



INSTRUCTION TO SERVICE

ITS: 6234

SECTION:	420 Body Appearance Exterior
WRITTEN BY:	T Stutsky
SUBJECT:	Inspect front mask support bracket bond and repair if necessary

ITS 6234

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PROCEDURE:

1. Turn the main battery disconnect switch to the “OFF” position.
2. Using the inspection sheet in Appendix A, inspect the front mask support bracket to see if it is bonded to the front mask.
3. If the front mask support bracket is bonded in place there is no need to continue to step 4.
4. If the front mask support bracket is not bonded to the front mask do the following:
 - a. Open the destination sign door and locate the destination sign closeout panel brackets and remove streetside and curbside rivets. See Figure 1 and 2.



Figure 1: SS closeout bracket rivets

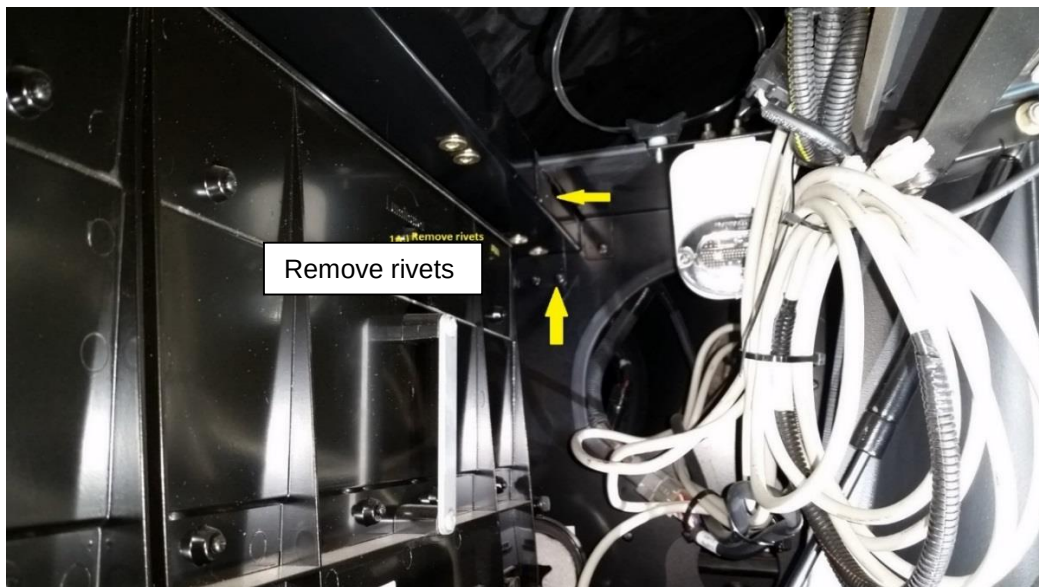


Figure 2: CS closeout bracket rivets

- b. Lay the destination sign close out panel bracket on the bottom of the destination sign closeout so it is out of the way. See Figure 3.



Figure 3: Move the bracket out of the way

- c. Unplug the marker light harnesses and remove the pass-through grommets. See Figure 4.

