



INSTRUCTION TO SERVICE

ITS: 59173		10-Feb-2021
SECTION:	219-Engine and Transmission	
WRITTEN BY:	Mike Pearson	
SUBJECT:	Inspect and replace BAE ISG mounting bolts	
ISSUE:	Existing ISG mounting bolts may be loose due to initial incorrect torque.	
SUMMARY:	ISG mounting bolts need to be replaced and installed with correct torque	

ITS59173

THIS ITS DOCUMENT SHOULD BE RETAINED AND REFERRED TO FOR FUTURE MAINTENANCE UNTIL THE NEW FLYER PARTS AND/OR SERVICE MANUAL IS UPDATED TO REFLECT WORK DONE AS A RESULT OF THIS DOCUMENT. ENSURE THAT THIS DOCUMENT IS AVAILABLE FOR PARTS AND MAINTENANCE STAFF GOING FORWARD.

PROCEDURE:

1. Set park brake and chock wheels.
2. Turn the main battery disconnect switch to the "OFF" position and lock out.
3. If necessary, raise coach in accordance with the New Flyer Service Manual.
4. Removal of the HV cable brackets may be required, this will allow room to access the ISG mounting bolts number 10 and 5, see Figure 1 for bracket bolt locations.

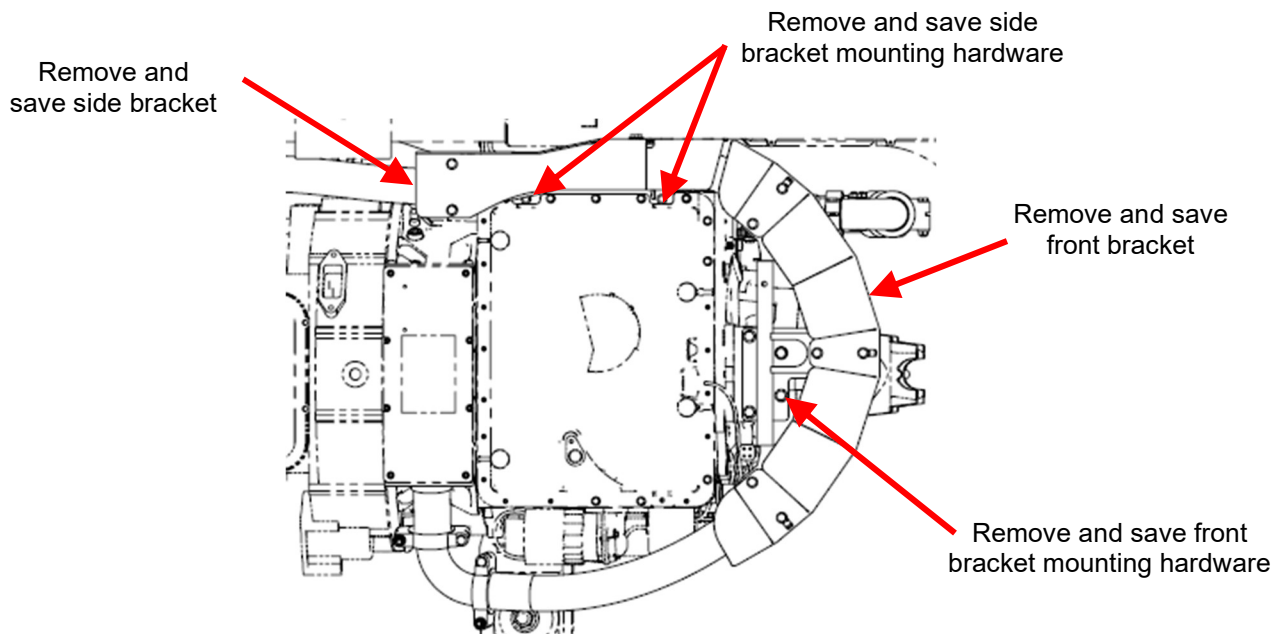


Figure 1: HV Cable Support Bracket Mounting Bolt Locations

5. Locate the BAE ISG mounting bolts as shown in Figure 2.

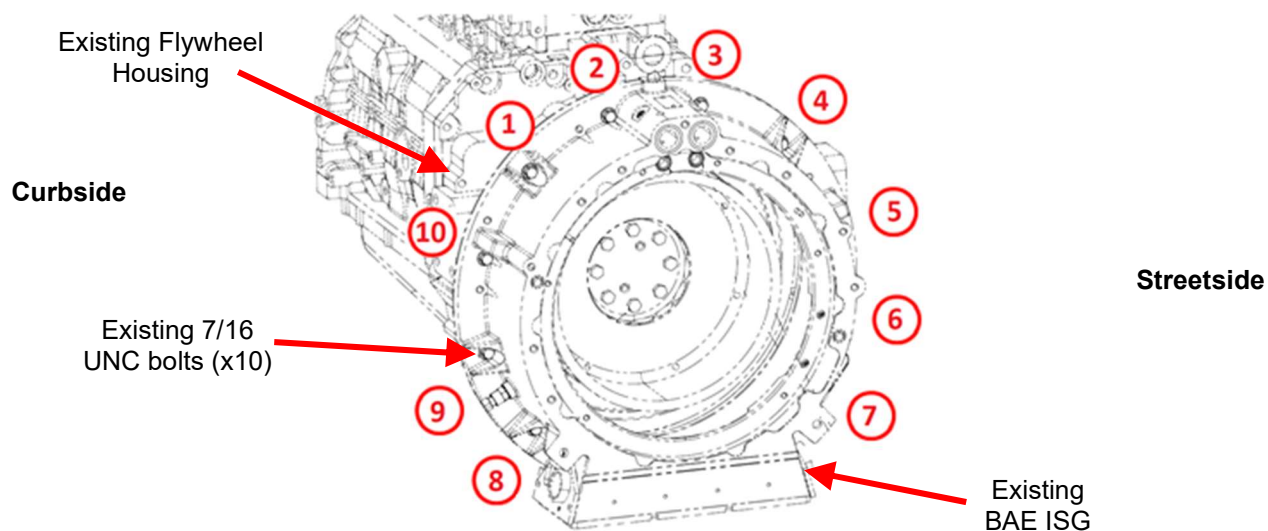


Figure 2: BAE ISG Mounting Bolt Locations

⚠ WARNING: If **ALL 10** bolts have torque stripes and **ALL 10** torque stripes are aligned, continue to the next Step. If **ANY** bolt is broken or has a missing or broken torque stripe, hold the bus from service and **contact your New Flyer RPSM for further instructions.**

