



PROTERRA



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	11-5-2020
REVISION DATE:	7-3-2022
SERVICE BULLETIN SUBJECT:	40 Foot Side Window Wider Seal Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-20-159
Labor Operation Code:	WG42Z

NOTICE! It is expected that this process will require 4 hours per bus. Please schedule appropriately to minimize vehicle downtime.

40 FOOT SIDE WINDOW WIDER SEAL RETROFIT

Retrofit Description:

This updates the side window seals to a wider version to prevent leaks.

Tools/Parts Required

Tools and Supplies Required:

- Suction Cups
- T-20 Torx Bit
- Drill Driver
- Calibrated Torque Wrench
- Approved Safety Knife
- Putty Knife
- Alcohol
- Shop Towels

Kit Parts Required:

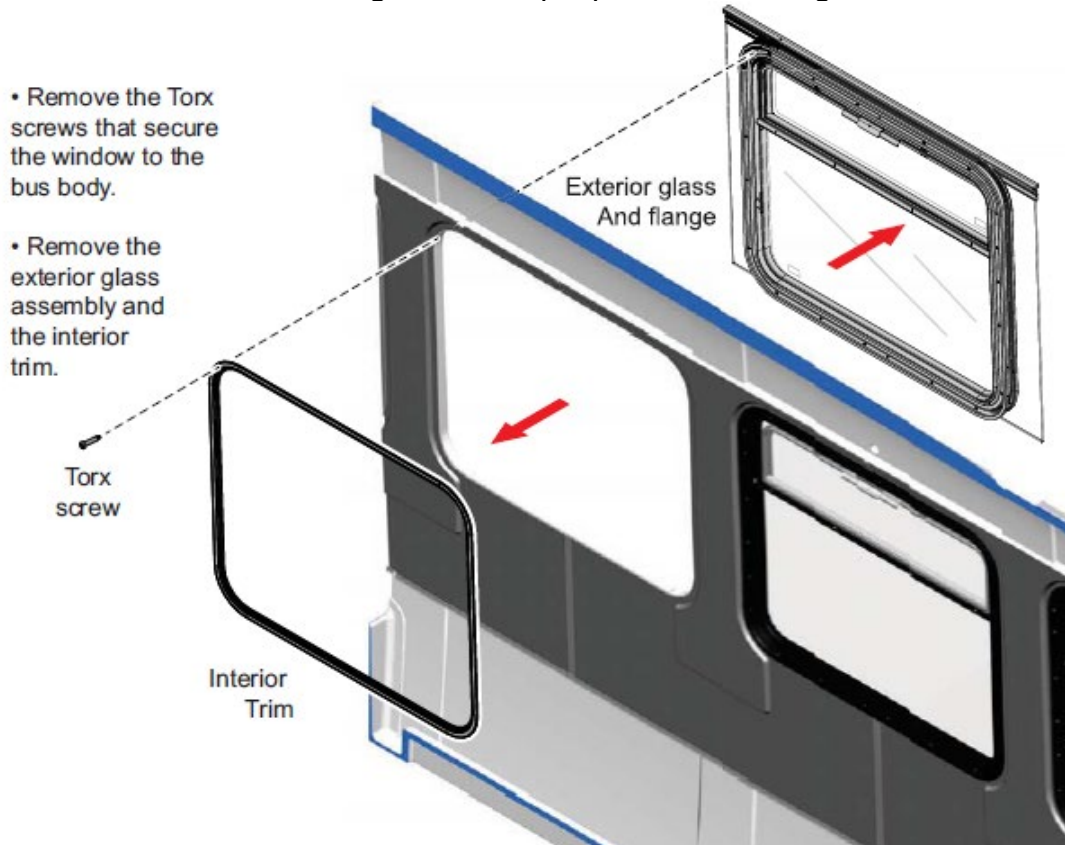
- 056021 SERVICE KIT, WINDOW SEALS, 40' (Consisting of)
 - 051506 SEAL, SIDE WINDOWS 198 FT
 - 017093 SCREW, #10 TORX PH, #8 HD, TEK, 410 SS, BLK OX, 1" 334 EA

