



INSTRUCTION TO SERVICE

ITS: 58518

SECTION:	422 Internal Applied Parts
WRITTEN BY:	James Ashdown
SUBJECT:	Install lanyards on stop request sign access door

ITS58518

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PROBLEM DESCRIPTION: Buses received without lanyards on stop request sign access door.

SOLUTION: Install lanyards on all applicable field buses.

PROCEDURE:

1. Enter bus and turn the battery disconnect switch to the "OFF" position.
2. Locate/open both stop request sign and HVAC center cover access doors. Refer to Figure 1.

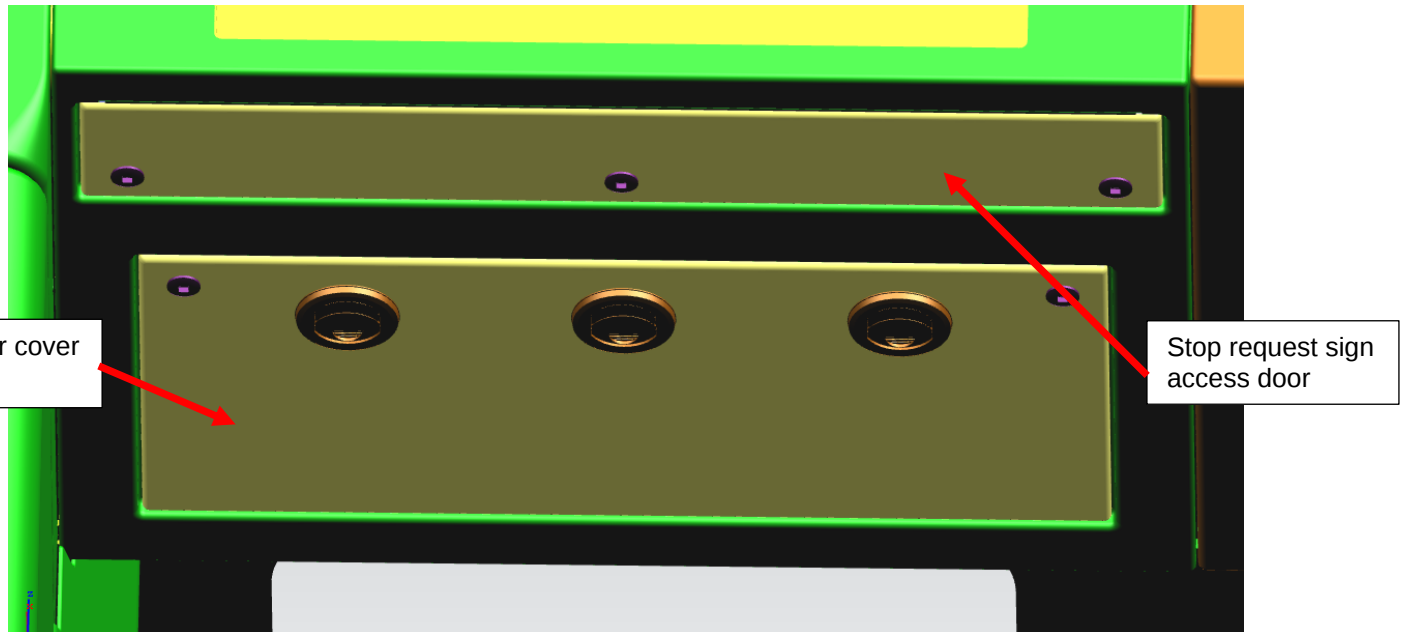


Figure 1 – Locate/open stop request sign and HVAC center cover access doors

3. Position HVAC C/O Brackets (P/N 363132 x2, P/N 496420 x2) on the insides of stop request access sign door panel and HVAC center cover panel in accordance with Figures 2 and 3. Lightly trace around brackets to later assist in positioning during Plexus application.

