



INSTRUCTION TO SERVICE

ITS61127		08/16/2024
SECTION:	260 Battery Compartment	
SUBJECT:	Rework end fairings to add support brackets (both curbside and streetside).	
ISSUE:	XHE side screen end fairings do not have sufficient outboard support.	
SUMMARY:	Rework end fairings to add support brackets.	

ITS61127

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. **⚠ WARNING:** Please follow all New Flyer safety procedures, as shown in the New Flyer Service Manual, when working on the roof of the bus and when working on or around high voltage cables. Please follow all local service facility's safety procedures when working on the roof of the bus and when working on or around high voltage cables.
3. Turn the main battery disconnect switch to the "OFF" position.
4. On the roof top of the bus, remove the rear fairings (PN: 1048248 & 1048237) from the bus. See Figure 1.

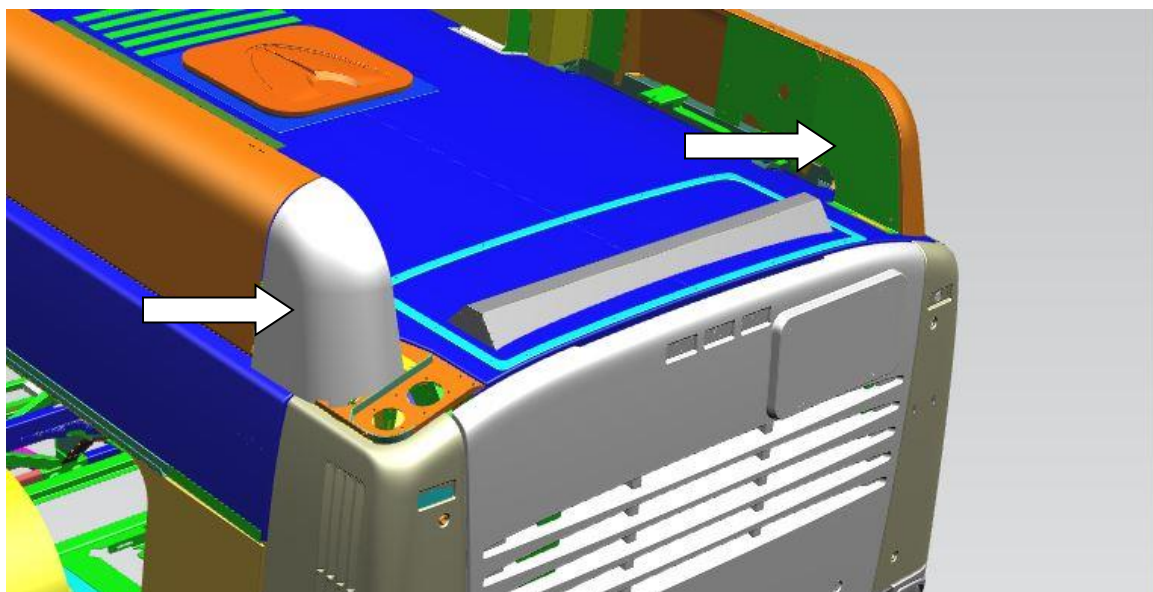
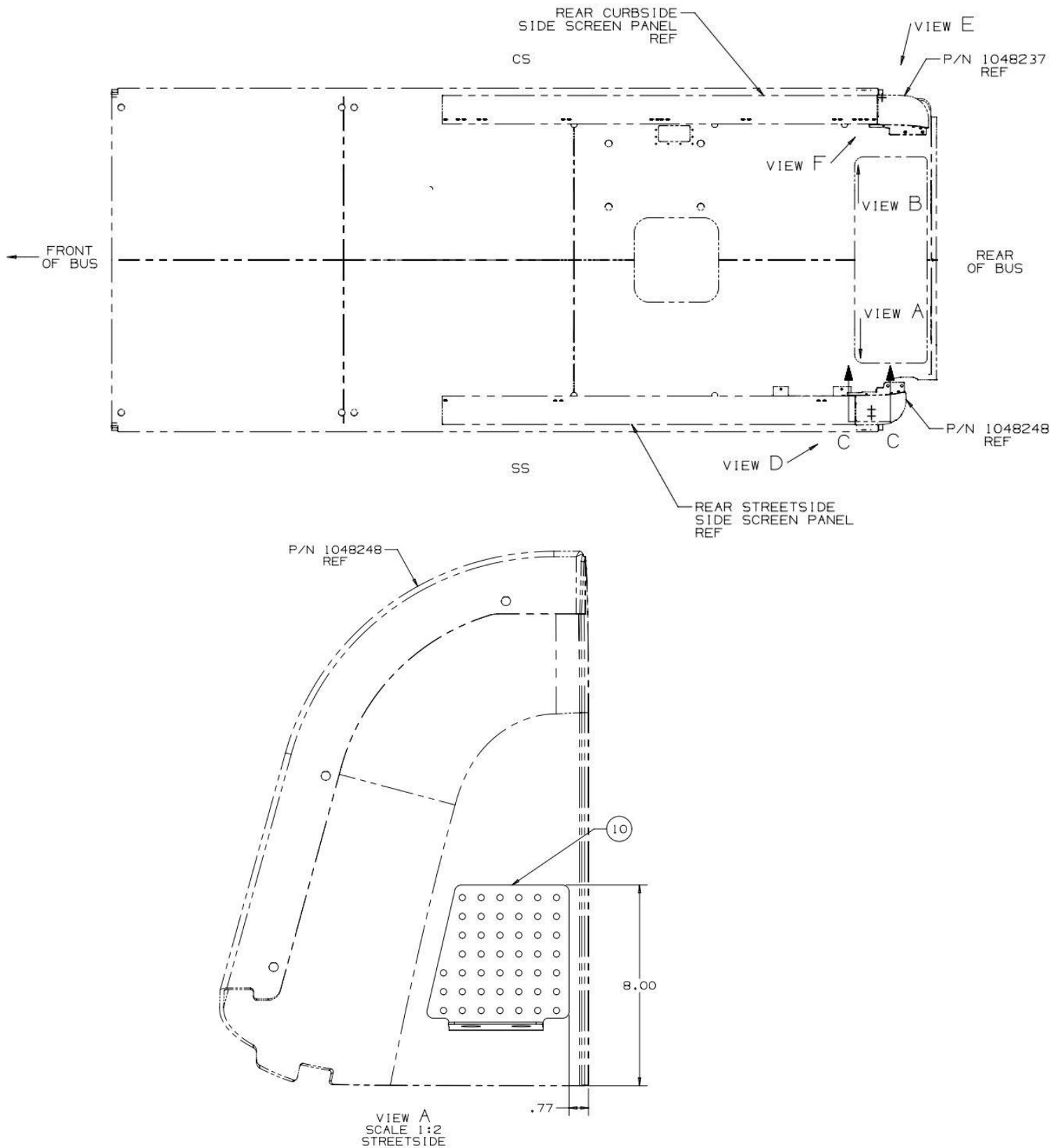
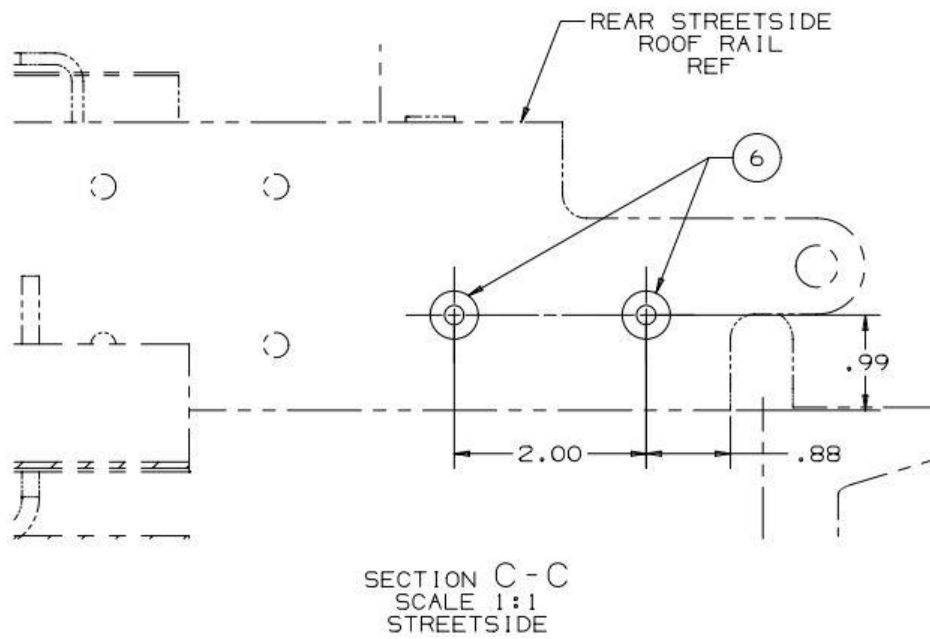
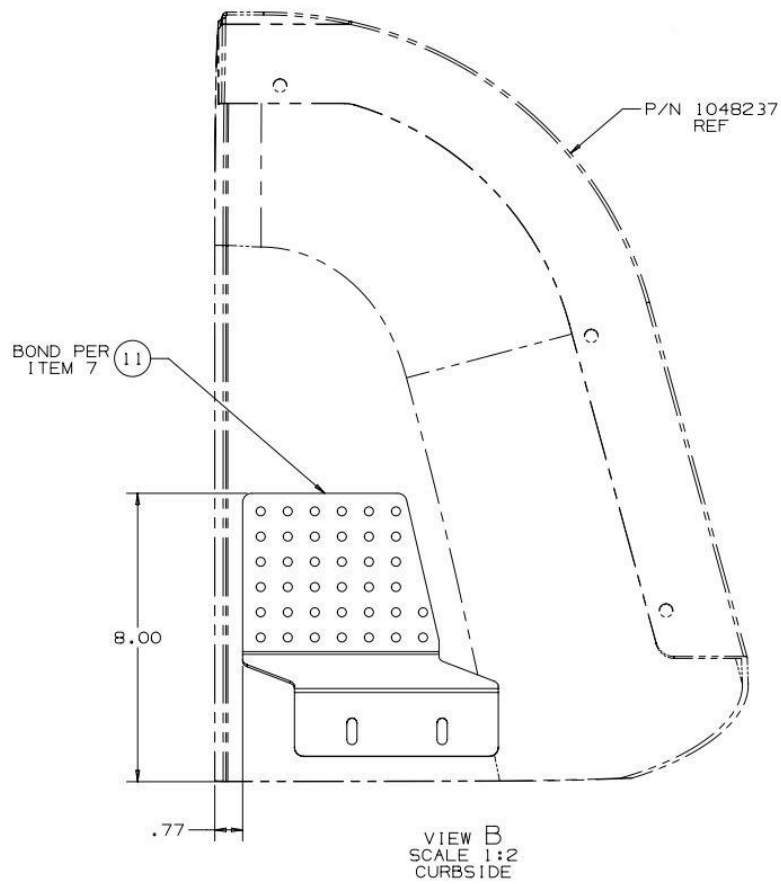
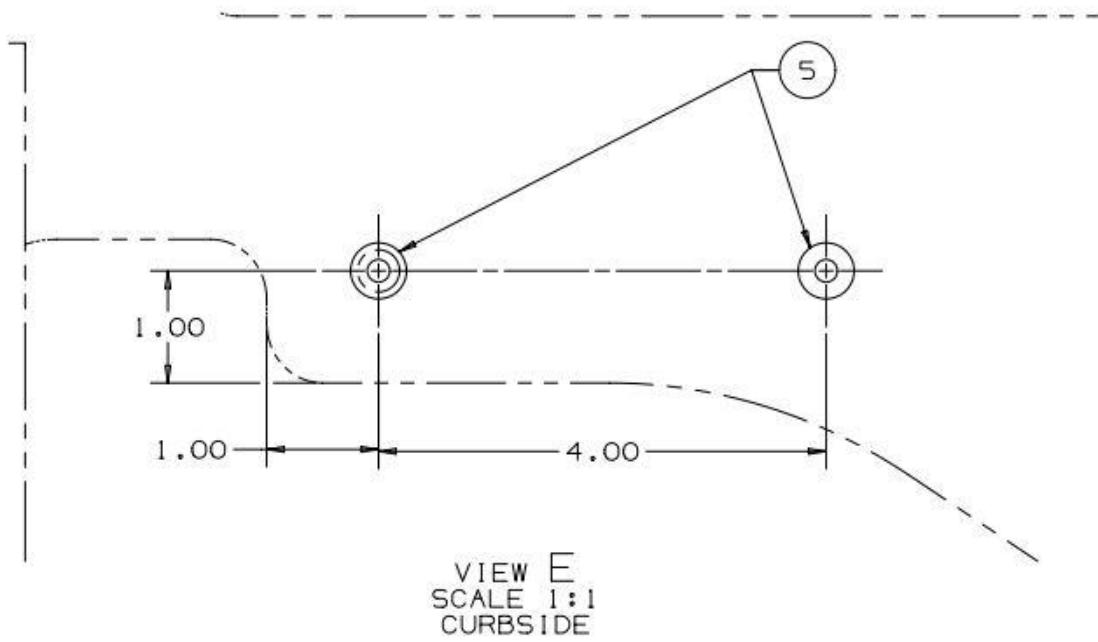


