



INSTRUCTION TO SERVICE

ITS: 58734	
SECTION:	420 – Exterior Doors
WRITTEN BY:	Daniel Tice
SUBJECT:	Door Louver Stiffener Rework

ITS-58734

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SAFETY PRECAUTIONS MUST BE FOLLOWED ACCORDING TO ACCEPTED INDUSTRY STANDARDS AND LOCAL/PROPERTY REQUIREMENTS.

Issue: Corner pillar access door louver breaking at joint.

Solution: Install corner pillar door louver joint stiffener.

PROCEDURE:

Removal of the corner pillar access door.

- 1) Park bus on a flat surface and apply the parking brake.
- 2) Turn the main battery disconnect switch to the "OFF" position.

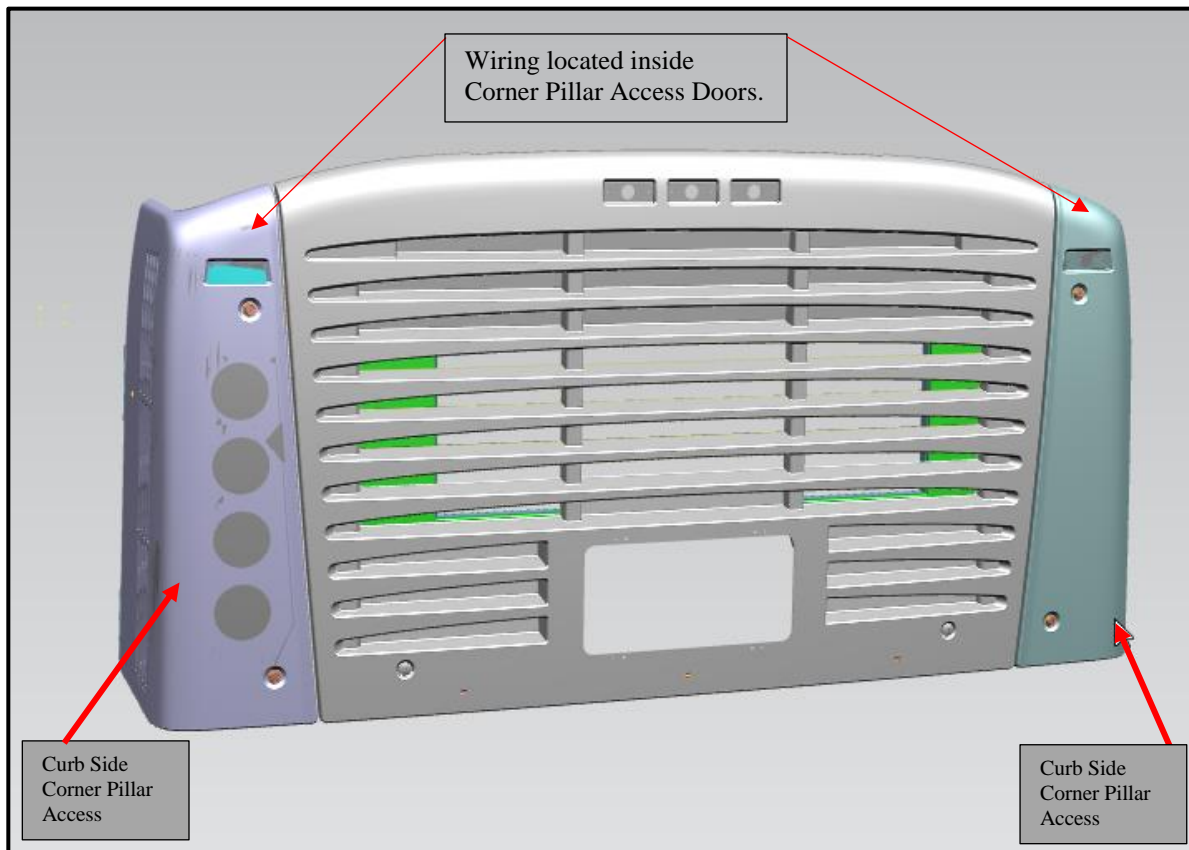


Figure 1: Corner Pillar Access Door Reference.