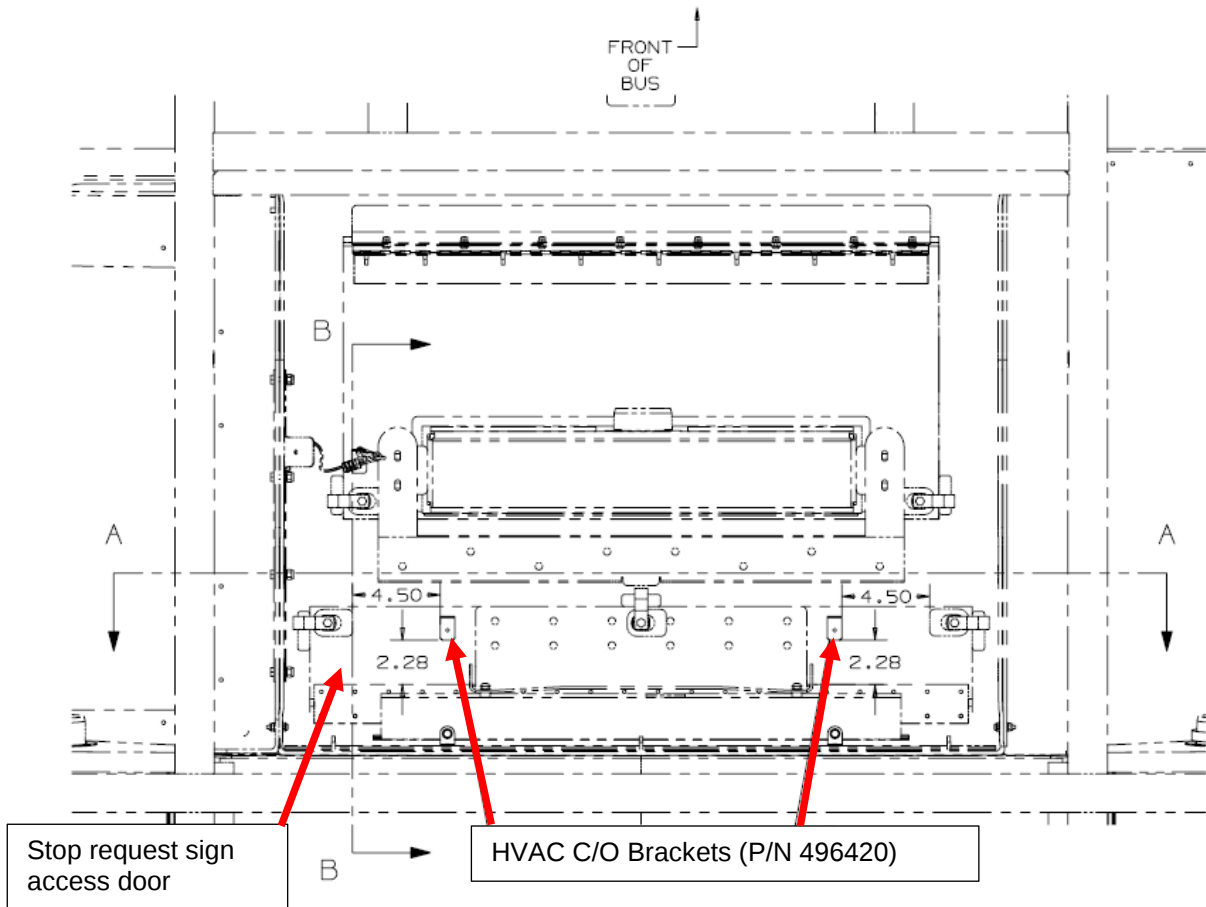


Figure 2 – View above stop request sign and HVAC center cover access doors (doors shown in closed position)