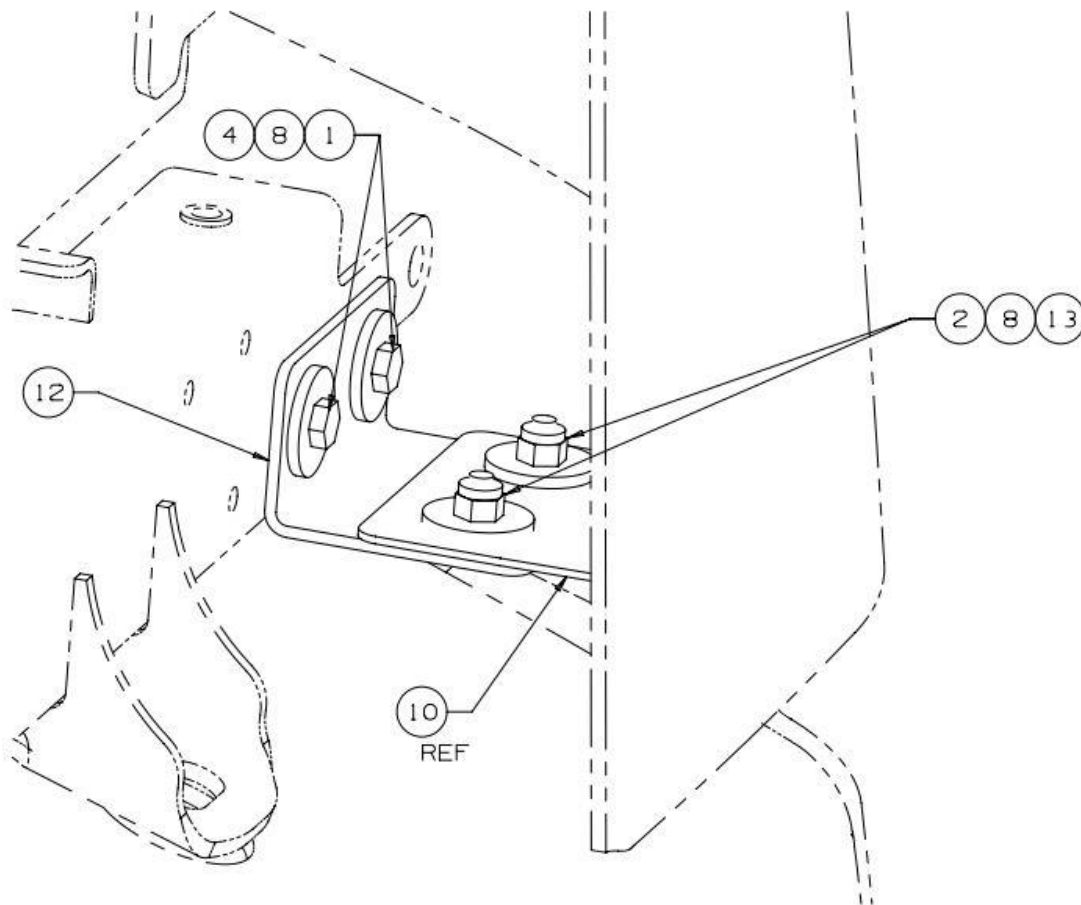
FIGURE 1: REMOVE THE ENTIRE CLOSEOUT AND CAP ON BOTH SIDES

5. Bond Item 10 – PN: 1047445 (S/S) and Item 11 – PN: 1048068 (C/S) bond to the fairings as per the Plexus procedure (Appendix A) as per the dimensions shown in view A & B. For steps 5 - 9, see Figure 2 - 4.