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- 3) Inspect the doors for damaged and cracked louvers.
 - 4) If broken or cracked louvers are found open the corner pillar access door and disconnect wiring.
 - 5) Remove corner pillar access door (Illustration is for reference only) See figure 2.
 - a. Remove nylon lock nut #1 (NF PN: 261556).
 - b. Remove flat washer #2 (NF PN: 50W04000).
 - c. Remove the door from bus and place on clean smooth protected surface not to damage the paint.
- 👉 **NOTE: Discard nylon lock nuts (# 1 NF PN: 261556.)**

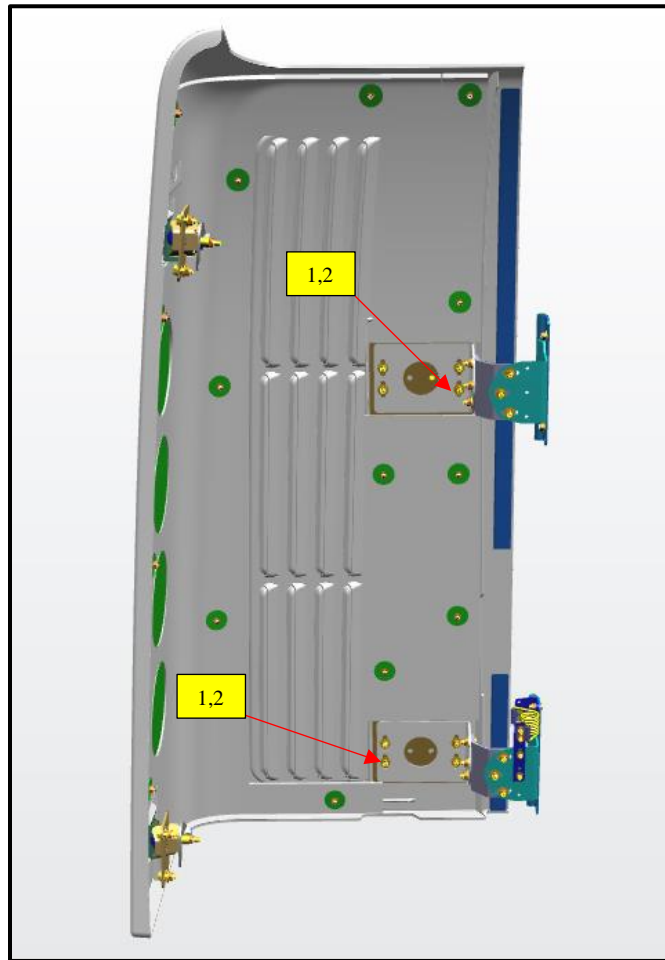


Figure 2: Removal of Corner Pillar Access Door Reference.

1	261556	Nut, Hex Lock Steel 1/4"- 20	8	EA
2	50W04000	Washer, Flat 1/4"- SST	8	EA



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⚠ WARNING: PPE required.

🔧 NOTE: Wear safety glasses and gloves while cleaning and preparing surfaces. Face shield and dust mask are required while grinding.

- 6) Prepare door panel for the louver stiffener bracket.
 - a. Fold Insulation back out of work area as needed. See figure 3.
 - b. Clean the area where the stiffener brackets will be installed. See figure 3.
 - c. Once these areas are clean, scuff with 200 grit sandpaper using hand pressure.
 - d. Once area is abraded clean entire bond surface with isopropyl alcohol and clean lint free cloth.
- 7) Prepare door louver stiffener bracket. See figure 3.
 - a. Clean entire bond surface area of the stiffener bracket #3 (NF PN: 811052) with isopropyl alcohol and clean with lint free cloth.

