



INSTRUCTION TO SERVICE

ITS: 6522	
SECTION:	410 Tapping Plates
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SUBJECT:	Part A: Inspect support brackets on air accessory tank. Part B: Add support brackets by the existing mounting bracket on the air accessory tank (CS forward tank only). This is only completed when support brackets are broken.

ITS6522

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PROCEDURE:

1. Turn the main battery disconnect switch to the “OFF” position.
2. On the interior of the bus, locate the first 2 light banks on the curbside front of the bus, directly behind the curbside luggage rack. Remove the first (x2) light banks to gain access to the air accessory tank. **Note:** If the light panel has hardware on the bottom side, remove and set aside to re-install later. **Refer to Figure 1.**
3. Disconnect the electrical on light panel before removal. Set aside panels to avoid damage and re-install later.

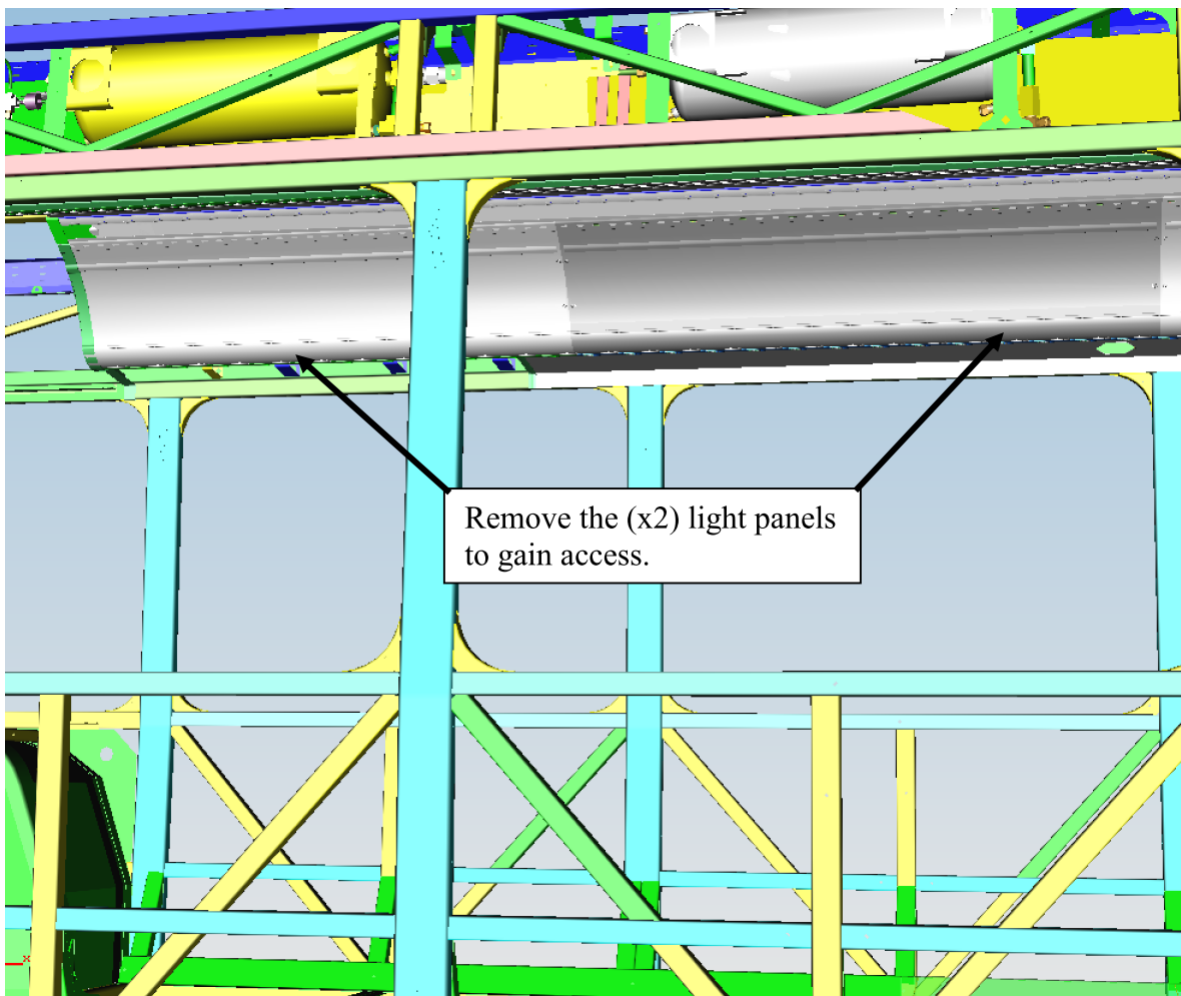


FIGURE 1: SHOWN LOCATION ON CURBSIDE TO REMOVE

4. LIGHT PANELS (X2)

4. Remove the black vinyl closeouts to gain access to the air accessory tank. Set aside to re-install later. **Refer to Figure 2.**

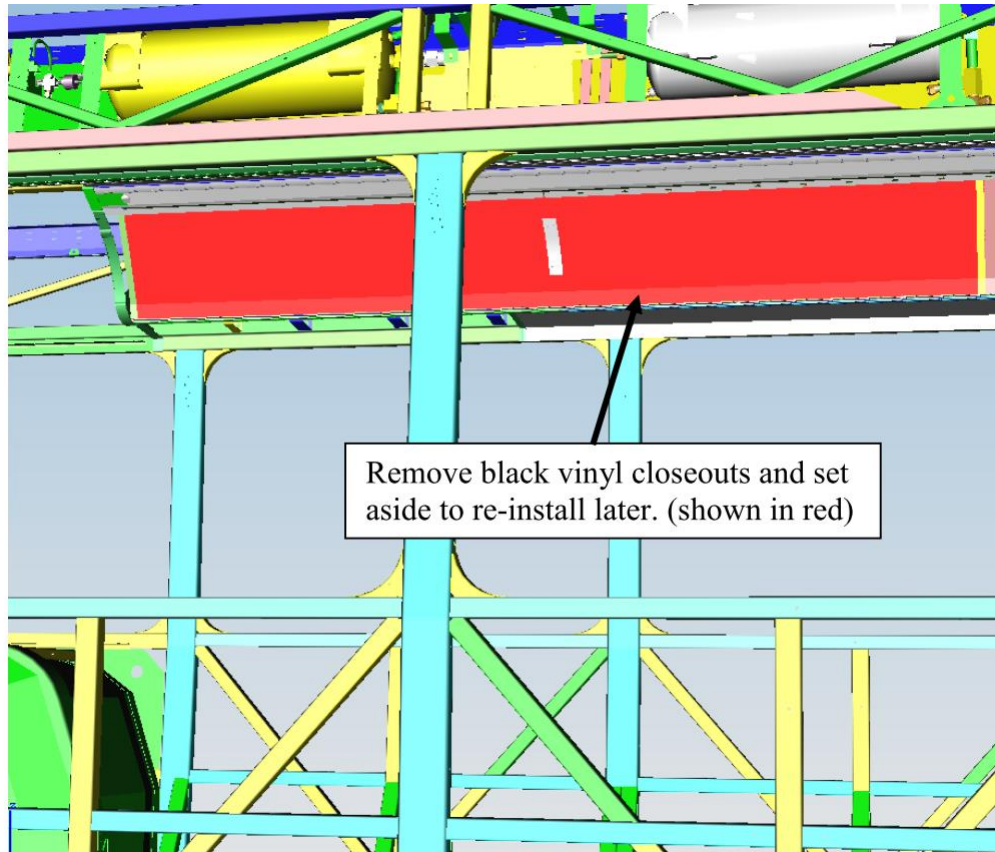


FIGURE 2: REMOVE BLACK VINYL CLOSEOUTS TO GAIN ACCESS

5. Once area is opened up, remove any components that maybe on the way – try and limit what needs to be removed to gain access.