VIEW D
SCALE 1:1
STREETSIDE

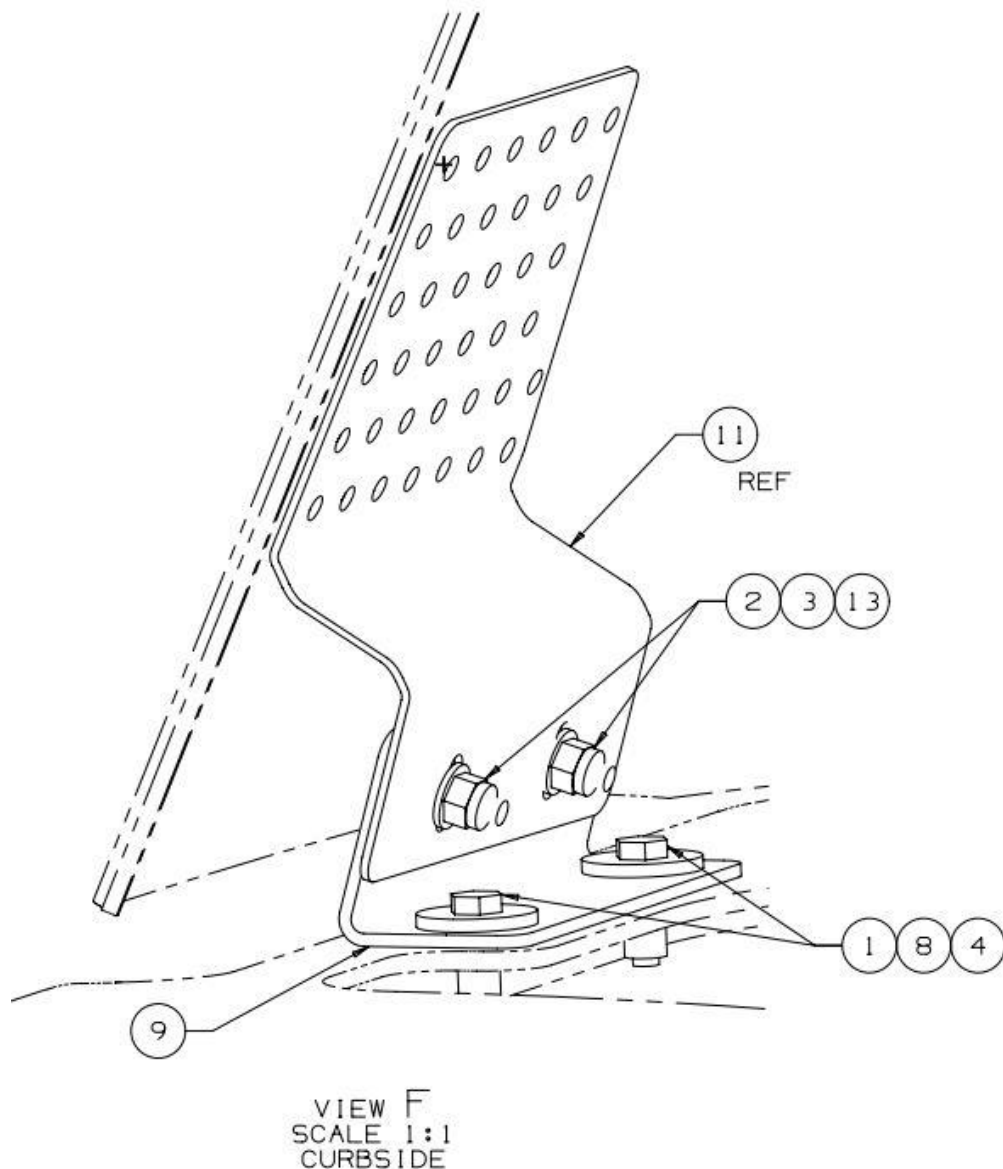
