



INSTRUCTION TO SERVICE

ITS61089		07/11/2024
SECTION:	400-Structures	
SUBJECT:	Inspect to see if there is a missing weld inside the PEM mounts (4 mounts)	
ISSUE:	Quality Alert was sent out to plant (Winnipeg), to review for an incomplete weld around PEM motor mtg bracket.	
SUMMARY:	Inspect inside of all 4 mounts to check for incomplete welds.	

ITS61089

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.

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

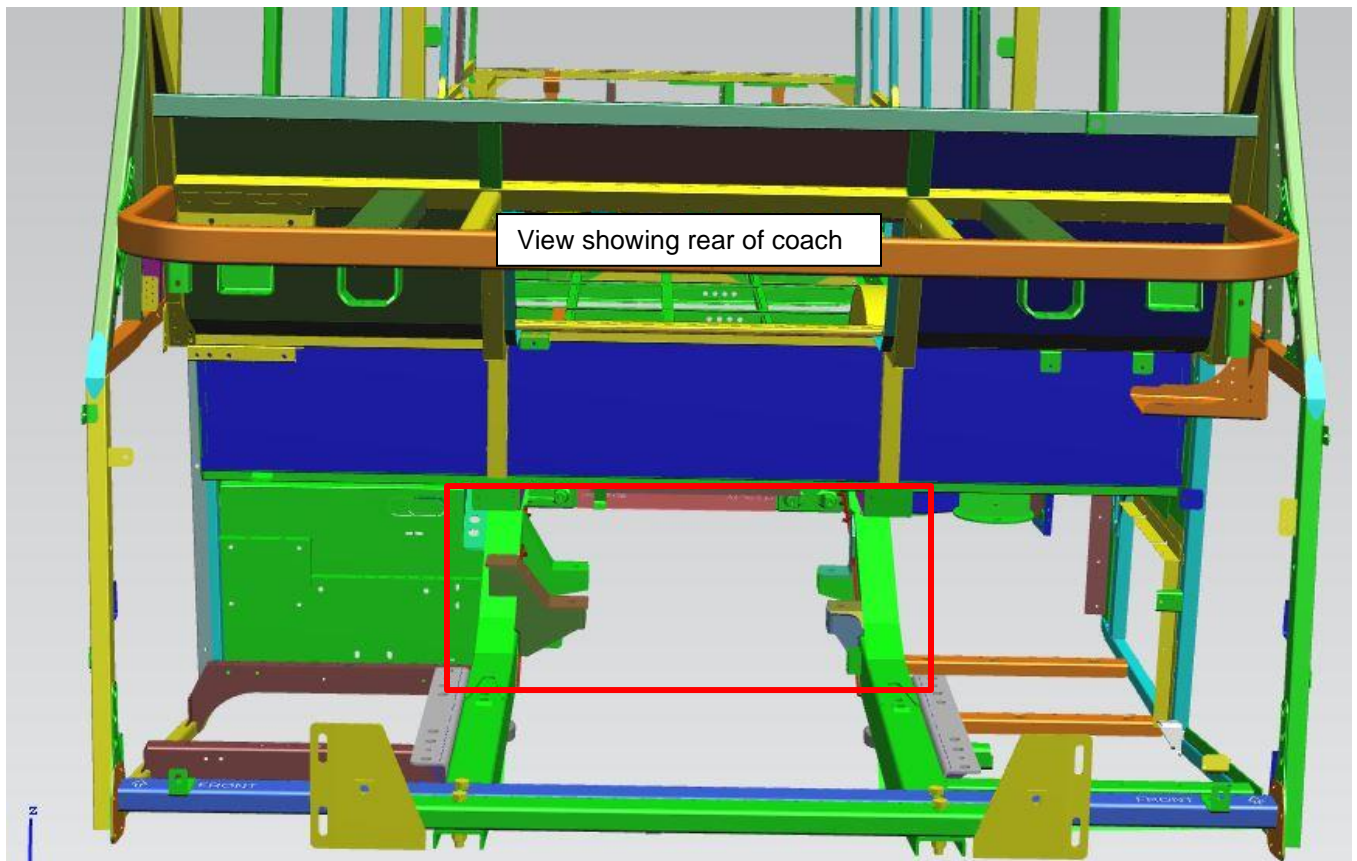
PROCEDURE:

1. Set Park brake and chock wheels.
2. Turn the main battery disconnect switch to the "OFF" position.
3. Raise coach in accordance with the New Flyer Service Manual.

