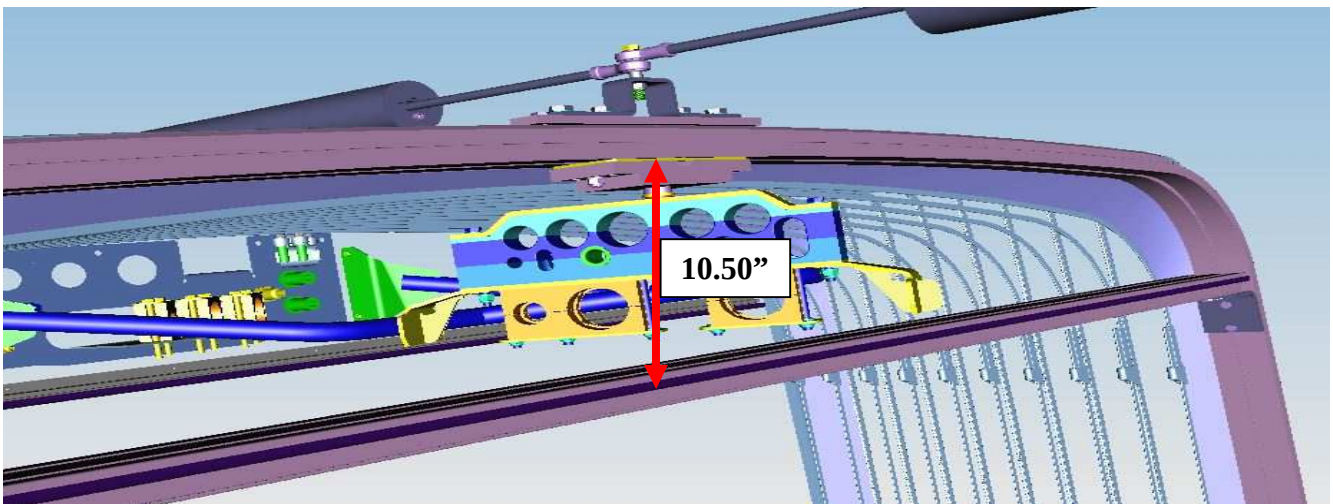


Figure 5: Lower the false ceiling strut to 10.50"

6. Check to ensure that you have an equal gap on each side of the false ceiling strut after adjustment. Figure 6.

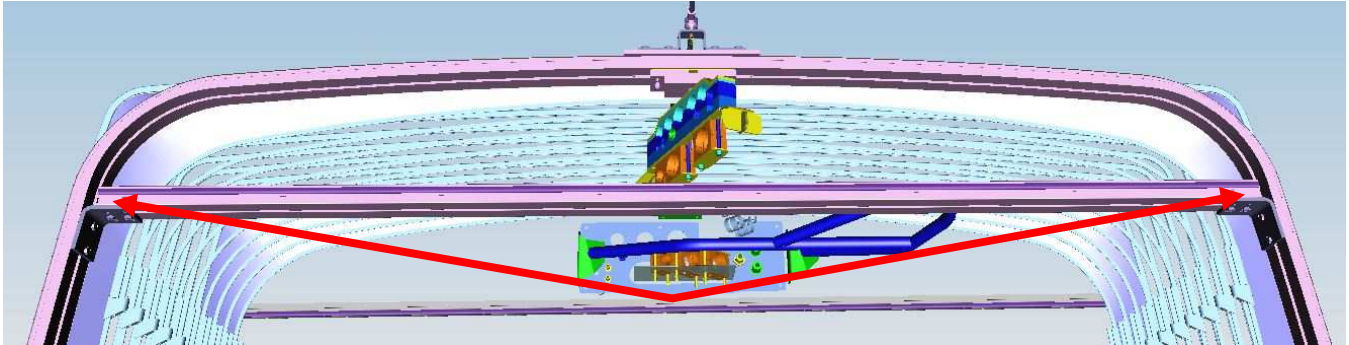


Figure 6: Check to ensure gaps are equal.

7. Trim the bottom of the stanchion (if so equipped) so when installed there's a $\frac{1}{4}$ " to $\frac{1}{2}$ " gap from the bottom of the retaining cup as shown in figure 7. Remove sharp burrs.

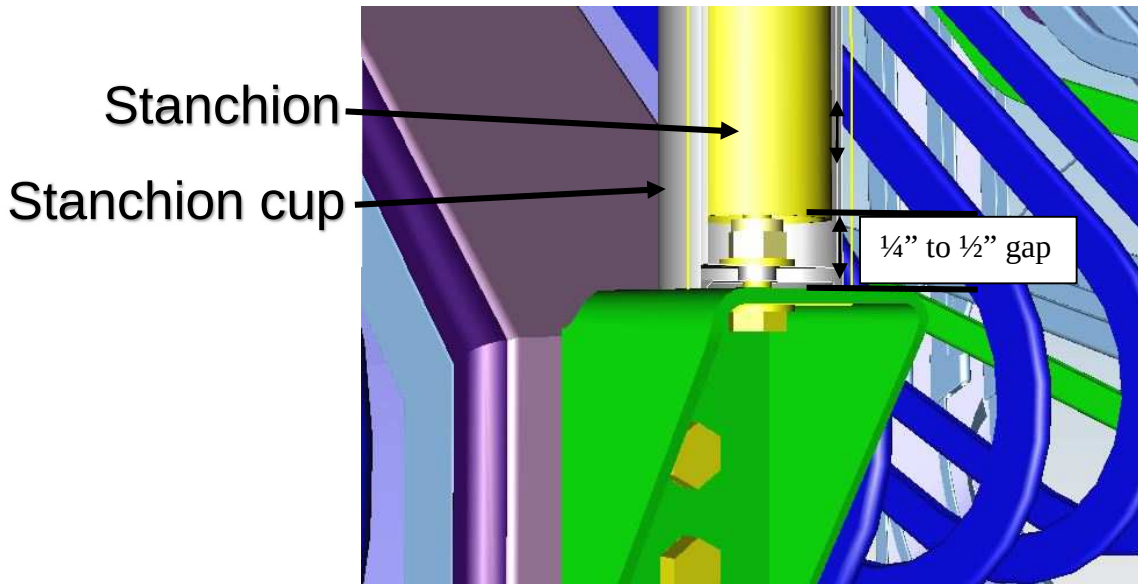


Figure 7: Cutaway of stanchion and stanchion retaining cup

8. Reinstall the Stanchions, add Loctite 243 to the threads and torque the upper screws to 177 in-lbs.
 9. Reinstall the false ceiling bellows using new screws NF # 489001 (40 pcs) and install the rubber cover lock.
 10. Turn the main battery disconnect switch to the "ON" position.

LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Remove and rework false ceiling and spider clamp studs.	2	1.5	3.0

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	489001	SCREW-PHILLIPS HEAD BELLOWS LOCK	40	EA	