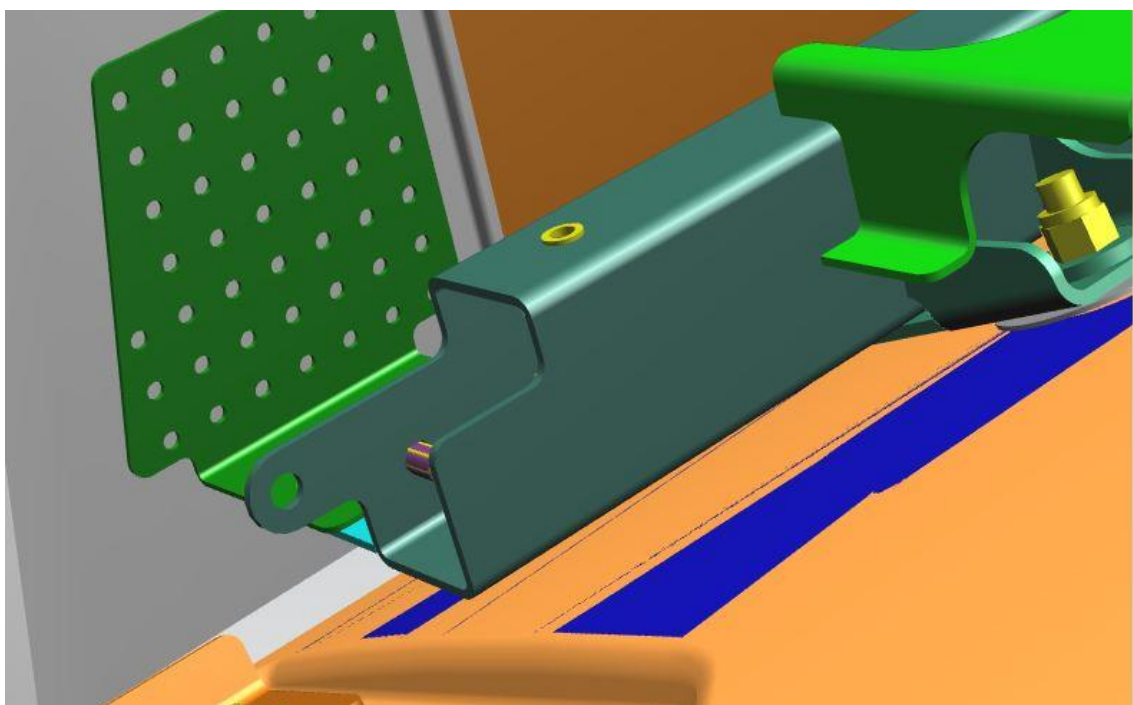
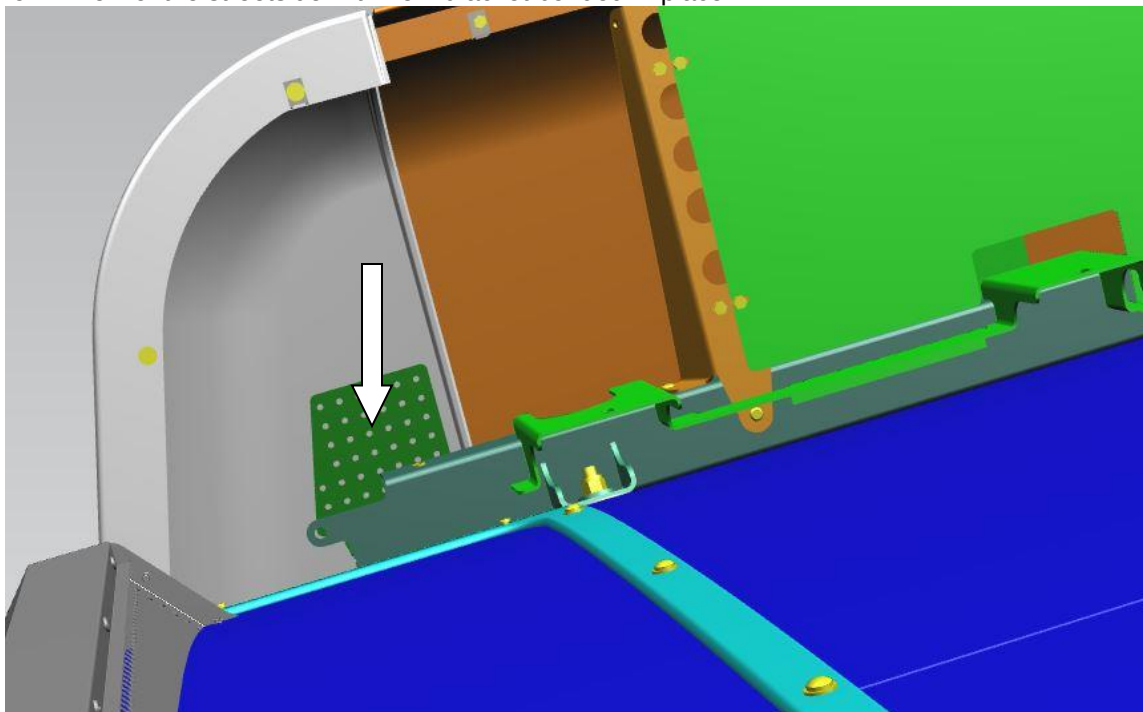


