



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	10/22/2021
SERVICE BULLETIN SUBJECT:	800 Volt 35 Foot Modesty Panel Wall Bracket Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-21-147
LABOR OPERATION CODE:	N/A

NOTICE! It is expected that this process may require up to 2 hours per bus. Please schedule appropriately to minimize vehicle downtime.

800 VOLT 35 FOOT MODESTY PANEL WALL BRACKET RETROFIT

Description

The procedure replaces the modesty panel wall brackets with a more robust version.

Tools/Parts Required

Tools and Supplies Required:

- Ratchet
- 10mm Socket
- T-30 Torx Driver
- T-30 Torx Socket
- Center Punch
- Power Drill
- 5mm Drill Bit
- M6 x 1 Tap
- Cutting Fluid
- Ruler
- Permanent Marker
- 36-Grit Sanding Disk
- 36-Grit Sandpaper
- Shop Towels
- Isopropyl Alcohol
- Gorilla Tape

Kit Parts Required:

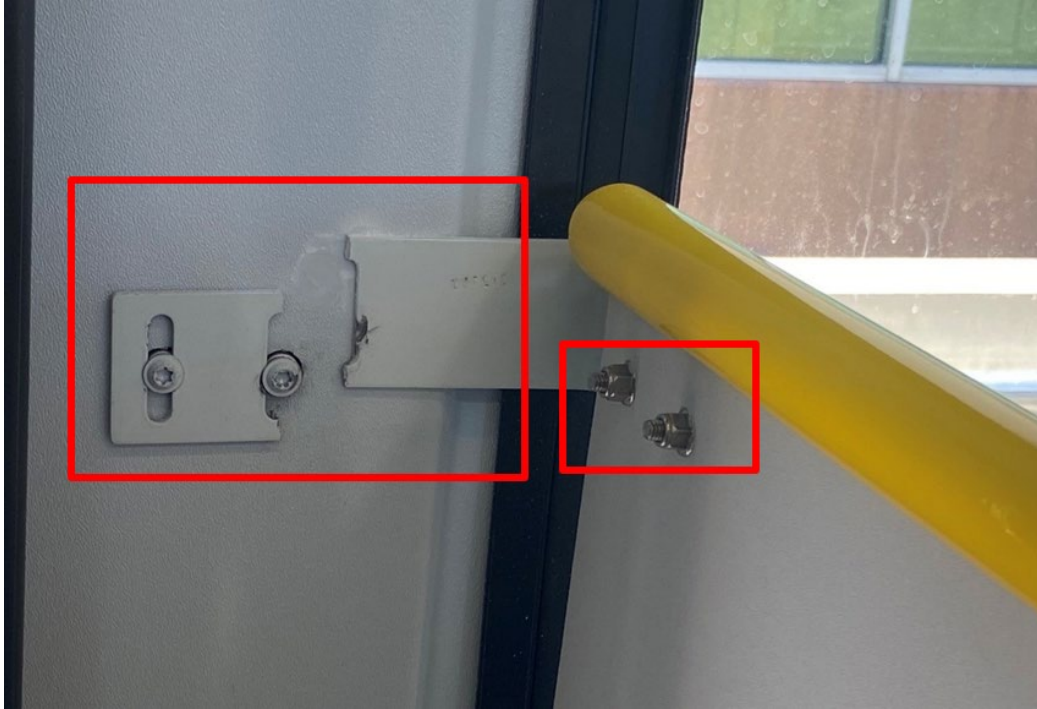
- 059530 RETROFIT KIT, MODESTY PANEL BRACKETS, 35' RR (Consisting of)
 - 147-1409 BRACKET, MODESTY PANEL, CS 1 EA
 - 147-1412 BRACKET, MODESTY PANEL, SS 1 EA
 - 025840-01AA01 PANEL, WALL, PLUG 1 EA
 - 025843-01AF01 PANEL, WALL 1 EA
 - 139-7153 SPACER, BONDED, MODESTY PANEL 2 EA
 - 018082-007 SCREW, BUTTON, FLANGE, TORX, M6-1.0X35X35 4 EA
 - 016876 WASHER, FLAT, SS, M6 4 EA
 - 025129-004 SCREW: BUTTON FLANGE: TORX: M6-1.0X20X20 4 EA
 - 019239 NUT, ACORN, M6 4 EA

