



PROTERRA



TECHNICAL SERVICE BULLETIN

ISSUE DATE:	6/29/2020
REVISION DATE:	7-13-2022
SERVICE BULLETIN SUBJECT:	Side Window Seal Retrofit
VINs or MODELS AFFECTED:	Service Specified Buses
COMPLETE BY:	Next Service Opportunity
SERVICE BULLETIN #:	SB-20-85

SIDE WINDOW SEAL RETROFIT

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

Retrofit Description:

This retrofit adds improved window seals to prevent water intrusion into the bus.

Tools/Parts Required

Tools and Supplies Required:

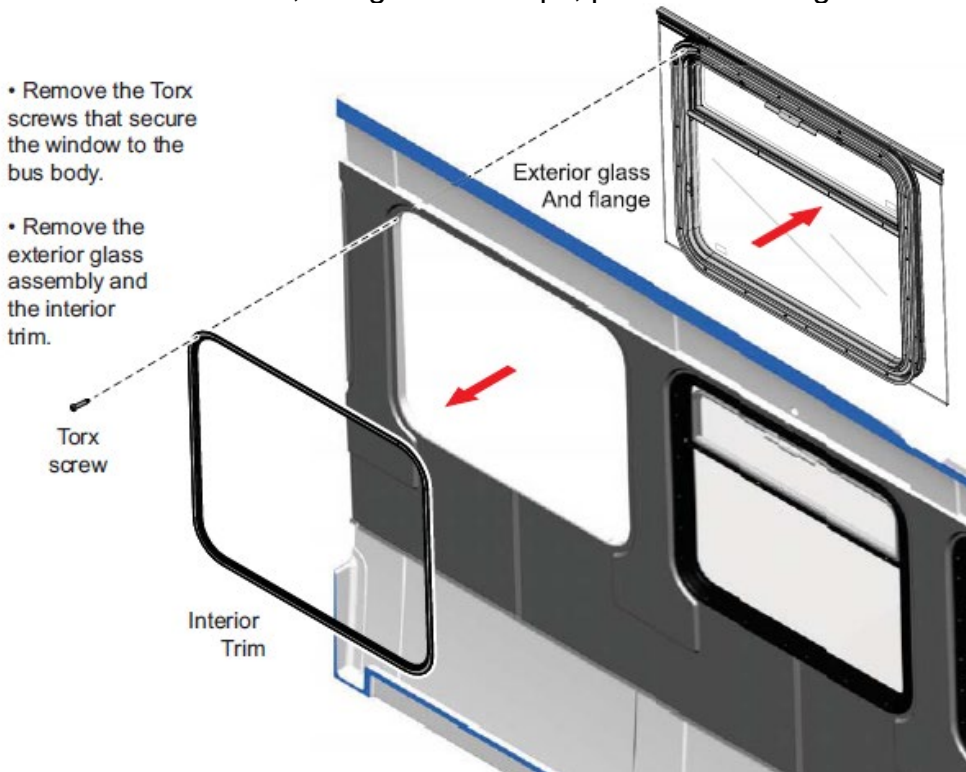
- Suction Cups
- T-20 Torx Bit
- Drill Driver
- Masking Tape
- Permanent Marker
- Calibrated Torque Wrench
- Putty Knife
- Approved Safety Knife

Parts Required:

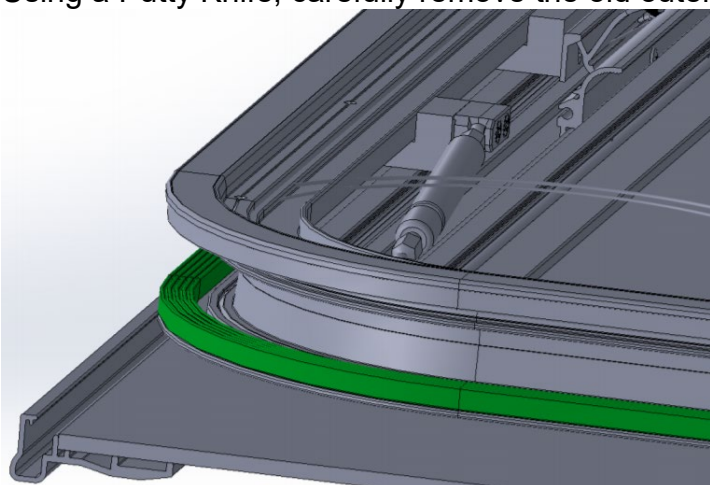
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|----------|--|--------|
| • 051506 | SEAL, SIDE WINDOWS | 170 FT |
| • 017093 | SCREW, #10 TORX PH, #8 HD, TEK, 410 SS, BLK OX, 1" | 334 EA |
| • 016103 | SEALANT, BUTYL, NON-HARDENING | 1 EA |

