

REFERENCE:	Nova Bus Manuals
SECTION:	01: Structure
RS N°:	MQR 7621-1030
EFFECTIVE IN PROD.:	L961 (2016MA)

APPLICATION DEADLINE: 2017JN26
CLAIM REFERENCE NUMBER: WB-3667

SUBJECT:	Right wall structure with 1:6 ramp
JUSTIFICATION:	Vertical beam might crack above front door second post capping.

LEVEL	DESCRIPTION	DIRECT CHARGES		TIME
		LABOUR	MATERIAL	
1	Stop drill the crack and weld stiffening plates.	Nova Bus	Nova Bus	8h
2	–	–	–	–

MATERIAL

QTY	PART N°	REV.	DESCRIPTION	REPLACES PART N°
LEVEL 1				
1	N71118	–	PLATE FRONT DOOR (90°)	–
1	N71119	–	PLATE FRONT DOOR	–
1	N71120	–	BRACKETS BETWEEN TUBES	–
2	N30702	–	POP RIVET 3/16 X 0.440 X 0.125	–
LEVEL 2				
–	–	–	–	–

Materials will be available within 14 days. To order, please contact Prevost Parts by phone at 1-800-771-6682, by fax at 1-888-668-2555 or by email at prevostparts.commandes@volvo.com. Specify document number, quantity of parts required and shipping address.

DISPOSAL OF PARTS

REMOVED PARTS ARE:	DISCARDED *	RETAINED	* Dispose of the unused parts and the defective parts in accordance with local environmental standards in effect.
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REVISION HISTORY

REV.	DATE	CHANGE DESCRIPTION	WRITTEN BY
NR	2016MA12	Initial release	André Pelletier

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
New York City Transit - New York	L608	8000	8014	L82U6B4000047	L82U0B4000061	15
New York City Transit - New York	L620	8015	8074	L82U2B4000062	L82U7B4000123	60
New York City Transit - New York	L621	8075	8089	L82U9B4000124	L82U9B4000138	15

PROCEDURE

**WARNING**

Follow your internal safety procedures. Before performing any welding operation on the vehicle, sensitive electronic components must be disconnected. Ask a qualified electrician to place the main battery cut-off switch in the off position and disconnect the proper components per maintenance manual section 01: Structure.

