INSTRUCTION TO SERVICE

ITS61456	02/12/26
SECTION:	460-Windows
SUBJECT:	Realign windshield support plate
ISSUE:	Vertical stress crack on windshields
SUMMARY:	Rework windshield frame per this ITS

ITS61456

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.

SAFETY PRECAUTIONS MUST BE FOLLOWED ACCORDING TO ACCEPTED INDUSTRY STANDARDS AND LOCAL/PROPERTY REQUIREMENTS.

PROCEDURE:

1. Park bus on a flat surface and apply parking brake. Place wheel chocks underneath the front wheels.
2. Inspect windshields for vertical stress cracks. Depending on the location of the crack, proceed with the repairs detailed below as applicable.

Example of a vertical stress crack located on the LH (driver side) windshield.

Repair if crack is on the curb side (RH) windshield

3. If windshield was recently replaced due to vertical stress crack, and the new windshield has no cracks now, then the frame repair can be done from inside, without removing the windshield. Inspect side plate alignment from outside: if the aft edges of the center and side plates are aligned then repair is required. Refer to Figure 1 below.

Figure 1: Side plate alignment inspection

4. Remove grab rail, bulkhead panel, defroster louvers and CS dash panel to get access to the windshield support frame. Refer to Figure 2.

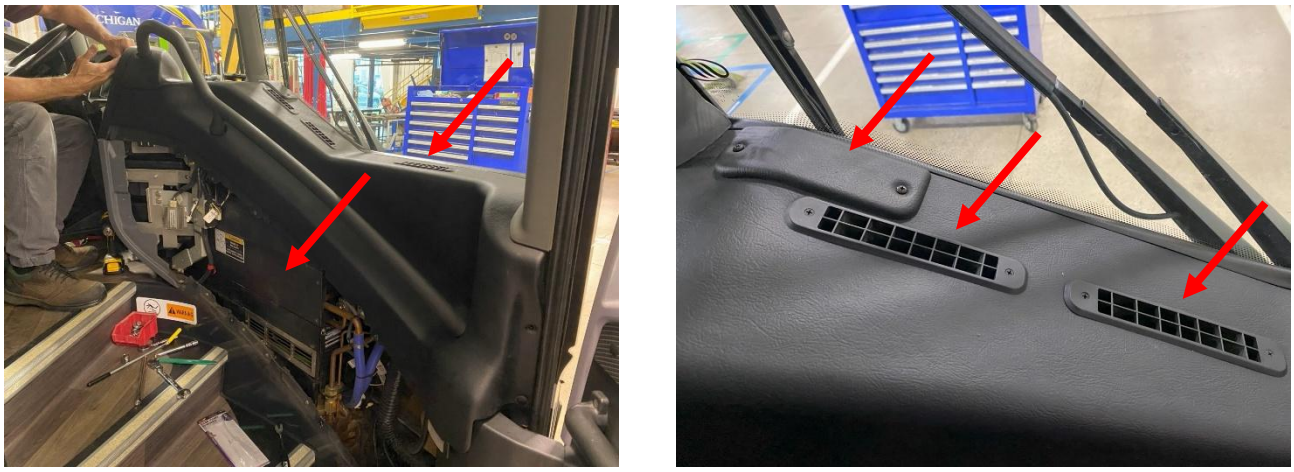

Figure 2: Remove interior components to get access to the windshield support frame

5. Drill the head of the mounting rivets of the plate out. Use a piece of cardboard to protect the windshield in case the drill jerks or jumps. Refer to figure 3.

Figure 3: Drill out the head of the rivets

6. Punch the rivets into the structure.

Figure 4: Punch rivets into the structure

7. Remove the plate. Clean metal shavings from both the bus frame and plate. Refer to Figure 5.

Figure 5: Support plate is removed

8. If windshield was removed, then install new windshield into the rubber seal but don't install lacing yet. Windshield is required so the plate can be positioned correctly to match the curvature of the windshield.
9. Apply silicone spray or soapy water onto the plate, then push the plate into the horizontal groove of the seal all the way forward. Secure plate to the structure with a clamp. Refer to Figure 6.

Figure 6: Push plate forward, into the slot of the rubber seal

10. Drill top surface of the structural tube through the existing holes of the plate by using a #10 size (0.1935") drill bit.

