ISSUE DATE:	10-27-2022
SERVICE BULLETIN SUBJECT:	ZX5 Overhead Destination Sign Bracket Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-22-135
LABOR OPERATION CODE:	N/A

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

ZX5 OVERHEAD DESTINATION SIGN BRACKET RETROFIT

Description:

This procedure describes the process of updating the Overhead Destination Sign Bracket to a more robust version.

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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:

- Ratchet
- 13mm Socket
- 10mm Socket
- Calibrated Torque Wrench
- Orange Torque Stripe Paint

Kit Parts Required:

- 063012 KIT, SERVICE, DESTINATION SIGN FRAME REPLACEMENT (Consisting of)
  - 051619 FRAME, OVERHEAD, FRONT DESTINATION SIGN 1 EA
  - 005443-002 BOLT, HEX, FLANGE, STL, YZPL, CLASS 10.9, M8-1.25X16X16 16 EA
  - 030266 U-NUT, M6, 0.8-4.0mm THICK 40 EA
  - 019493-005 SCREW, BUTTON,FLG,TORX,SS,EPOXY BLACK, M6-1.0X25X25 40 EA
  - 033222 WASHER, DIN 9021, STL, HDN, BLK WATCH #53259, M6 40 EA
  - 005442-003 BOLT, HEX, FLANGE, STL, YZPL, CLASS 10.9, M6-1.0X16X16 4 EA

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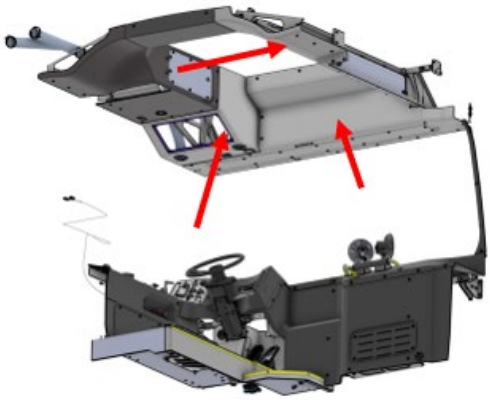
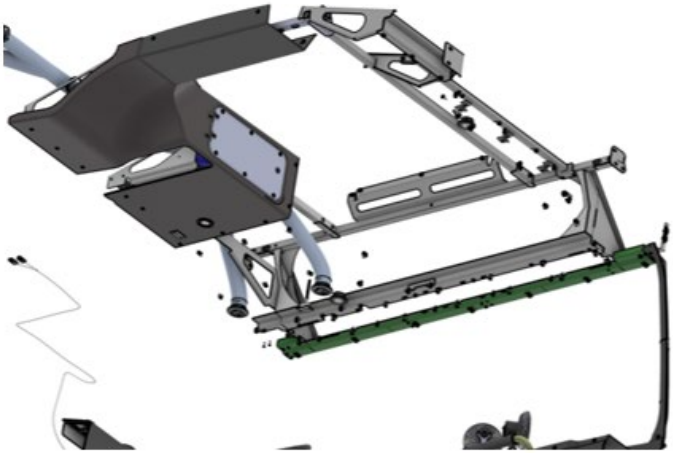
Procedure:

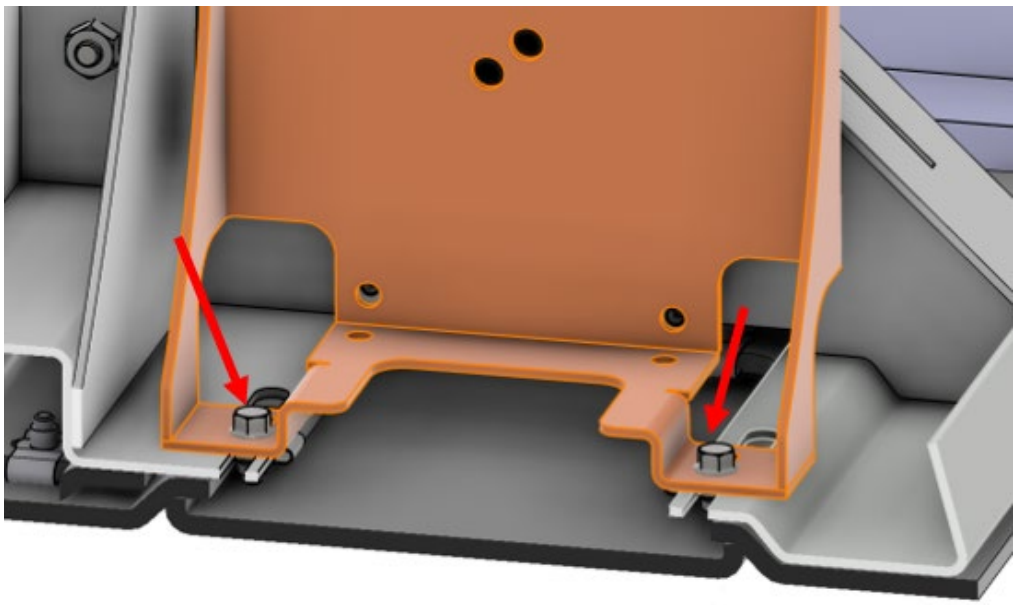
1. Use the Proterra approved Lockout/Tagout procedure to make the bus safe for work.

