



PROTERRA



TECHNICAL SERVICE BULLETIN

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| ISSUE DATE: | 1-11-2022 |
| SERVICE BULLETIN SUBJECT: | 40 Foot Duopower Ride Height Manifold Bracket Retrofit |
| VINs or MODELS AFFECTED: | Service Specified Buses |
| COMPLETE BY: | Next Service Opportunity |
| SERVICE BULLETIN #: | SC-22-4 |
| Labor Operation Code: | N/A |

NOTICE! It is expected that this process will require one (1) hour per bus. Please schedule appropriately to minimize vehicle downtime.

40 FOOT DUPOWER RIDE HEIGHT MANIFOLD BRACKET RETROFIT

Retrofit Description:

This procedure describes the process of replacing the rear Ride Height Manifold Bracket with a more robust version.

Tools/Parts Required

Tools and Supplies Required:

- Wheel Lifts (4 Each)
- Jack Stands (4 Each)
- Ratchet
- Calibrated Torque Wrench
- 10mm Socket
- Orange Torque Stripe Paint

Parts Required and Included in the kit:

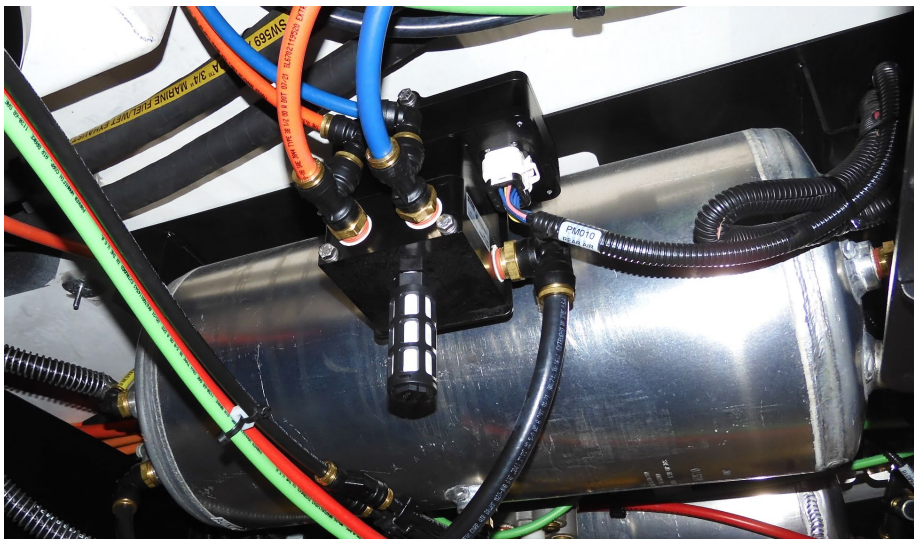
- 059309 KIT, AIR TANK MANIFOLD BRACKET DUOPOWER (Consisting of)
 - 127-6737 BRACKET, AIR, RIDE HEIGHT 1 EA
 - 017029-029 BOLT, HEX, M6-1.0x110x18 3 EA
 - 016921 WASHER, SPRING LOCK, SS, M6 3 EA
 - 016876 WASHER, FLAT, SS, M6 3 EA
 - 019276-003 BOLT, HEX, M6-1.0X16X16 4 EA

Procedure

1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using four (4) Wheel Lifts, raise the bus into the air. Using four (4) Jack Stands, support the bus for safety.

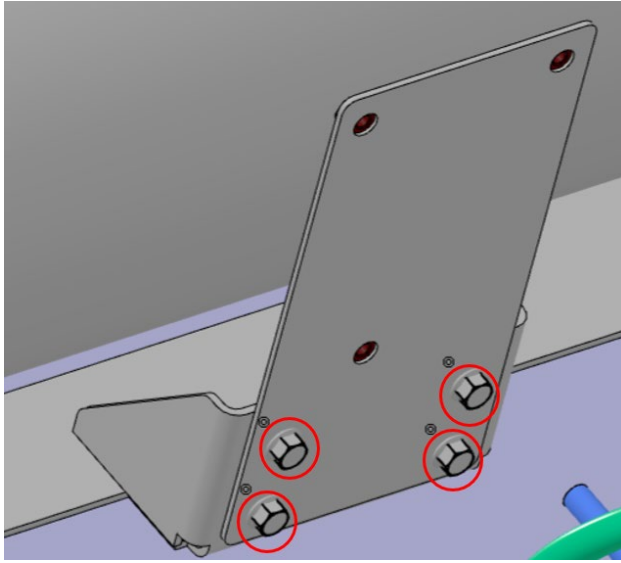


3. Working underneath the bus, locate the Ride Height Manifold shown in the following photograph. This is located on the rear curbside of the bus near the air tank assembly.

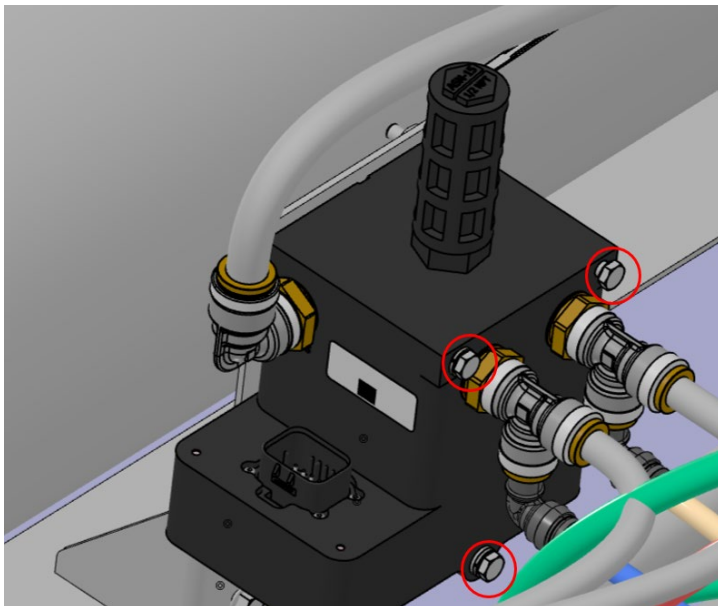


4. Using a 10mm Ratchet/Socket, remove the three M6 Bolts that secure the Manifold to the Mounting Bracket.
5. Remove the Manifold from the Mounting Bracket and allow it to hang on the hoses. Be careful not to damage the hoses or the wiring harness.

- Using a 10mm Ratchet/Socket, remove the four (4) M6 Bolts that secure the original Ride Height Manifold Mounting Bracket to the Rear Air Tank Bracket. The Bolts are shown circled in red below. Discard these Bolts. They will not be reused.



- Using a 10mm Ratchet/Socket, install the new Ride Height Manifold Bracket (127-6737) in place of the old one using four (4) new M6 Bolts (019276-003) from the kit.
- Using a Calibrated Torque Wrench with a 10mm Socket, **torque the M6 Bolts (019276-003) to 89 inch-pounds.**
- Using Orange Torque Stripe Paint, mark the properly torqued fasteners.
- Place the Ride Hide Manifold onto the new Bracket (127-6737).
- Using a 10mm Ratchet/Socket, install the Manifold onto the Bracket (127-6737) using M6 Bolts (017029-029), Spring Washers (016921), and Flat Washers (016876).



12. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the M6 Bolts (019276-003) to 53 inch-pounds.**
13. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.
14. Remove the Jack Stands.
15. Safely lower the bus using the Wheel Lifts.
16. Remove the Lockout/Tagout devices and power ON the bus.
17. Return the bus to service after ensuring that no air leaks are present.