



INSTRUCTION TO SERVICE

ITS: 6467	
SECTION:	410 Tapping Plates
WRITTEN BY:	Jeff Kosheluk
SUBJECT:	Add re-enforcement brackets to the existing mounting bracket on the air accessory tank (CS forward tank only)

ITS6467

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PROCEDURE:

Note: This retrofit will only be completed on buses that show no cracks on the forward curbside air tank. This will add a support bracket to the original bracket.

1. Turn the main battery disconnect switch to the “OFF” position.
2. Only drain the air on the accessory tank (forward curbside tank) as per the Service Manual.
3. 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.**
4. Disconnect the electrical on light panel before removal. Set aside panels to avoid damage and re-install later.

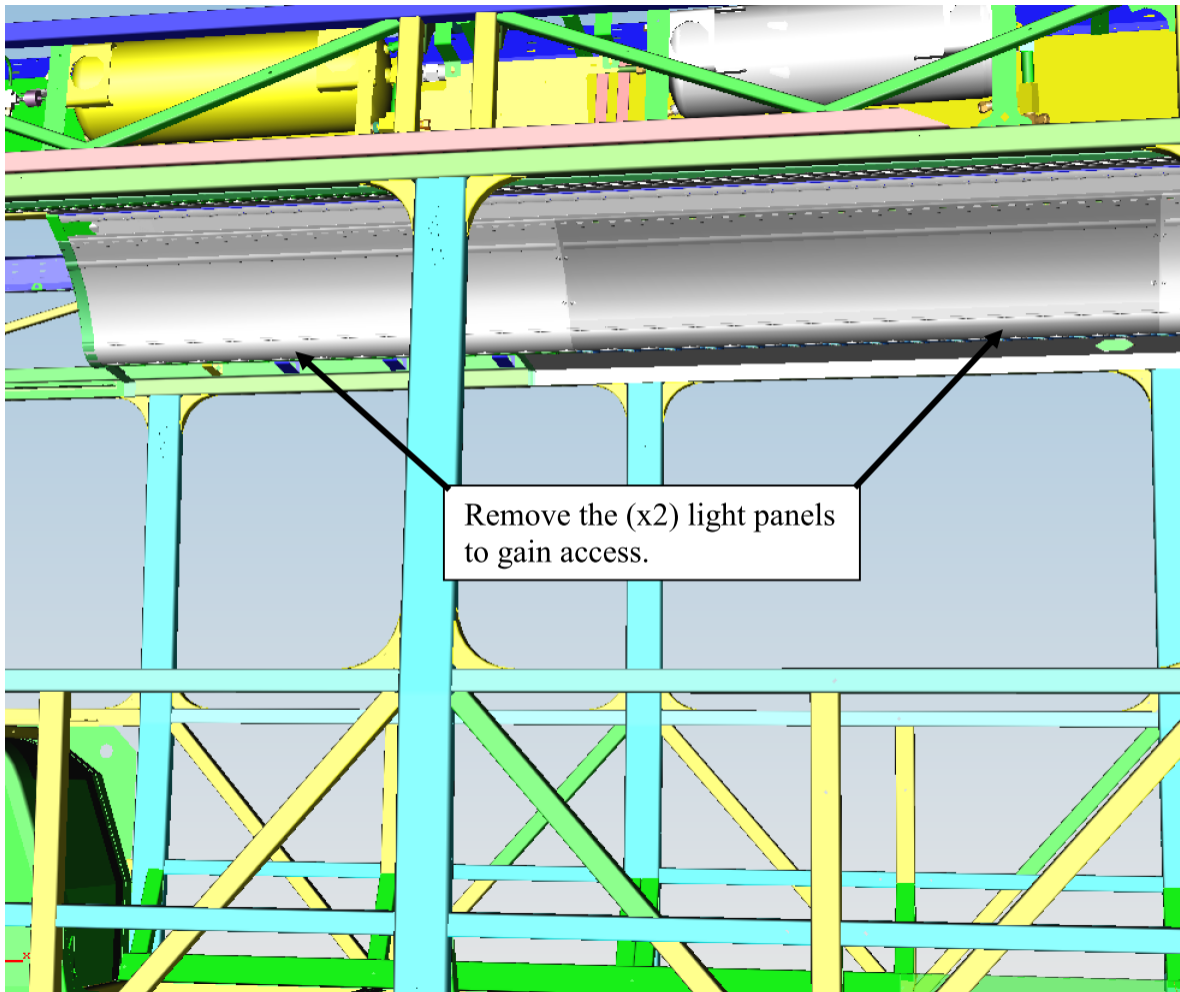


FIGURE 1: SHOWN LOCATION ON CURBSIDE TO REMOVE LIGHT PANELS (X2)



