



# TECHNICAL SERVICE BULLETIN

<b>ISSUE DATE:</b>	4/26/2021
<b>SERVICE BULLETIN SUBJECT:</b>	Duopower Belly Pan Fastener Retrofit
<b>VINs or MODELS AFFECTED:</b>	Service Specified Buses
<b>COMPLETE BY:</b>	Next Service Opportunity
<b>SERVICE BULLETIN #:</b>	SC-21-60
<b>LABOR OPERATION CODE:</b>	UU43Z

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

## DUOPOWER BELLY PAN FASTENER RETROFIT

### Description

The procedure replaces the belly pan fasteners with improved fasteners for better weather resistance.

## Tools/Parts Required

### Tools and Supplies Required:

- Ratchet
- 10mm Socket
- Calibrated Torque Wrench
- Orange Torque Stripe Paint
- Heavy Duty Jacks
- Heavy Duty Jack Stands

### Kit Parts Required:

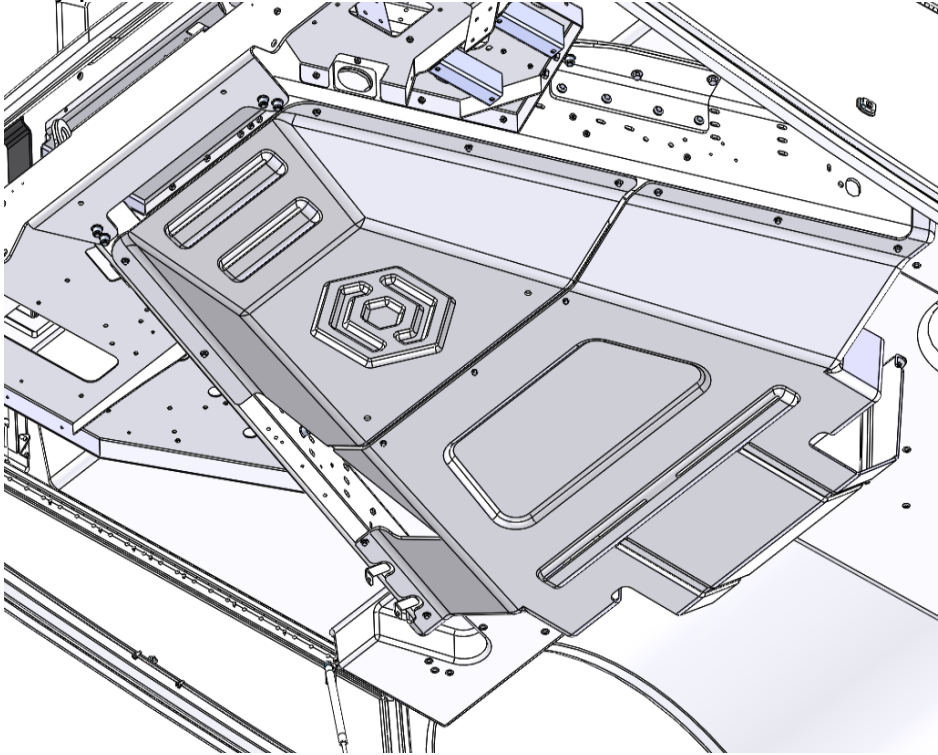
- 057554 SERVICE KIT, DUOPOWER BELLYPAN FASTENERS (Consisting of)
  - 017655-005 BOLT,HEX,FLG,STL,1000HSS,CLASS 8.8,M6-1.0X25X25 15 EA

### Parts Required but not Included in the Kit:

- 018218 WASHER,LARGE FLAT,STL,1000HSS,CLASS 10.9, M6 15 EA

## Procedure

1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. Using Heavy Duty Jacks and Jack Stands, safely lift and support the bus to access the rear belly pans on the bus.



3. Using a 10mm Ratchet/Socket, remove each of the original fasteners one at a time.
4. Using a 10mm Ratchet/Socket, replace the removed fastener with a new M6 Bolt (017655-005) and Washer (018218).
5. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the fastener to 80 inch pounds.**
6. Repeat the process to replace and torque all the belly pan Bolts (017655-005) and Washers (018218).
7. Safely lower the bus.
8. Remove the Lockout/Tagout devices and power on the bus.