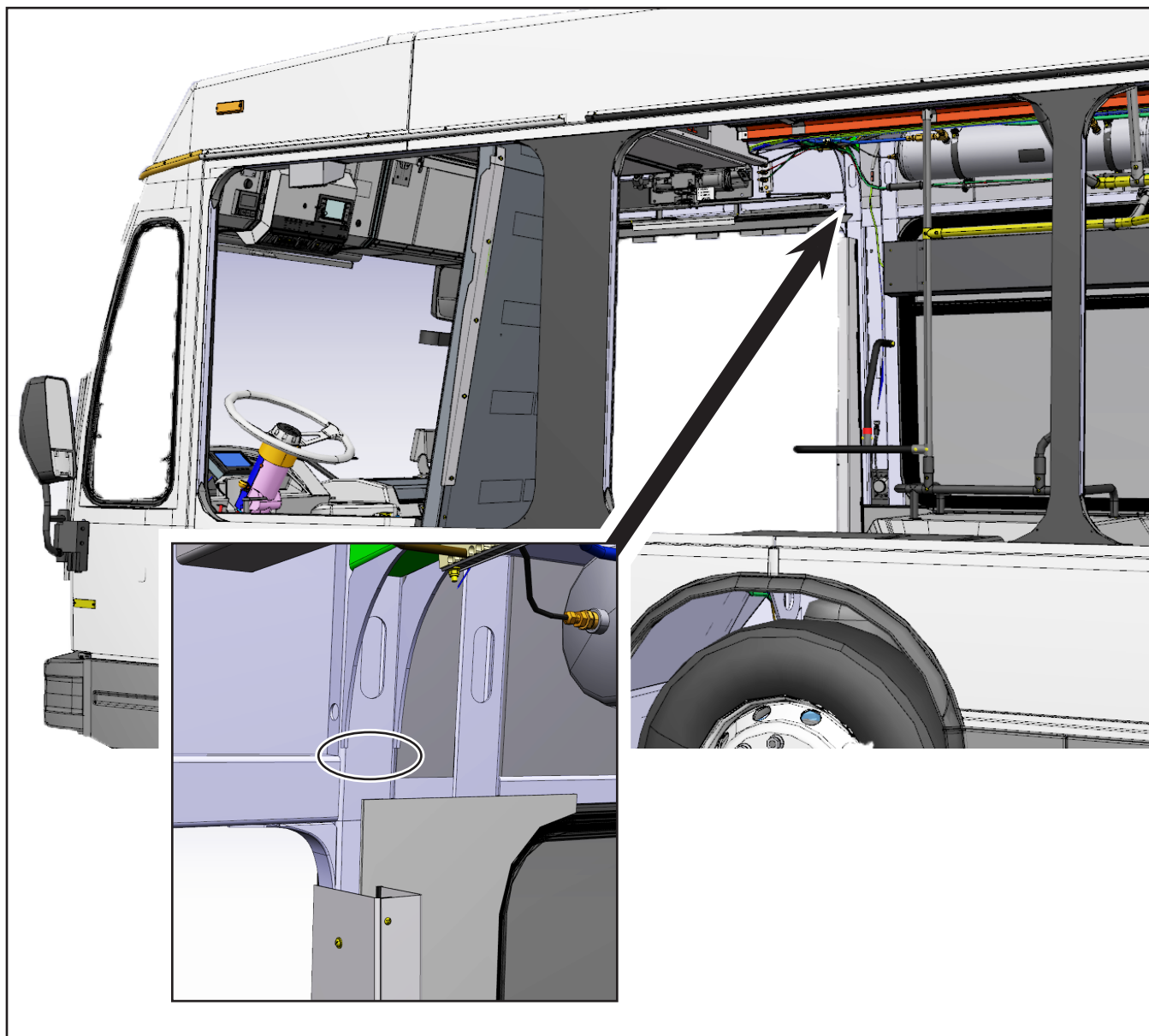


Figure 1 - Possible Crack Location

**NOTE**

Retain hardware removed during the procedure for later reinstallation.

- 1.1. Remove the access panel above the first curb side window. See Figure 2.