6. Remove one bolt at a time in a star pattern.
7. Use a thread chaser to clean the threads in the bellhousing, then use a blow gun to spray compressed air into the hole to clean the hole of any old Loctite or sealant.
8. Apply Loctite 243, p/n 081034 to the new bolt threads p/n 10B07032 and the internal threads of the mating holes in the flywheel housing and install.
9. Torque the new bolt to 59 +/- 5.9 lb-ft. and torque seal the bolt. See Figure 3 to show how the torque seal must be applied.



Figure 3: Pictorial of Correct Bolt Torque Stripe

10. Repeat for the 9 remaining ISG mounting bolts, removing one bolt at a time in a star pattern.
11. Reinstall the side bracket if removed in Step 4, in the same location and orientation as removed and torque existing hardware to 5 to 7 ft lb.
12. Reinstall the front bracket if removed in Step 4, in the same location and orientation as removed and torque existing hardware and torque to 44 +/- 4-ft lb.
13. If necessary, lower coach in accordance with the New Flyer Service Manual.
14. Remove lock out and switch the bus on, then return the bus to service.

LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Inspect and replace BAE ISG mounting bolts	1	1.0	1.0

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	10B07032	Bolt-7/16 UNC x 2.00	10	EA	
2	081034	Loctite-243 Medium 10ml	.01	EA	
3	523940	Paint-Tamper Torque Mark, Red	.2	EA	