NOTE: Only trained personnel can operate lifts. Follow safety instructions written on the lift and NF Service manual.

4. Once bus is raised, install 4 or 6 (if bus is a 60' articulated) stands below jacking pads on the underbody.
5. On the bottom of the chassis on the rear coach, locate the 4 PEM motor mount brackets. See Figure 1 below.

Shown view with structure only – no exterior panels



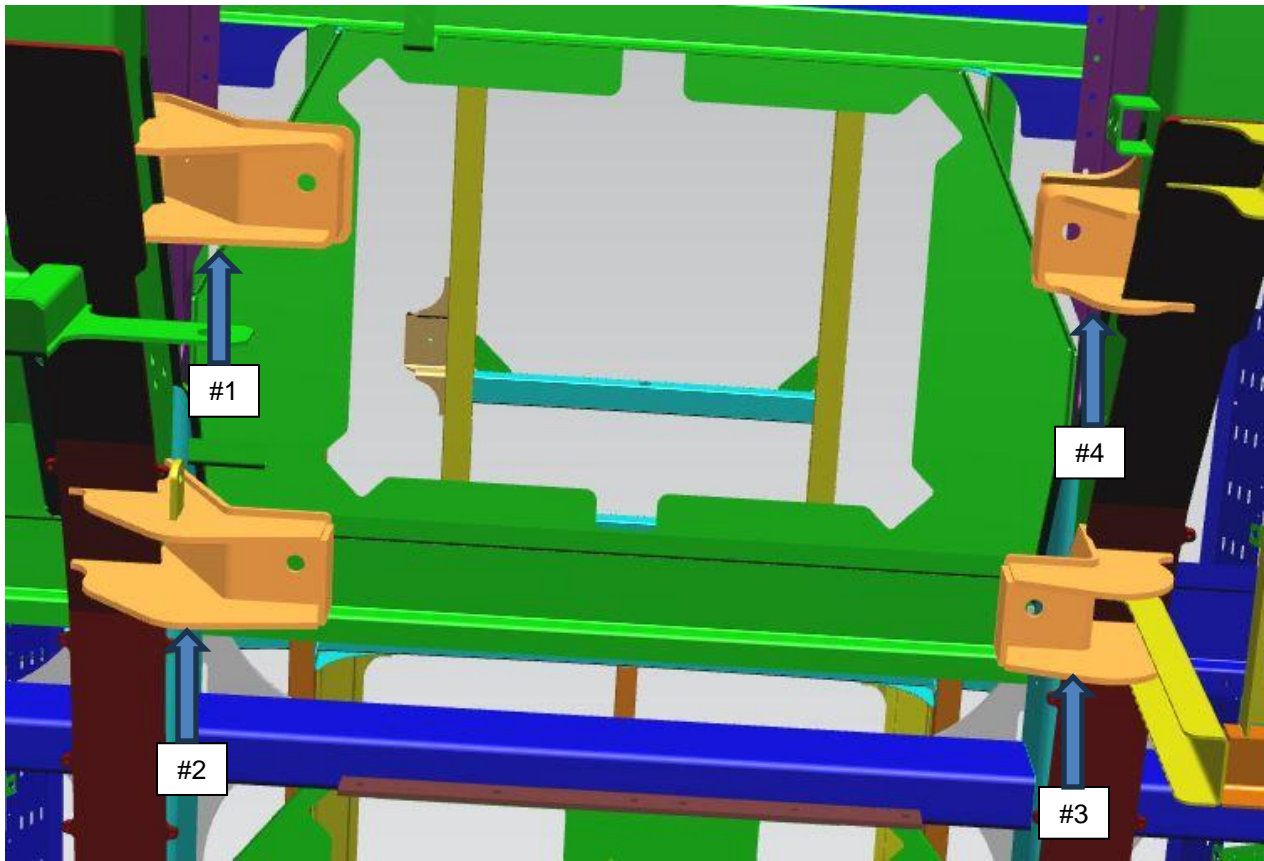


FIGURE 1: SHOWN AREA TO BE INSPECTED ON REAR CHASSIS (FROM UNDER THE BUS)

6. Inspect to see if weld is incomplete as shown below (Figure 2). Welds should be complete as shown in Figure 3.

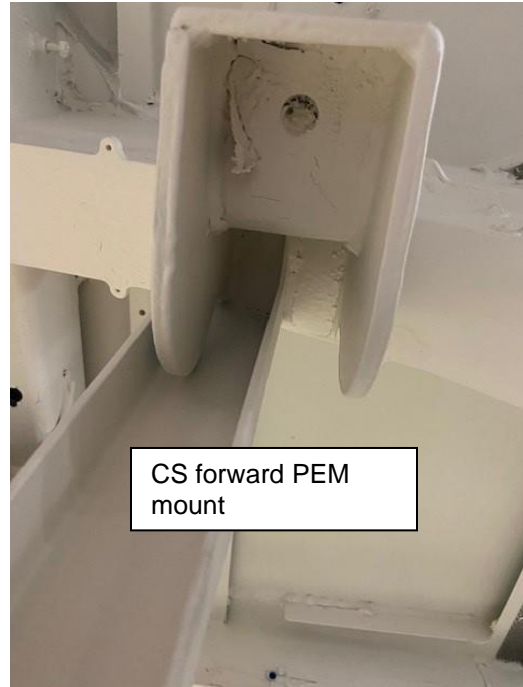


FIGURE 2: SHOWN VIEW OF MISSING WELD – INSPECT TO SEE IF ALL WELDS COMPLETE (MISSING WELD NEAR END)

