ISSUE DATE:	3-18-2021
SERVICE BULLETIN SUBJECT:	Upper Intermediate Shaft to Steering Column Torque Verification
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-21-45
LABOR OPERATION CODE:	N/A

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

UPPER INTERMEDIATE SHAFT TO STEERING COLUMN VERIFICATION

Retrofit Description:

This procedure applies the proper torque to the intermediate steering column bolt.

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PROTERRA
Headquarters: 1815 Rollins Road, Burlingame, CA 94010
East Coast Manufacturing: 1 Whitlee Court, Greenville, SC 29607
West Coast Manufacturing: 383 Cheryl Lane, City of Industry, CA 91789

Tools/Parts Required

Tools and Supplies Required:

- T-30 Torx Driver
- Ratchet
- Calibrated Torque Wrench
- 11/16-Inch Socket
- 11/16-Inch Combination Wrench
- Orange Torque Stripe Paint

Parts Required:

- None

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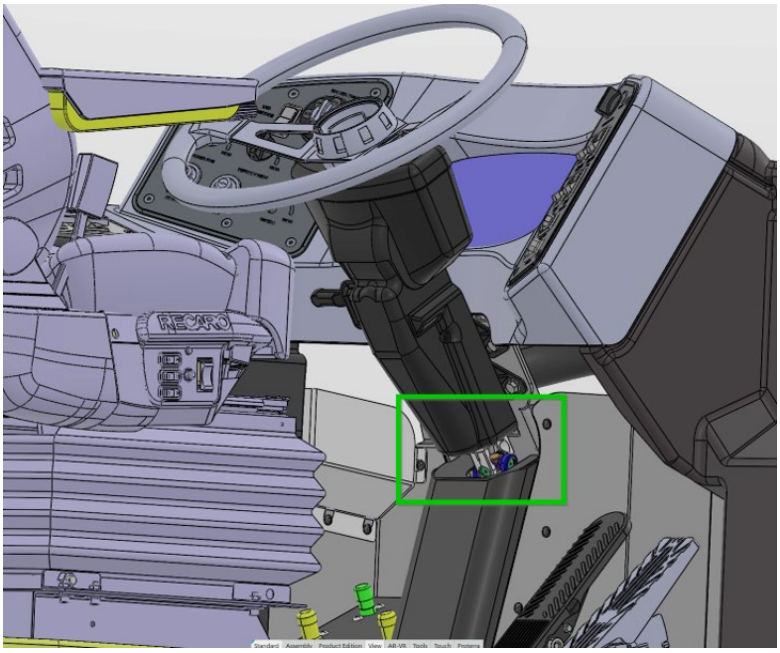
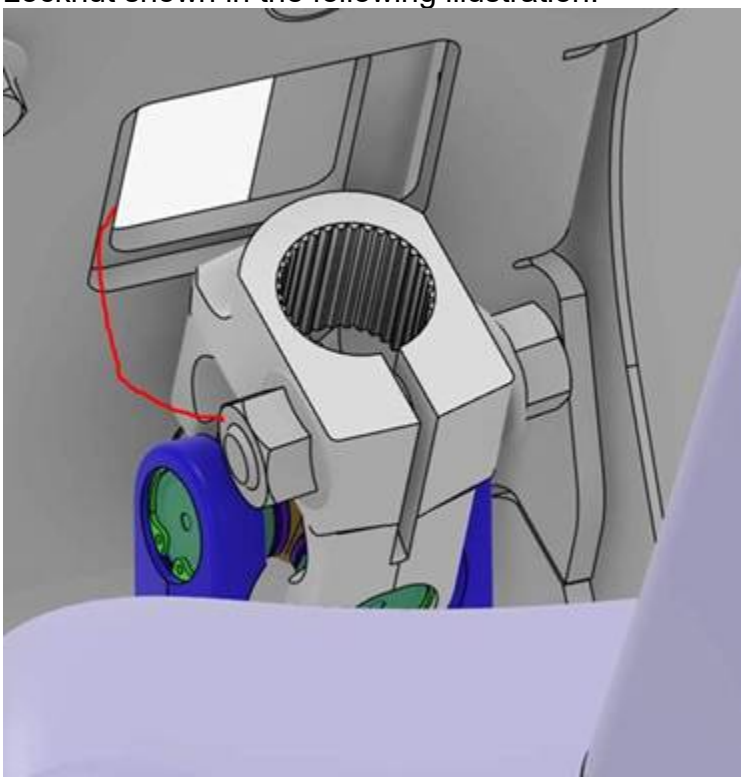
Procedure

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

2. Using a T-30 Torx Driver, remove any panels necessary to access the Steering Column Intermediate Shaft shown inside the Green Box in the following illustration.



3. Using an 11/16-Inch Ratchet/Socket and a 11/16-inch Combination Wrench, loosen the Locknut shown in the following illustration.



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4. Using a Calibrated Torque Wrench with an 11/16-Inch Socket on the Locknut and a 11/16-Inch Combination Wrench on the Bolt, **torque the Locknut to 60 foot pounds.**

5. Rotate the Steering Wheel left and right throughout its full range to ensure that it operates smoothly with no interference from adjacent components.

6. Using Orange Torque Stripe Paint, mark the properly torqued Locknut.

7. Using a T-30 Torx Driver, replace any panels that were removed to access the hardware.

8. Remove the Lockout/Tagout devices and return the bus to service.

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