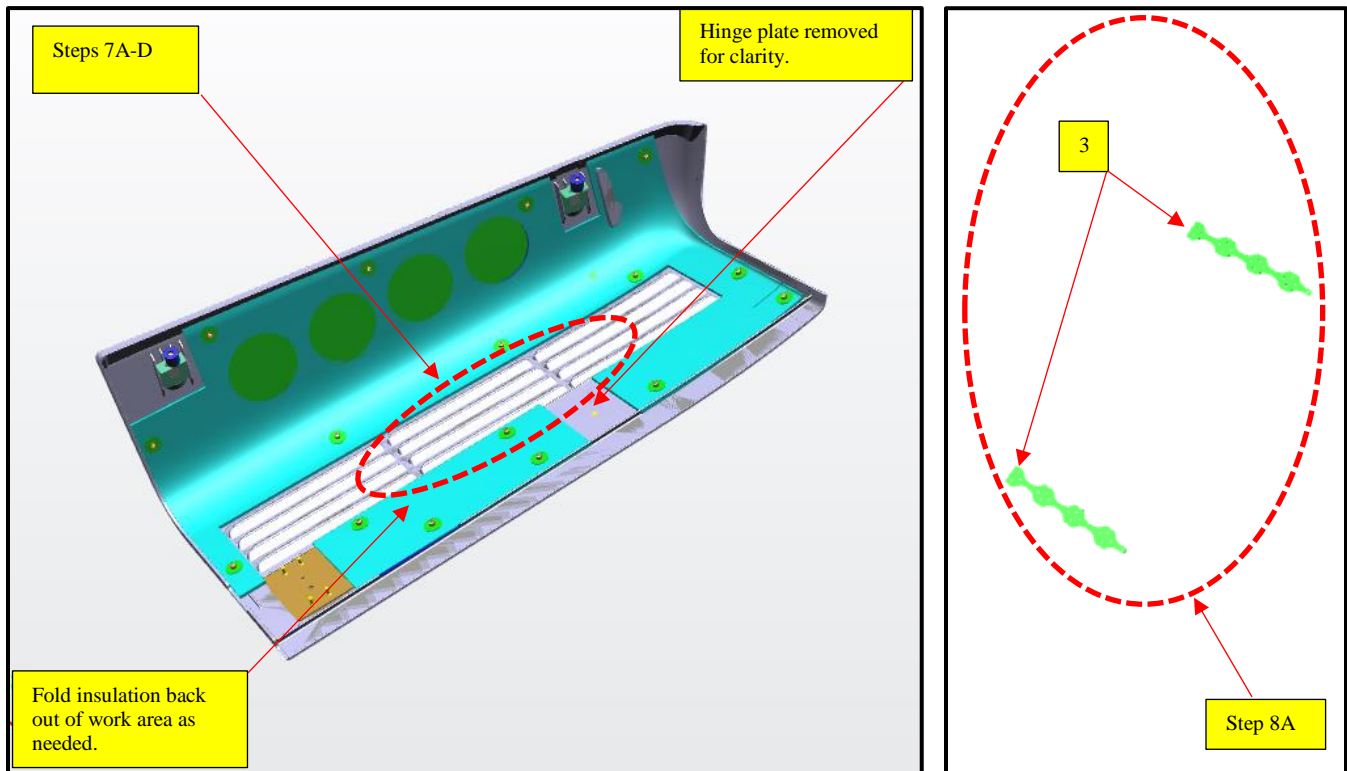


Figure 3: Louver Door Stiffener Bracket Preparation Location Reference.

3	811052	Bracket, Louver Support	2	EA
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8) Install louver stiffener bracket using steps 8 A-F.

⚠ WARNING: PPE required.

**** SAFETY: Applicator shall use rubber gloves and approved respirator when using Primer and Adhesive.**

- a. Wipe down all contact surfaces with clean lint free cloth, ensure that surface area is free of grease and debris. See figure 4.
- b. Create a temporary splint to address any misalignment and mask off outer surface of the cracked region. Ensure the masking takes form to the contour of the louver and door to prevent adhesive from squeezing through.
- c. Apply Plexus PC120 Primer #4 (NF PN: 067196) on the surfaces of the stiffener bracket using a clean cloth. Remove excess primer with clean lint free cloth and allow to flash for a minimum of 1 minute and a maximum of 3 minutes.
- d. Apply Plexus MA920 Adhesive #5 (NF PN: 067197) to indicated surface. See figure 4.
👉 NOTE: When using a new nozzle dispense adhesive the length of the nozzle before applying to primed surface. Within 4 minutes of applying the plexus adhesive assemble the stiffener bracket item #3 (NF PN: 811052) to the panel. See figure 4.
- e. Place bonding surfaces together, press with 1 PSI of pressure with weights or clamps and allow 20 minutes of cure time before removing.
- f. After curing remove any excess material that squeezed-out.

