



# TECHNICAL SERVICE BULLETIN

<b>Subject</b>	Destination Sign Hat Bracket Repair
<b>Issue Date</b>	02/29/2024
<b>Service Bulletin Number</b>	SC-23-070
<b>Models Affected</b>	Service Specified Vehicles
<b>Complete By</b>	Next Service Opportunity
<b>Labor Operation Code</b>	IS47Z
<b>Description</b>	This bulletin covers the procedure to re-install de-bonded destination sign brackets and to secure attachment with fiberglass.

Labor Table				
	Operation	Technicians	Hours	Labor Time (T x H)
1	Steps 1-17	1	10	10 Hours
		<b>Total Labor Time:</b>		10 Hours

Contact the Proterra Customer Service Team with any questions related to the following procedure.

**864-438-0000**  
**Service@Proterra.com**

**Parts Required:**

		Qty.	UOM	
	050318	Promoted Resin	8	OZ.
	050677	E-BXM 1708 Biaxial Fiberglass (100 mm x 250 mm)	4	EA
	050677	E-BXM 1708 Biaxial Fiberglass (125 mm x 270 mm)	4	EA
	009479	Disposable Brush	1	EA
	050675	MEKP	3	CC
	018362	MA-530 PLEXUS	1	EA
	042536	Manual Adhesive Applicator Gun	1	EA

**Tools/Materials Required:**

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- Grinding Discs - (Qty. 2)
- Grinding Disc Bit
- Permanent Marker
- Shop Vacuum
- Battery Operated Drill
- Sanding Disc 30-Grit
- Safety Gloves
- Mixing Sticks
- Plexus Mixing Tip
- 17mm socket and wrench
- Duct Tape

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**Overview:**

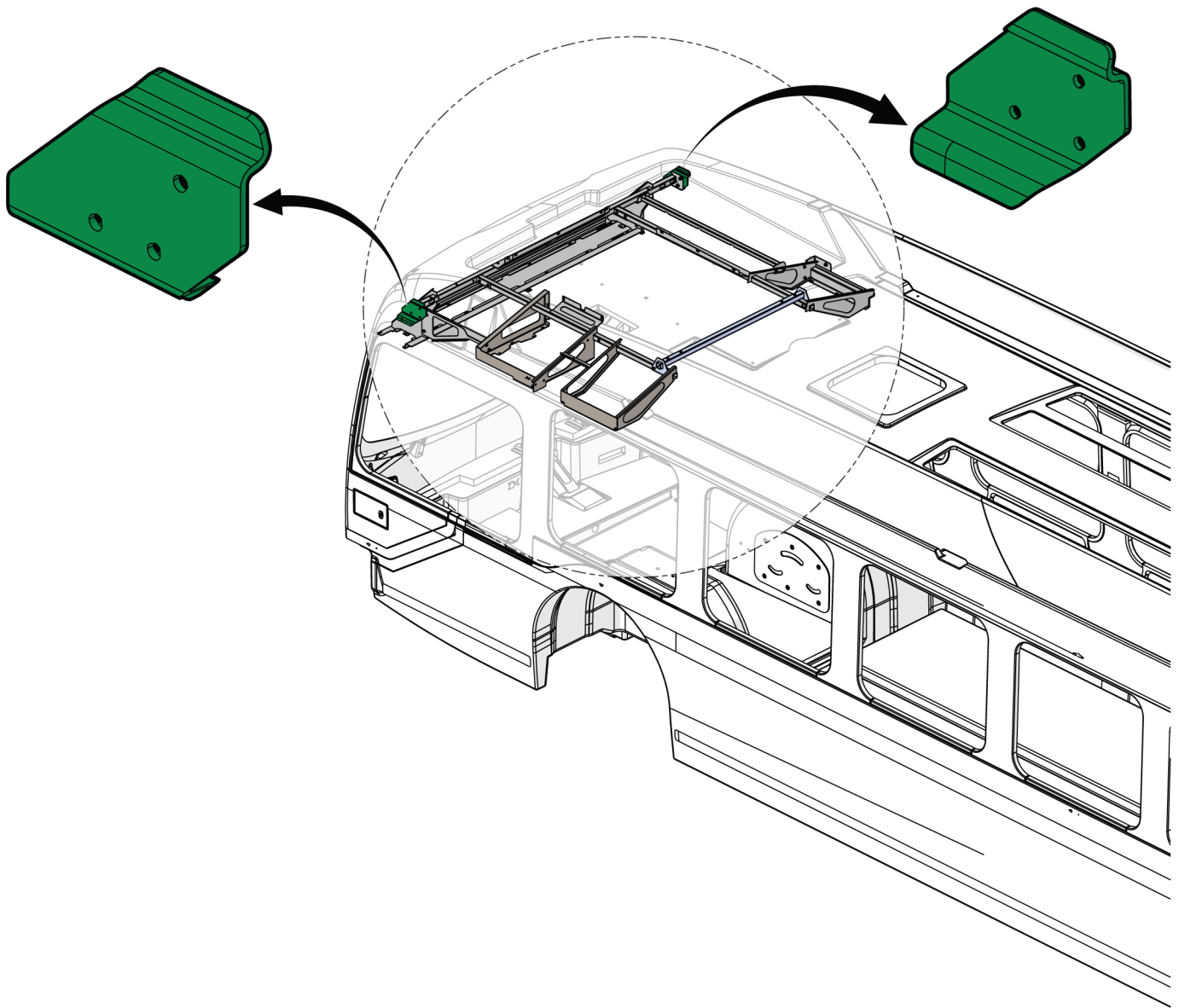
- Remove overhead panels and destination sign structure.
- Clean bonding surfaces and prepare fiberglass resin.
- Re-install brackets and apply fiberglass bonding strips.

