ISSUE DATE:	7-27-2020
SERVICE BULLETIN SUBJECT:	Driver's Barrier Door Stanchion Mount Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-20-105

NOTICE! It is expected that this process will require 4 hours per bus. Please schedule appropriately to minimize vehicle downtime.

DRIVER'S BARRIER DOOR STANCHION MOUNT UPDATE

Retrofit Description:

This procedure updates the driver's barrier stanchion mount to a more robust design.

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East Coast Manufacturing: 1 Whitlee Court, Greenville, SC 29607
West Coast Manufacturing: 383 Cheryl Lane, City of Industry, CA 91789

Tools/Parts Required

Tools and Supplies Required:

- Ratchet
- 1/2-Inch Socket
- Chisel
- Permanent Marker
- Power Drill
- 9mm Drill Bit
- 10mm Drill Bit
- 21/32 Drill Bit
- Mixing Cup
- Tongue Depressor
- Plexus Gun
- 36-Grit Sanding Disk
- Isopropyl Alcohol
- Shop Towels

Kit Parts Required:

- 054731 KIT, AROW BARRIER DEBONDING RETROFIT (Consisting of)
  - 112-5492 BRACKET, DRIVERS BARRIER, RETRO 1 EA
  - 019657 INSERT, POTTED, M8-1.25X16 (WITTEN) 3 EA
  - 005443-002 BOLT,HEX,FLANGE, CLASS 10.9, M8-1.25X16X16 3 EA
  - 018362 PLEXUS, MA-530 1 EA

Parts Required but not included in kit:

- 009479 RESIN, EPOXY, WEST SYSTEMS 1 EA
- 027017 FILLER, HIGH DENSITY, WEST SYSTEMS 1 EA
- 009499 HARDENER, EPOXY, FAST, WEST SYSTEMS 1 EA
- 043223 EQUIPMENT, SERVICE, WEST SYSTEM MINI PUMP 1 EA
- 020990 PRIMER,COND.,0-RMD,PLE QT.IP120 PC 120 1 EA

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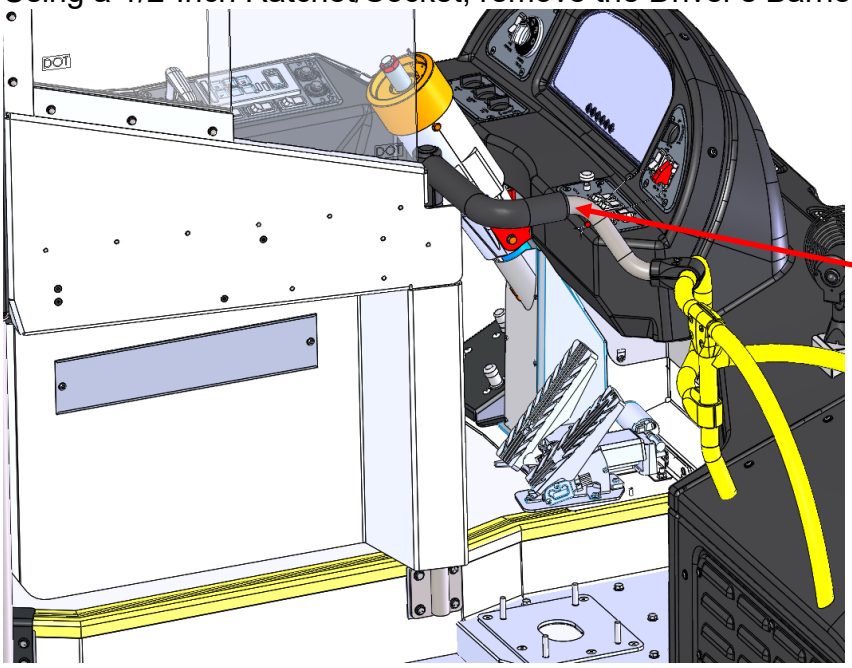
Procedure

1. Perform the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using a 1/2-Inch Ratchet/Socket, remove the Driver's Barrier Stanchion from the bus.