PART A: INSPECT AIR TANK SUPPORT BRACKETS FOR CRACKS

6. Inspect the forward and rearward air tank support mounting plate to see if the support plate is cracked.
YES/NO & cracked/broken (circle). Refer to Figure 3. If no cracks found, proceed to step 20.
Forward Bracket- Cracked or Broken: YES/NO
Rearward Bracket – Cracked or Broken: YES/NO

PART B: INSTALL NEW SUPPORT BRACKET FOR AIR ACCESSORY TANK

7. Drain the air on all the tanks, locate the drains on the outside of the bus (refer to Service Manual for locations). Open the valve, once all the air is out, close the valve.
8. Label the airlines so that the airlines get connected into the correct valves on the air tank when re-connecting. Disconnect the airlines.
9. Loosen off the mounting hardware on the accessory air tank, carefully remove the air tank and set off to the side.
10. Start with the forward most bracket at the air accessory tank. For steps 12 - 18, refer to **Figure 3 & 4**.
11. Remove the lower bracket that secures Velcro in place above the speaker panel. This allows to gain access when applying the bottom rivets for the new brackets.



12. Cut off the section of the original support plate to allow the new support plate (**PN: 656599**) to be installed.
13. Install Assy. – LG Tank SPRT (**PN: 656599**) into the position shown as per the dimensions. Drill the (x4) holes (0.267" diameter) using the holes in the bracket as a template. Install rivets (**PN: 336379**) and crimp in place.
14. Repeat step 12 & 13 to install bracket (**PN: 656597**) at the rear location.