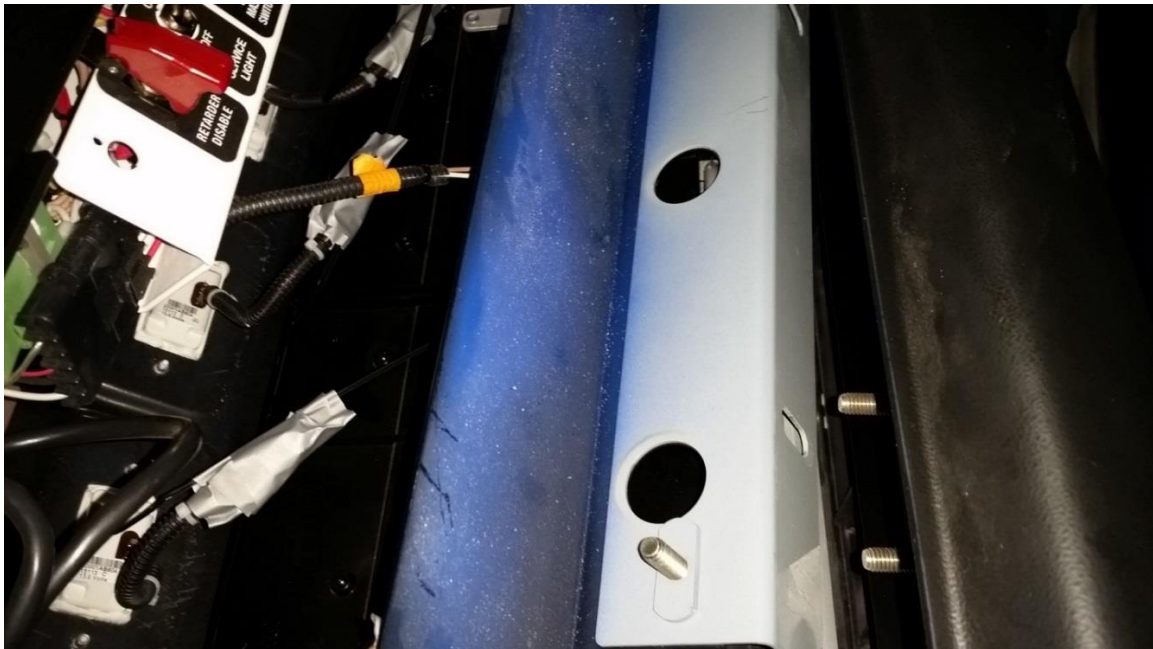


Figure 4: Unplug the marker light harnesses

- d. Tape cable ties or something equivalent to the marker light connectors to help make it easier to pull them through the pass-through holes when assembling later. See Figure 5.



Figure 5: Cable ties taped to the connectors

- e. Remove and retain the bolts from the front mask support bracket and remove the bracket. See Figure 6.



Figure 6: Remove the front mask support bracket

- f. Use a lint free cloth dampened with Sika Aktivator/Cleaner (NF PN 055702) and apply it on the bonding surfaces of the bracket and the front mask. Let it flash off for 10-15 minutes or until completely dry. See Figure 7 and 8.



Figure 7: Apply Sika Aktivator/Cleaner on the bonding surface of the bracket



Figure 8: Apply Sika Aktivator/Cleaner on the bonding surface of the mask

- g. Using a brush or equivalent tool, apply Sika 206 primer (NF PN 6358899) to the bonding surface of the bracket and let it flash off for 10-15 minutes or until completely dry. See Figure 9.



Figure 9: Apply Sika primer to the bracket

- h. Apply a continuous bead of Sika 252 adhesive (NF PN 055698) to the bonding surface of the bracket as shown in Figure 10 and 11.