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

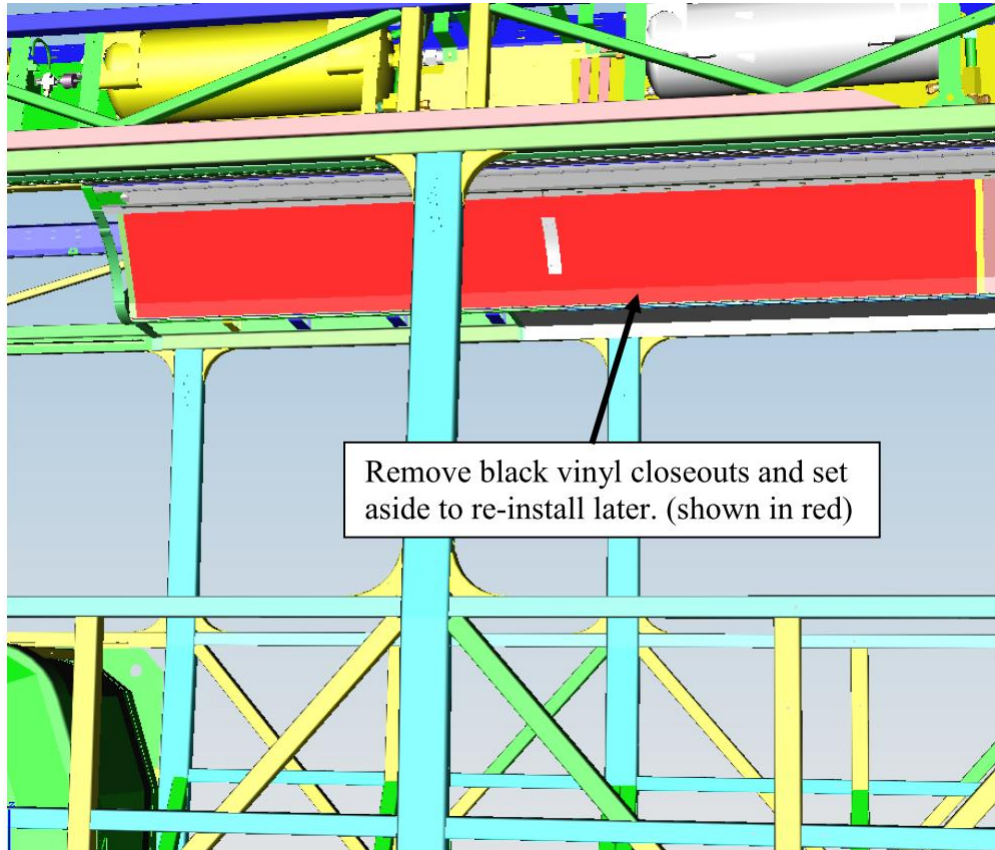


FIGURE 2: REMOVE BLACK VINYL CLOSEOUTS TO GAIN ACCESS

6. Once area is opened up, remove any components that maybe on the way – try and limit what needs to be removed to gain access.
7. Start with the forward most bracket at the air accessory tank. For steps 7 - 13, refer to Figure 3 - 5.
8. Remove the A/C duct hose to have access to drill and rivet on the bracket.
9. Remove hardware off air tank bracket. Install bracket (**PN: 676820**) at the bottom bolt location by sliding behind the air tank mount bracket and position in place so that the bracket is positioned horizontally/level. Install washer – dual tank spacer (**PN: 676843**) at the top bolt location behind the air tank bracket. Install hardware: *flat washer* (**PN: 014241**) & *nut* (**PN: 10N05000**) at each bolt location. Tighten up hardware to secure bracket in place but do not torque hardware yet until the other end of the bracket is riveted in place.