Additional Parts Required:

- 053106 Shim, Window 1/16" thick 30 EA
- 053107 Shim, Window 3/16" thick 30 EA
- 016103 SEALANT, BUTYL, NON-HARDENING 1 EA

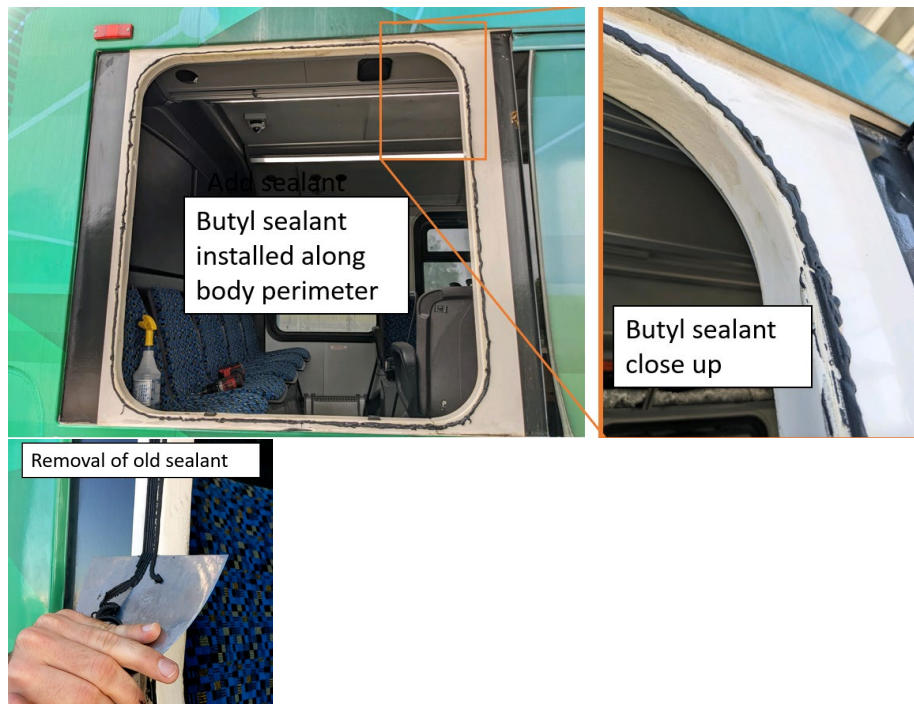
Procedure:

1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. On the interior of the bus, remove the side window trim (031241) that covers the fasteners securing the side window in place and mark the trim location using tape and a marker.
3. On the interior of the bus and working one window at a time, using a T-20 Torx Bit and Drill Driver, remove all Torx screws securing the side window.
IMPORTANT! Ensure the exterior window glass and frame are properly supported on the exterior of the vehicle, using suction cups, prior to removing all of the Torx screws.