Figure 10: Sika adhesive application

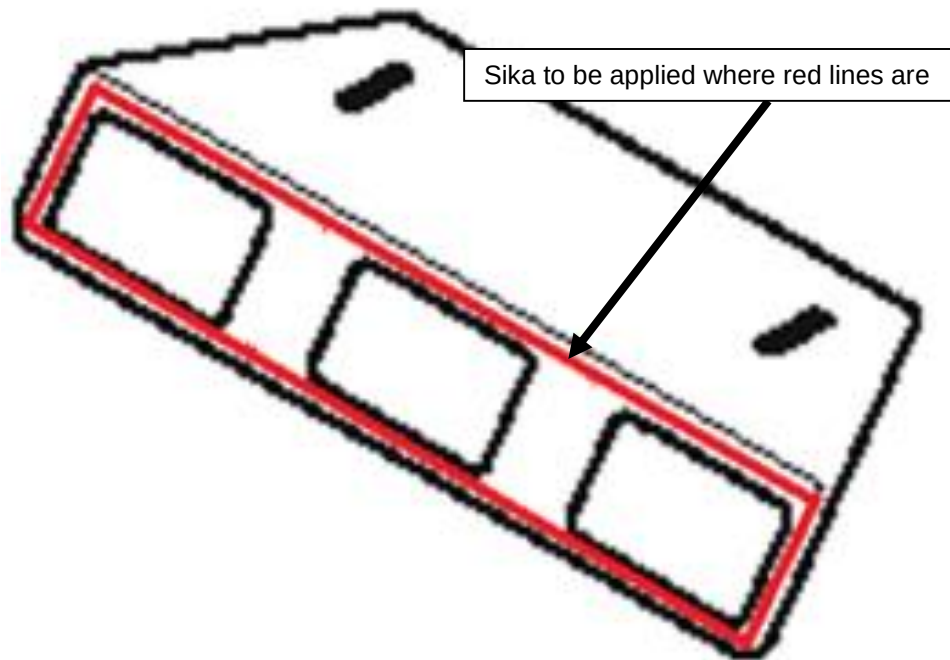


Figure 11: Sika adhesive application

- i. Install the front mask support bracket and pull marker light wires through it. See Figure 12.