Additional Parts Required:

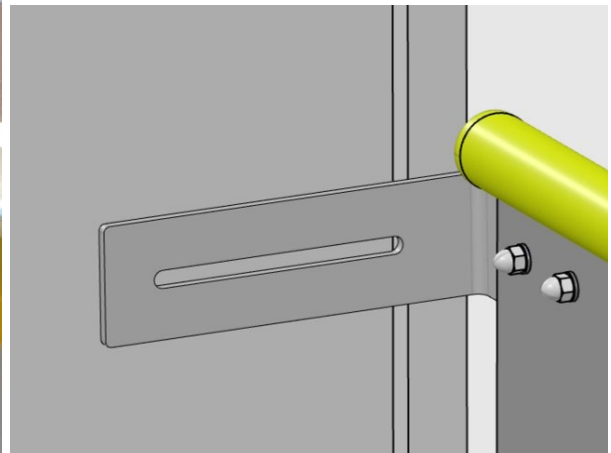
- 042536 TOOL, SERVICE, MANUAL ADHESIVE GUN 1 EA
- 020990 PRIMER, COND., 0-RMD, PLE QT. IP120 PC 120 1 EA
- 018362 PLEXUS, MA-530 1 EA

Procedure

1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using a T-30 Torx Driver and a 10mm Ratchet/Socket, remove the Modesty Panel Bracket and the Modesty Panel shown in the following photograph. Complete this for both sides of the bus. The Bracket may be intact or broken as shown.