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**Step 1:**

Wear proper protective equipment and perform the Proterra-approved lockout/tagout procedure before beginning work.

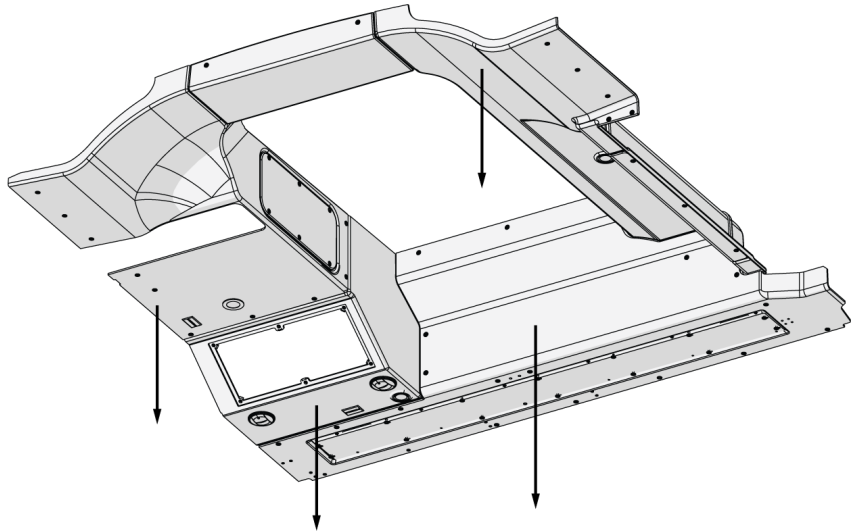
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**Step 2:**

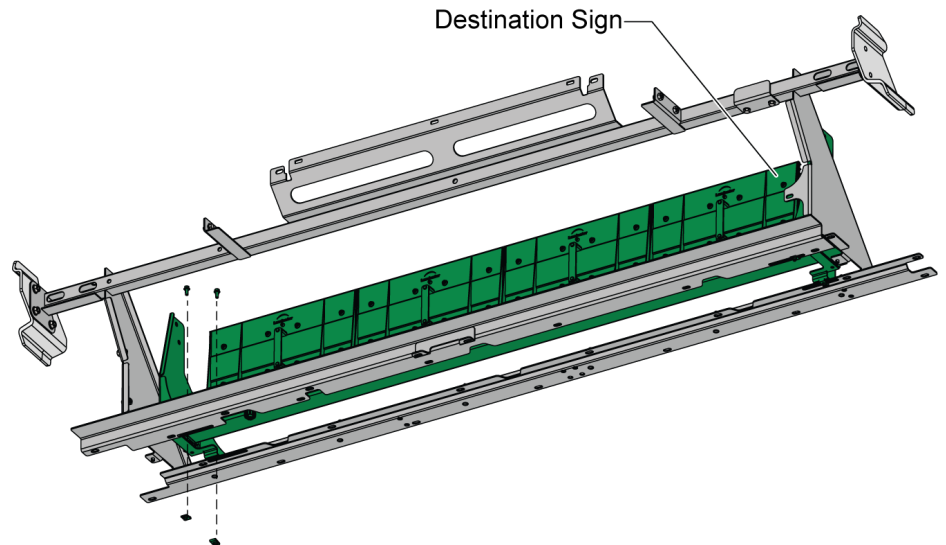
Remove interior overhead panels to access the destination sign mounting bracket.



