ISSUE DATE:	10-22-2020
SERVICE BULLETIN SUBJECT:	Wheel Well Box Gas Strut Reinforcement Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SC-20-150
Labor Operation Code:	ID43Z

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

WHEEL WELL BOX GAS STRUT REINFORCEMENT RETROFIT

Retrofit Description:

This procedure adds reinforcement plates to the gas struts on both wheel boxes.

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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:

- Power Drill
- 3/16-Inch Drill Bit
- Ratchet
- 7mm Allen Socket
- 2.5mm Allen Socket
- 2.5mm Allen Driver
- Calibrated Torque Wrench

Parts Required:

- 052582-002 WWB LOWER STRUT MOUNT REINFORCEMENT KIT (Consisting 0f)
  - 052582 PLATE, BACKING, WWB STRUT MOUNT 4 EA
  - 014201-012 SCREW, FLAT HEAD, M4X25X25 8 EA
  - 018255 LKNT, HEX NYLON, SS, M4-0.7 8 EA

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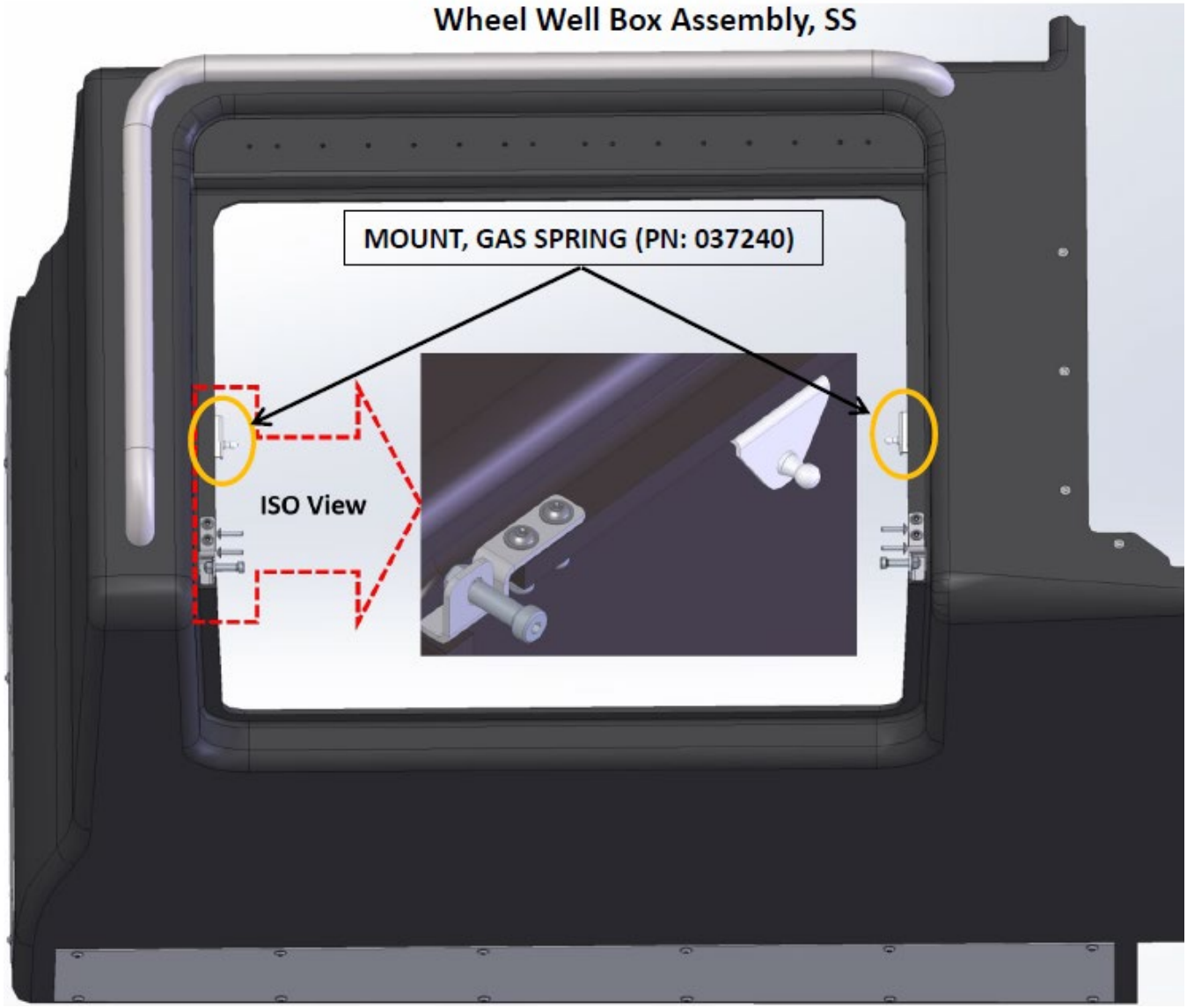
Procedure:

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

   Section A: Complete for all buses.

2. The first steps in this procedure will install reinforcement plates on the Streetside Wheel Well Box as shown in the following illustration.



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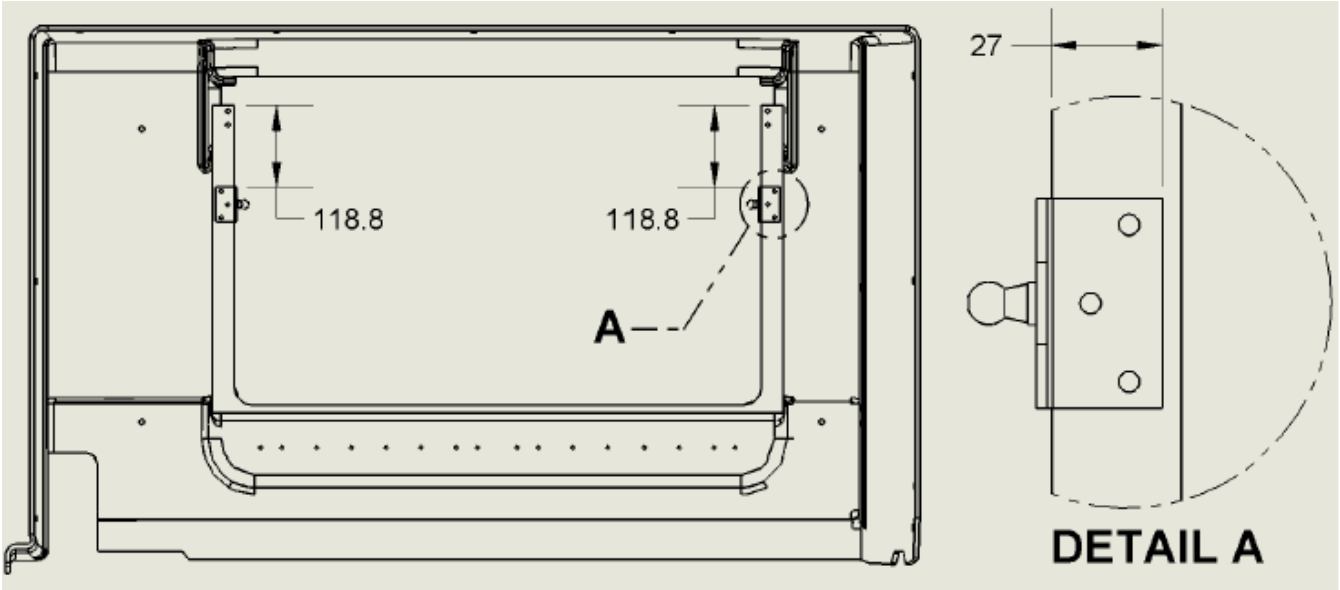
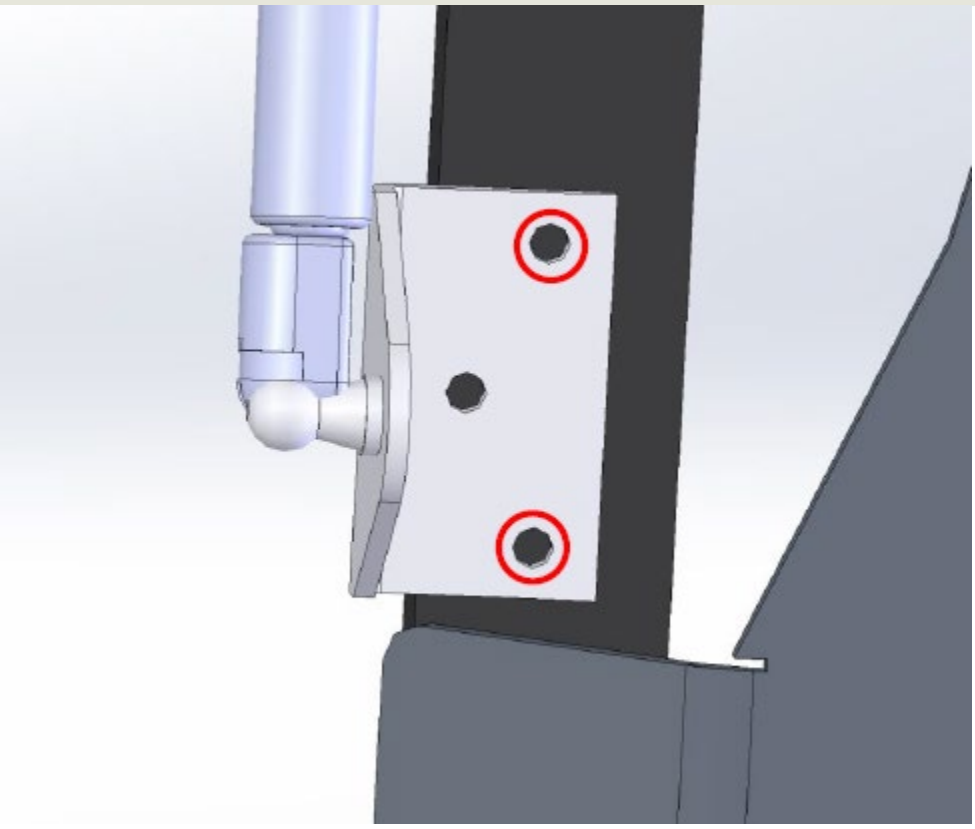
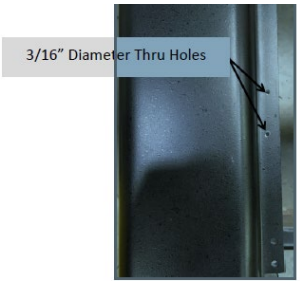
3. Using a Power Drill with a 3/16-Inch Drill Bit, drill a hole in each location shown circled in red in the second illustration below. Do not remove the plate if it is still bonded to the Wheel Well Box. If the plate has de-bonded, use the first illustration to locate the plate before drilling.