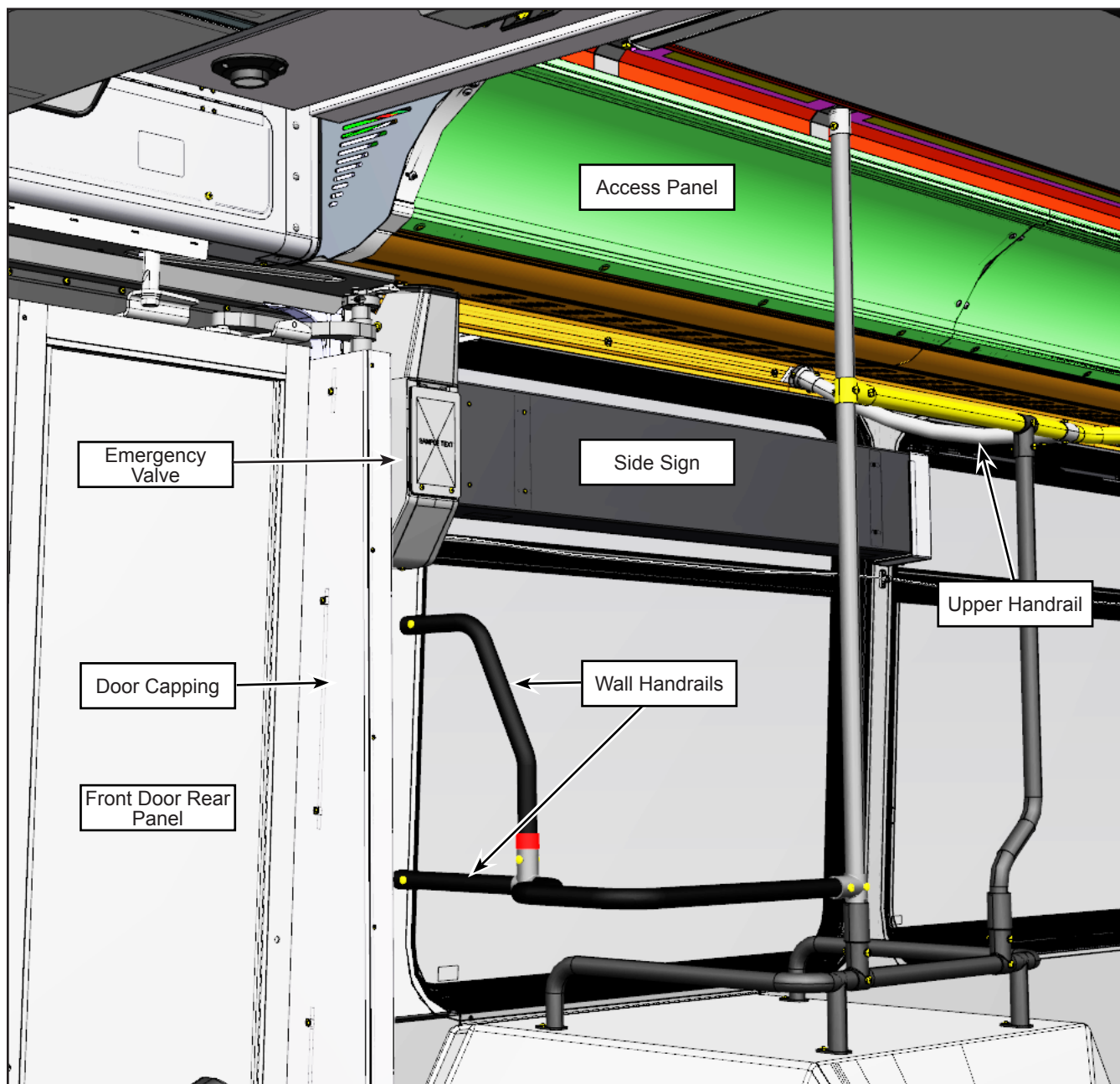


Figure 2 - Parts Identification

- 1.2. Remove the front door, rear panel only.
- 1.3. Remove the upper handrail and wallhand rails.
- 1.4. Mark the height position of the door second capping for later reinstallation. Remove door capping (2 pieces).
- 1.5. Remove the door operator connecting rod on top of the door shaft.
- 1.6. To remove the door shaft, remove the three bolts under the operator support plate. See Figure 3.

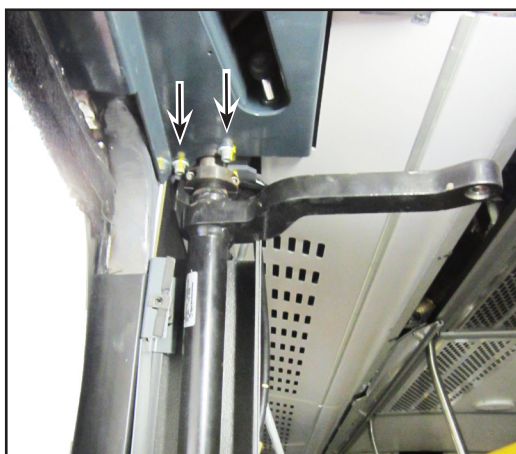


Figure 3 - Remove Door Shaft

- 1.7. Remove the emergency valve capping.
- 1.8. Disconnect the two chime cord wires and remove chime cord assembly. See Figure 4.



Figure 4 - Remove Chime Cord Assembly

- 1.9. Drain the air system, then disconnect the two pneumatic hoses and the connector at the emergency valve.
- 1.10. Remove the emergency valve assembly.
- 1.11. Disconnect and remove the side sign with the help of an assistant.
- 1.12. Remove the window frame screws from the upper horizontal and the front vertical frame portions in order to facilitate the baselight and melamine removal.
- 1.13. To remove the first baselight, start by drilling out the two rivets at the joint of the second baselight. See Figure 5.