2. Using a T-30 Torx Driver, remove the overhead panels necessary to access the destination sign bracket. Retain the M6 Panel Fasteners and Washers for reuse.





3. Using a 10mm Ratchet/Socket, remove the Destination Sign by removing the M6 Fasteners shown in the following illustration.



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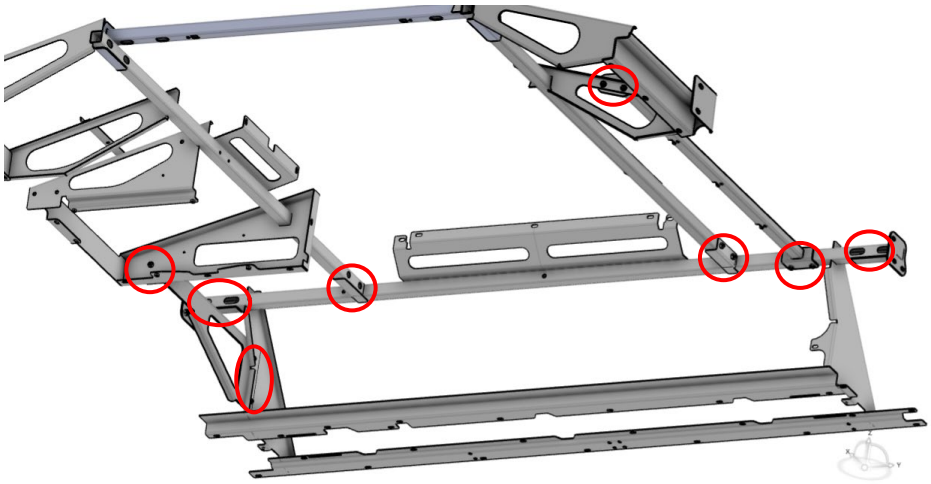
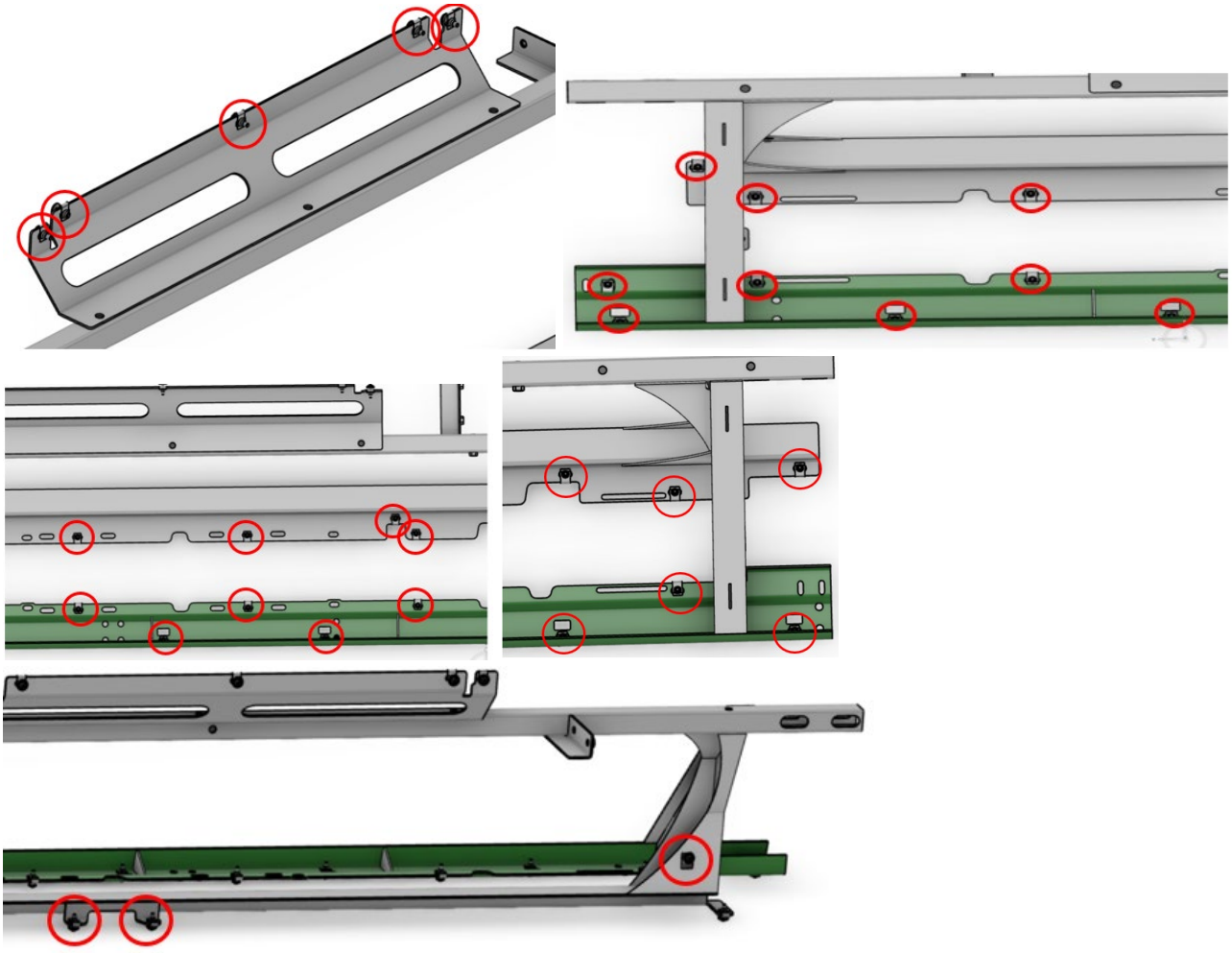
4. Using a 13mm Ratchet/Socket, remove the Destination Sign Brackett from the bus by removing the M8 Fasteners shown in the following illustration.



