



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	4/7/2020
SERVICE BULLETIN SUBJECT:	Side Window Leaking Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SB-20-61

SIDE WINDOW LEAKING RETROFIT

NOTICE! It is expected that this process will require 6 hours per bus. Please schedule appropriately to minimize vehicle downtime.

Retrofit Description:

This retrofit replaces the shims on the side windows to obtain an improved portal seal to prevent leakage.

Tools/Parts Required

Tools and Supplies Required:

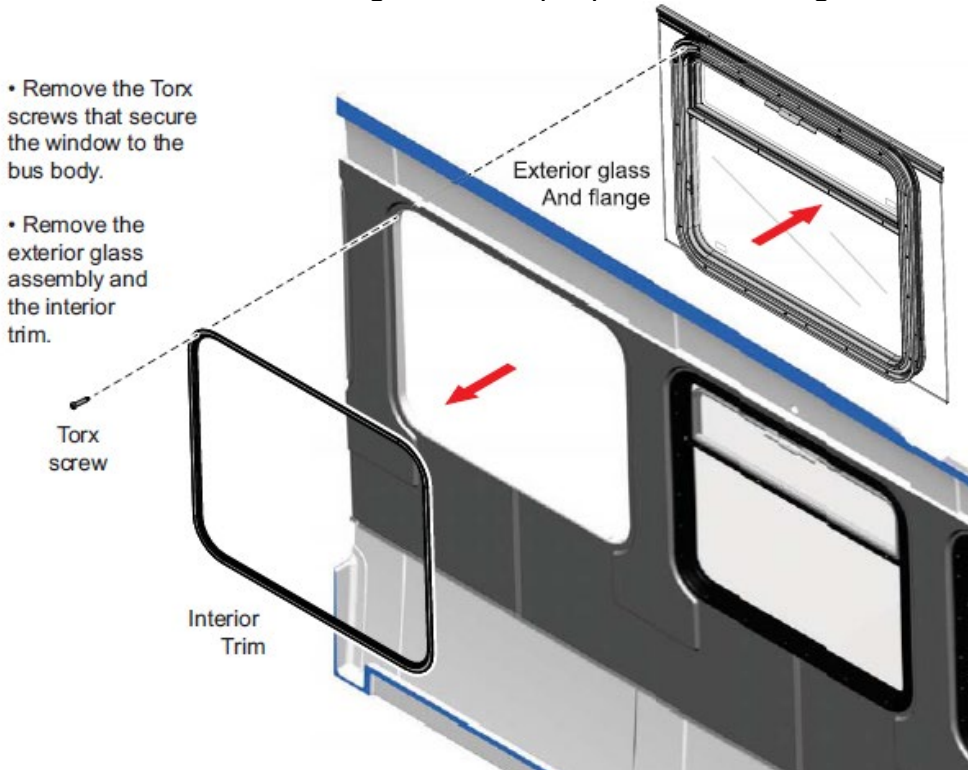
- Suction Cups
- T-20 Torx Bit
- Drill Driver
- Calibrated Torque Wrench
- Masking Tape
- Marker/Pen

Parts Required:

- 053106 – Shim, Window 1/16" thick 30 EA
- 053107 – Shim, Window 3/16" thick 30 EA

