



PROTERRA



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	1-4-2022
SERVICE BULLETIN SUBJECT:	Steering Gearbox Valve Housing Torque Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-22-1
Labor Operation Code:	SC51Z

NOTICE! It is expected that this process will require two (2) hour per bus. Please schedule appropriately to minimize vehicle downtime.

STEERING GEARBOX VALVE HOUSING TORQUE RETROFIT

Retrofit Description:

This procedure describes the process of verifying that the Steering Gearbox Housing bolts are properly torqued.



Tools/Parts Required

Tools and Supplies Required:

- Wheel Lifts (Four Required)
- Heavy Duty Jack Stand (Four Required)
- Calibrated Torque Wrench
- Ratchet
- E18 External Torx Socket
- Orange Torque Stripe Paint

Parts Required:

- None

Procedure:

1. Perform the Proterra approved Lockout/Tagout process to make the bus safe for work.
2. Using four Wheel Lifts, raise the bus into the air. Using four Jack Stands, support the bus for safety.

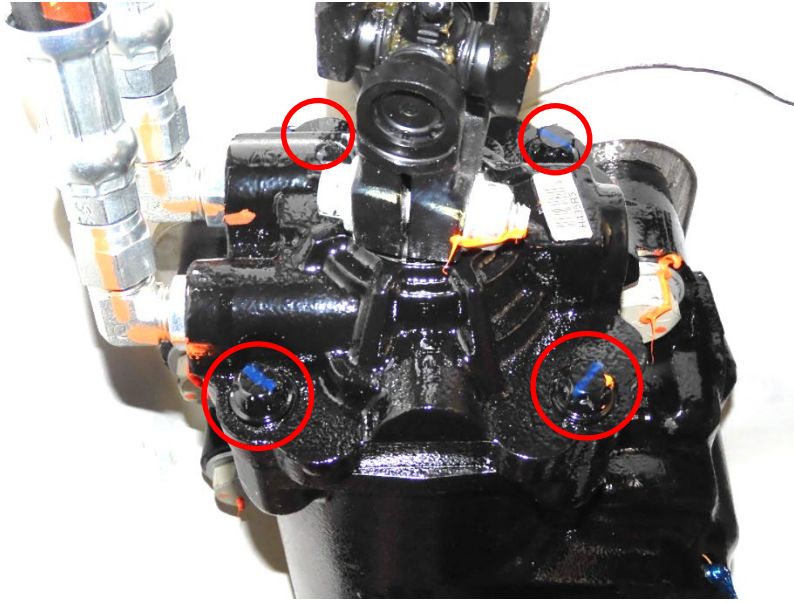


3. Working safely underneath the bus, access the Steering Gearbox Housing shown in the following photograph.



Steering
Gearbox
Housing

4. Using a Ratchet with an E18 Torx Socket, loosen one of the four Torx bolts shown circled in red in the following photograph.



5. Using a Calibrated Torque Wrench with an E18 Torx Socket, **torque the bolt to 118 foot-pounds.**
6. Using Orange Torque Stripe Paint, mark the properly torqued bolt.
7. Repeat the process to properly torque and mark the remaining three (3) bolts.
8. Remove the four (4) Jack Stands.
9. Lower the bus using the four (4) Wheel Lifts.
10. Remove the Lockout/Tagout devices and return the bus to service.