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**Step 3:**

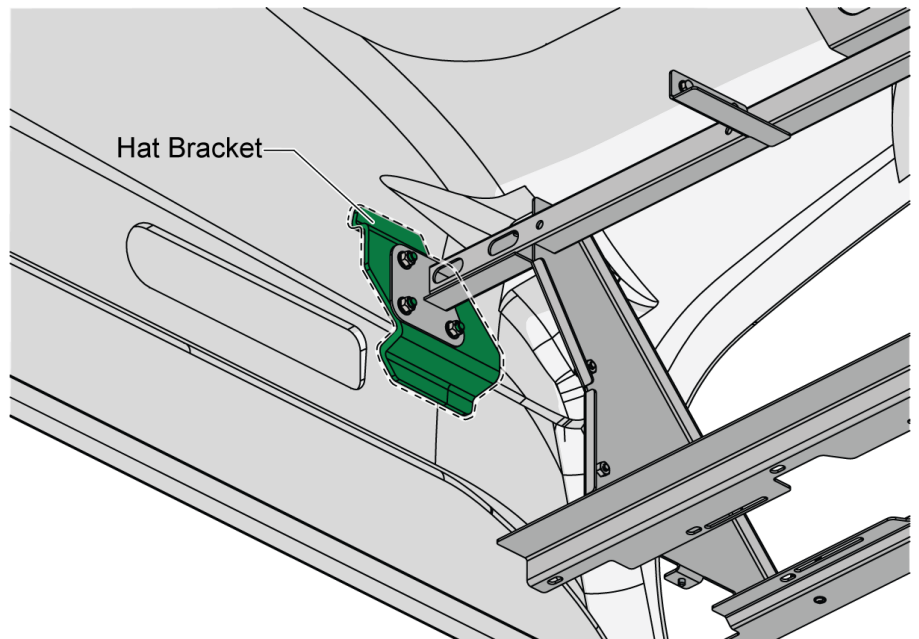
Remove destination sign by unscrewing four M6 fasteners and disconnecting electrical harness.



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**Step 4:**

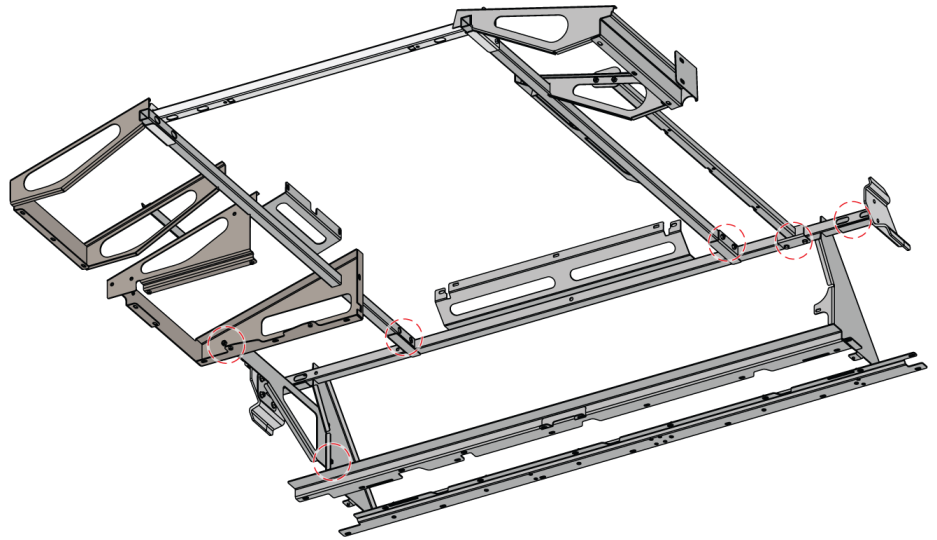
Mark the location of the hat brackets by tracing the outline onto the interior bus body for both curbside and streetside brackets.