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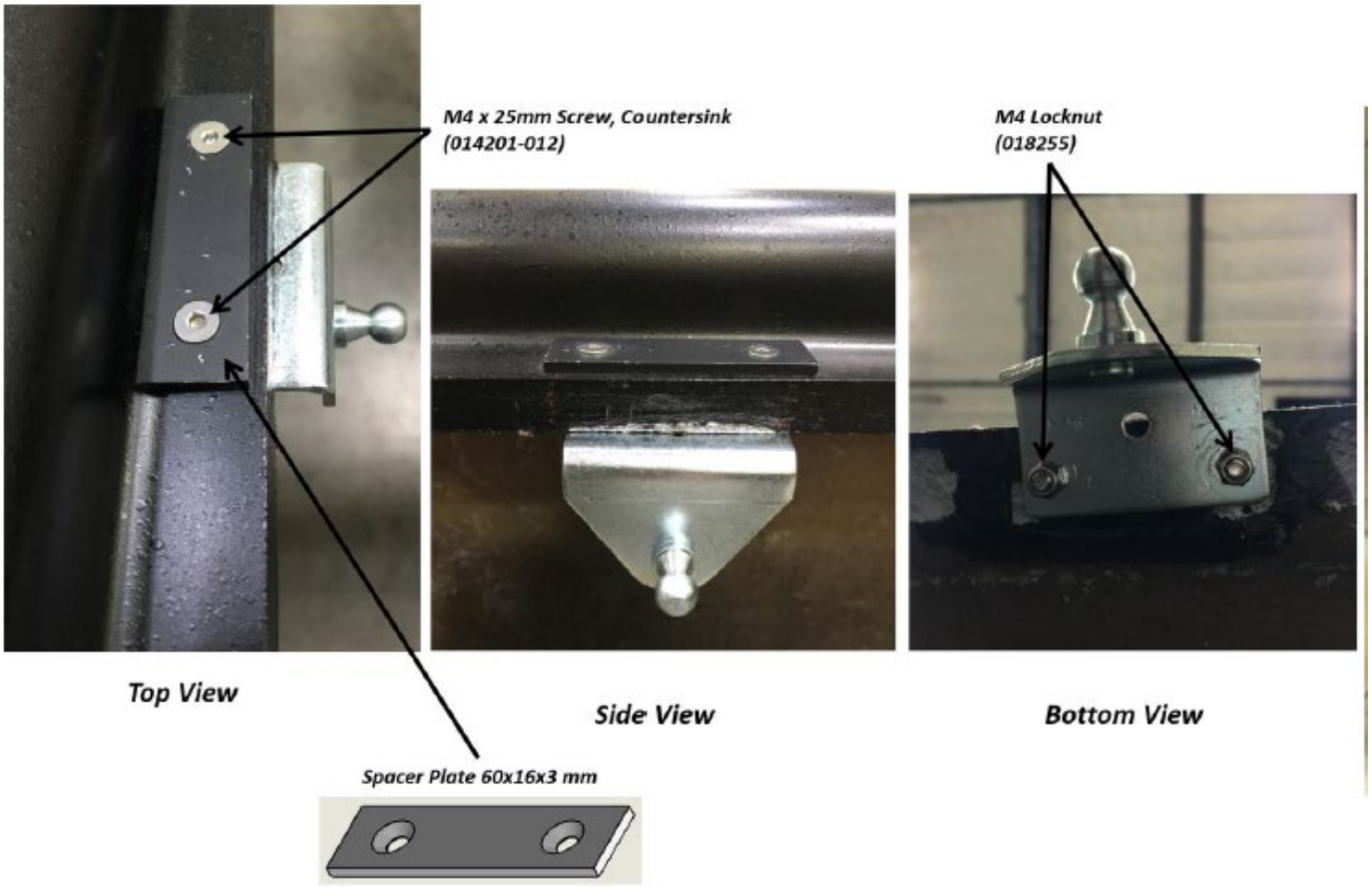
4. Using the following illustrations as a guide, install the Spacer Plates (052582). Use a 2.5mm Allen Socket on the M4 Screws (014201-012) and a 7mm Ratchet/Socket on the Locknuts (018255).