5. Working with the new Destination Sign Frame **(051619)**, install 32 U-nuts **(030266)** in the positions shown in the following illustrations.



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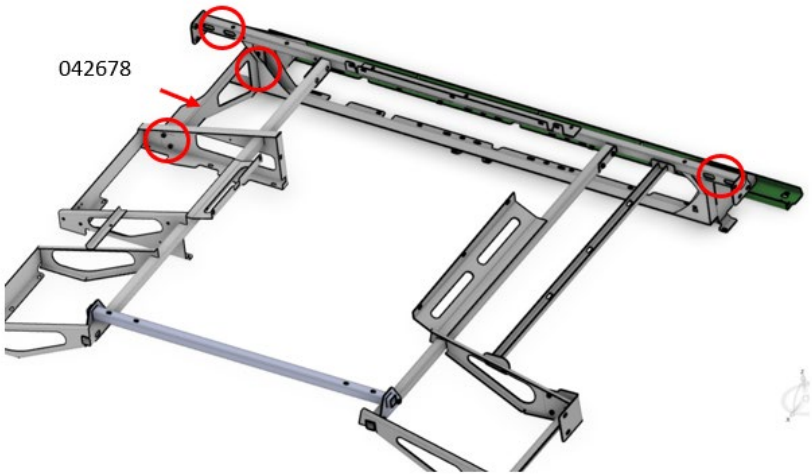
6. Using a 13mm Ratchet/Socket, install the Sign Frame **(**051619**)** into the support brackets as shown using two M8 Bolts **(005443-002)** per side.