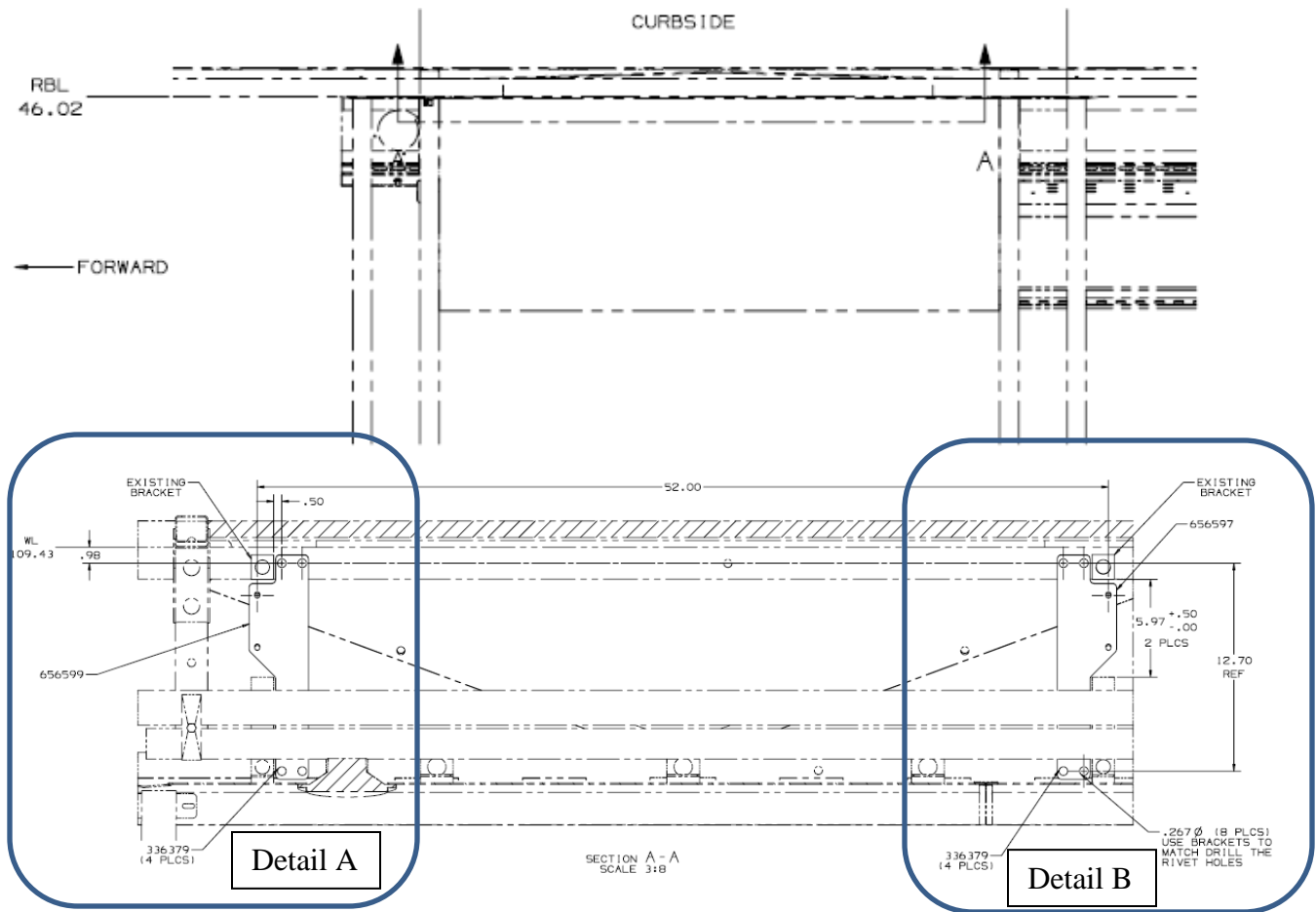


FIGURE 3: SHOWN VIEW TO CUT OFF SECTION OF THE ORIGINAL BRACKET TO INSTALL NEW BRACKET. DETAIL A & B WILL PROVIDE MORE DETAILS.