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**Step 5:**

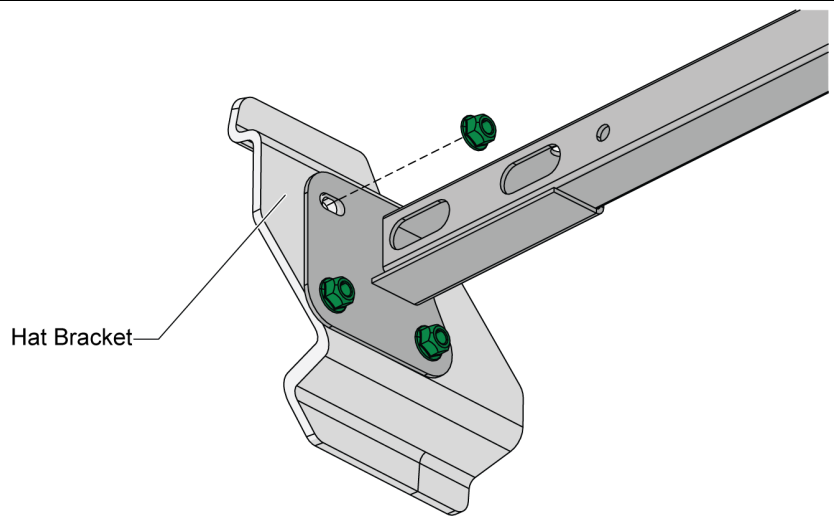
Remove the destination sign bracket from the bus by unbolting the M8 fasteners in the locations shown.



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**Step 6:**

Remove the streetside and curbside hat brackets from the destination sign structure.



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**Step 7:**

After removing the brackets, clean any remaining adhesive from the mounting surfaces of the brackets and/or interior bus body without damaging fiberglass.

It may be necessary to replace the brackets if there are signs of damage/delamination. Inspect brackets for the following signs of delamination:

- Separation from body/Plexus is not clean
- Discoloration of the bracket flanges
- Pieces of fiberglass staying attached to the brackets.

Use the chart below to order replacement brackets if necessary.

Body	Part No.	Description
40-foot Heron	048838	PAD, MOUNTING, SS FRONT OVERHEAD
	048814	PAD, MOUNTING, CS FRONT OVERHEAD
35-foot Heron	045497	PAD, MOUNTING, SS FRONT OVERHEAD, 35' ZX5
	045499	PAD, MOUNTING, CS FRONT OVERHEAD, 35' ZX5

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**Step 8:**

Abrade the bonding flanges of the hat brackets and their mating surfaces with a 30-grit sanding disc.

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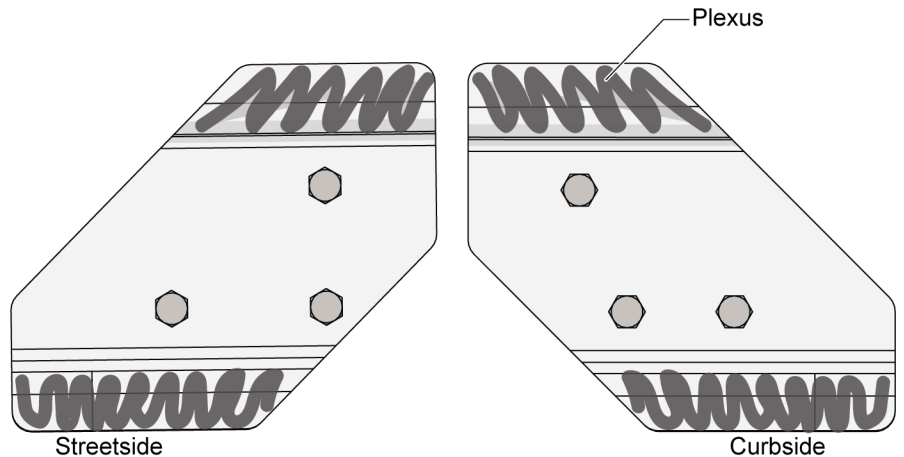
**Step 9:**

Clean all mounting surfaces with isopropyl alcohol.

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**Step 10:**

Apply Plexus to bonding flanges of both curbside and streetside hat brackets.



