



# INSTRUCTION TO SERVICE

ITS: 59239		May 6, 2021
<b>SECTION:</b>	460-Windows	
<b>WRITTEN BY:</b>	Troy Stutsky	
<b>SUBJECT:</b>	Inspect SDS Window Parts & Function and Rework if Required	
<b>ISSUE:</b>	Some SDS windows with T-Handle release and gas struts were not built to print which can cause the windows not to fully latch in the closed position. Part affected is NF PN 678774.	
<b>SUMMARY:</b>	Inspect the windows for any of the conditions outlined in this document and rework the windows as required.	

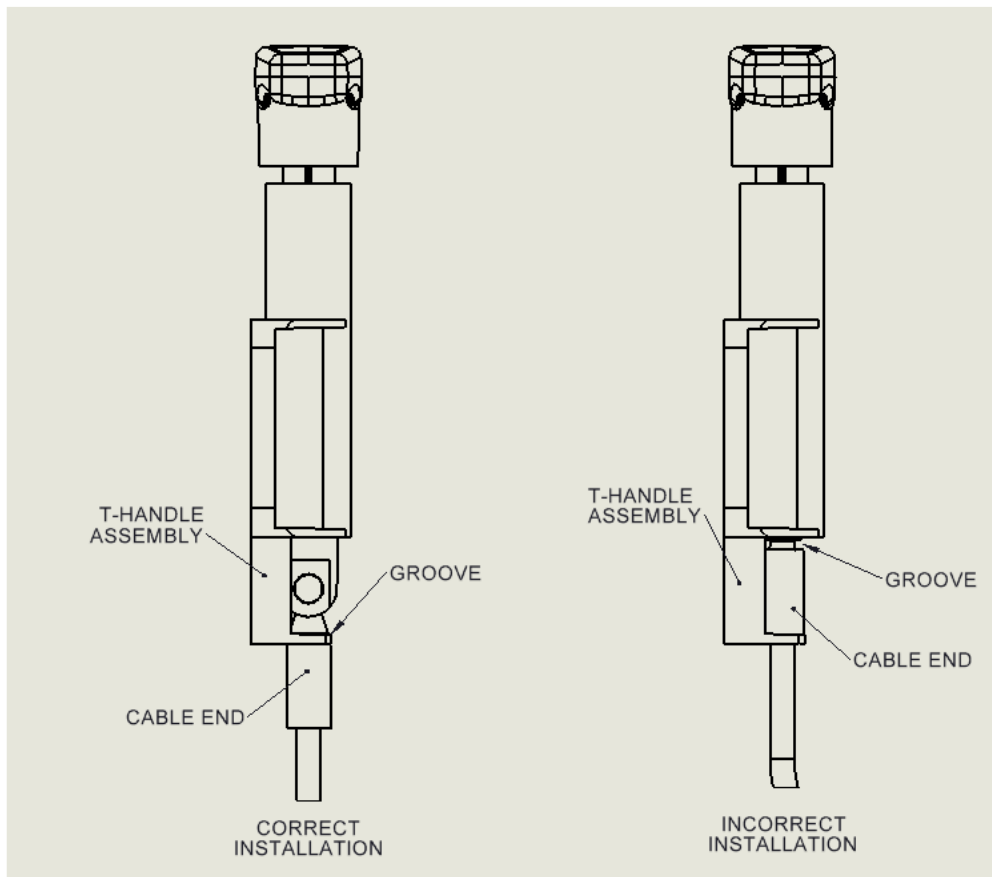
# ITS59239

Ref. NHTSA Recall No.	Ref. Transport Canada Recall No.
Not Applicable	Not Applicable

