



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	1/4/2023
SERVICE BULLETIN SUBJECT:	Destination Sign M6 Fastener Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-23-1
LABOR OPERATION CODE:	IS46Z

Repair Procedure	Time Allotted
No Equipment Installed on Overhead Panel	1 Hour
Equipment Installed on Overhead Panel	1.5 Hours

DESTINATION SIGN M6 FASTENER RETROFIT

Description:

The procedure describes the process of installing new fasteners on the destination sign bracket for improved durability.

Tools/Parts Required:

Tools and Supplies Required:

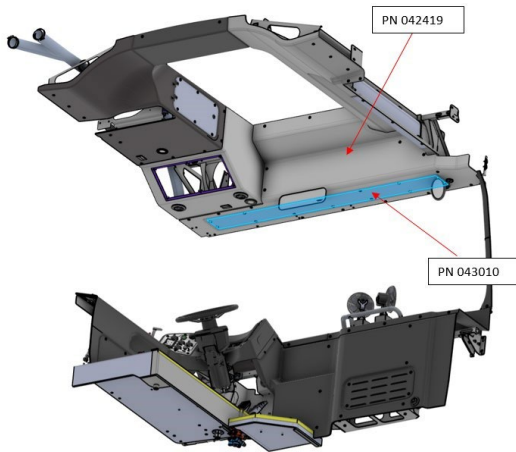
- Ratchet
- 10mm Socket
- 10mm Combination Wrench
- Calibrated Torque Wrench
- Orange Torque Stripe Paint
- Die Grinder
- Deburr Tool

Kit Parts Required:

- 063466 KIT, SERVICE, DESTINATION SIGN FASTENERS, M6 (Consisting of)
- 005442-004 BOLT,HEX,FLANGE,STL,YZPL,CLASS 10.9, M6-1.0X20X20 4 EA • 018933
WSHR, DIN 9021, STL, HDN, ZPL, M6 8 EA • 005448
LKNT,HEX,FLANGE,STL, ZPL,CLASS 10, M6-1.0 4 EA

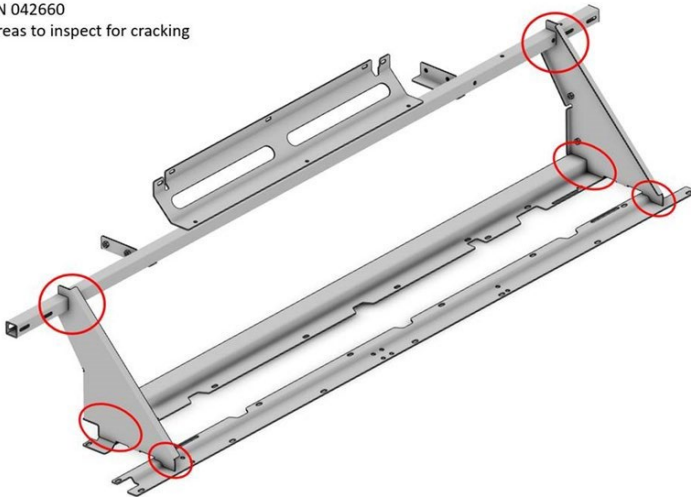
Procedure:

1. Perform the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using a T-30 Torx Driver, remove the Cover (**043010**) and Panel (**042419**) shown in the following illustration.



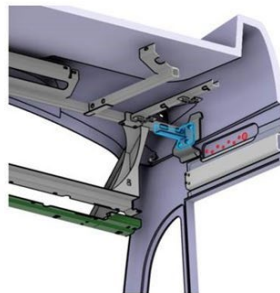
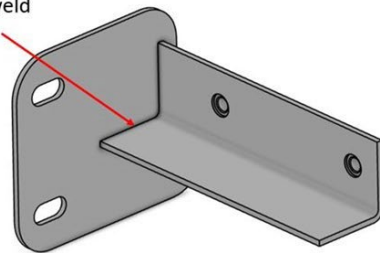
3. Before beginning any repairs, inspect the following areas for cracking. Contact Proterra Service Engineering before continuing this procedure if any cracking is found.