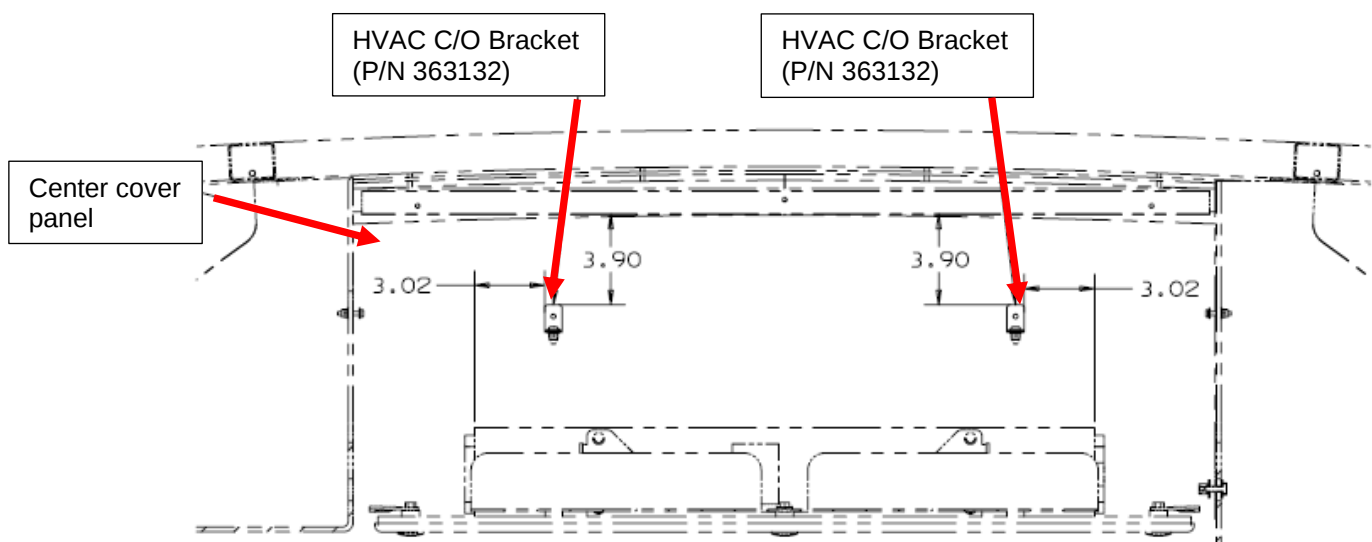


Figure 3 – View inside stop request sign compartment looking aft



4. Wipe down the bonding surfaces of HVAC C/O Brackets (P/N 363132 x2, P/N 496420 x2), stop request access sign door panel and center cover panel with a lint free cloth and Isopropyl Alcohol (P/N 134336). Let flash dry for a minimum of 5 minutes to a maximum of 60 minutes. Refer to Figures 2 and 3.

Note: Ensure that all bonding surfaces are free of grease and debris. Refer to Appendix A – Plexus Application Procedure for Steps 4 - 7.

5. Apply a thin layer of Plexus PC120 Primer (P/N 067196) to bonding surfaces of HVAC C/O Brackets (P/N 363132 x2, P/N 496420 x2) and let dry for one minute.
6. Apply Plexus Adhesive MA920 (P/N 067197) to bonding surfaces of HVAC C/O Brackets (P/N 363132 x2, P/N 496420 x2) within one hour of applying Plexus PC120 Primer (P/N 067196).
7. Clamp and secure HVAC C/O Brackets (P/N 363132 x2, P/N 496420 x2) in position on approximately 20 minutes. Ensure to wipe off excess Plexus squeeze out before curing. Refer to Figures 2 and 3.

Note: Adhesive must come out of bond holes in brackets to ensure a proper bond.

8. Secure Lanyards (P/N 444987) x2 to HVAC C/O Brackets (P/N 363132) x2 on center cover panel using Screws (P/N 14S00010) x2, Washers (P/N 10W00000) x4, and Locknuts (P/N 40N00000) x2. Refer to Figure 4.