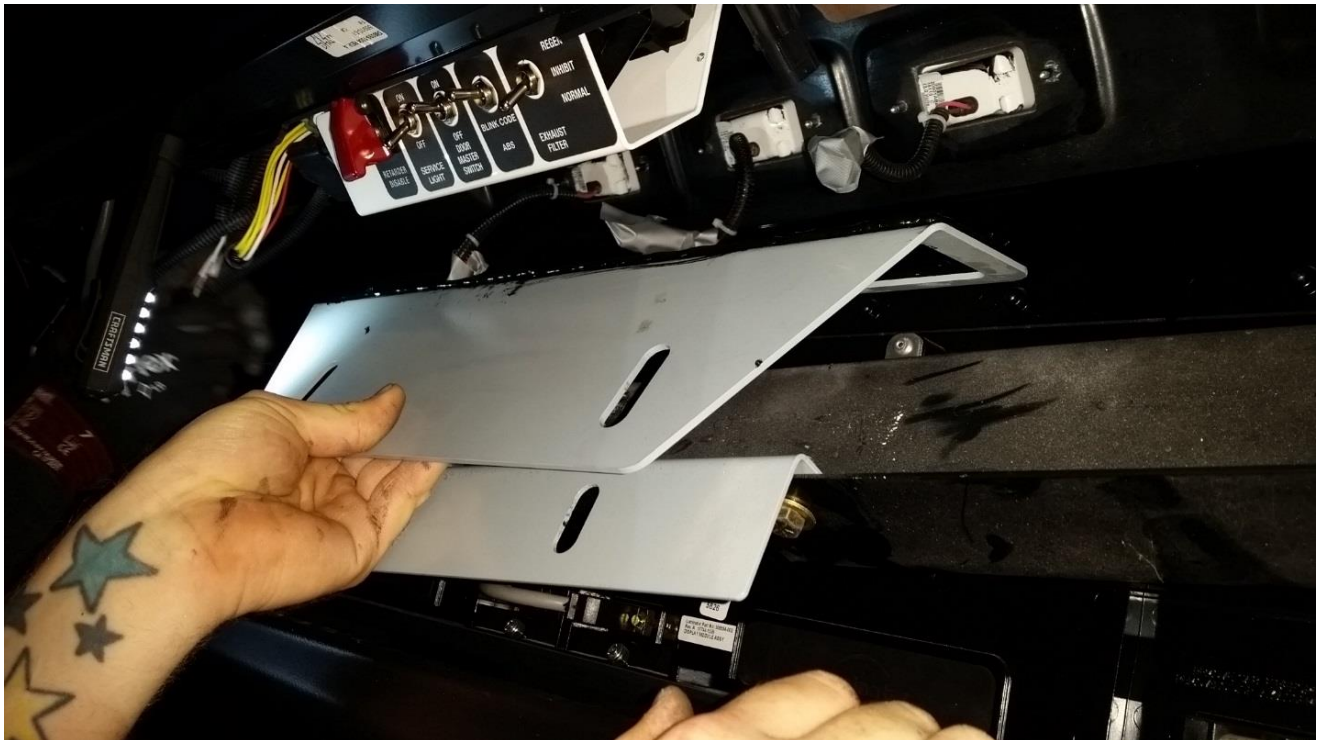


Figure 12: Re-install front mask support bracket

- j. Push the bracket up against front mask making sure to line up the bracket mounting holes and hold the bracket in place with the existing hardware. Allow the Sika adhesive to adhere to the front mask for 40 mins. See Figure 13 and 14.



Figure 13: Front mask support bracket placement

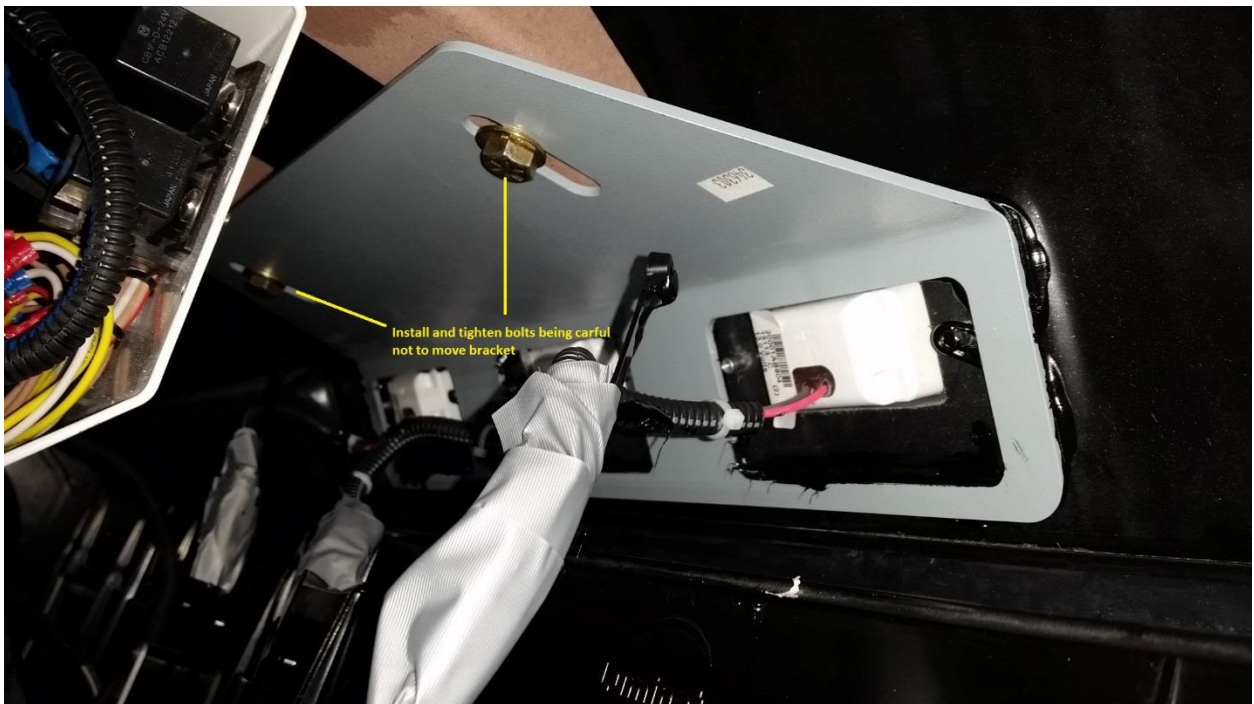


Figure 14: Fasten the front mask support bracket in place to allow adhesive to bond

- k. Once the Sika adhesive has been allowed to bond for 40 mins, remove and retain the hardware from the front mask support bracket.
- l. While installing the destination sign closeout bracket, pull the marker light wires through the destination sign closeout bracket and hold the bracket in place. See Figure 15.