**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.**

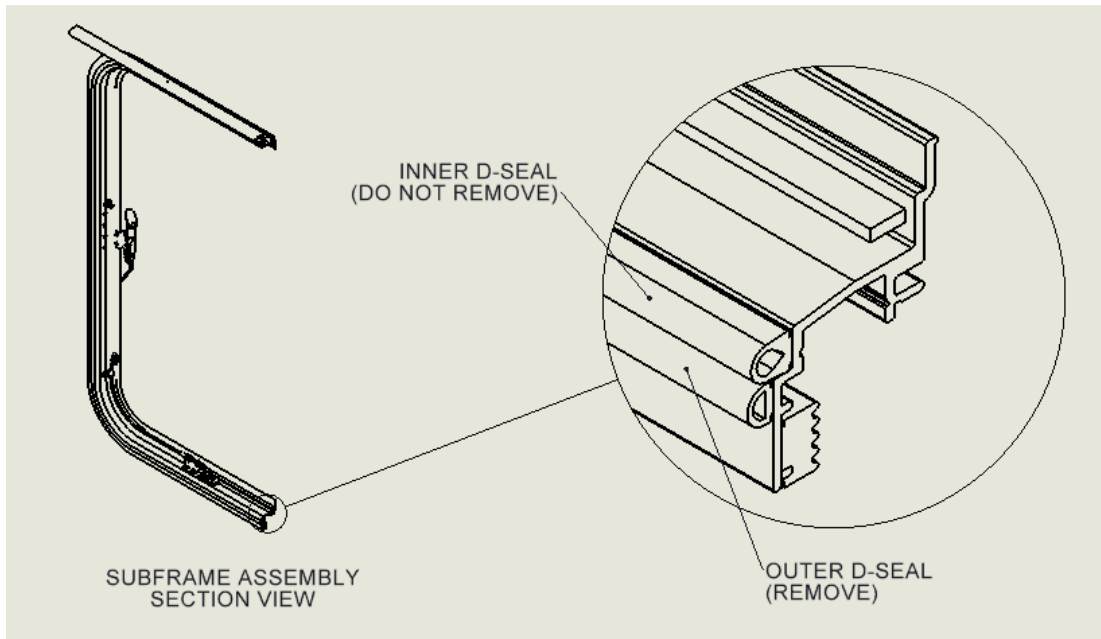
**PROCEDURE:**

1. Set park brake and chock wheels.
2. Turn the main battery disconnect switch to the “OFF” position.
3. From the inside of the bus, open the window located behind the SDS box by lifting the T-Handle to release the latches and lifting the window up from the outside of the bus.
4. From the outside of the bus, inspect the T-Handle assembly to make sure the T-Handle cable is installed in the correct location. The cable must be captured via the groove in the cable end. The cable cannot be fully captured within the T-Handle assembly. If the cable is captured fully in the T-Handle assembly this can be corrected by removing the cable from the T-Handle assembly and reassembling via the groove in the cable end. See Figure 1.



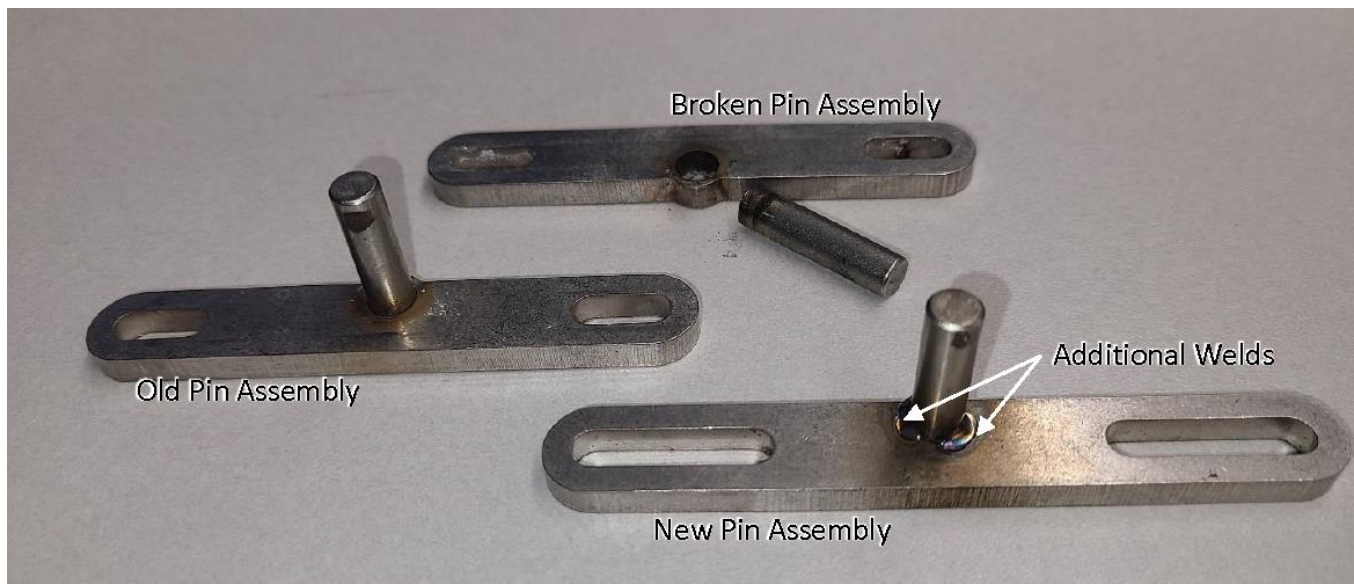
**Figure 1: T-Handle Cable Inspection and Repair**