FIGURE 2: SHOWN REWORK APPLICATION OF THE END CLOSEOUTS

6. If the rear curbside roof rail doesn't already have inserts installed in the location shown in section C-C, drill 25/64" diameter holes at the dimensions shown in section C-C. Drill 25/64" diameter holes at the dimensions shown in section C-C. Install insert – ¼ - 20 UNC SST (PN: 614488).
7. Mount assy – XHE Rear SS Fairing Mount, lower (PN: 1048399) – Item 12 to the inserts in the roof rail. Open the rear streetside screen panel (if not already opened), re-install the end fairing with the added bracket.
8. Drill 25/64" diameter holes at the dimensions shown in view E and install Item 5 (PN: 514877).
9. Mount item 9 (PN: 1046158) to the inserts in the roof panel. Open the rear curbside screen panel (if not already opened), re-install the end fairing with the added bracket.

Shown View of the streetside with new bracket bonded in place.



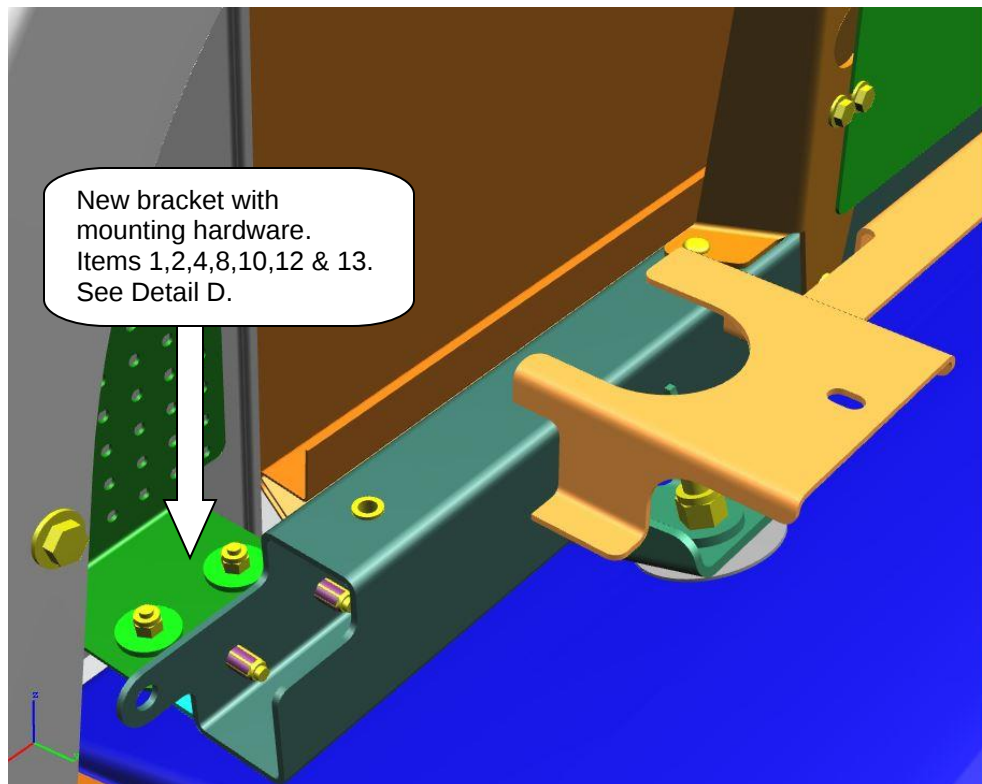
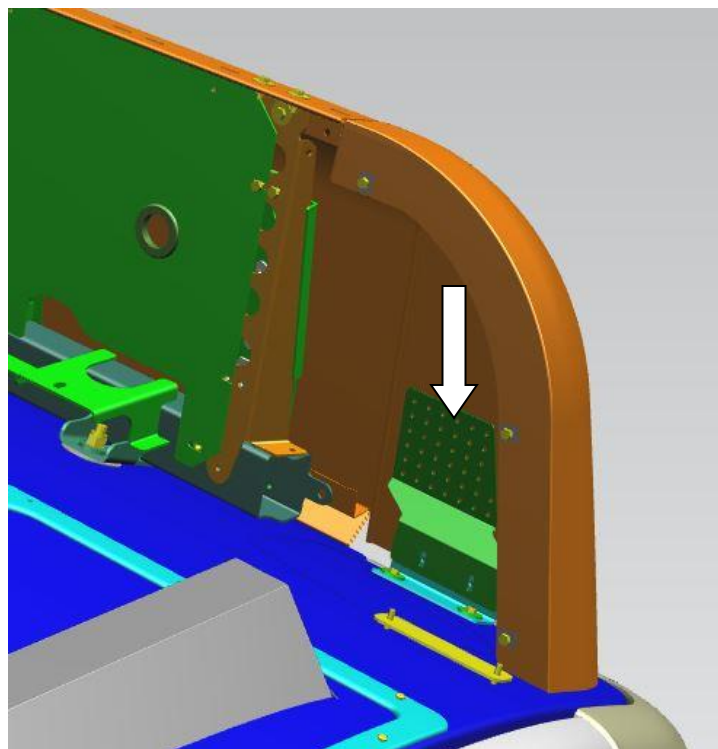


FIGURE 3: REWORK TO ADD SUPPORT BRACKET ON S/S REAR CLOSEOUT PANEL.