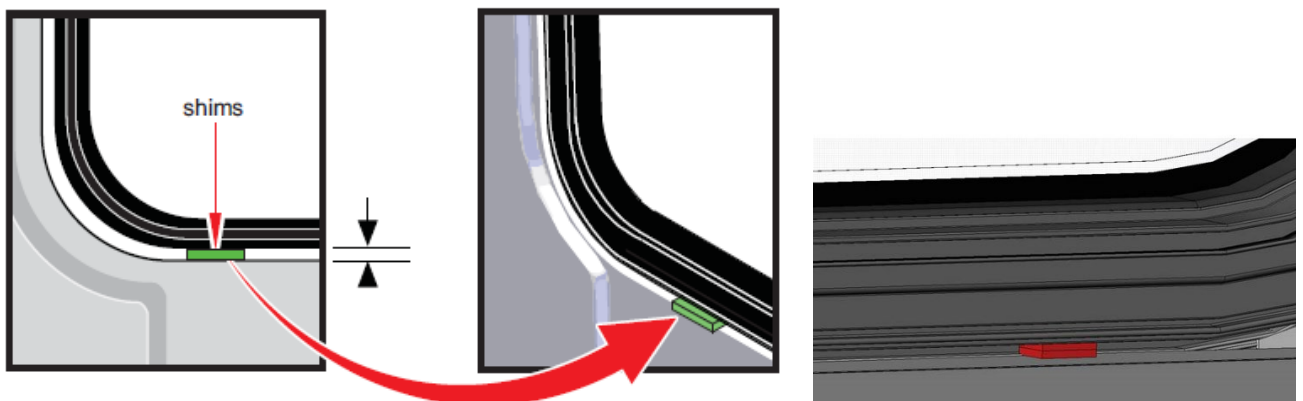
4. Inspect the window for damage before carefully placing the window in a suitable location for replacing the Seal (051506).
5. Using a Putty knife, remove the existing Seal from the window.
6. Using Alcohol and Shop Towels, clean the area where the seal was removed.
7. Place the new Seal (051506) around the window and cut it to length with an approved safety knife.
8. Remove the Adhesive Backing from the Seal (051506) and attach the Seal to the outside of the window.

9. Using a Putty Knife, prep the window portal for reinstalling the window by removing the Butyl Sealant from the portal as shown in the following photographs.



10. Using Alcohol and Shop Towels, clean the portal.
11. Apply new Butyl Sealant (**016103**) to the portal.
12. Once the window portal has been prepped, lift and install the exterior window glass and flange into position.
IMPORTANT! Ensure the exterior glass and flange are properly supported using suction cups.
13. On the interior of the bus and working one window at a time, position the appropriate Shims (053106 or 053107) to properly position the side window in the portal to create the proper window seal.

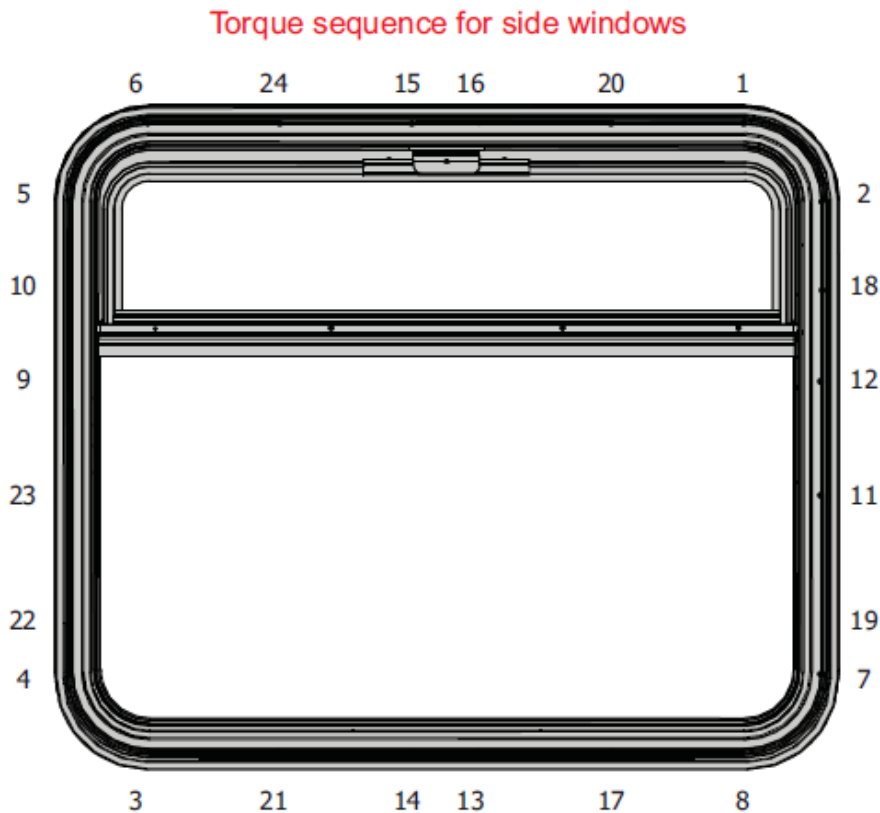
- Place the new window
- During installation use shims under the exterior window frame.