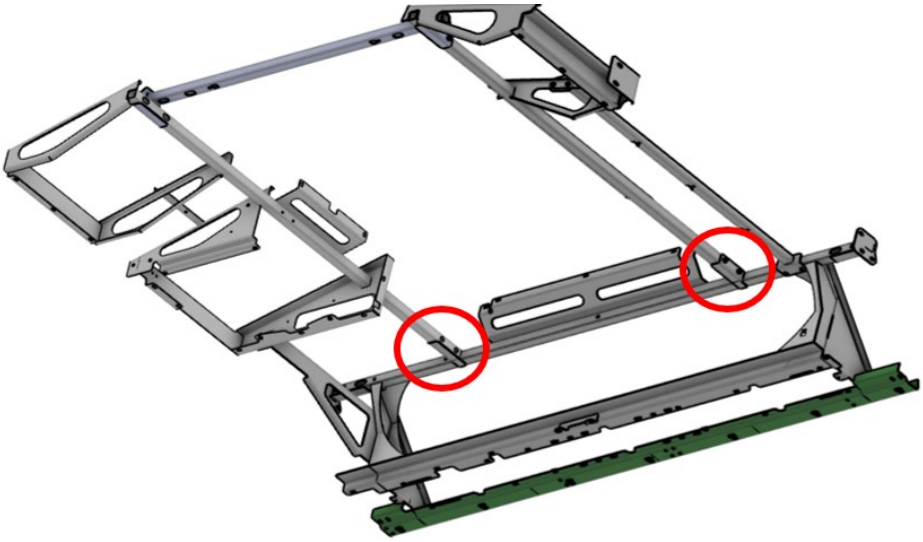


7. Using a 13mm Ratchet/Socket, Install the Support Bracket **(042678)** using four M8 Bolts **(005443-002)**.

8. Using a Calibrated Torque Wrench with a 13mm Socket, **torque the M8 Bolts to 23 foot-pounds.**

9. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.

10. Using a 13mm Ratchet/Socket, attach the Sign Frame **(**051619**)** to the upper frame using four M8 Bolts **(**005443-002**)** as shown in the following illustration.



11. Using a Calibrated Torque Wrench with a 13mm Socket, **torque the M8 Bolts to 23 foot-pounds.**

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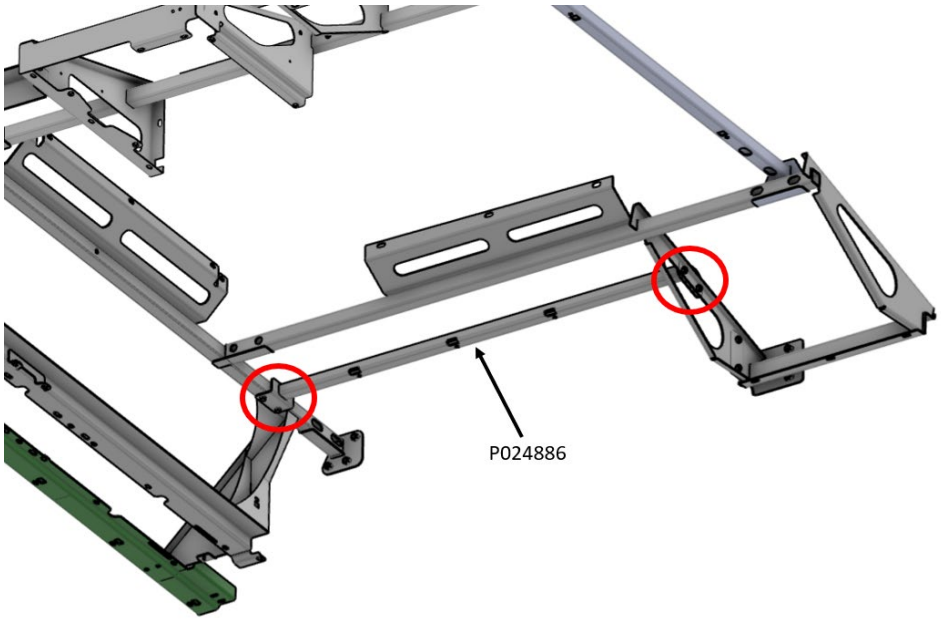
12. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.