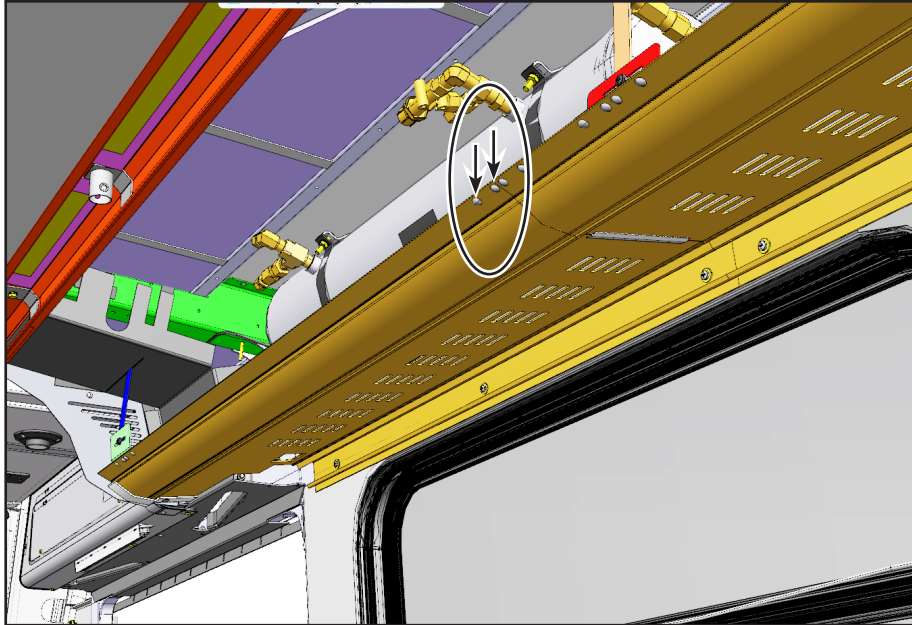


Figure 5 - Drill Out the Two Rivets

- 1.14. Disconnect the harness and remove the baselight.
- 1.15. Remove the melamine using a utility knife to cut the double face tape between the wall and the melamine. See Figure 6.

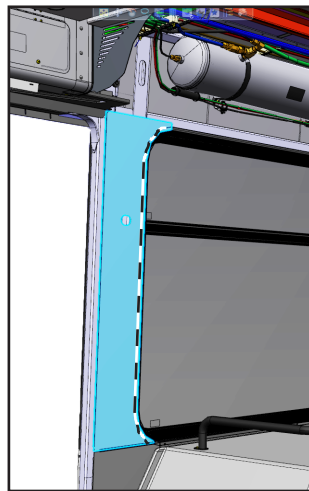


Figure 6 - Remove Melamine

- 1.16. Remove the wires and the pneumatic hoses from the wall structure, including the pneumatic drain hose into the vertical tube (see Figure 7) and attach them temporarily away from the area to be reworked.

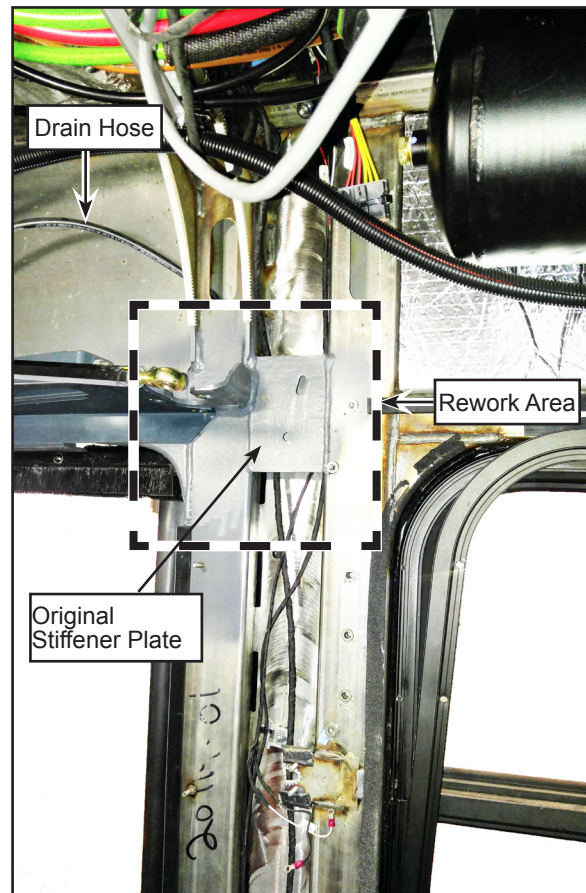


Figure 7 - Secure All Hoses and Wires Away From the Rework Area

- 1.17. Cut and remove the original stiffener plate between the two vertical tubes, see Figure 7. This plate will be replaced by N71120, see Figure 8.



CAUTION

All components must be protected from heat, spatter and flame during the welding process. Refer to maintenance manual section 01: Structure for welding procedure.