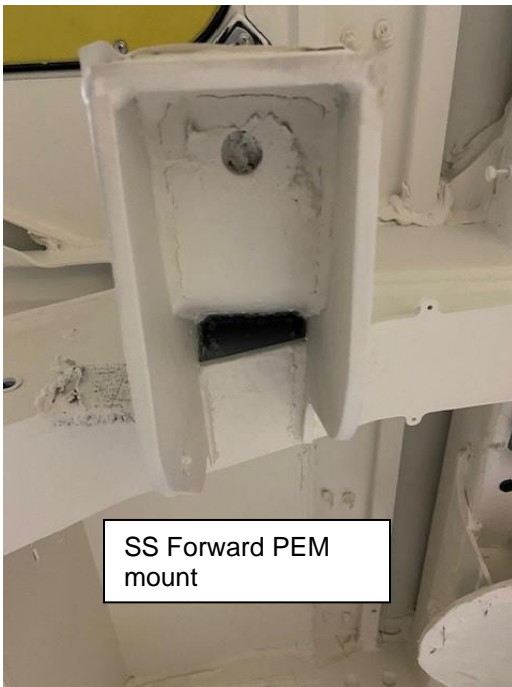
CS rear PEM mount



CS forward PEM mount



SS Forward PEM mount



SS Rear PEM mount



FIGURE 3: SHOWN VIEW WITH ALL WELDS COMPLETE - REFERENCE



7. Complete Appendix A inspection sheet.
8. Remove all tools and debris from work area to return coach to service.
9. Remove jack stand and lower the bus as per the service manual.

☞ NOTE: Only trained personnel can operate lifts. Follow safety instructions written on the lift and NF Service manual.

10. Turn the main battery disconnect switch to the "ON" position.

APPENDIX A:
INSPECTION DOCUMENT



LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Inspect 4 mounts for any incomplete welds.	1	1	1

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
		No parts required			