11. Install 3/16” size SST rivets (PN **19-13-0333**) through the holes. Refer to Figure 7.

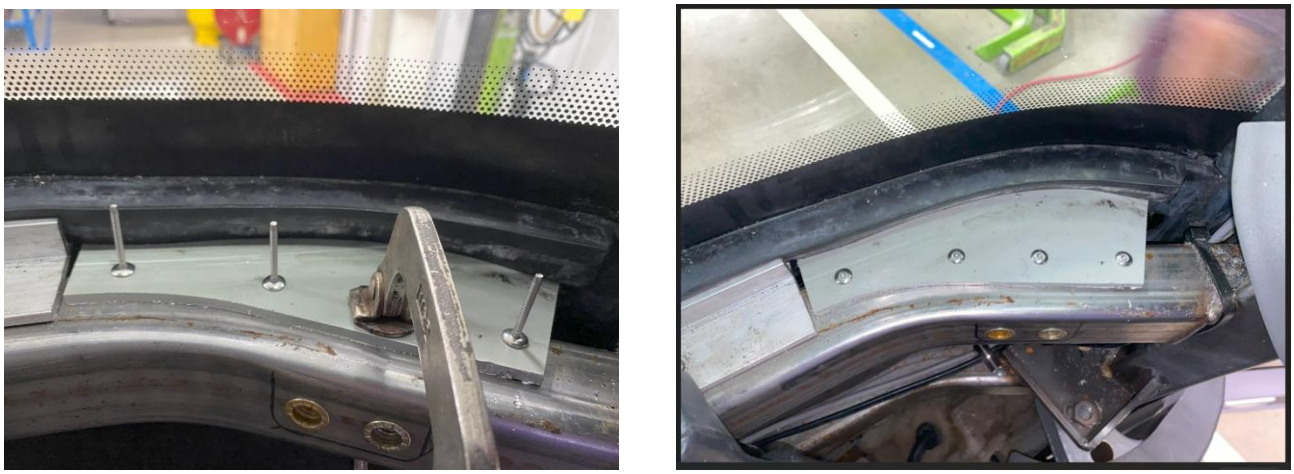

Figure 7: Secure support plate with 3/16” size SST rivets

12. Install lacing to complete the windshield installation (if new windshield was installed).
13. Reinstall dash panel, bulkhead panel and grab rail.

Repair on the LH (driver side)

14. To rework the side support plate at the LH side, the windshield must be removed.
15. Drill out rivets, clean plate, apply soapy water on it and push it forward inside the horizontal groove of the rubber seal as described before. See paragraphs 5-9.
16. Since the windshield had to be removed to get access to the side plate, the alignment of the side plate must be done with more attention:
    a. Pull the rubber seal off from the joint area of the side plate and the center support profile. Refer to Figure 8.

Figure 8: Pull seal off from the joint area

b. Push the side plate forward and ensure that its forward edge is aligned with the center profile. Refer to Figure 9.

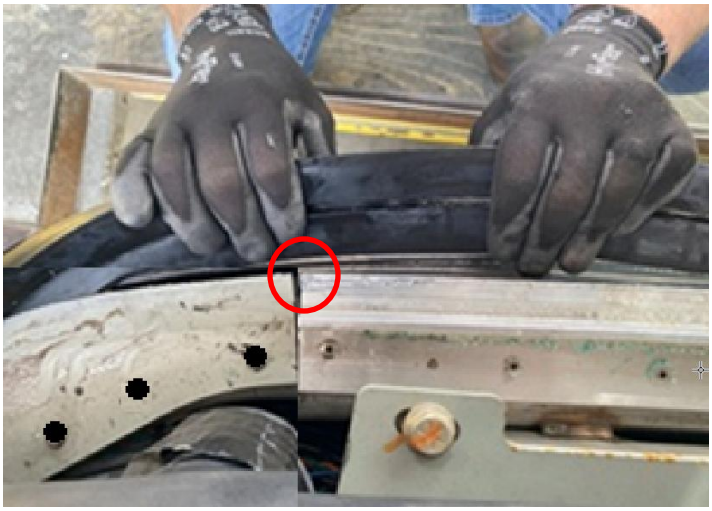

Figure 9: Align inner corner of the side plate with the center profile

c. Secure this inner corner of the side plate to the structure with a clamp.
d. Push the outer corner of the side plate into the horizontal groove of the rubber seal. Ensure the inner corner of the side plate is still aligned with the center profile.

17. Drill structure, install rivets as described before. Refer to paragraphs 10-11.
18. Ensure the joint area of the side plate and center profile are aligned and leveled. Use a file or grinding disc to remove sharp edges and smoothen the joint area if required.
19. Reinstall rubber seal onto the joint area of the side plate and center profile. Ensure that the plate is fully engaged into the horizontal groove of the rubber seal. Refer to the top photo at Figure 6.
20. Reinstall LH windshield.
21. Remove tools, debris and unused parts from the bus to return it to service condition.

LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Rework one support plate per this ITS	1	6	6

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	19-13-0333	RIVET 3/16 DIA , SST	9	EA	

SPECIAL TOOLS REQUIRED					
Item	Part Number	Description	Qty.	Units	Notes
1	NA	Windshield lacing tool, drill, rivet gun			