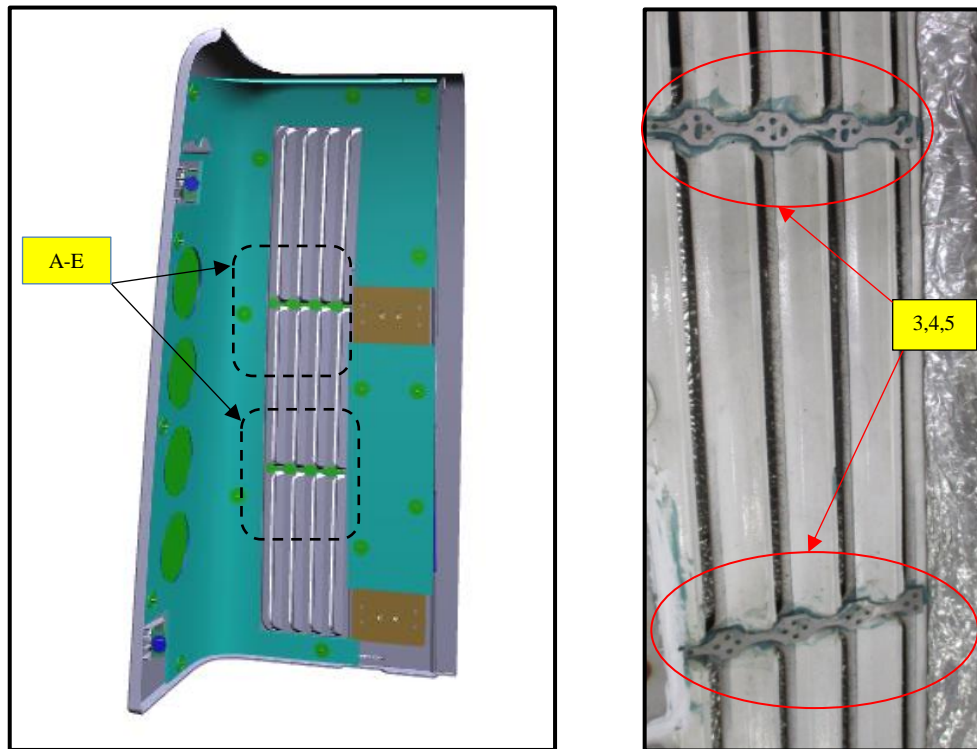


Figure 4: Louver Door Stiffener Bracket Preparation Location reference.

3	575286	Bracket, Corner Door Hinge SST	2	EA
4	067196	Primer, PC120	0.10	AR
5	067197	Plexus MA 920	0.10	AR



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- 10) Remove splint and have the exterior of the door painted.
- 11) Paint the interior of door with New Flyer standard white paint #6 (NF PN: 375246). See figure 5.

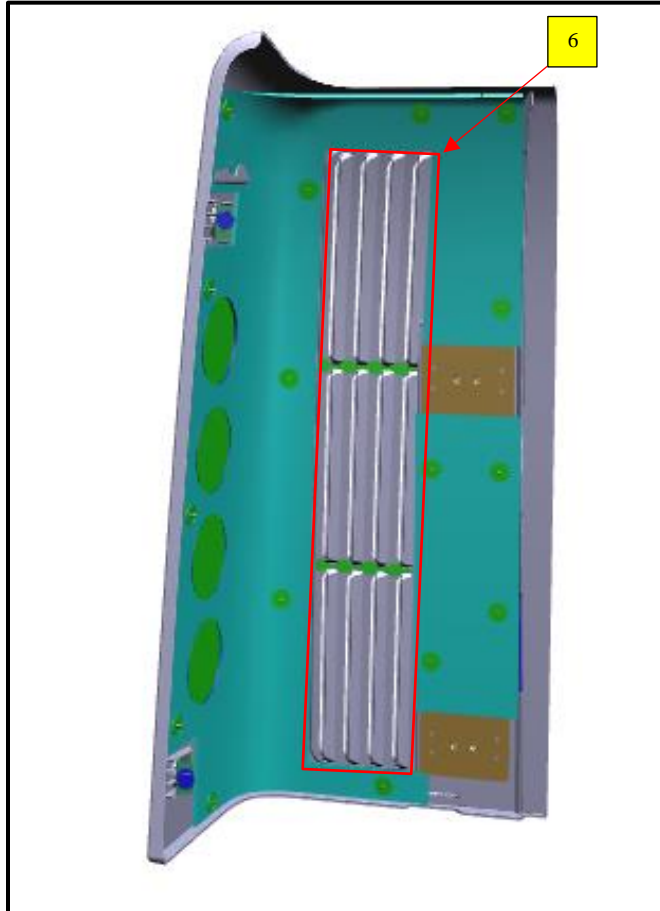


Figure 5: Louver Door Stiffener Bracket Paint Location reference.