5. Inspect the rubber seals on the subframe of the SDS window. If the window has two side-by-side D-seals on the subframe of the window, the outer D-seal must be removed. This D-seal has been found to restrict the window from being able to fully latch in the locked position. There is a detailed instruction on how to remove this D-seal in active ITS-59216 that can be obtained from your local New Flyer Service Representative. See Figure 2 for outer D-seal location reference.



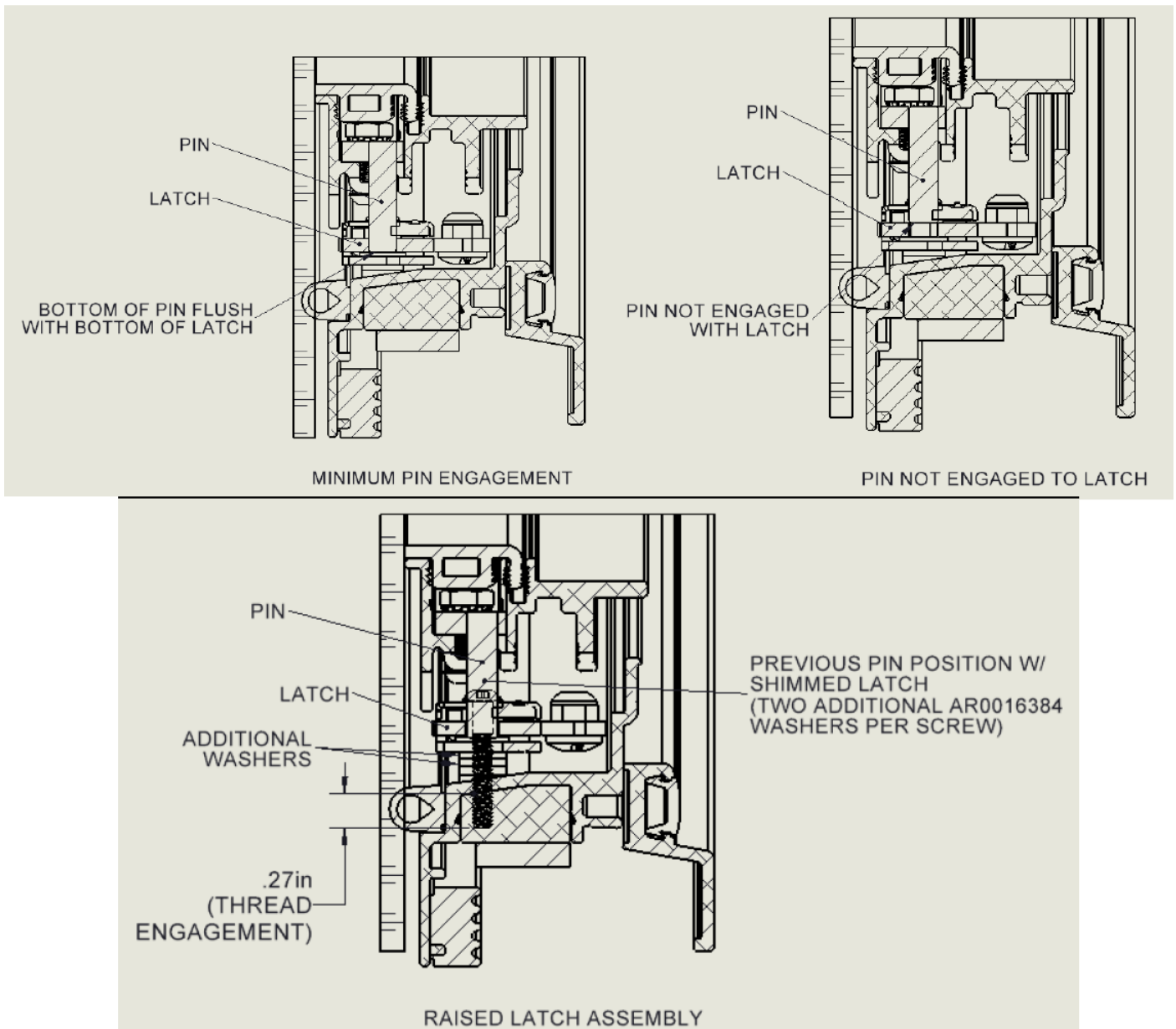
**Figure 2: Removal of Outer D-seal if Required**