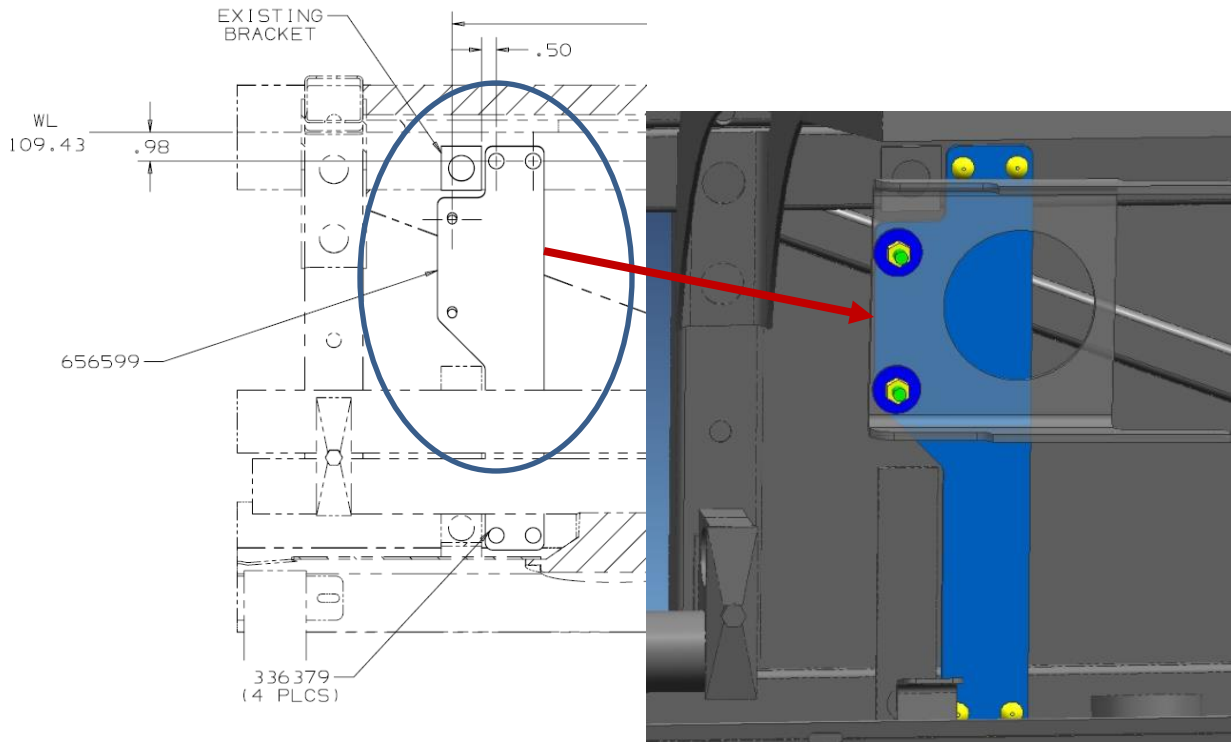


FIGURE 3A: SHOWN A VIEW OF **DETAIL A**. REFER TO DIMENSIONS FOR