PN 042660
Areas to inspect for cracking

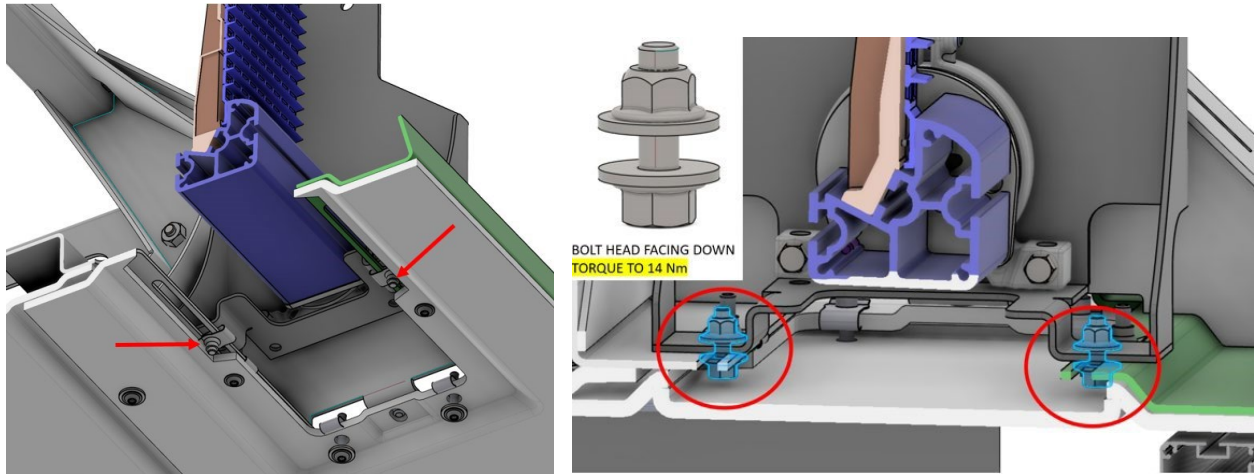


PN 046180, 046186

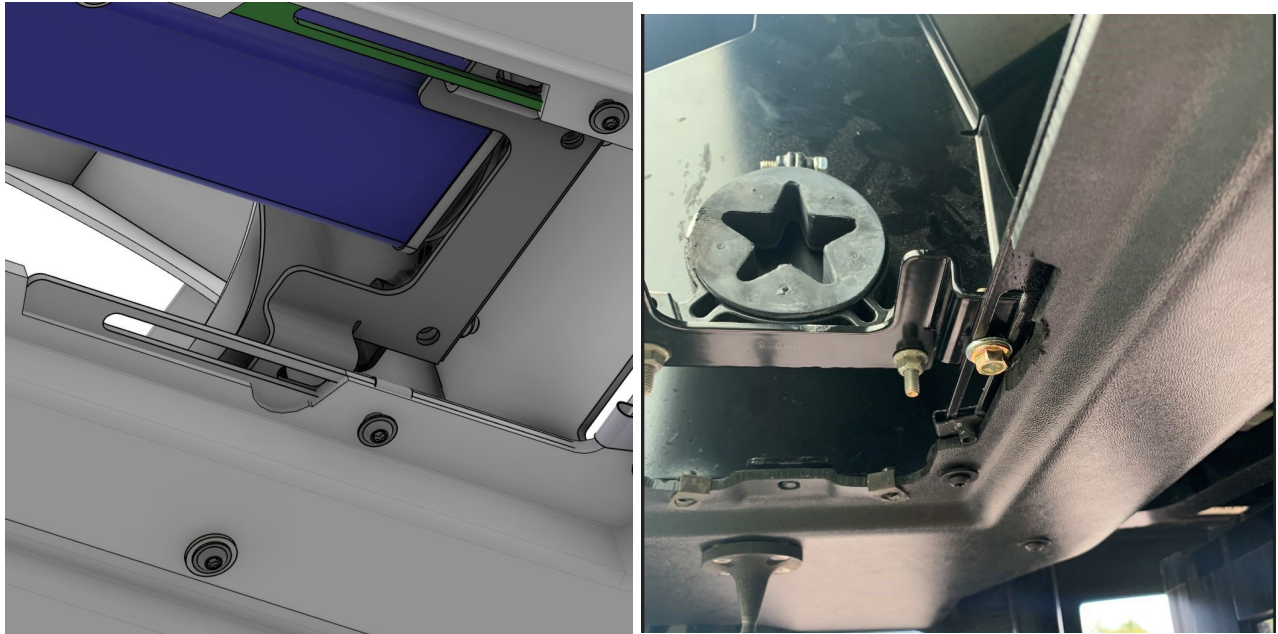
Inspect full weld
perimeter



4. Using a 10mm Ratchet/Socket, remove and replace each M6 Bolt and M6 Clip with a M6 Bolt (**005442-004**), two M6 Washers (**018933**), and one M6 Locknut (**005448**). Replace these fasteners one at a time to maintain the rigidity of the brackets. The Bolts should be oriented with the threads facing upward and the Bolt head facing down.



5. Using a Die Grinder, remove material from the plastic overhead trim panel to allow room for the M6 Bolt (**005442-004**) and M6 Washer (**018933**).



6. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the fasteners to 10 footpounds.**
7. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.
8. Using a T-30 Torx Driver, replace the panels that were removed earlier.
9. Remove the Lockout/Tagout devices and return the bus to service.