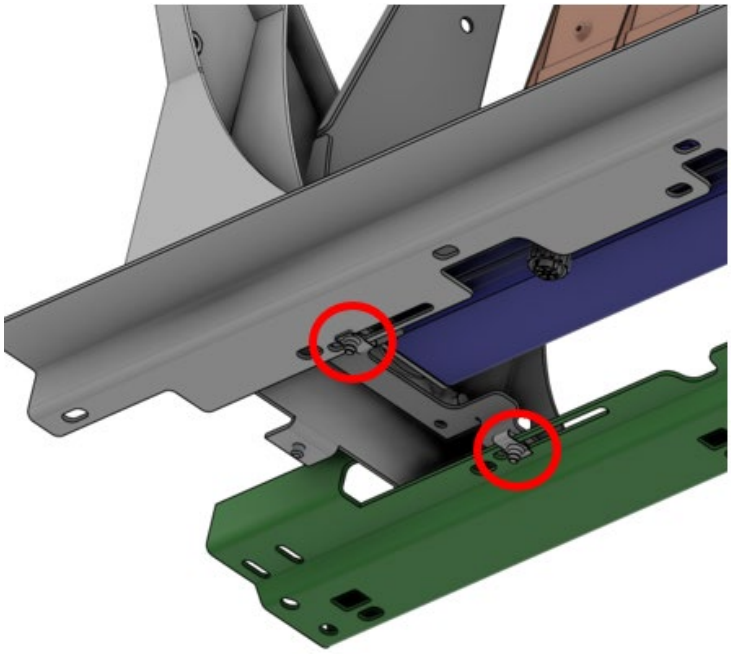
13. Using a 13mm Ratchet/Socket, attach the Support Frame **(P024883)** to the Sign Frame **(**051619**)** as shown in the following illustration.



14. Using a Calibrated Torque Wrench with a 13mm Socket, **torque the M8 Bolts to 23 foot-pounds.**

15. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.

16. Install four U-nuts **(**030266**)** for the Destination Sign as shown in the following illustration.



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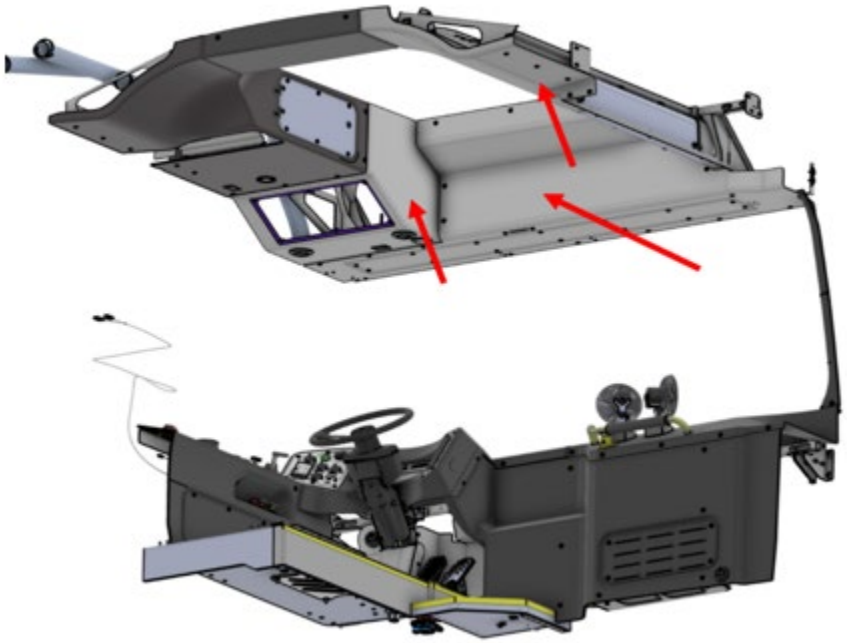
17. Using a 10mm Ratchet/Socket, reinstall the Destination Sign using four new M6 Bolts **(005442-003)** and connect the harness.

18. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the fasteners to nine foot-pounds.**

19. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.

20. Using a T-30 Torx Driver, reinstall the overhead panels that were removed earlier using M6 Screws **(019493-005)** and M6 Washers **(033222)** as shown in the following illustration.



21. Remove the Lockout/tagout devices and return the bus to service.

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