MOUNTING OF THE FRONT BRACKET

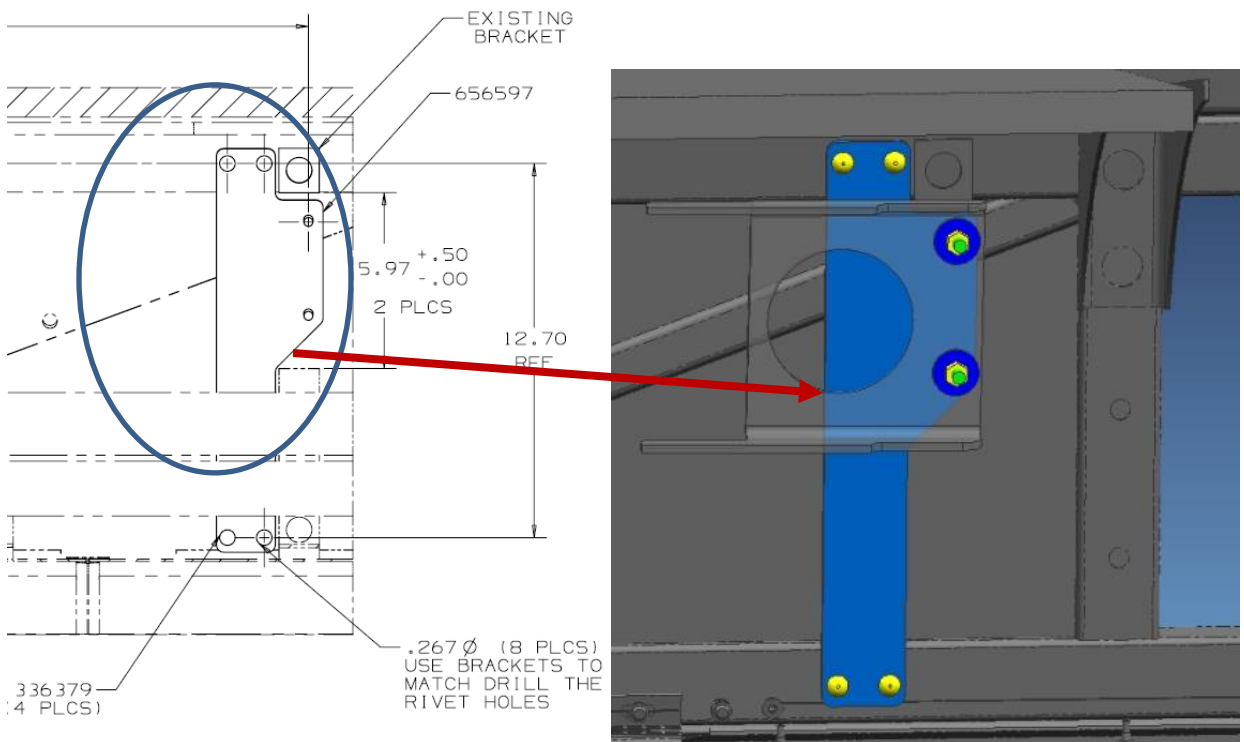
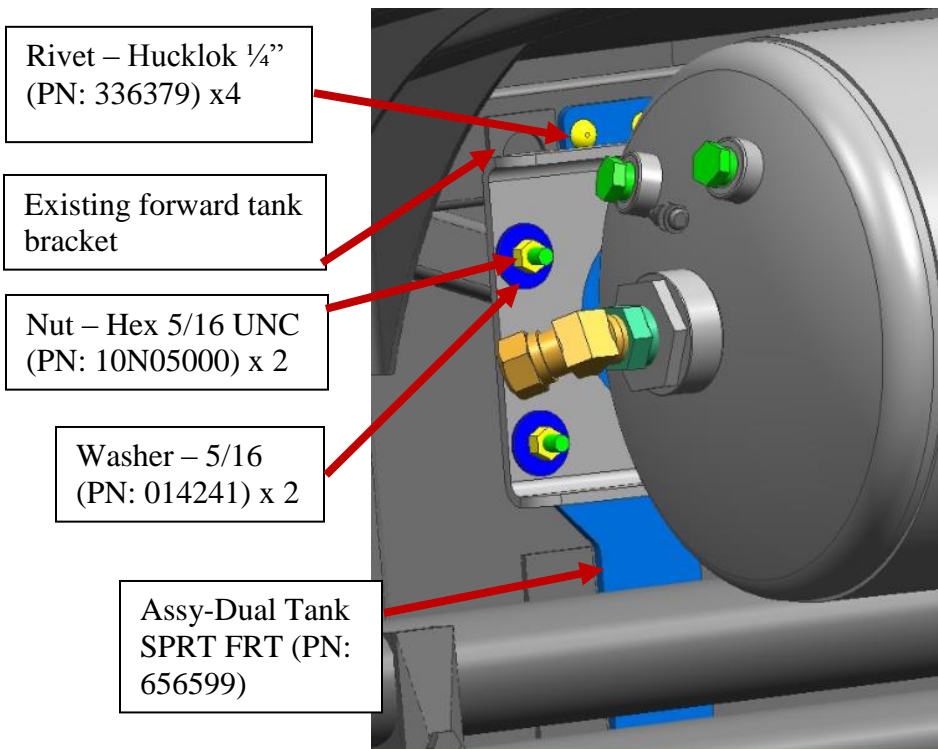