5. Using a 2.5mm Allen Driver and a Calibrated Torque Wrench with a 7mm Socket, **torque the Locknuts (018225) to 22 Inch Pounds.**

End of Section A:

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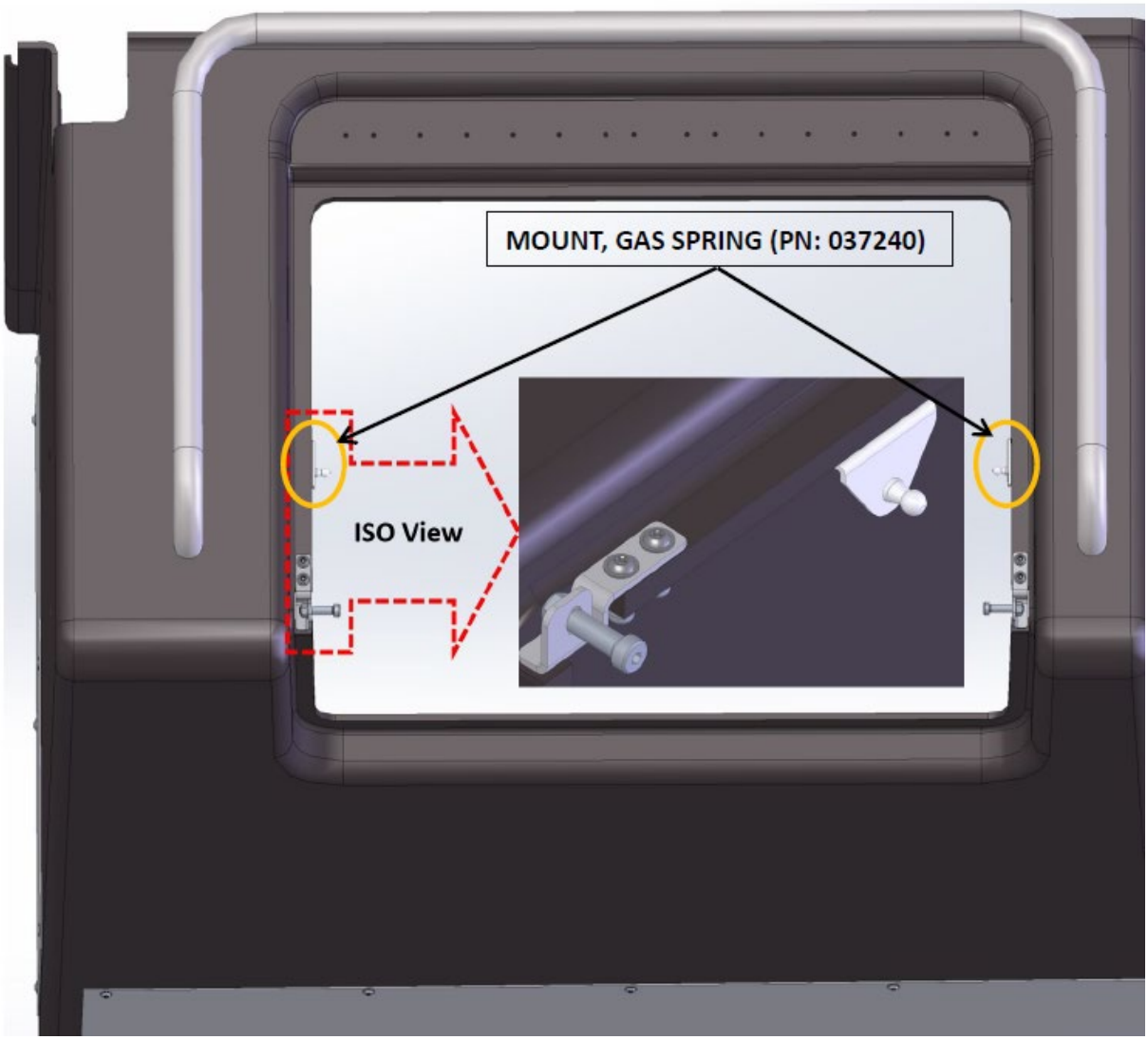
Section B: Complete only on buses with a single Curbside Wheel Well Box Lid.

6. Repeat the previous process to install Spacer Plates (052582) on the Curbside Wheel Box as shown in the following illustration.

Wheel Well Box Assembly, CS



7. If the bus has a single lid on the Curbside of the bus, the retrofit process is complete.
8. Verify that the lids on both wheel well boxes open and close smoothly.
9. Remove the Lockout/Tagout devices and return the bus to service.

End of Section B:

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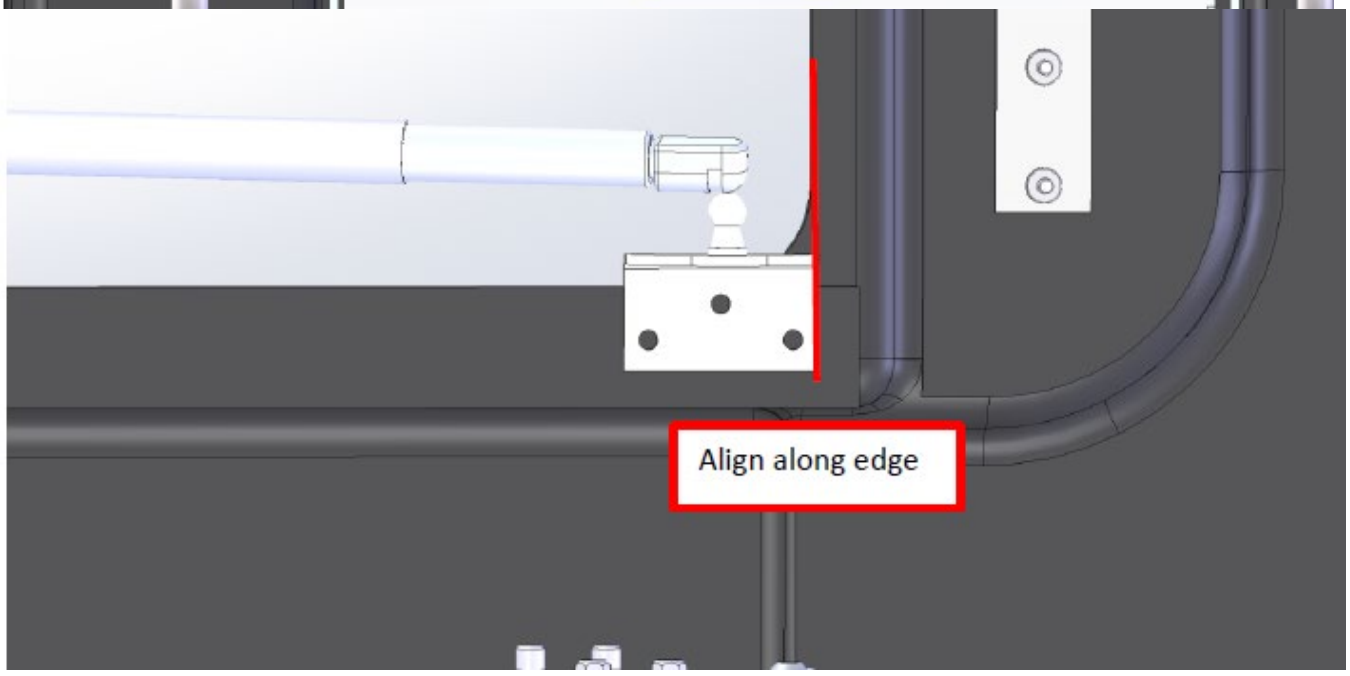
Section C: Complete only on buses with a double Curbside Wheel Well Box Lid.

10. This part of the procedure will install reinforcement plates on the Curbside Wheel Well Box with double lids as shown in the following illustrations.