- 1.18. Inspect the location shown in Figure 1. If a crack is found, make 1/8" stop holes at both ends if possible.
- 1.19. Start the repair weld at one of the stop holes and continue to the midpoint of the crack. Then start at the other end and work toward the midpoint. If the crack stops at the edge of the part, the weld should begin at the stop hole and continue right to the edge of the cracked part. Because other parts will be welded in the same area, make sure to get a smooth flat surface. Grind slightly if required.

- 1.20. Grind as required to get smooth surfaces and weld stiffening plates N71118, N71119 and N71120. See Figure 8. Given the heat transfer to the wall, take care not to damage the parts in the surrounding area, such as the outside fiberglass panel. Make a full weld on every possible edge to the structure, not to the wall.

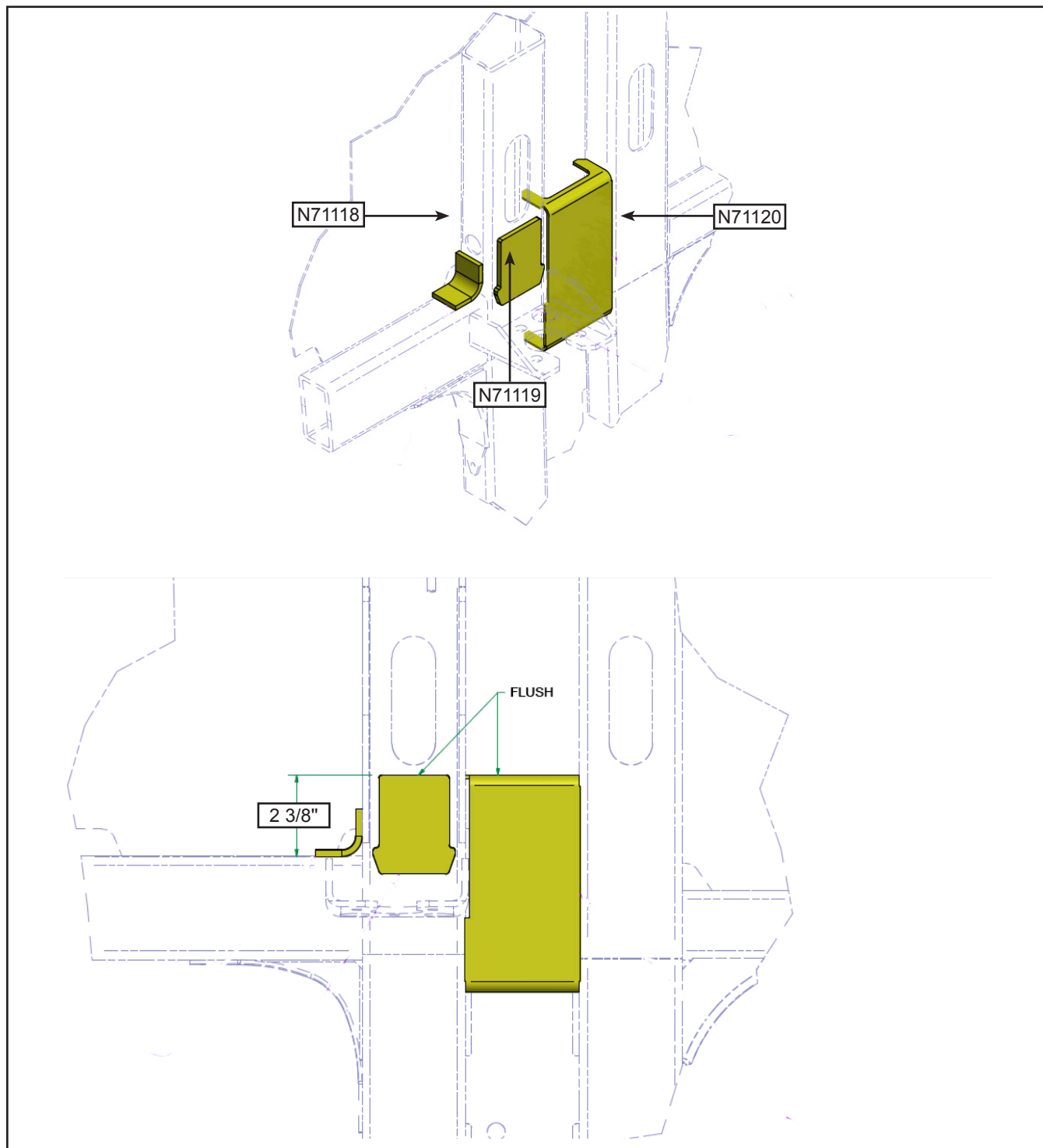


Figure 8 - Plate Positions

- 1.21. Install the door shaft and apply a torque of 4.4 lb-ft to the three bolts. Use thread locker 9985283 or equivalent. See Figure 9.