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10. Use 2 holes on the bracket at each vertical structure post (diagonal holes) – x2 places. Drill 0.267” hole using the holes in the bracket as a template. Install rivet (**PN: 336379**) and crimp in place. **Typical 4 places.**
11. Once bracket is riveted in place, tighten up and torque hardware to **10 FT/LBS** at 2 places.
Note: Apply torque strips on all hardware and bracket.
12. Drill 0.25 diameter hole at the location shown to install the saddle clamp to secure the airlines and prevent chaffing. Install saddle clamp (**PN: 5955944**), using screw (**PN: 14s04012**), on the backside install washer (**PN: 50W04000**) and lock nut (**PN: 40N04000**). Secure airlines with ty-rap and trim off end once ty-rap secured in place. Refer to Figure 3.

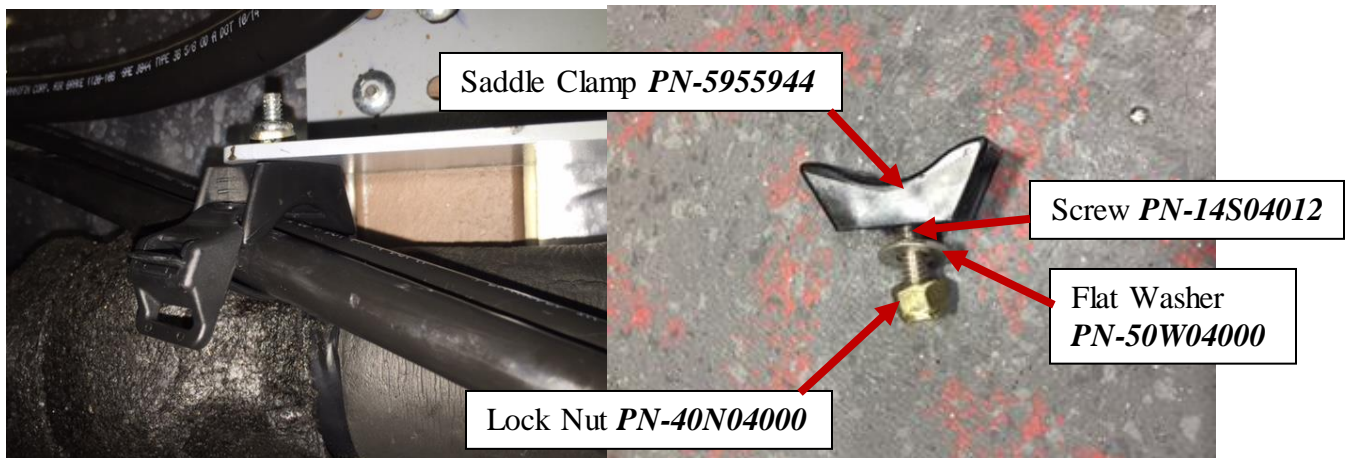


FIGURE 3: INSTALLATION OF SADDLE CLAMP TO PREVENT LINES FROM CHAFFING

13. Additionally, the P-clamp holding the HVAC hose can be secured with nut and bolt at the existing structure above. Refer to Figure 4.
14. Repeat steps 9 – 11 to install the rear support bracket (**PN: 676860**). Refer to Figure 4 & 5.
15. Remove x3 air lines to allow access to install bracket. Use a long extension to drill rear – front hole on bracket.
16. Once tank is properly secured in place, re-install any components that were removed and secure any airlines with ty-raps that had the ty-raps removed to gain access. This includes re-connecting the airlines.
17. Air test tank for any leaks.
18. Re-install the Velcro covers that were set aside.
19. Re-install the light panel, connect electrical and install hardware to secure light.
20. Turn the main battery disconnect switch to the “ON” position.

