ISSUE DATE:	1-8-2021
SERVICE BULLETIN SUBJECT:	Battery Ground Cable Lug Torque Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-21-5
Labor Operation Code:	HB41Z

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

BATTERY GROUND CABLE LUG TORQUE RETROFIT

Retrofit Description:

This procedure ensures that the high voltage battery cable ground lugs are torqued to the proper specification.

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:

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

Parts Required:

- None

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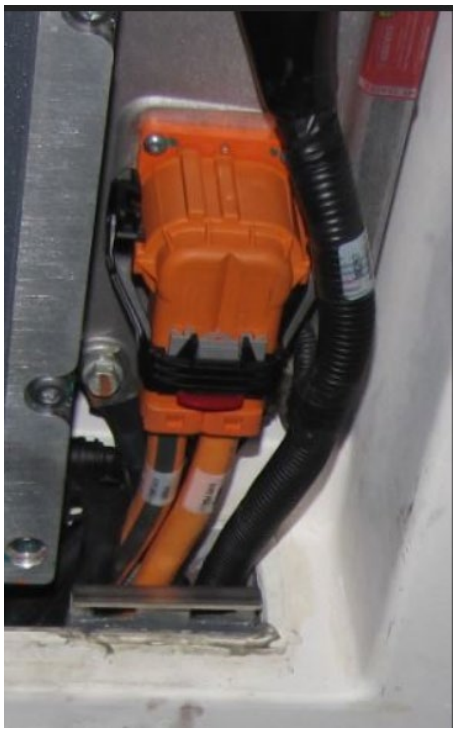
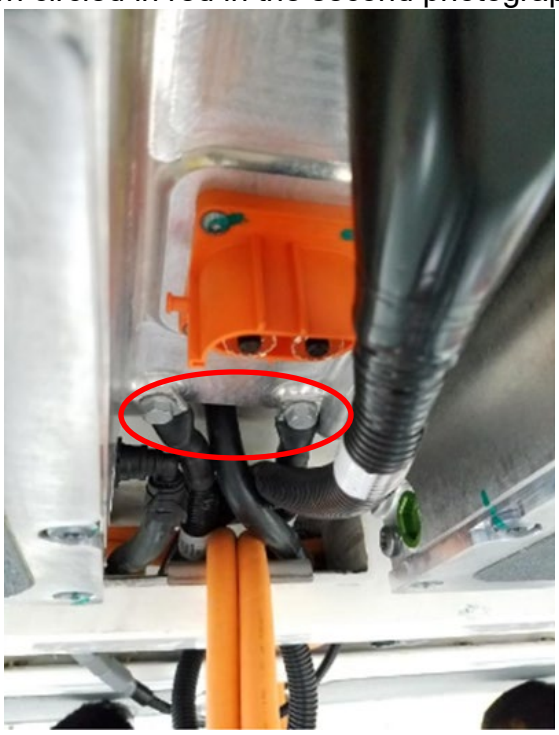
Procedure:

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

2. Using proper safety procedures, lift the bus to access the high voltage battery packs underneath the bus. Ensure that the bus is properly supported with Jack Stands.

3. Locate the two Ground Connections shown in the following photographs on one of the battery packs. The second photograph shows the ground connections with the high voltage connector removed for clarity. This connector should not need to be removed to access the ground connections. The bolts are shown circled in red in the second photograph.





4. Using a 10mm Ratchet/Socket, remove one of the bolts.

5. Apply a small amount of Loctite 242 to the threads of the removed bolt.

6. Using a 10mm Ratchet/Socket, reinstall the bolt.

7. Using a Calibrated Torque Wrench with a 10mm Socket, **torque the bolt to 13 foot pounds.**

8. Using Orange Torque Stripe Paint, mark the properly torqued bolt.

9. Repeat the process for the second ground connection on this battery pack.

10. Continue this process to properly torque and mark the bolts on the remaining high voltage battery packs. If the bus has rooftop battery packs, these bolts must be torqued as well.

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

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