Procedure:

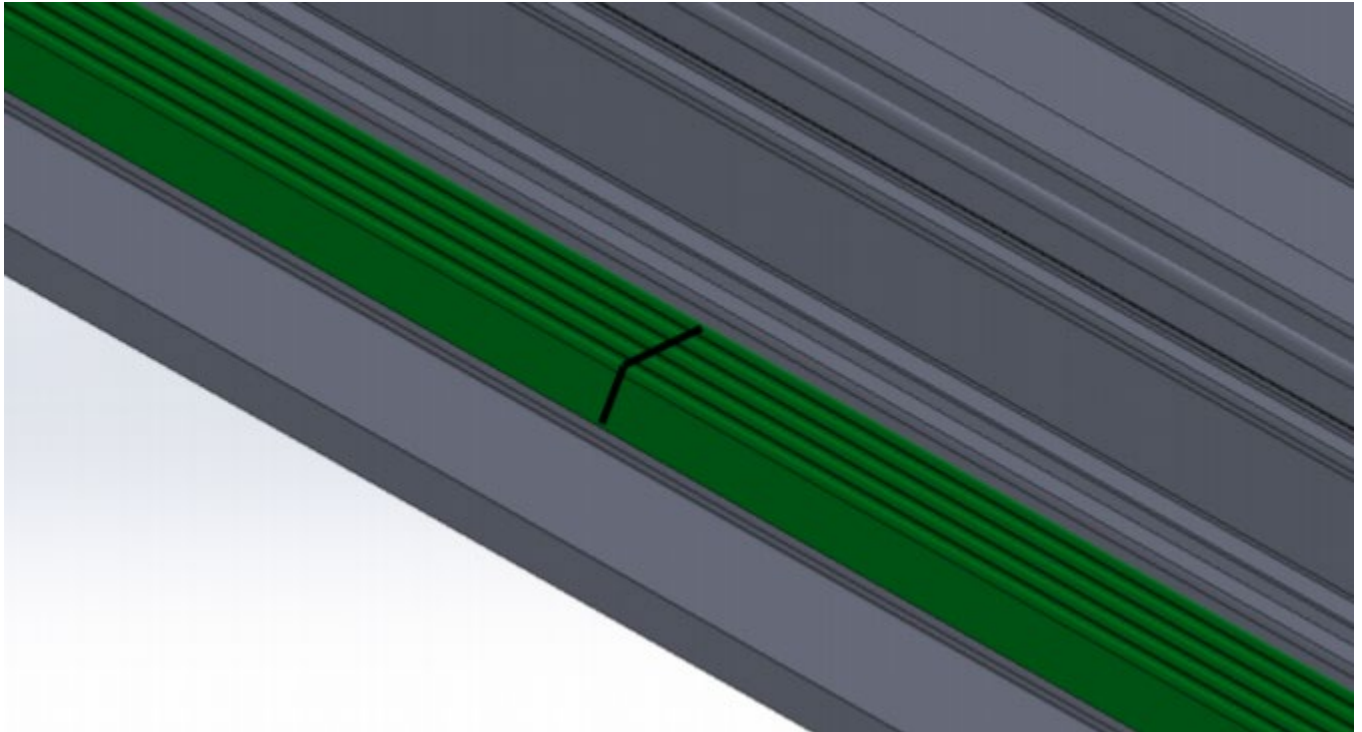
1. Complete the Proterra approved Lockout/Tagout procedure to make the bus safe for work.
2. On the interior of the bus, remove the side window trim (**031241**) that covers the fasteners securing the side window in place and mark the trim location using tape and a marker.
3. On the interior of the bus 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 the Torx screws.