Figure 15: Place the destination sign closeout bracket in place

- m. Fasten the destination sign closeout bracket back in place with six 3/16" rivets (NF PN 8410642). See figure 16 and 17.

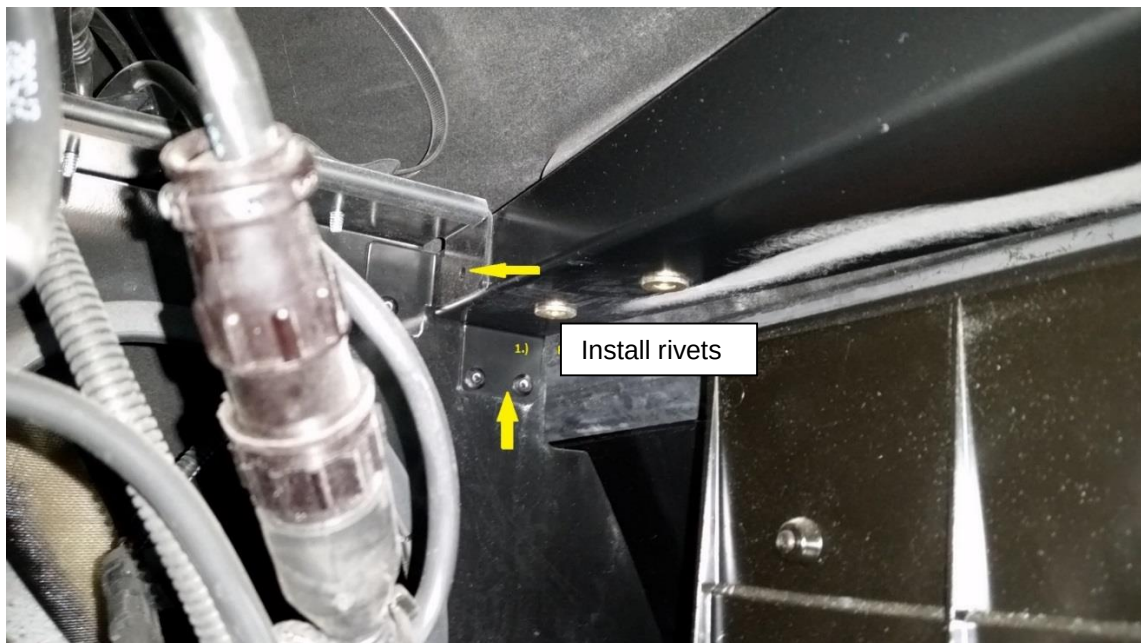


Figure 16: Install SS closeout bracket rivets

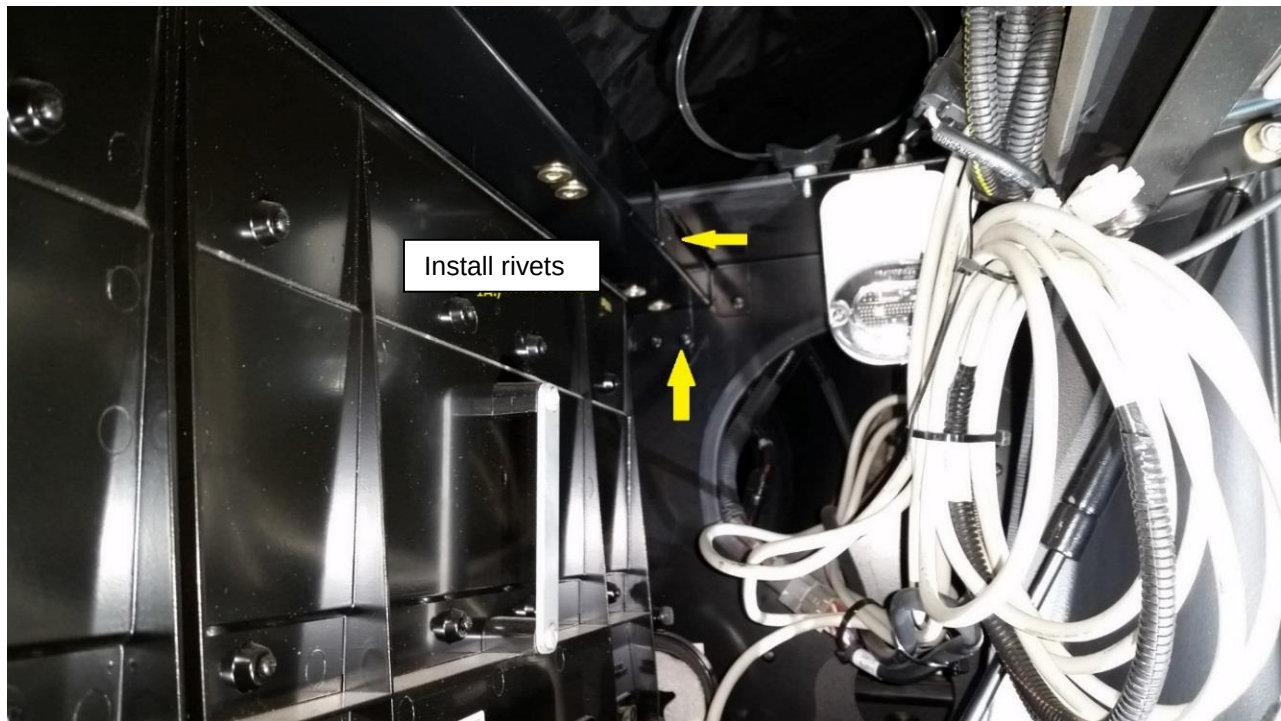


Figure 17: Install CS closeout bracket rivets

- n. Apply Loctite 243 (NF PN 081034) to front mask support bracket bolts. See Figure 18.



Figure 18: Apply Loctite to the bracket bolts

- o. Fasten the front mask support bracket and destination sign closeout bracket back in place to the structure tubes using the existing hardware that has Loctite 243 applied to the bolts. See Figure 19.