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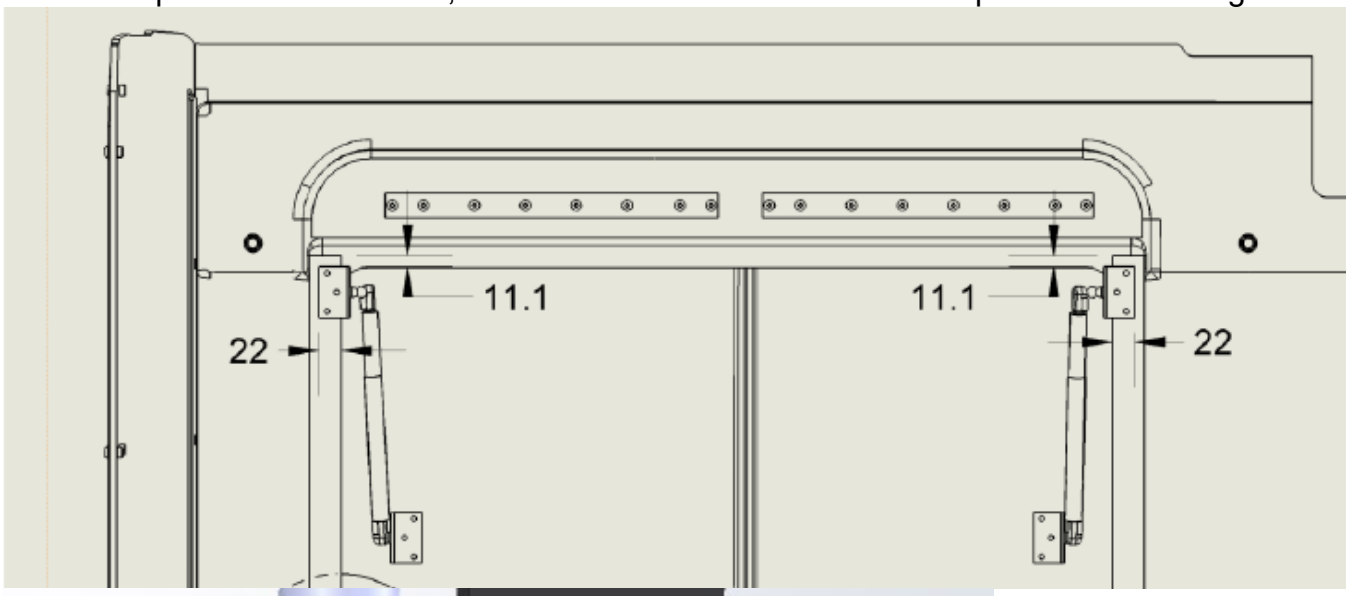
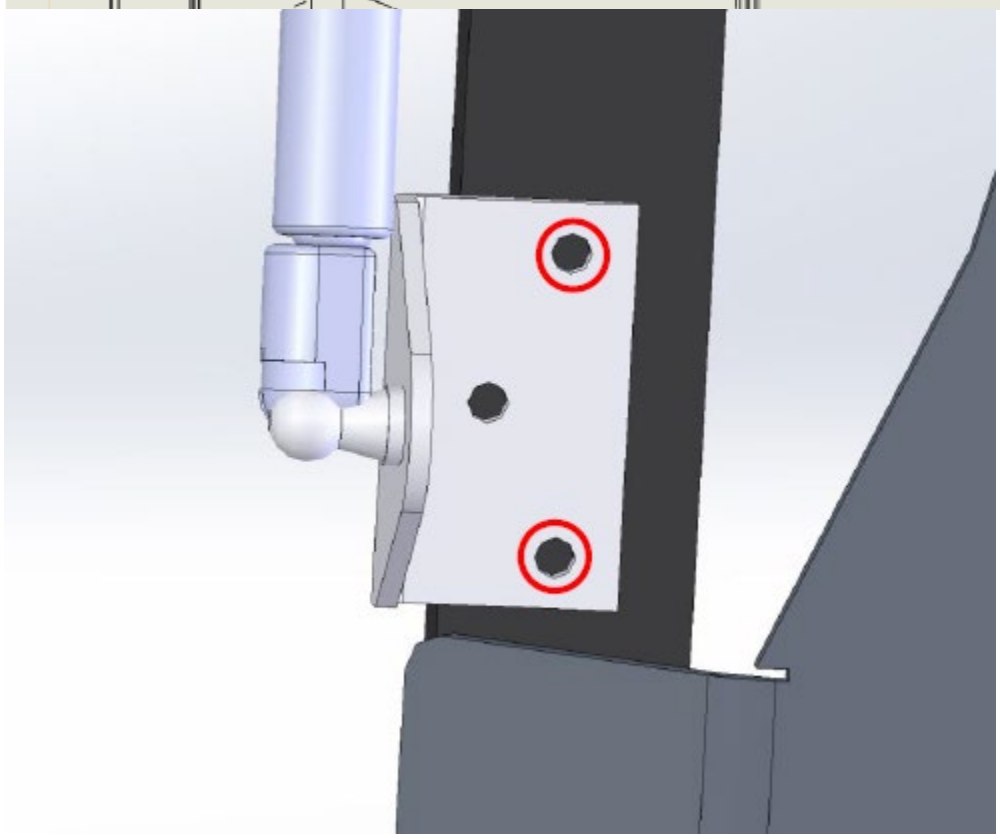
11. Using a Power Drill with a 3/16-Inch Drill Bit, drill a hole in each location shown circled in red in the second illustration below. Do not remove the plate if it is still bonded to the Wheel Well Box. If the plate has de-bonded, use the first illustration to locate the plate before drilling.