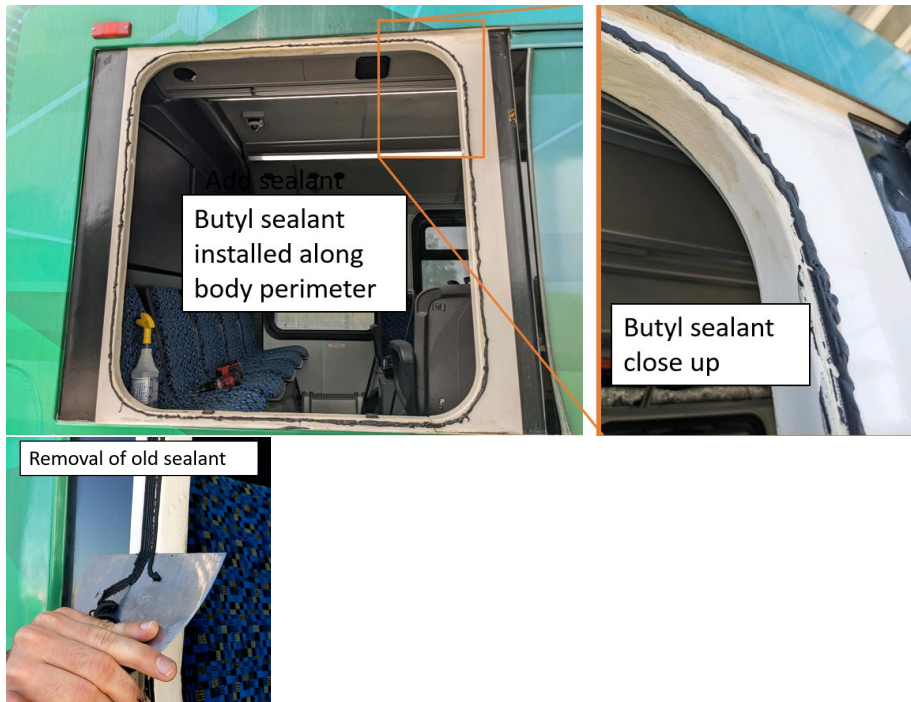
4. Carefully place the window in a suitable location for installing the new Seal (**051506**).
5. Using a Putty Knife, carefully remove the old outer seal from the window frame.



6. Using Shop Towels and Isopropyl Alcohol, remove any leftover seal residue from the window frame and clean the surfaces of the frame.
7. Using an approved Safety Knife, cut the new Seal **(051506)** to the correct length to fit the window.
8. Carefully peel the Adhesive Backing off the new Seal **(051506)**.
9. Starting at the bottom of the window, press the adhesive side of the Seal (051506) to the window frame. Continue around the window frame to attach the remaining portion of the Seal to the frame.
10. Using an approved Safety Knife, carefully trim the Seal (051506) so that the two ends meet at the bottom of the window. Try to leave the least amount of gap as possible between the ends of the seal as shown below.



11. 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.



12. Using Alcohol and Shop Towels, clean the portal.

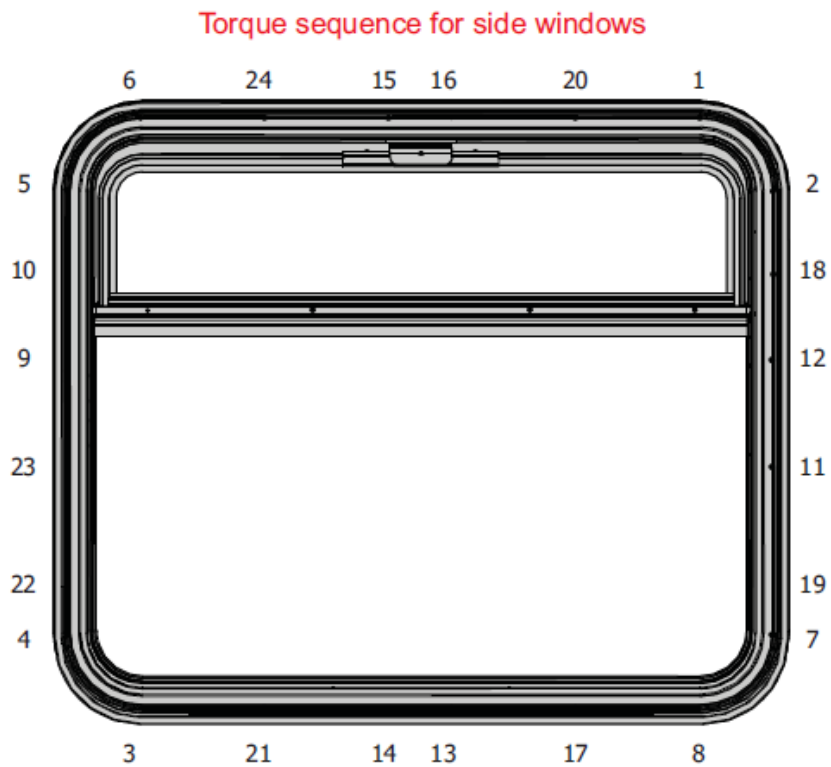
13. Apply new Butyl Sealant (**016103**) to the Seal (**051506**).

14. Carefully place the window with the new Seal (**051506**) back into the window portal.

15. With the window properly positioned in the portal, using a T-20 Torx Bit and Drill Driver, install and hand tighten all new 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 the Torx screws.

16. Following the torque pattern shown below, **torque each of the Torx Screws (017093) to 40 Inch Pounds.**



17. Verify window trim position and then reinstall the interior window trim that covers the fasteners.
18. Repeat this procedure for all side windows.
19. When the Seals **(051506)** have been replaced on all windows, remove the Lockout/Tagout devices and return the bus to service.