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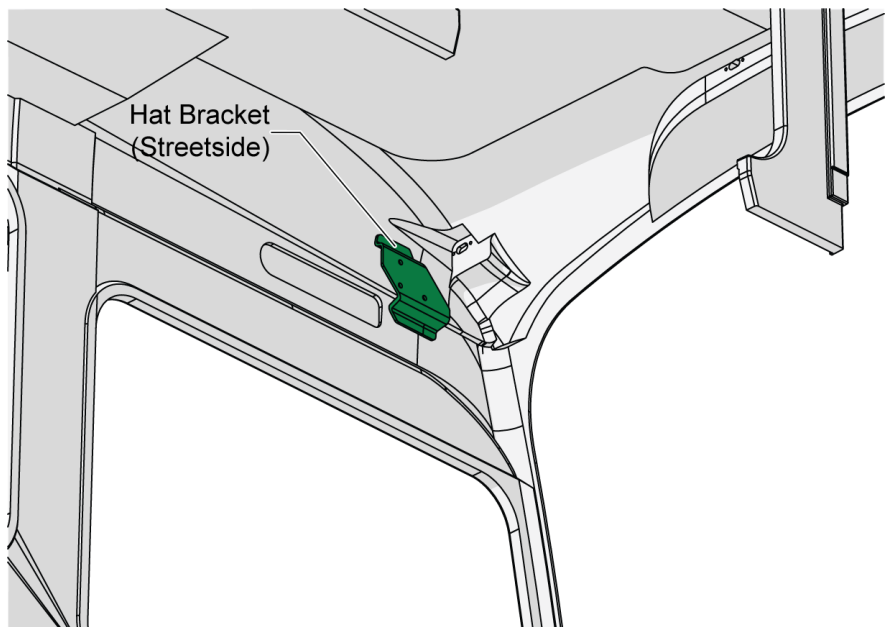
**Step 11:**

Use the outlines created in Step 4 to identify the location of the brackets.

Apply streetside and curbside brackets to the bus body interior and secure in position with duct tape.

Remove any excess Plexus squeeze out.

Allow 90 minutes to cure.



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**Step 12:**

After the Plexus has fully cured, remove and discard duct tape used to secure the brackets.

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**Step 13:**

Mix resin and MEKP together in 99:1 ratio.

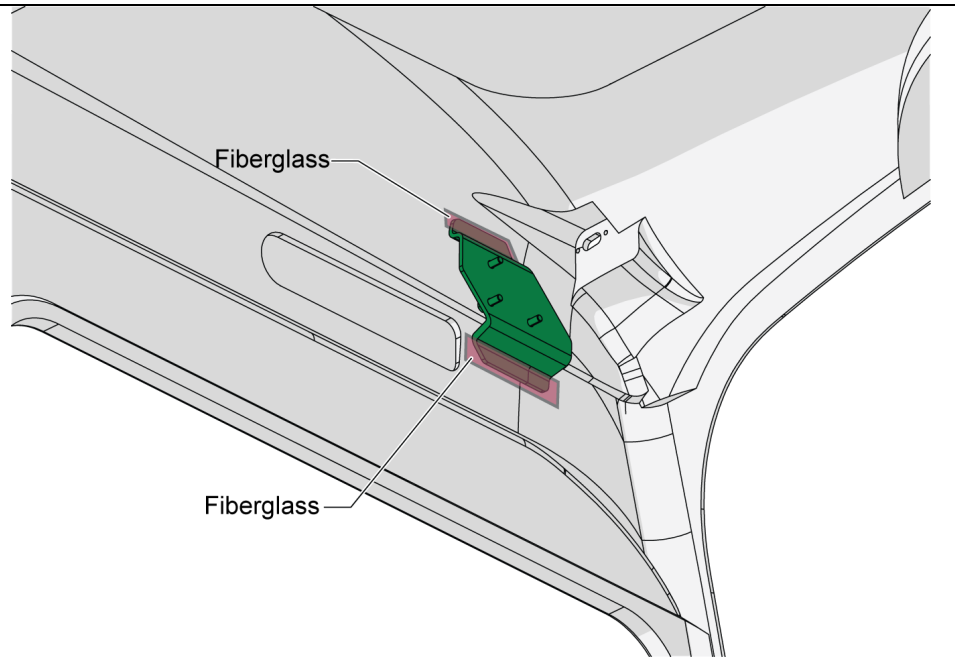
Wet out 1708 fiberglass strips to prepare for bonding.

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**Step 14:**

Place the smaller 1708 fiberglass strips (four total) over the bonding flanges of each bracket (curbside and streetside).



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**Step 15:**

Place the larger 1708 fiberglass strips over the smaller strips applied in Step 9.

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**Step 16:**

Allow 90 minutes for resin to cure.

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**Step 17:**

Clean the work area thoroughly and re-install all components removed in previous steps.

The bus may now be returned to service.