Item	Part Number	Part Description	Qty. per Coach	Units
6	375246	White Paint	0.10	EA



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12) Re-install corner pillar access door (Illustration is for reference only) See figure 6.

- a. Install flat washer #2 (NF PN: 50W04000).
- b. Install nylon lock nut #1 (NF PN: 261556).

👉 **NOTE: Do not tighten hardware completely until door has been aligned correctly. See figure 7.**

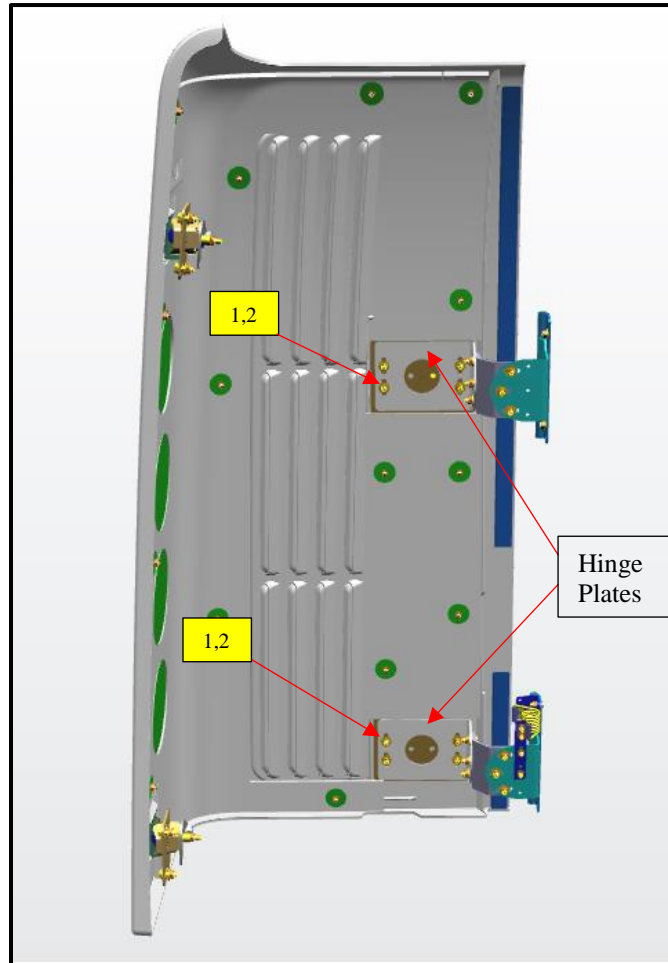


Figure 6: Installation of Corner Pillar Access Door Hardware Location Reference.

1	261556	Nut, Hex Lock Steel 1/4"- 20	8	EA
2	50W04000	Washer, Flat 1/4"- SST	8	EA



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- 13) Align Bottom of door panel to be flush with rear door $.26'' \pm .06$. See Figure 7
- 14) Open and close the door gently to ensure it is aligned correctly with no binding and functions as it should, adjust as needed then tighten hardware #2 (NF PN: 261556) See figure 6.
- 15) Re-install lights in door panel.
- 16) Re-connect and secure wiring to the door panel.
- 17) Close and lock access door when work is complete.
- 18) Turn the main battery disconnect switch to the "ON" position.