6. Inspect the two latch striker pin assemblies located on the main frame of the window. If the pin assemblies do not have the double welds in the location where the pin joins to the pin bracket, the existing pin assemblies will need to be replaced with new pin assemblies (NF PN 6477370) and new hardware, screws (NF PN 6474082), nuts (NF PN 6487878). See Figure 3 for old pin assembly vs new pin assembly for inspection reference. There is a detailed instruction on how to remove and replace the latch striker pin assemblies in active ITS-59216 that can be obtained from your local New Flyer Service Representative. The new pin assemblies and hardware to secure them will be provided under ITS-59216.



**Figure 3: Old Latch Striker Pin & New Latch Striker Pin Comparison**

7. Place the SDS window gently in the lowered position with out closing it. Inspect the vertical latch strike pin engagement within the rotary latch on both latches. Ensure that the bottom of the latch pins rest flush or slightly below the bottom of the rotary latch. Windows with inadequate pin engagement must have the rotary latch assembly shimmed with additional washers (NF PN 6488222) to achieve proper engagement. To maintain proper latch mounting screw engagement, no more than two additional washers (0.125" height) are to be added to the two that are existing per screw. It is acceptable to have a maximum total of four washers stacked on top of each other per latch screw to maintain proper screw engagement with the subframe. See Figure 4.



**Figure 4: Inspect and Shim Latches if Required**

8. If the latch striker pins engage the latches at the proper depth as outlined in step 7, no additional washers are required however, the latch mounting hardware should be removed, 1-2 drops of Loctite 243 (NF PN 081034) added to the threads of the hardware and the hardware should be retightened, hand-tight, using a hand tool only.

**NOTE: Take important care to not get any Loctite in the latch pawl mechanism as this will affect the performance of the latch and could cause the latch to not operate as intended.**

9. Test the window to make sure it closes and opens properly. On this SDS window, due to the gas struts on it, additional force is required to fully close the window vs the regular egress windows on the bus. With the SDS window open 30-45 degrees, shove the window firmly to “slam” the window into the fully closed position. This action will provide the force required to fully engage the latch strike pins into the latches and lock them in the closed position. To verify the window will open as intended, from inside the bus, lift the T-Handle to open the latches. From the outside of the bus, lift the window to the open position.

**NOTE: While performing the steps in this instruction, check that the latch strike pin assemblies are not bent or broken, rotary latches are fully functional, strike pins are aligned to properly engage the latches and there are no loose locator blocks. New latch strike pin assemblies (NF PN 6477370) and hardware, screws (NF PN 6474082), nuts (NF PN 6487878) will be provided with ITS-59216 and labor to replace them is also included in ITS-59216. New rotary latches (NF PN 6473655) and hardware, screws (NF PN 6475263), washers (NF PN 6488222) will be provided if required.**

10. Clean up all tools and debris and return the bus to service condition.

11. Turn the main battery disconnect switch to the “OFF” position.



<b>LABOUR ESTIMATE</b>				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Inspect T-Handle, D-Seal, Strike Pins, Latch Engagement	1	0.25	0.25
2	Rework T-Handle Cable (If Required)	1	0.25	0.25
3	Add Shims Under Rotary Latches (If Required)	1	0.25	0.25
4	Add Loctite to Rotary Latch Hardware	1	0.25	0.25
5	Replace Damaged Rotary Latch (If Required)	1	0.25	0.25

<b>PARTS REQUIRED</b>					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	6477370	LATCH PIN ASSEMBLY	2	EA	Supplied in ITS-59216
2	6474082	10-24 X 3/4" LG BHCS, BL. OX., W/NYLON PATCH	4	EA	Supplied in ITS-59216
3	6487878	NUT, 10 - 24, AG SDS WINDOW PIN STRIKER	4	EA	Supplied in ITS-59216
4	6488222	FLAT WASHER (.188" ID x .375" OD x .065" THK)	4	EA	If Required
5	081034	LOCTITE-243 MEDIUM 10ML	0.01	EA	Source Locally
6	6473655	ROTARY LATCH	2	EA	If Required
7	6475263	SCREW, #8-32 X 1.00 PH SST BLACK	4	EA	If Required