3. Using a Chisel, carefully remove the nut plate from the floor.

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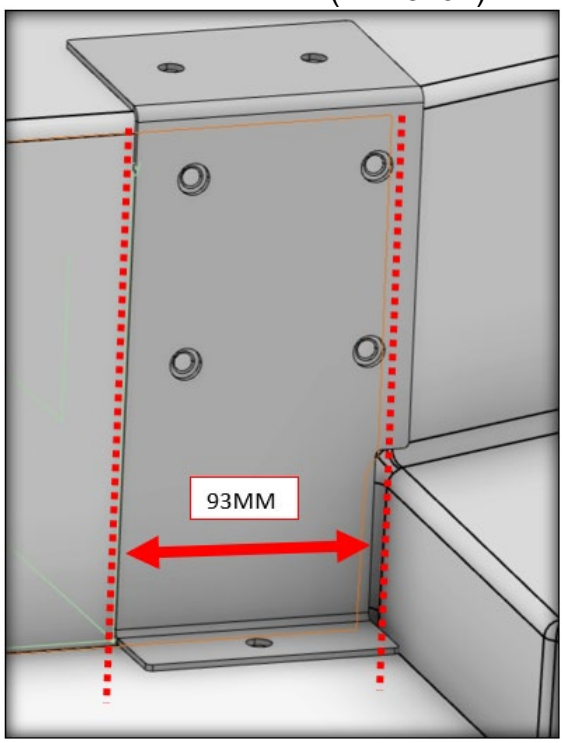
4. Prepare the area where the nut plate was removed by removing all Plexus, the flooring, and yellow trim.

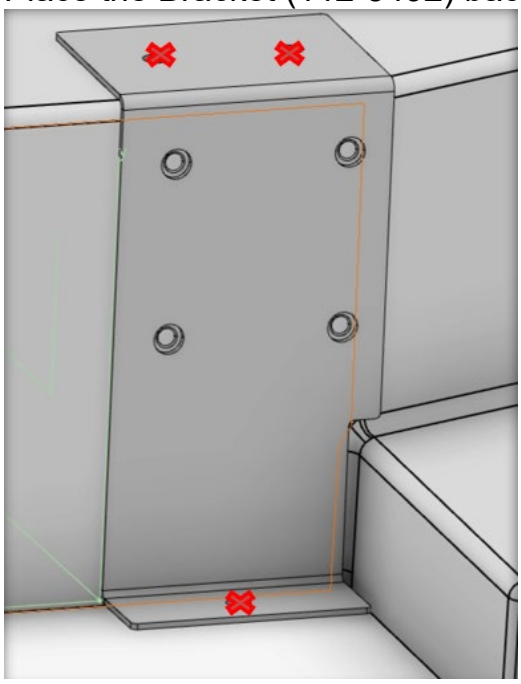
5. Place the new Bracket (112-5492) in the position shown in the following illustration.



6. Using a Permanent Marker, mark the four holes on the vertical portion of the bracket for drilling.

7. Using a Power Drill with a 9mm Drill Bit, drill a hole that is at least 15mm deep in each of the marked locations. These will be clearance holes for the stanchion fasteners.

8. Place the Bracket (112-5492) back into position over the drilled holes.



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9. Using a Permanent Marker, mark the three holes shown by the red x-marks in the previous illustration.

10. Remove the Bracket (112-5492) in preparation for drilling.

11. Using a Power Drill with a 10mm Drill Bit, drill pilot holes in the marked locations. The holes should be 26mm deep.

12. Using a Power Drill and a 21/32-Inch Drill Bit, enlarge the holes to their final size and 26mm depth.

13. Mix West Systems 105 Epoxy Resin with West Systems 205 Hardener to get the amount required to install the three Inserts (019657).

14. Mix in West Systems 404 High Density Filler until the mixture has the consistency of mayonnaise.

15. Using a plastic bag with a corner cut off or a tongue depressor, apply the Epoxy to the outer surfaces of the Inserts (019657).

16. Place the Epoxy covered Inserts (019657) into the mounting holes. Make sure that the Inserts are square with the body and that the tops of the Inserts are just below the top surface of the body. Use the small Plastic Keepers that are supplied with the Inserts to keep them square to the floor.

17. Allow one hour for the epoxy to cure before continuing this procedure.

18. Using Alcohol and Shop Towels, clean the Bracket (112-5492).

19. Using a Power Drill with a 36-Grit Sanding Disk, scuff the back of the Bracket (112-5492).

20. Using Shop Towels and Isopropyl Alcohol, clean the scuffed area on the bracket.

21. Using Shop Towels, apply Plexus Primer (020990) to the scuffed area on the bracket.

22. Using a Plexus Gun, apply Plexus to the back vertical surface of the Bracket (112-5492).

23. Place the Bracket (112-5492) onto the bus body.

24. Secure the Bracket (112-5492) to the bus body using three M8 Bolts (005443-002).

25. Remove any excess Plexus.

26. Allow three hours for the Plexus to cure.

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27. Using a Calibrated Torque Wrench with a 13mm Socket, **torque the M8 bolts to 26 foot pounds.**

28. Using a 1/2-Inch Ratchet/Socket, reinstall the Driver's Barrier Stanchion using the original hardware.

29. Remove the Lockout/Tagout devices and return the bus to service.

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