Procedure

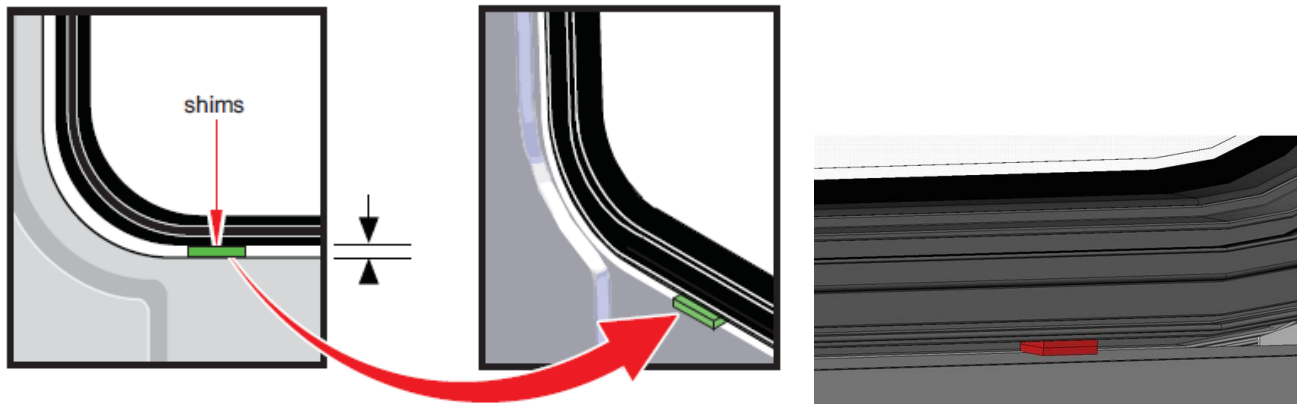
1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. On the interior of the bus, remove the side window trim (031241) that covers the fasteners securing the side window in place and mark the trim location using tape and a marker.
3. On the interior of the bus and working one window at a time, using a T-20 Torx Bit and Drill Driver, remove all Torx screws securing the side window.
IMPORTANT! Ensure the exterior window glass and frame are properly supported on the exterior of the vehicle, using suction cups, prior to removing all of the Torx screws.



4. Carefully place the window in a suitable location and prepare the window portal for reinstallation.
5. Once the window portal has been prepped, lift and install the exterior window glass and flange into position.
IMPORTANT! Ensure the exterior glass and flange are properly supported using suction cups.

6. On the interior of the bus and working one window at a time, position the appropriate Shims (053106 or 053107) to properly position the side window in the portal to create the proper window seal.

- Place the new window
- During installation use shims under the exterior window frame.

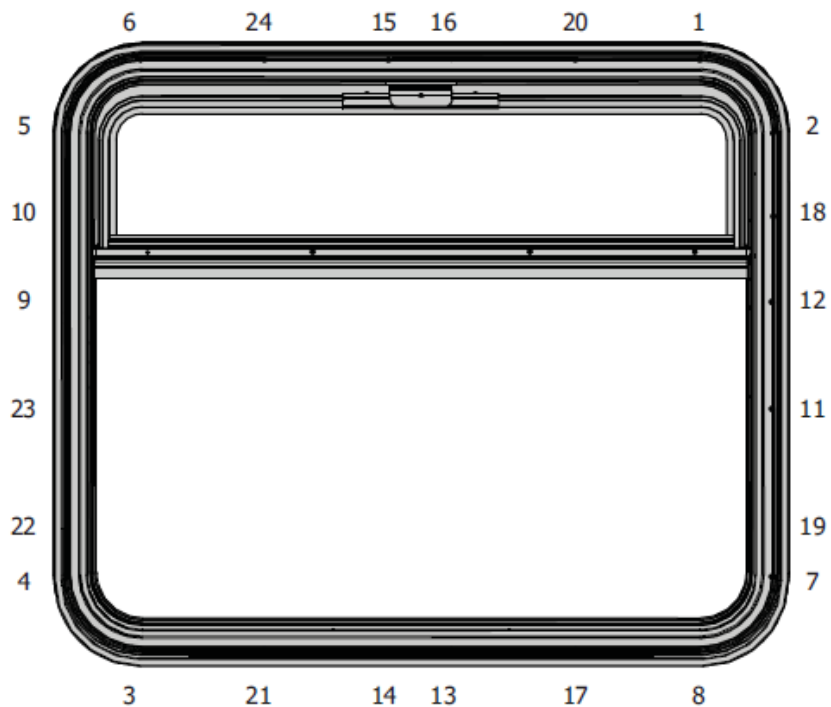


7. With the window properly positioned in the portal, using a T-20 Torx Bit and Drill Driver, install and hand tighten all Torx screws securing the side window.

IMPORTANT! Ensure the exterior window glass and frame are properly supported on the exterior of the vehicle, using suction cups, while installing all of the Torx screws.

8. Following the torque pattern shown below, **torque each of the Torx screws to 4.5Nm.**

Torque sequence for side windows



9. Verify window trim position and then reinstall the interior window trim that covers the fasteners.
10. Repeat this procedure for all side windows.