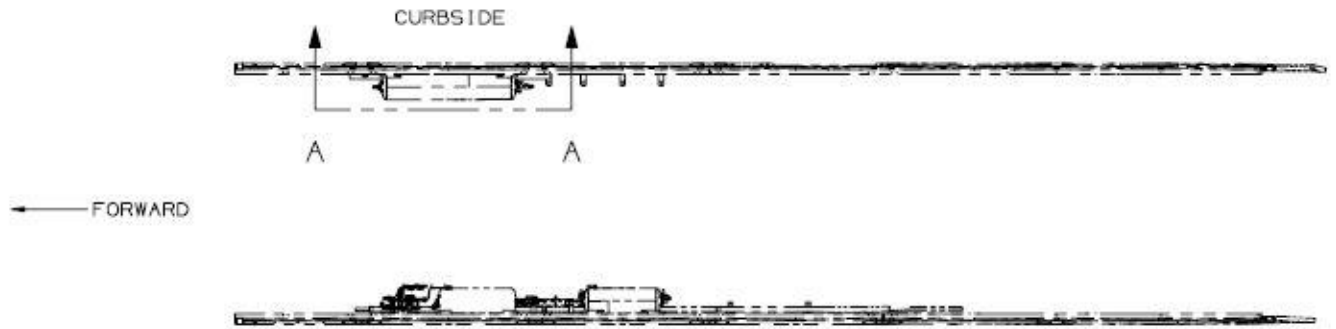
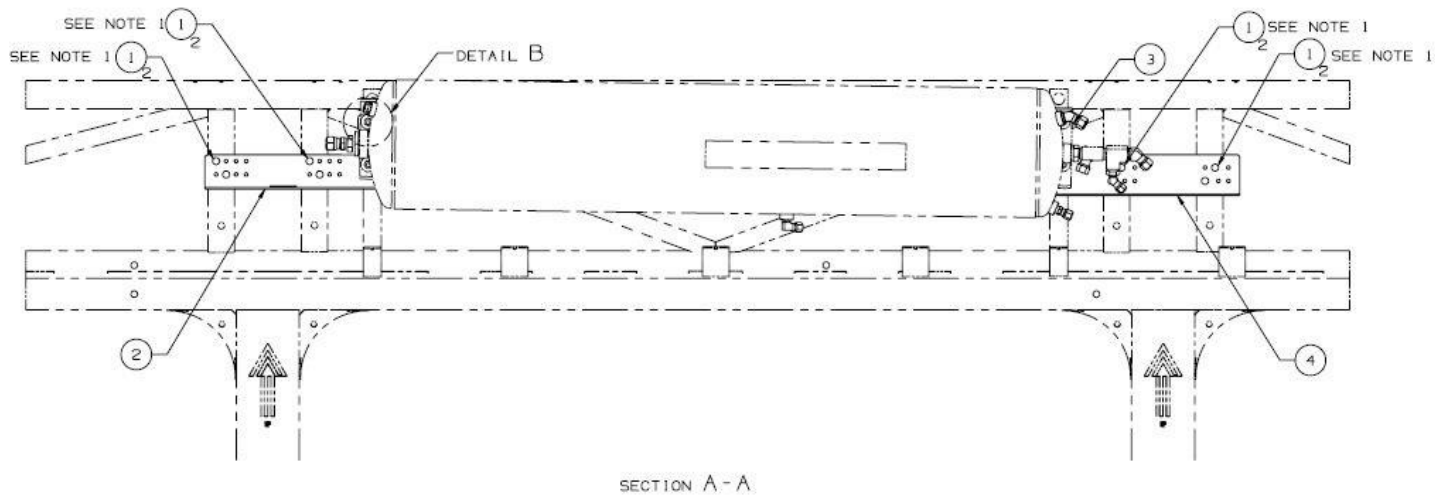


FIGURE 4: VIEW OF THE AIR ACCESSORY TANK FOR REWORK



Notes:

1. Drill .261 - .272 Ø hole for each rivet. Be sure there are no waxing holes in line with the rivet holes of the reinforcement brackets before drilling the rivet holes.
2. Apply Loctite to threaded fasteners.
3. Loosen tank bolts before installing reinforcement brackets and spacers. After rivets are installed, torque air tank nuts to 10 ft-lbs.