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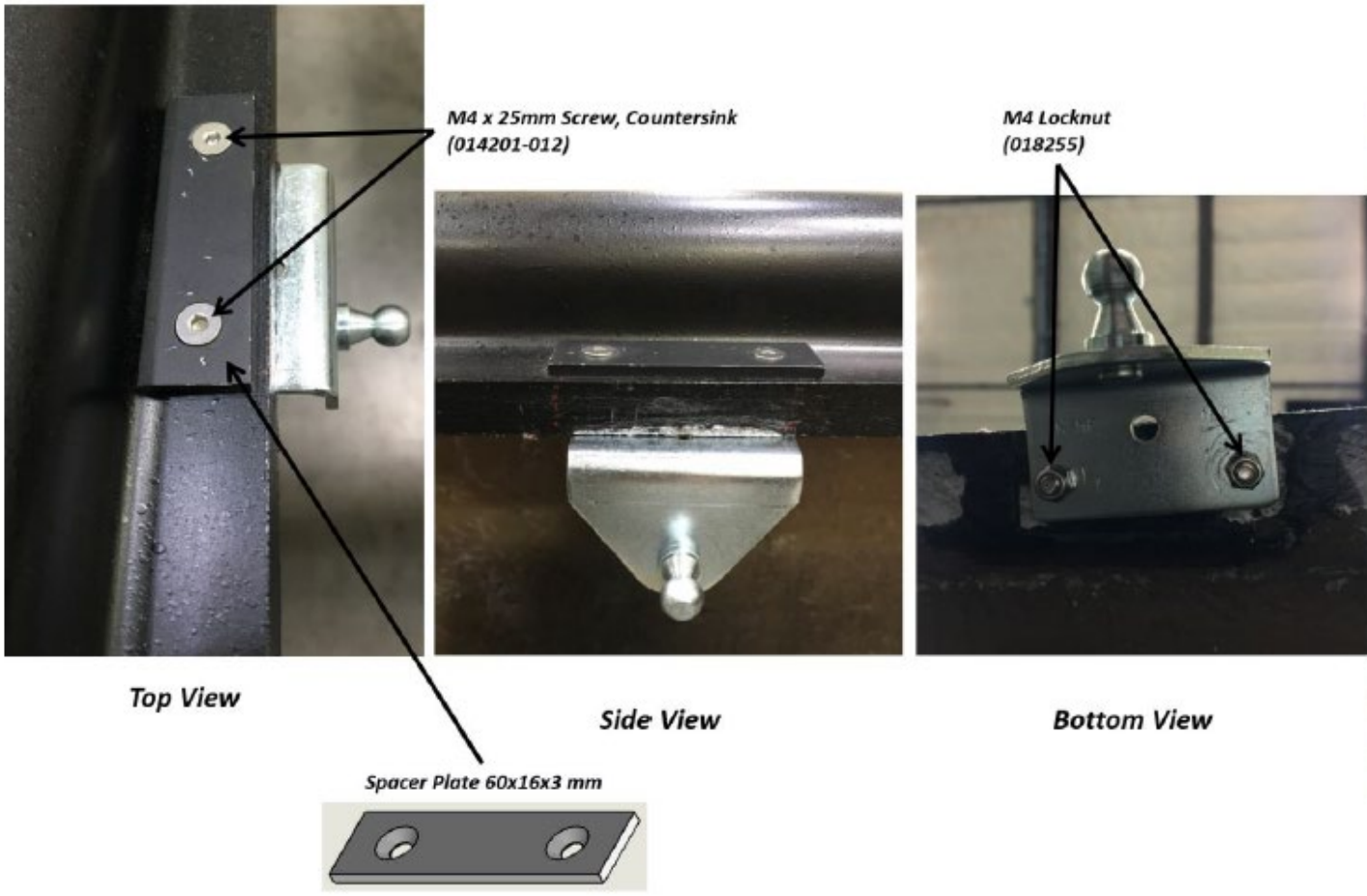
12. Using the following illustrations as a guide, install the Spacer Plates (052582). Use a 2.5mm Allen Socket on the M4 Screws (014201-012) and a 7mm Ratchet/Socket on the Locknuts (018255).



13. Using a 2.5mm Allen Driver and a Calibrated Torque Wrench with a 7mm Socket, **torque the Locknuts (018225) to 22 Inch Pounds.**

14. Verify that the lids on both wheel well boxes open and close smoothly.

End of Section C:

15. Remove the Lockout/Tagout device and return the bus to service.

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