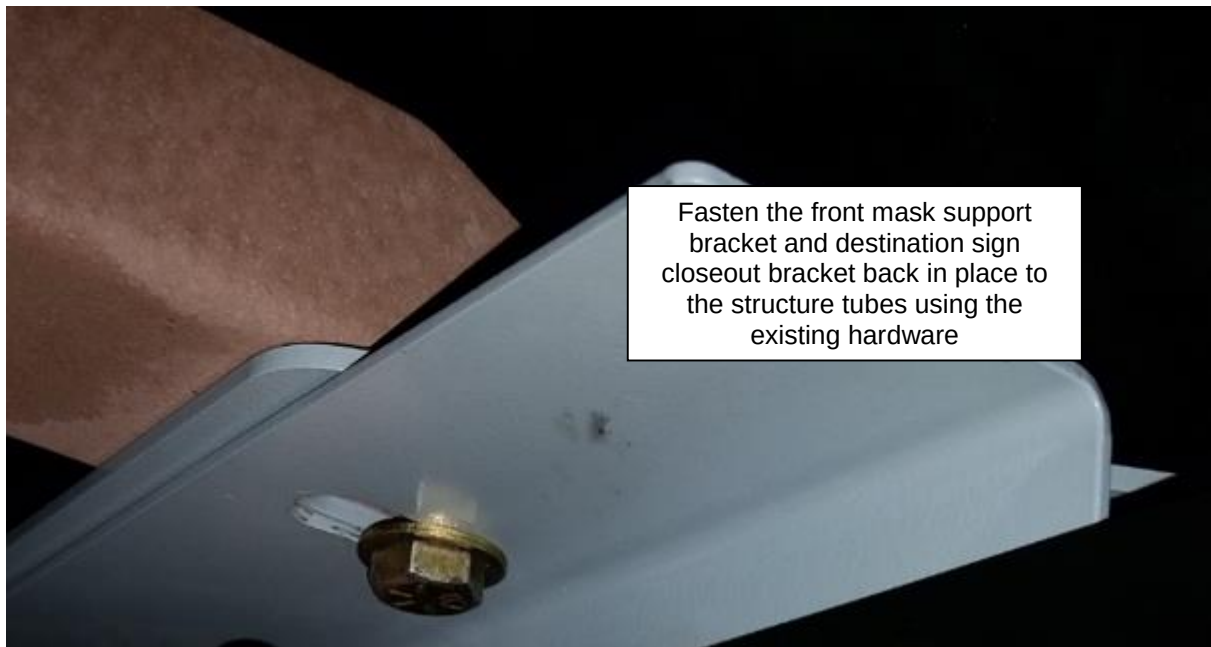


Figure 19: Fasten the brackets to the structure tubes

- p. Re-install the grommets and re-connect the marker lights. See Figure 20.



Figure 20: Re-connect the marker lights

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

LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Inspect the front mask support bracket bonding	1	0.25	0.25
2	Re-bond the front mask support bracket	2	1.25	2.5

PARTS REQUIRED

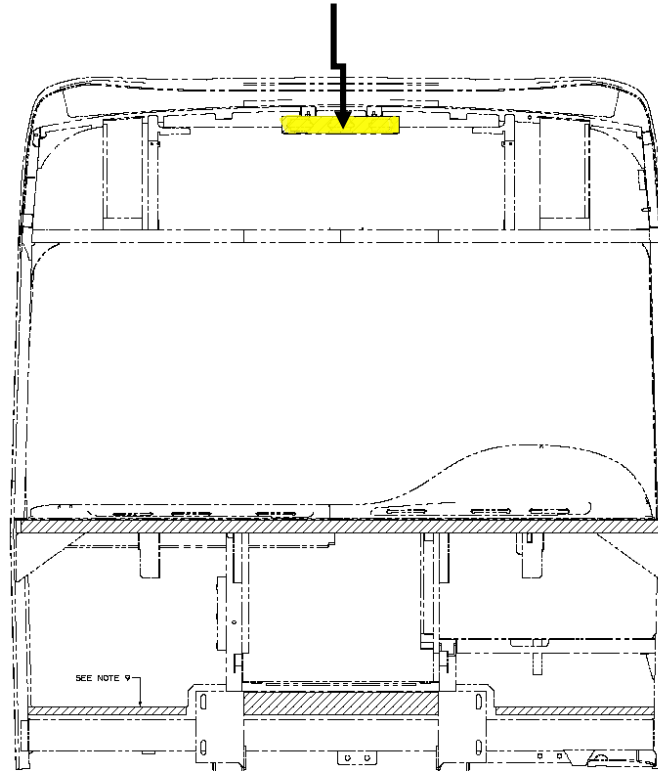
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	055702	AKTIVATOR-SIKA 205	0.01	EA	
2	6358899	SIKA 206 PRIMER (250 ML)	0.01	EA	
3	055698	ADHESIVE 252 BLK	0.5	EA	
4	081034	LOCTITE-243 MEDIUM 10ML	0.01	EA	Source Locally
5	8410642	RIVET BLIND BLACK PAINTED 3/16" X .187/.437	6	EA	

Appendix A

Front Mask Inspection

Date _____ SR# _____ Bus# _____ Inspector Name _____

Front Mask Support Bracket



1. From inside the destination sign access door, reach up to where the front mask and front mask support bracket bonded joint is (highlighted in the picture above). Push out on the front mask next to the bonded area. Does the front mask and front mask support bracket separate?

Please circle - YES NO

Is there Sika adhesive present?

Please circle - YES NO

1. Inspect to see that the front mask support bracket hardware is installed and is tight.

Is the hardware installed?

Please circle - YES NO

If yes, is the hardware tight?

Please circle - YES NO