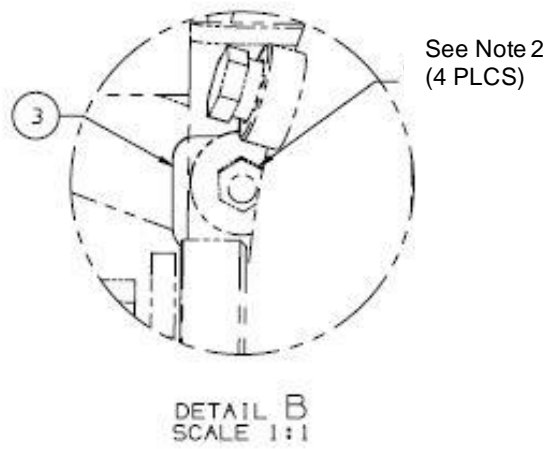


FIGURE 4B: VIEW OF DETAIL B

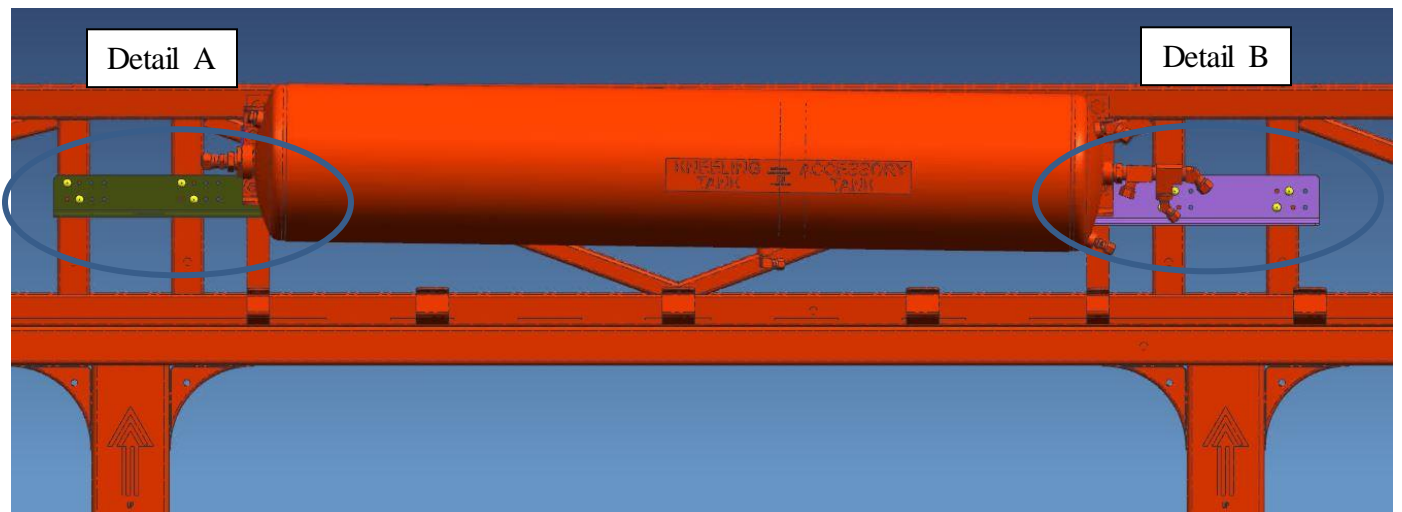