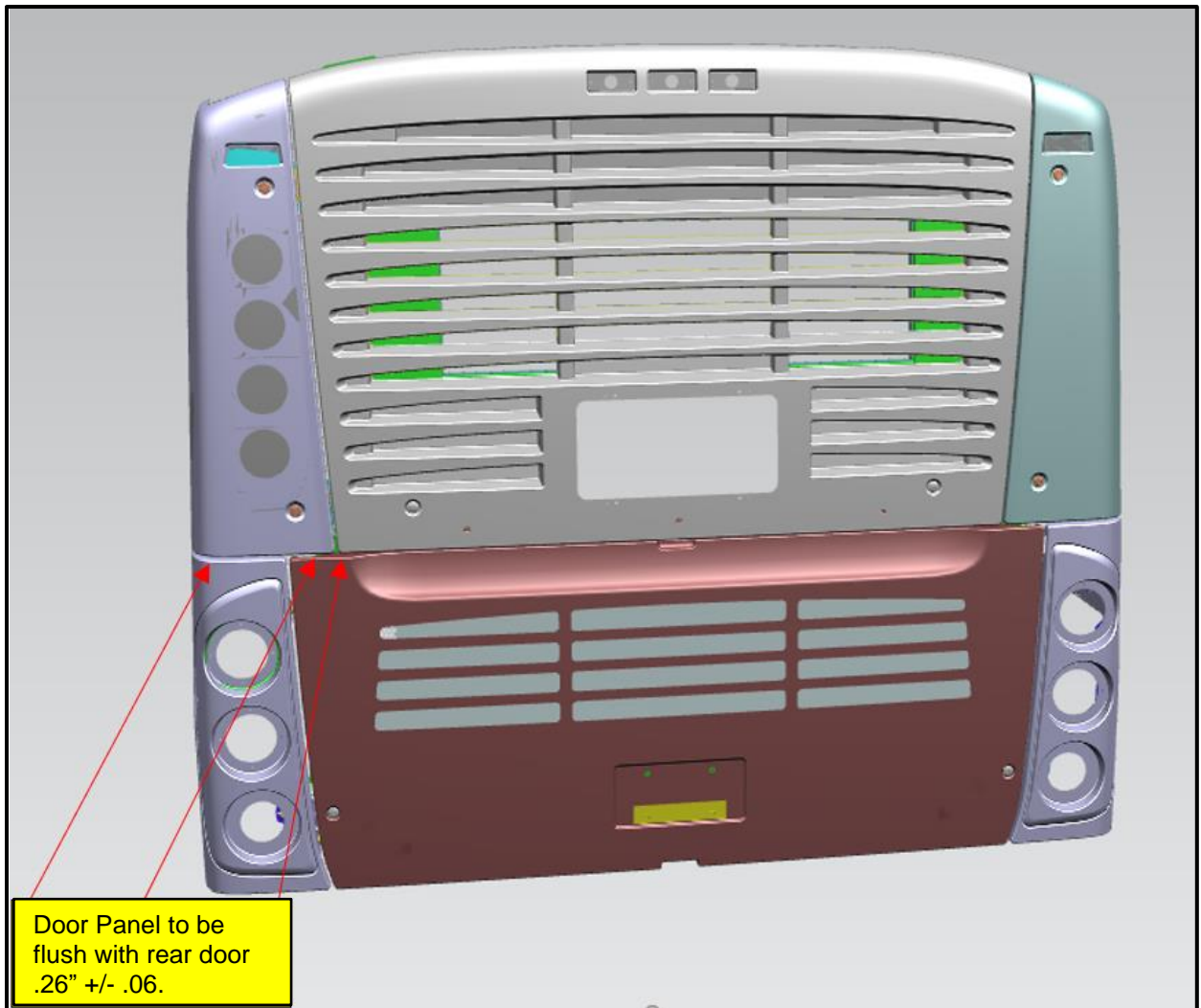


Figure 7: Adjustment of Corner Pillar Access Door Location Reference.



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LABOUR ESTIMATE

	Operation	Men	Hours	Labor Time M X HR
1	Door Louver Stiffener Rework	1	1.5	1.5

Total Man hrs. 1.5 hrs.

PARTS REQUIRED FOR DOOR HINGE PLATE AND LOUVER SUPPORT REWORK

Item	Part Number	Description	Qty. per bus	Units	Notes
1	261556	Nut, Hex Lock Steel 1/4" - 20	8	EA	
2	50W04000	Washer, Flat 1/4" - SST	8	EA	
3	575286	Bracket, Corner Door Hinge SST	2	EA	
4	067196	Primer, PC120	.010	EA	
5	067197	Plexus MA 920	.010	EA	
6	375246	White Paint	0.10	EA	