



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	11/2/2021
SERVICE BULLETIN SUBJECT:	Duopower Solenoid Dust Cover Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-21-157
LABOR OPERATION CODE:	N/A

NOTICE! It is expected that this process may require up to 1 hour per bus. Please schedule appropriately to minimize vehicle downtime.

DUOPOWER SOLENOID DUST COVER RETROFIT

Description

The procedure adds a gasket to the Duopower dust cover to prevent intrusion of dust and road debris.

Tools/Parts Required

Tools and Supplies Required:

- Ratchet
- 10mm Socket
- Calibrated Torque Wrench
- Orange Torque Stripe Paint
- 7/32-Inch Combination Wrench
- Loctite 567

Kit Parts Required:

- 059594 Duo Power Solenoid Dust Cover Service Kit (Consisting of)
 - 047322 SEAL, TRIM, BULB 36 IN

Additional Parts Required:

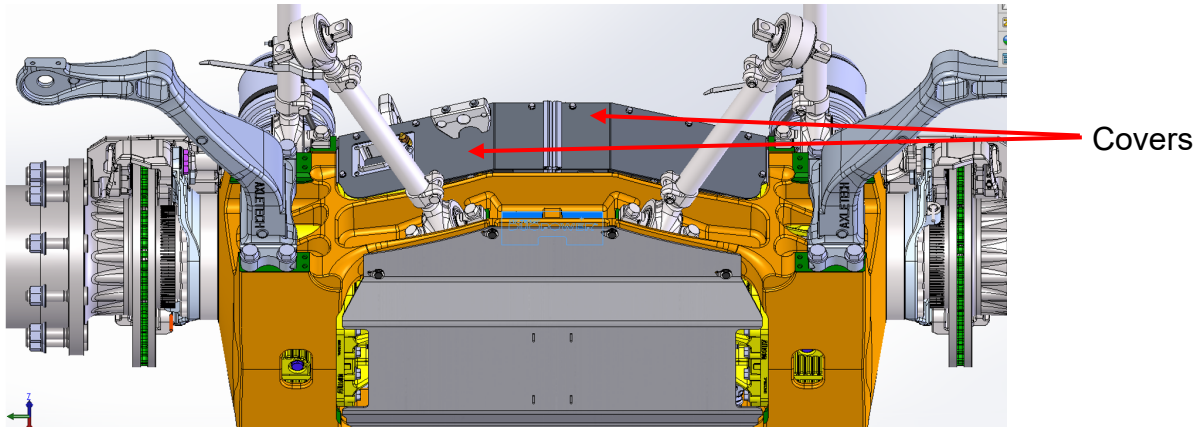
- 019581 EXHAUST FILTER, SOLENOID, 1/4 MPT HI FLOW 4 EA

Procedure

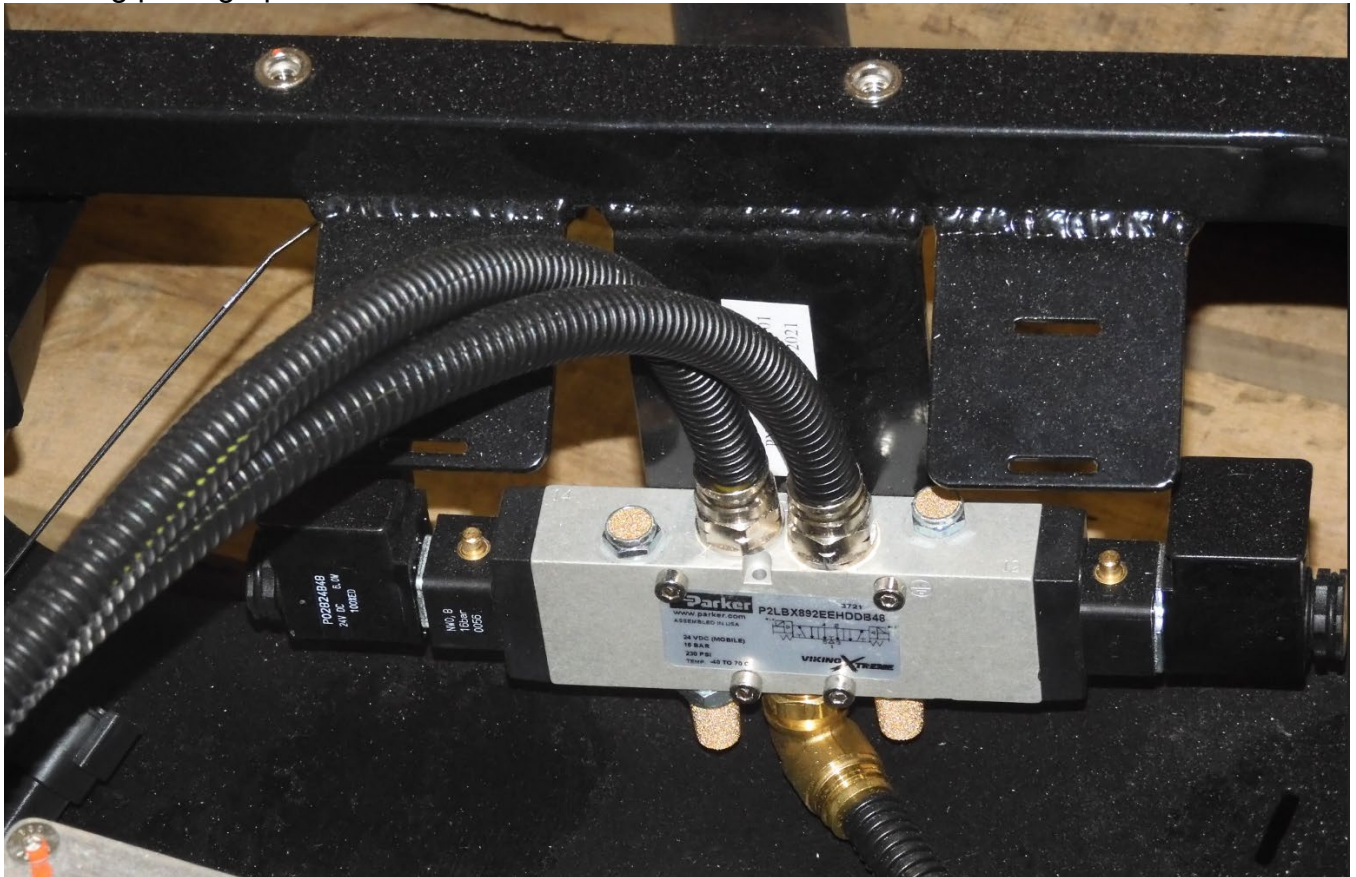
1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using four Wheel Lifts, raise the bus into the air. Using four Jack Stands, support the bus for safety.