FIGURE 5: VIEW OF THE AIR ACCESSORY TANK FOR REWORK

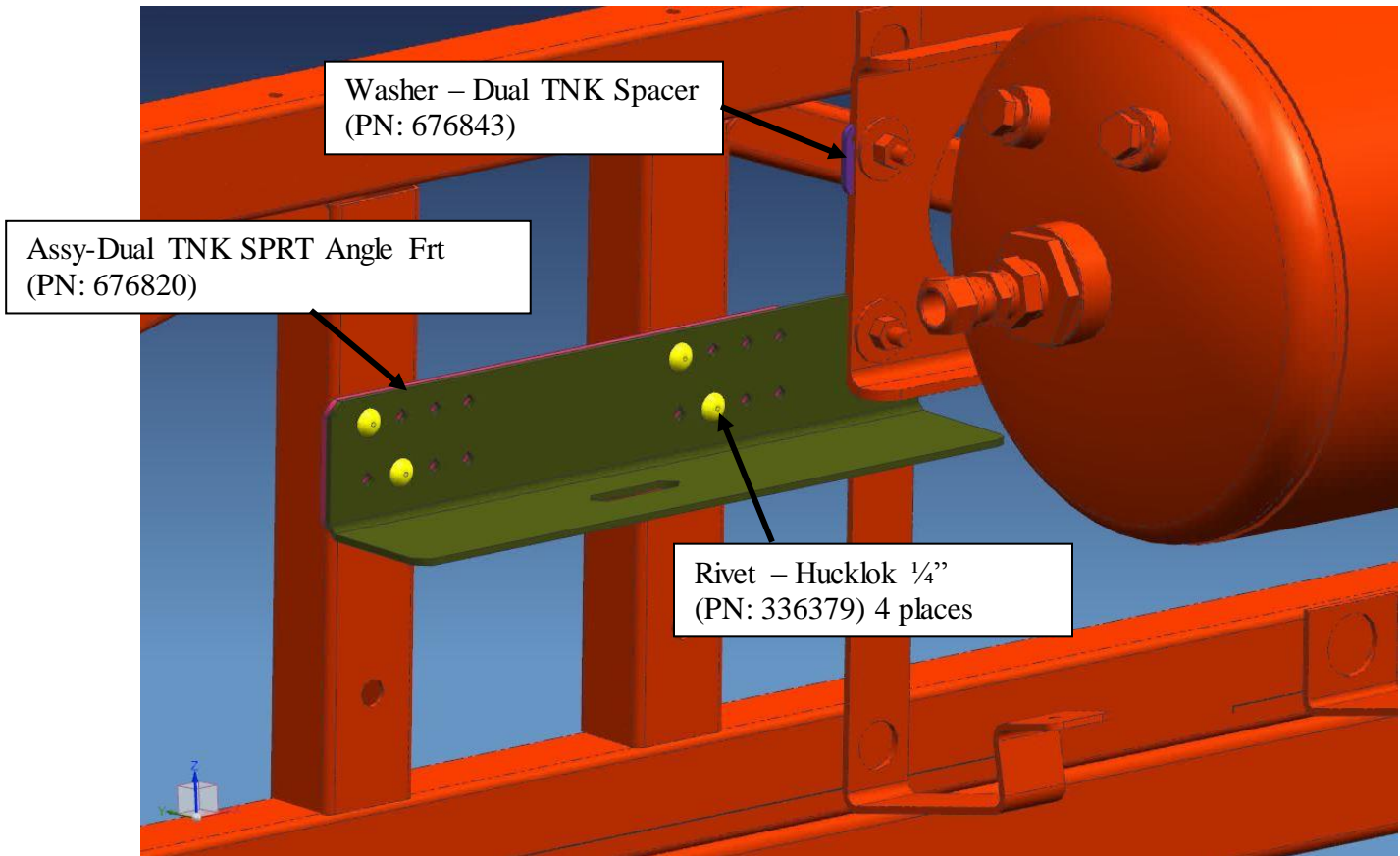


FIGURE 5A: VIEW OF DETAIL A (FORWARD BRACKET)