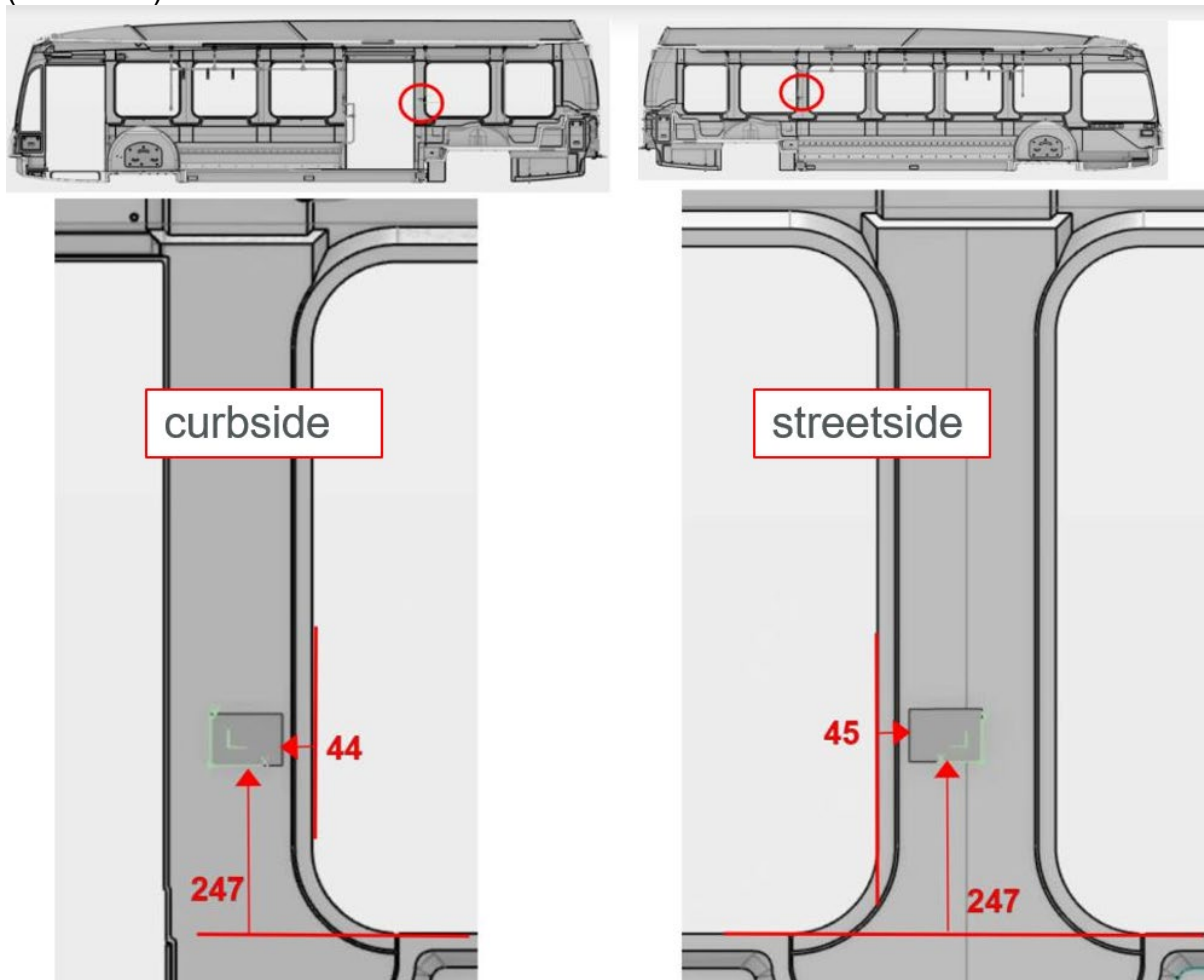


3. Remove both Wall Panels in the locations directly behind the Modesty Panel locations.
4. Remove the Spacers that were installed behind both Modesty Panel Brackets.
5. Test fit the CS Bracket (147-109) and SS Bracket (147-1412) to determine if the mounting slot aligns with the existing tapped holes on the hard points. Do not force the alignment.