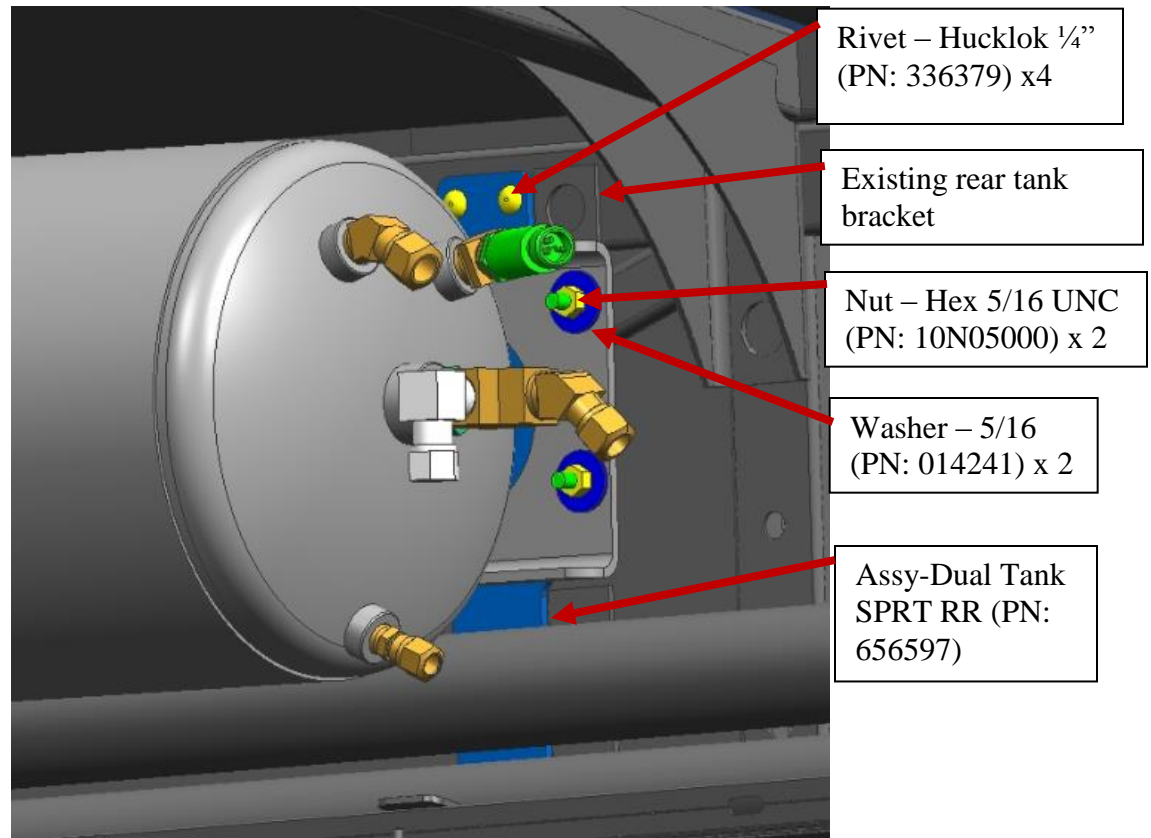
FIGURE 3B: SHOWN A VIEW OF **DETAIL B**. REFER TO DIMENSIONS FOR MOUNTING OF THE REAR BRACKET