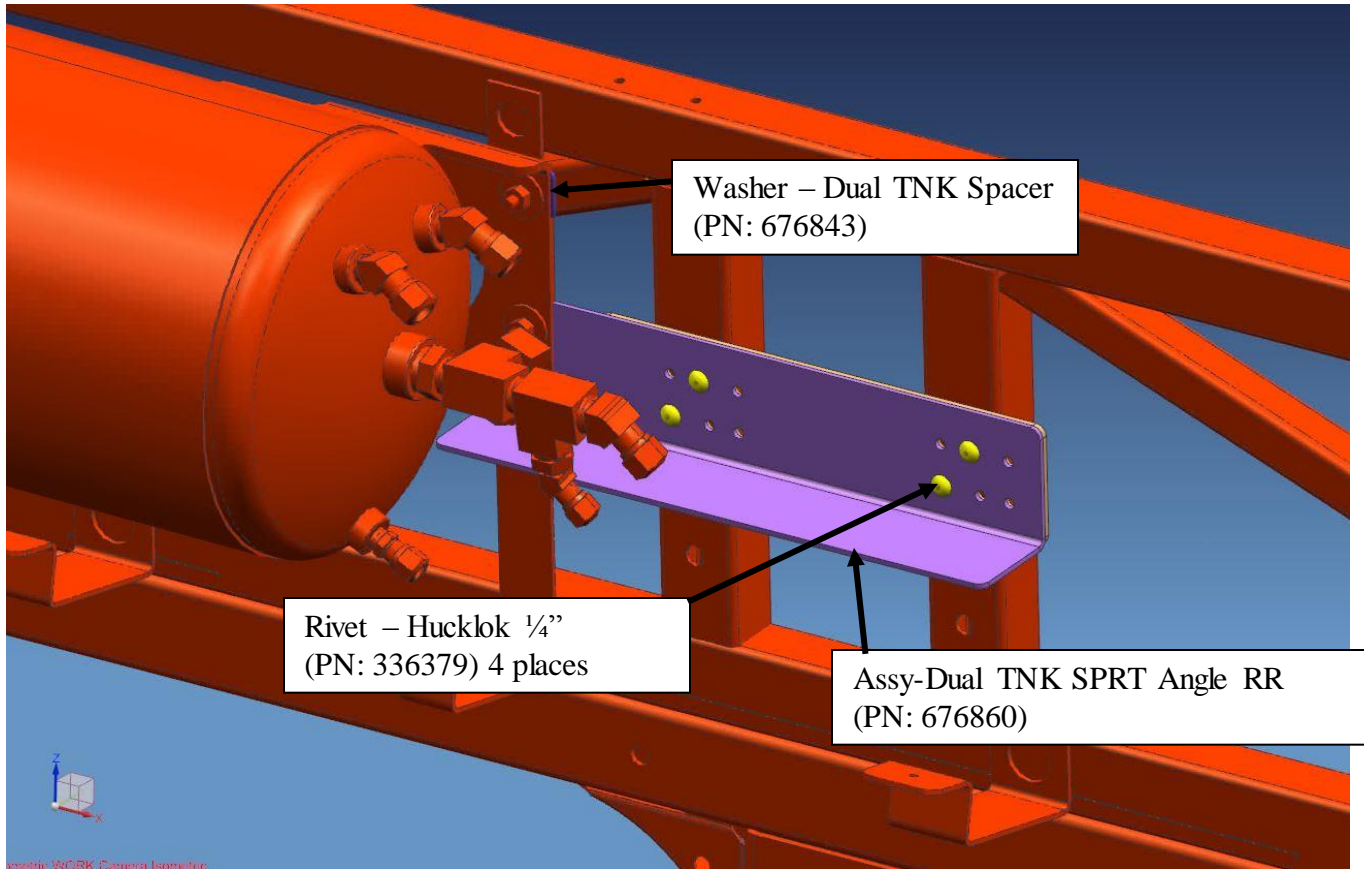


FIGURE 5B: VIEW OF DETAIL B (REARWARD BRACKET)



LABOUR ESTIMATE

	Operation	Men	Hours	Labour Time M X HR
1	Add re-enforcement support brackets to the existing support bracket for the air accessory tank (curbside forward tank).	1	1	1

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	676820	Assy – Dual TNK SPRT Angle Frt	1	EA	
2	676860	Assy – Dual TNK SPRT Angle RR	1	EA	
3	676843	Washer – Dual TNK Spacer	2	EA	
4	336379	Rivet – Hucklock ¼” 0.187-0.437	8	EA	
5	081034	Loctite – 243 Medium 10 ml	0.01	EA	
6	014241	Washer 5/16 x 1.125 x 0.063	4	EA	
7	10N05000	Nut – Hex 5/16 UNC	4	EA	
8	5955944	Mounting Base	1	EA	
9	14S04012	Screw	1	EA	
10	40N04000	Lock Nut	1	EA	
11	50W04000	Flat Washer	1	EA	
12	5955945	Ty-rap 14”	3	EA	