



PROTERRA



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	12-10-2021
SERVICE BULLETIN SUBJECT:	800 Volt HVJB Mounting Torque Update Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-21-176
Labor Operation Code:	HE44Z

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

800 VOLT HVJB TORQUE UPDATE RETROFIT

Retrofit Description:

This procedure describes retorquing the HVJB mounting bolts to a higher torque value for improved reliability.

Tools/Parts Required:

Tools and Supplies Required:

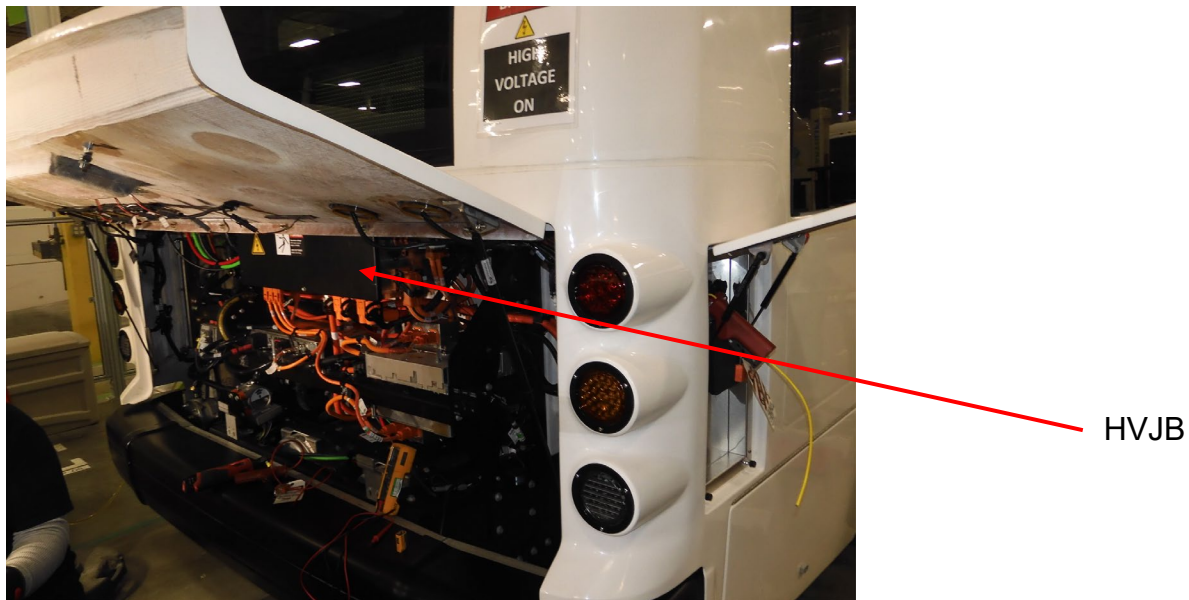
- Square Key
- Ratchet
- Calibrated Torque Wrench
- 15mm Socket
- Shop Towels
- Isopropyl Alcohol
- Orange Torque Stripe Paint
- Loctite 242

Parts Required:

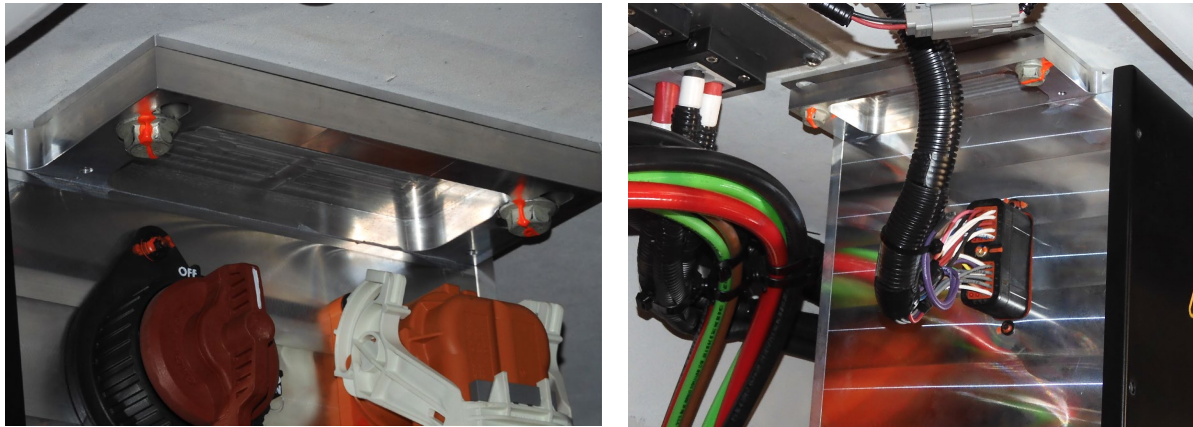
- None

Procedure:

1. Perform the Proterra approved Lockout/Tagout process to make the bus safe for work.
2. Using a Square Key, open the trunk to locate the HVJB.



3. Locate the four bolts that secure the HVJB to the bus body shown in the following photographs.



4. Using Isopropyl Alcohol and Shop Towels, remove the Orange Torque Stripe Paint from the four bolts.
5. Using a 15mm Ratchet/Socket, remove one of the bolts.
6. Apply a drop of Loctite 242 to the threads of the bolt.
7. Reinstall the bolt into the position from which it was removed.
8. Using a Calibrated Torque Wrench with a 15mm Socket, **torque the Bolt to 41 foot-pounds.**
9. Using Orange Torque Stripe Paint, mark the properly torqued fastener.

10. Repeat the process to apply Loctite 242 and torque the remaining three bolts.
11. Ensure that all bolts are torque striped.
12. Using a Square Key, close and latch the Trunk.
13. Remove the Lockout/Tagout devices and return the bus to service.