- Working underneath the rear of the bus, locate the forwardmost Covers on the Duopower drive.

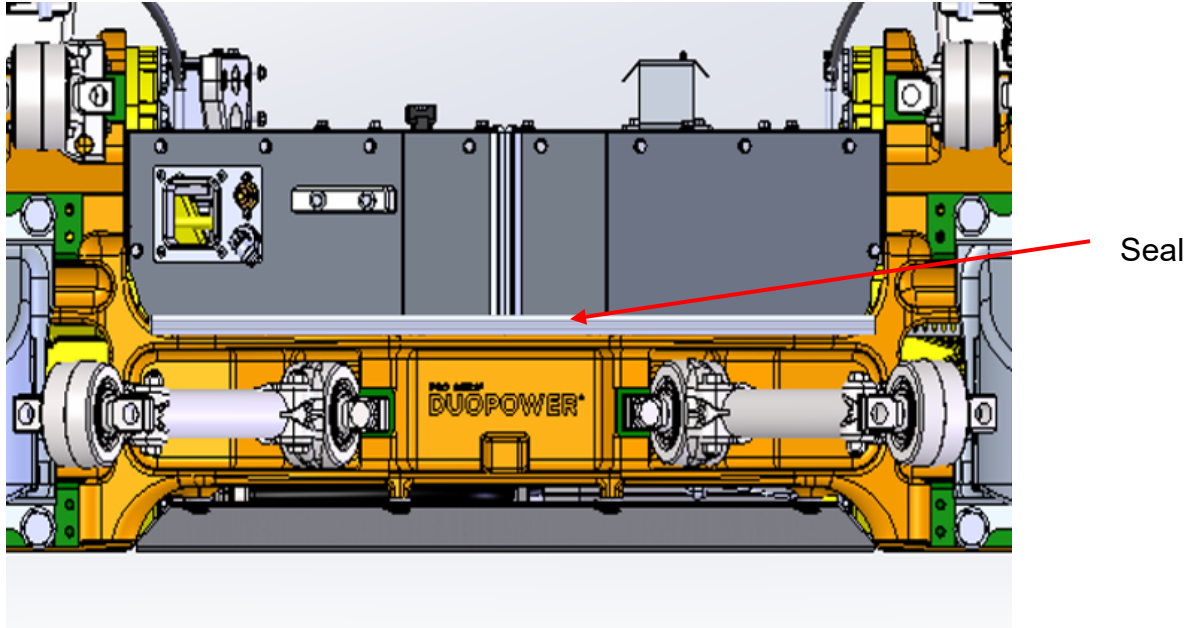


- Using a 10mm Ratchet/Socket, Remove the bolts that secure the Covers to the Duopower drive. Remove the Covers.
- Inspect the Filters on the Solenoid shown in the following photograph.
- If the Filters are dirty, they must be replaced. If the Filters are clean, proceed to step 11 of this procedure.
- Using a 7/32-Inch Combination Wrench, remove the Filters on the Solenoid. shown in the following photograph.



- Apply a small amount of Loctite 567 to the threads of each filter.

9. Using a 7/32-Inch Combination Wrench, replace the Filters (019581) on the Solenoid.
10. Using a 7/32-Inch Combination Wrench, **torque the Filters (019581) 1.5 to 3 turns past finger tight.**
11. Using an approved Safety Knife, trim the Seal (047322) to fit the gap as shown in the following illustration.



12. Replace the Covers that were removed from the bus.
13. Using a 10mm Ratchet/Socket, hand tighten the bolts that secure the Covers to the Duopower drive.
14. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the bolts to 8 foot pounds.**
15. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.
16. Safely remove the Jack Stands and lower the bus using the Wheel Lifts.
17. Remove the Lockout/Tagout devices and return the bus to service.