14. With the window properly positioned in the portal, using a T-20 Torx Bit and Drill Driver, install and hand tighten all Torx screws (017093) securing the side window.

IMPORTANT! Ensure the exterior window glass and frame are properly supported on the exterior of the vehicle, using suction cups, while installing all of the Torx screws.

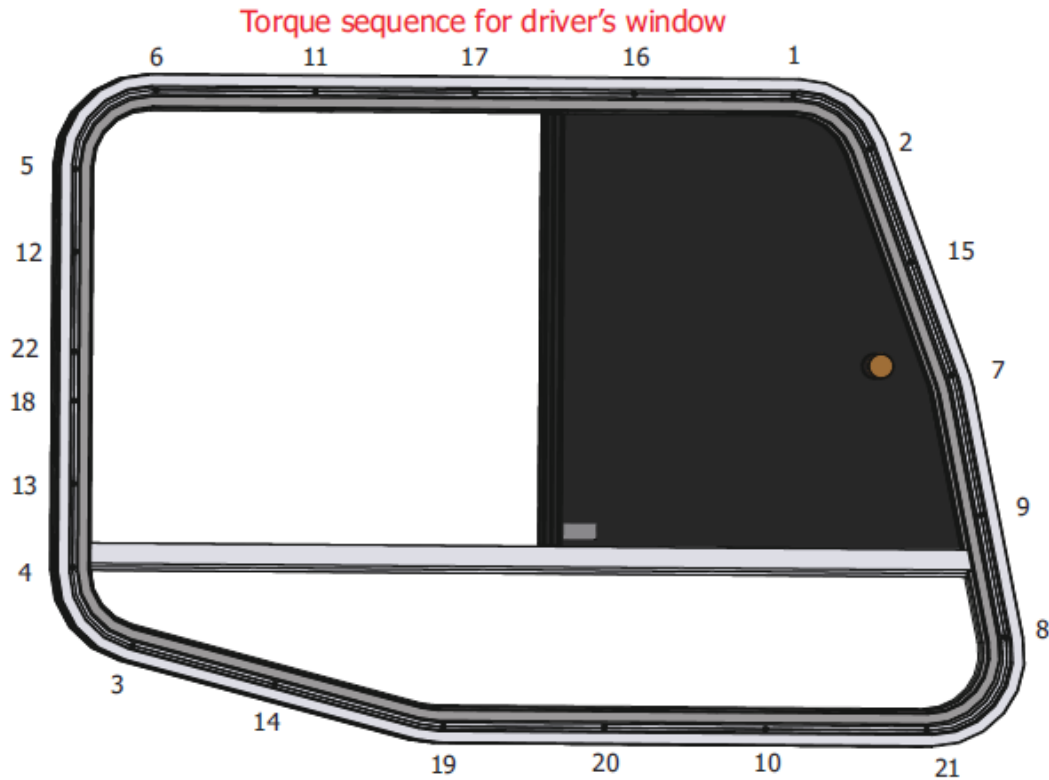
15. Following the torque pattern shown below, **torque each of the Torx screws to 4.5Nm.**



16. Verify window trim position and then reinstall the interior window trim that covers the fasteners.

17. Repeat this procedure for all side windows.

18. When the side windows are complete, repeat the process to replace the Driver's Window. The process is the same except for the torque sequence which is shown below.



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