



INSTRUCTION TO SERVICE

ITS: 61283		March 4, 2025
SECTION:	219-Exhaust System	
WRITTEN BY:	New Flyer Service Engineering	
SUBJECT:	Replace existing turbo outlet exhaust elbow with redesigned elbow and gasket	
ISSUE:	Exhaust leak present at the turbo outlet and exhaust elbow joint	
SUMMARY:	The existing elbows will be replaced with a redesigned elbow that has a gasket implemented in the joint to ensure no exhaust leak is present.	

ITS61283

Ref. NHTSA Recall No.	Ref. Transport Canada Recall No.
Not Applicable	Not Applicable

THIS ITS DOCUMENT SHOULD BE RETAINED AND REFERRED TO FOR FUTURE MAINTENANCE UNTIL THE NEW FLYER PARTS AND/OR SERVICE MANUAL IS UPDATED TO REFLECT WORK DONE AS A RESULT OF THIS DOCUMENT. ENSURE THAT THIS DOCUMENT IS AVAILABLE FOR PARTS AND MAINTENANCE STAFF GOING FORWARD.

PROCEDURE:

1. Set park brake and chock wheels.
2. Turn the main battery disconnect switch to the “OFF” position.
3. In the engine compartment of the bus, locate and remove and retain the existing turbo outlet exhaust elbow and clamps.
4. Inspect the existing gasket on the exhaust tube side of the elbow for gasket integrity. If any damage is found replace with a new gasket (NF PN 395859).
5. Insert the new gasket into the turbo outlet end of the exhaust elbow and install the redesigned exhaust elbow (NF PN 1115025).
6. Ensure the turbo exhaust elbow is aligned with both the turbo outlet and the exhaust tube. Torque the existing clamps as shown in Figure 1.

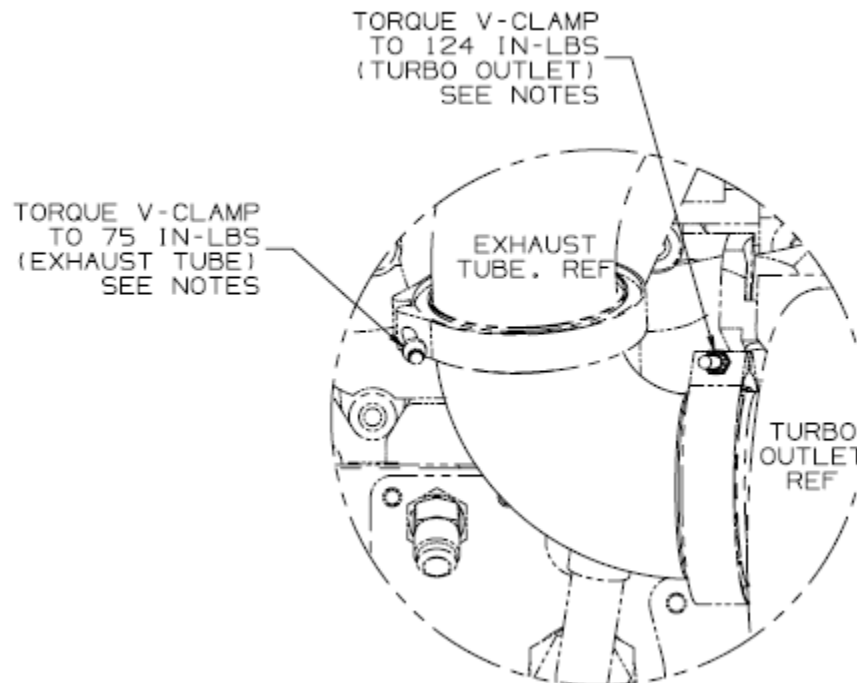


Figure 1: Align Turbo Exhaust Elbow and Torque Clamps

7. Tap lightly around the perimeter of the clamps with a rubber mallet to ensure the elbow and gaskets have properly seated, then recheck the torque on the clamps. Repeat as required until the torque value is consistently maintained.
8. Return the removed turbo exhaust elbow to your New Flyer Regional Product Support Manager.
9. Clean up all tools and debris and return the bus to service condition.
10. Turn the main battery disconnect switch to the “ON” position.

LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Replace existing turbo outlet exhaust elbow with redesigned elbow and gasket	1	1.5	1.5

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	395859	GASKET-MARMON 3.5" STD	2	EA	If Required
2	1115025	TUBE-EXHAUST TURBO OUT L9	1	EA	