



**PROTERRA**



# IMPROVEMENT OFFERING

<b>ISSUE DATE:</b>	9/7/2021
<b>SERVICE BULLETIN SUBJECT:</b>	Underbody Horn Shield Retrofit
<b>VINs or MODELS AFFECTED:</b>	Service Specified Buses
<b>COMPLETE BY:</b>	Next Service Opportunity
<b>SERVICE BULLETIN #:</b>	SC-21-121
<b>LABOR OPERATION CODE:</b>	UU46H

**NOTICE!** It is expected that this process will require 1/2 hour per bus. Please schedule appropriately to minimize vehicle downtime.

## UNDERBODY HORN SHIELD RETROFIT

### Description

This procedure adds a shield to the underbody horn to prevent water intrusion.

## Tools/Parts Required

### Tools and Supplies Required:

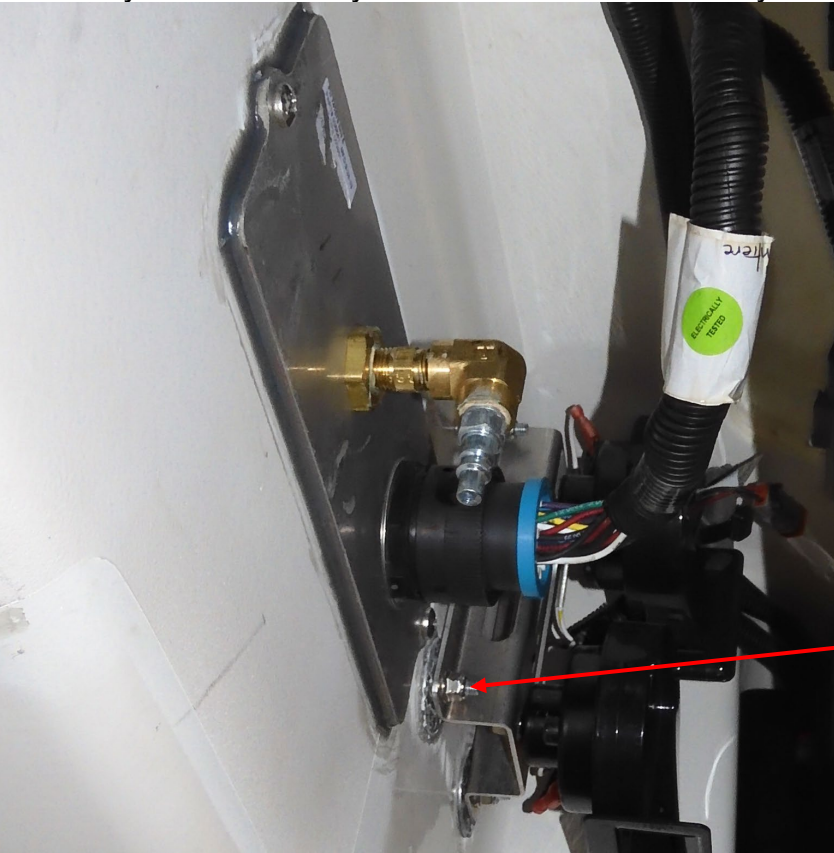
- Ratchet
- 10mm Socket
- Calibrated Torque Wrench
- Orange Torque Stripe Paint

### Kit Parts Required:

- 059283 RETROFIT KIT, HORN COVER, SPOKE (Consisting of)
  - 027937 COVER, HORN 1 EA
  - 018575 LOCKNUT, HEX, M6-1.0, SST, DIN 6926-A2, NYLOCK 2EA

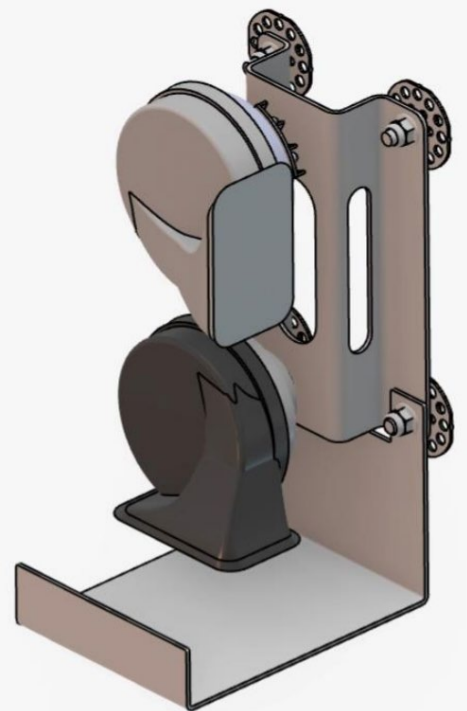
## Procedure:

1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using a 10mm Ratchet/Socket, remove the two locknuts that secure the bottom of the Horn Assembly to the bus body. Discard the Locknuts. They will not be reused.



Remove Bottom  
Two Locknuts

3. Place the Cover (027937 ) on top of the Horn Bracket as shown in the following illustration.



4. Using a 10mm Ratchet/Socket, secure the Cover (027937) to the Horn Bracket with two new Locknuts (018575) from the kit.
5. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the Locknuts (018575) to 71 inch pounds.**
6. Using Orange Torque Stripe Paint, mark the properly torqued fasteners.
7. Remove the Lockout/Tagout devices and return the bus to service.