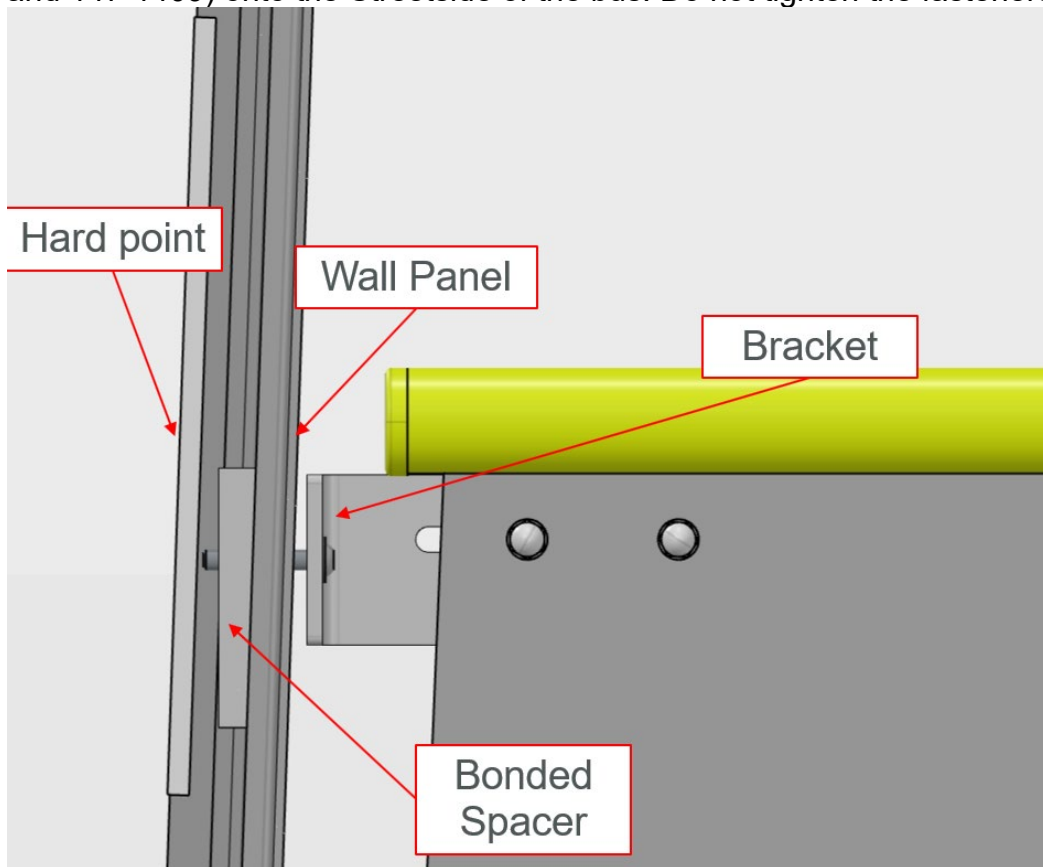


6. If either Bracket does not align with the holes, use a Center Punch to mark locations for new holes.

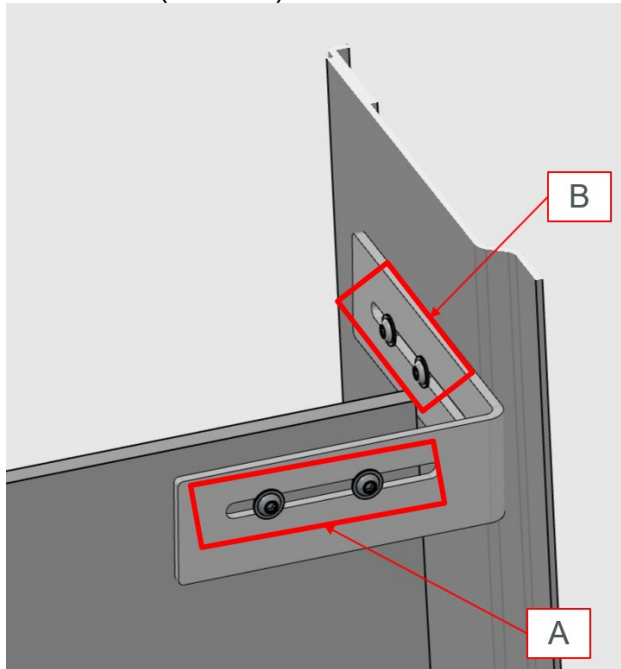
7. Using a Power Drill with a 5mm Drill Bit, drill any new holes that are required.
8. Using a M6 x 1 Tap with Cutting Fluid, tap any new holes that were drilled.
9. Beginning on the Streetside of the bus, use a Ruler and Permanent Marker to mark locations for drilling pass-through holes on a Spacer (139-7153). The locations marked should match the dimensions of the holes in the Hard Point.
10. Repeat the process to mark pass-through hole locations for the Curbside Spacer (139-7153).
11. Using a Power Drill with an 10mm Drill Bit, drill the pass-through holes in the Spacers (139-7153).
12. Using a Power Drill with a 36-Grit Sanding Disk, scuff the bonding surface of the Spacers (139-7153).
13. Using Isopropyl Alcohol and Shop Towels, clean the Spacers (139-7153).
14. Using Shop Towels, apply Plexus Primer (020990) to the bonding surfaces of the Spacers (139-7153).
15. Using the following illustrations as a guide, mark the locations shown for bonding the Spacers (139-7153) to the bus.



16. Using 26-Grit Sandpaper, scuff the bus body where the Spacers (139-7153) will be bonded.
17. Using Isopropyl Alcohol and Shop Towels, clean the scuffed areas on the bus body.
18. Using a Plexus Gun, apply Plexus (018362) to the bonding surface of the Streetside Spacer (139-7153).
19. Press the Spacer (139-7153) into position on the Streetside of the bus.
20. Using Gorilla Tape, secure the Spacer (139-7153) into position for curing.
21. Repeat the process to bond a Spacer (139-7153) to the Curbside of the bus.
22. Allow 90 minutes for the Plexus (018362) to cure.
23. Install the replacement Wall Panels (025840-01AA01 and 025843-01AF01) if they were provided in the kit.
24. Using a Power Drill with a 10mm Drill Bit, drill pass through holes in the Wall Panels that match the location of the pass-through holes in the Spacers (139-7153).
25. Using the following illustration as a guide, test fit the Modesty Panel and Brackets (147-1412 and 147-1409) onto the Streetside of the bus. Do not tighten the fasteners.



26. Using the following illustration as a guide, slide the Bracket along the slot shown as Group A so that it is flush with the wall panel and the panel is compressed down to the bonded Spacer (139-7153). The hardware for Group A is M6 Screw (025129-004), Washer (016876) and Acorn Nut (019239).



27. Install the M6 Screws (018082-007) into the location shown a Group B.
28. Using a Calibrated Torque Wrench with a T-30 Torx Socket, torque the fasteners to 5 foot pounds.
29. Repeat the process to install the Modesty Panel and Brackets to the Curbside of the bus.
30. Remove the Lockout/Tagout devices and return the bus to service.