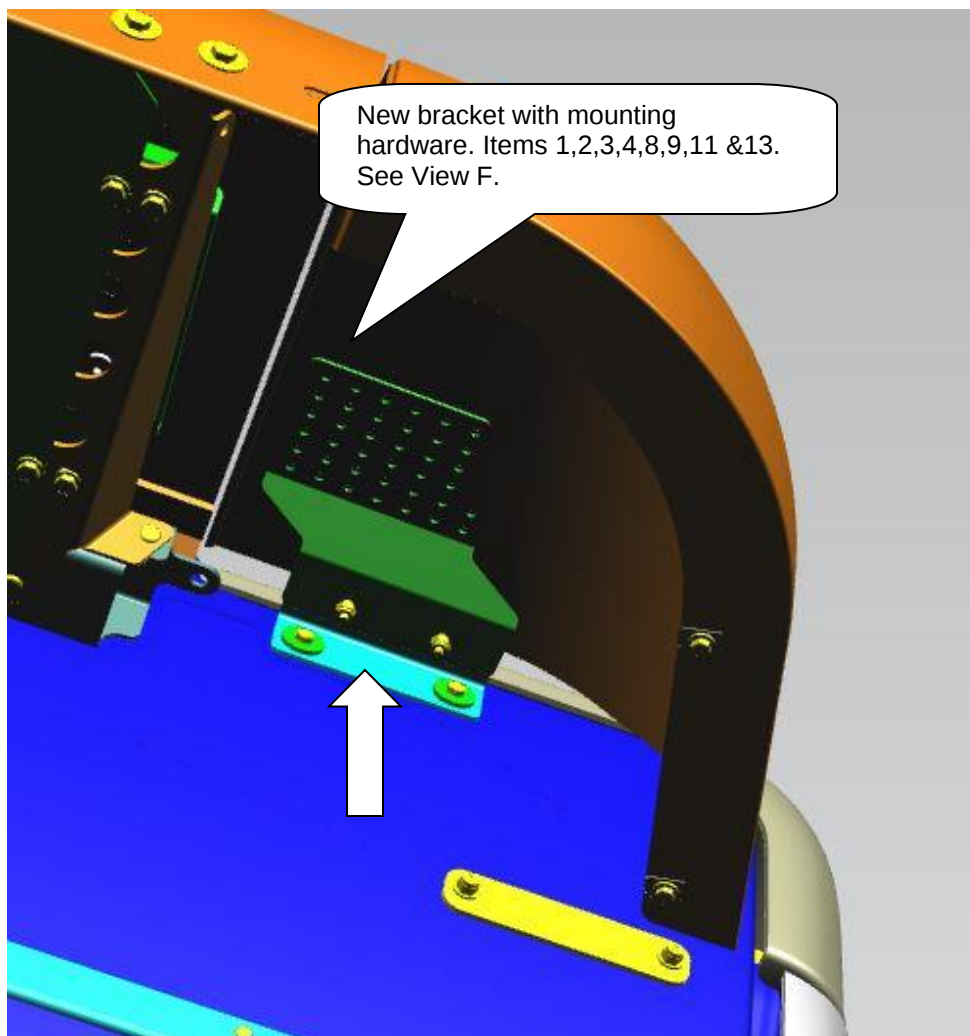


FIGURE 4: REWORK TO ADD SUPPORT BRACKET ON C/S REAR CLOSEOUT PANEL.

10. Remove all tools and debris from work area to return coach to service.
11. Turn the main battery disconnect switch to the "ON" position.

Appendix A

Plexus Application

Plexus Application Procedure

1. Wipe down all contact surfaces with clean lint free cloth, ensure that surface area is free of grease and debris.
2. Apply Plexus PC120 Primer along all surfaces which are to be bonded using clean cloth. Let flash off until completely dry.
3. Apply Plexus MA920 Adhesive to indicated surface. Dispense adhesive length of mix nozzle when using a new nozzle before applying to primed surface.
4. Place bonding surfaces together, pressing bonding surfaces firmly together and apply clamps.
5. Remove any excess squeezed-out adhesive and allow drying for 20 minutes before removing clamps.

**** SAFETY:**

Applicator shall use rubber gloves and approved respirator when using Plexus Primer and Adhesive.

LABOUR ESTIMATE

	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Rework end fairings to add support brackets (both curbside and streetside).	1	2.5	2.5

PARTS REQUIRED

Item	Part Number	Description	Qty. per Coach	Units	Notes
1	20B04016	BOLT HX SS 1/4X1.00	4	EA	
2	42N04000	NUT-NYLON LOCK 1/4-20 UNC SST	4	EA	
3	50W04000	WASHER-FLAT 1/4 NOM	2	EA	
4	081034	LOCTITE-243 MEDIUM 10ML	0.01	EA	
5	514877	INSERT-1/4-20 UNC SST	2	EA	
6	522558	INSERT-1/4-20 UNC SST	2	EA	
7	067197	ADHESIVE – PLEXUS MA920	1	EA	Order 1 for entire SR
8	614488	WASHER-SPL 1/4X1.125X.12 SST	6	EA	
9	1046158	ASSY-XHE REAR CS FAIRING MOUNT, LOWER	1	EA	
10	1047445	BRACKET-XHE REAR SS FAIRING MOUNT, UPPER	1	EA	
11	1048068	BRACKET-XHE REAR CS FAIRING MOUNT, UPPER	1	EA	
12	1048399	ASSY-XHE REAR SS FAIRING MOUNT, LOWER	1	EA	
13	5928660	NEVER SEIZE	0.01	EA	
14	067196	PRIMER-PLEXUS PC120	1	EA	Order 1 for entire SR
15	6472958	PLEXUS MANUAL APPLICATOR GUN FOR 490 ML	1	EA	Order 1 for entire SR
16	6470588	MIXING NOZZLES	1	EA	