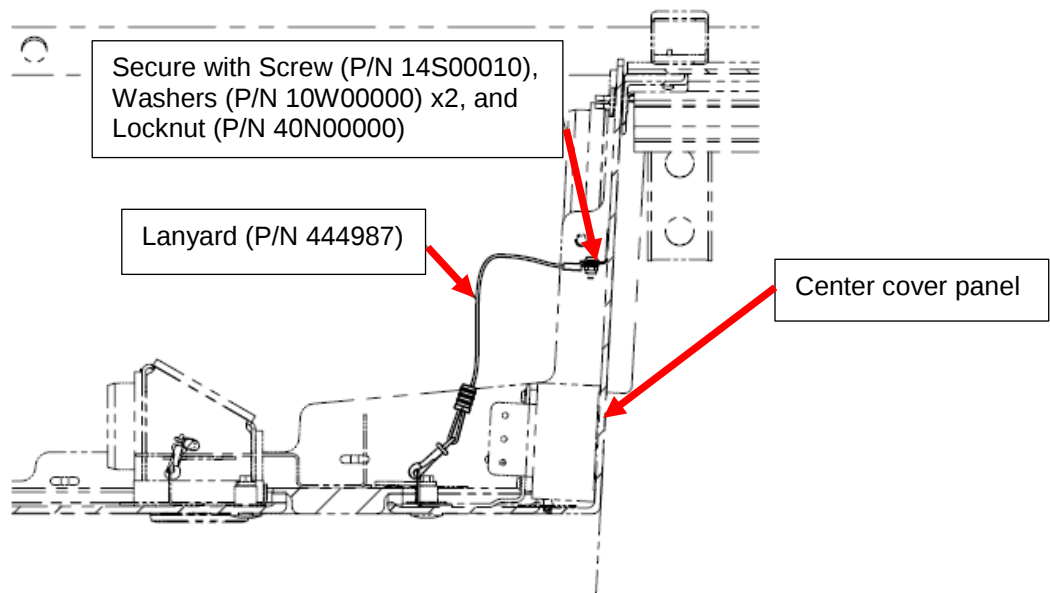


Figure 4 – Secure lanyards to HVAC C/O Brackets (Door in closed position - one lanyard location shown)



9. Close and secure both stop request sign and HVAC center cover access doors.
10. Remove all tools and debris and return the bus to service condition.
11. Turn the main battery disconnect switch to the "ON" position.



LABOUR ESTIMATE

	Operation	Men	Hours	Labor Time M X HR
1	Install lanyards on stop request sign access door	1	0.75	0.75

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	067196	PRIMER-PLEXUS PC120	.01	QT	
2	067197	ADHESIVE-PLEXUS MA920	.01	EA	
3	14S00010	SCREW PH CROSS RECESS SS #10 24 UNC X 5/8" LG.	2	EA	
4	10W00000	WASHER-FLAT #10 NOM	4	EA	
5	134336	ISOPROPYL-ALCOHOL	0.01	EA	
6	444987	LANYARD-11.5 LG, TYPE 3 DTCHBL	2	EA	
7	40N00000	NUT LOCK NYLON #10 24 UNC	2	EA	
8	496420	BRACKET-HVAC C/O TETHER	2	EA	
9	363132	BRACKET-HVAC C/O TEATHER	2	EA	

SPECIAL TOOLS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6470988	MIXING NOZZLE 490ML	1	EA	
2	6472958	PLEXUS MANUAL APPLICATOR 490ML	1	EA	



Appendix A – Plexus Application Procedure

1. Wipe down all contact surfaces with clean lint free cloth, ensure that surface area is free of grease and debris.
2. Apply Plexus PC120 Primer along all surfaces which are to be bonded using a clean cloth. Let flash off until completely dry.
3. Apply Plexus MA920 Adhesive to indicated surface. Dispense adhesive length of mix nozzle when using a new nozzle before applying to primed surface.
4. Place bonding surfaces together, pressing bonding surfaces firmly together and apply clamps.
5. Remove any excess squeezed-out adhesive and allow drying for 20 minutes before removing clamps.

**** SAFETY:**

Applicator shall use rubber gloves and approved respirator when using Plexus Primer and Adhesive.