- 1.22. Install the door mechanism rod to the top of the shaft, torque to 13.3 lb-ft and apply thread locker 9985283 or equivalent. We recommend applying grease N24412 or equivalent to the pivot, if needed. See Figure 9.

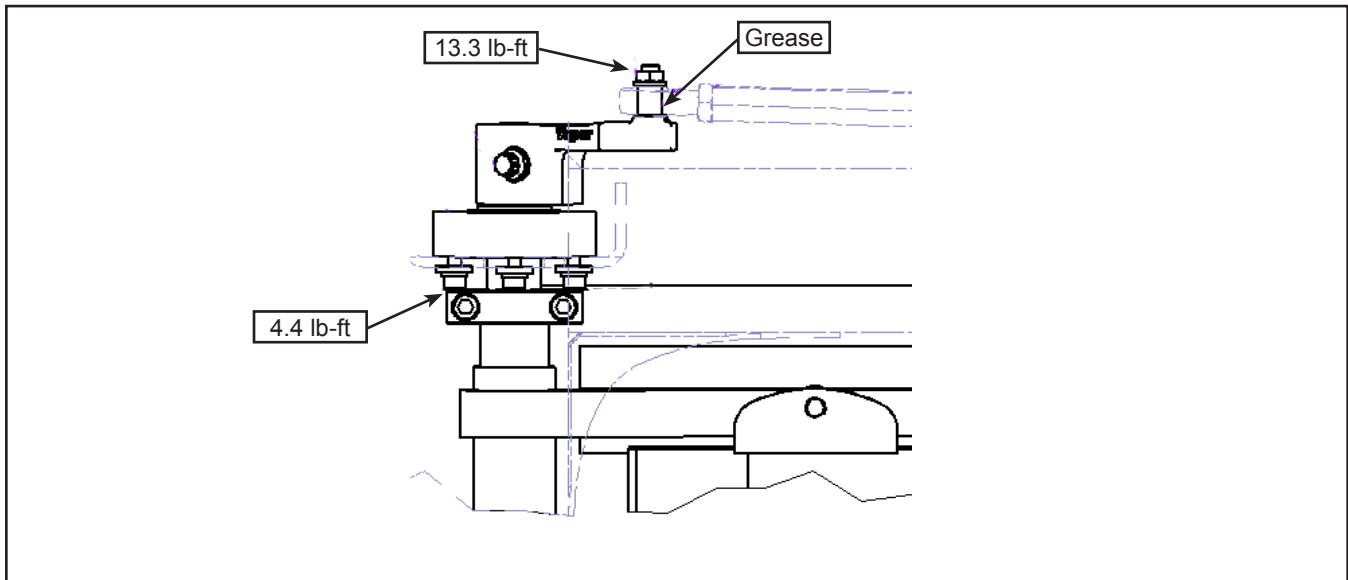


Figure 9 - Torque Door Shaft

- 1.23. Check that there is enough space between the new plate N71119 and the door mechanism. Grind the plate if necessary.
- 1.24. Put the drain hose back in place in the vertical tube and the wires on the structure.
- 1.25. Transfer the original U-channel edge protector on plate N71120.
- 1.26. Install the melamine and route the chime wires through the hole.
- 1.27. Install the door shaft capping at its original height.
- 1.28. Install the baselight and add two N30702 rivets. Connect the baselight harness.
- 1.29. Install the window frame.
- 1.30. With an assistant, connect and install the side sign.
- 1.31. Install the emergency handle assembly. Connect the hoses and harness.
- 1.32. Install the chime cord assembly. Connect the two wires.
- 1.33. Install the emergency handle capping.
- 1.34. Install the wall and upper hand rails.
- 1.35. Install the access panel. ❖