15. Carefully re-install the air tank in place. Apply Loctite 243 (PN: 081034) on the bolt threads first. Loosely install new hex nut (PN: 10N05000) and flat washer (PN: 014241) on both sides.
16. Re-connect the airlines onto the air tank. Tighten fittings in place. Be careful not to pinch or damage the line.
17. Once air tank in place and secured into position, tighten hardware and torque to **10 FT/LBS** at 2 places.
Note: Apply torque strips on all hardware and bracket.



DETAIL A VIEW.

FIGURE 4: SHOWN APPLICATION OF THE MOUNTING HARDWARE TO SECURE THE AIR TANK.



DETAIL B VIEW.

FIGURE 4A: SHOWN APPLICATION OF THE MOUNTING HARDWARE TO SECURE THE AIR TANK.

18. Turn on the battery switch. Start up the bus and air up the bus. Using soapy water, spray the fittings that were disconnected on the tank and check for air leaks (you will notice air bubbles if there is air leaks). Tighten up fittings as required. If no leaks found, turn off bus. **Note: Apply torque strips on airline fittings & tank fittings.**
19. Re-secure any electrical or airlines with ty-raps.
20. Re-install the bottom bracket that was removed in step 11. Tighten hardware.
21. Re-install the Velcro covers that were set aside.
22. Re-install the light panel, connect electrical and install hardware to secure light.
23. Turn the main battery disconnect switch to the “ON” position.



LABOUR ESTIMATE				
	Operation	Men	Hours	Labor Time M X HR
1	Inspect the existing support bracket on the air accessory tank (curbside forward tank) for cracks.	1	0.25	0.25
2	Add support brackets by the existing support bracket for the air accessory tank (curbside forward tank).	1	2.25	2.25

Total Time: 2.5 Hours

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	656597	Assy – Dual Tank SPRT RR	1	EA	
2	656599	Assy – Dual Tank SPRT FRT	1	EA	
3	336379	Rivet – Hucklock ¼” 0.187-0.437	8	EA	
4	081034	Loctite – 243 Medium 10 ml	0.01	EA	
5	014241	Washer 5/16 x 1.125 x 0.063	4	EA	
6	10N05000	Nut – Hex 5/16 UNC	4	EA	
7	5958112	7” Ty-rap	6	EA	
8	5963577	15” Ty-rap	6	EA	