



INSTRUCTION TO SERVICE

ITS61795		06/17/2026
SECTION:	450 – Flooring Applied Parts	
SUBJECT:	Inspect flooring for ridge/raised area, pull back flooring, add screws and re-apply flooring between front luggage racks.	
ISSUE:	Flooring pushing up at center support plate between front luggage racks.	
SUMMARY:	Inspect flooring and repair flooring in between front luggage racks.	

ITS61795

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. Raise the coach in accordance with the New Flyer Service Manual.
4. Support the front, center, and rear of the coach with jack stands at the jacking pad locations (8 places). There should be no weight on the wheels of the bus. **See Figure 1.**

 **NOTE:** Please leave the wheel lifts in place with no weight on them for safety reasons.

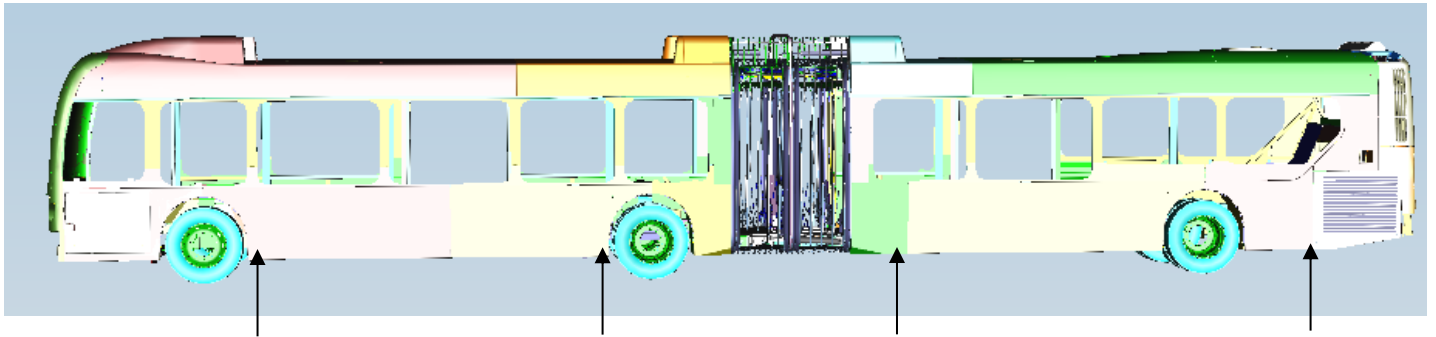


FIGURE 1: JACK STAND LOCATIONS (60 FOOT)

Part A: Inspect Flooring on inside and area below on underbody

5. Inspect the flooring in between the front luggage racks for ridge/raised area. This will be in between support plate and plywood section. **See Figure 2.**



FIGURE 2: SHOWN VIEW OF FLOORING RIDGED/RAISED AT AFFECTED AREA

From the underbody, look to see if there are screws protruding through. If there are screws protruding thru and no issues with flooring at the top, nothing further is required. These are the screws shown at the bottom that are mentioned.

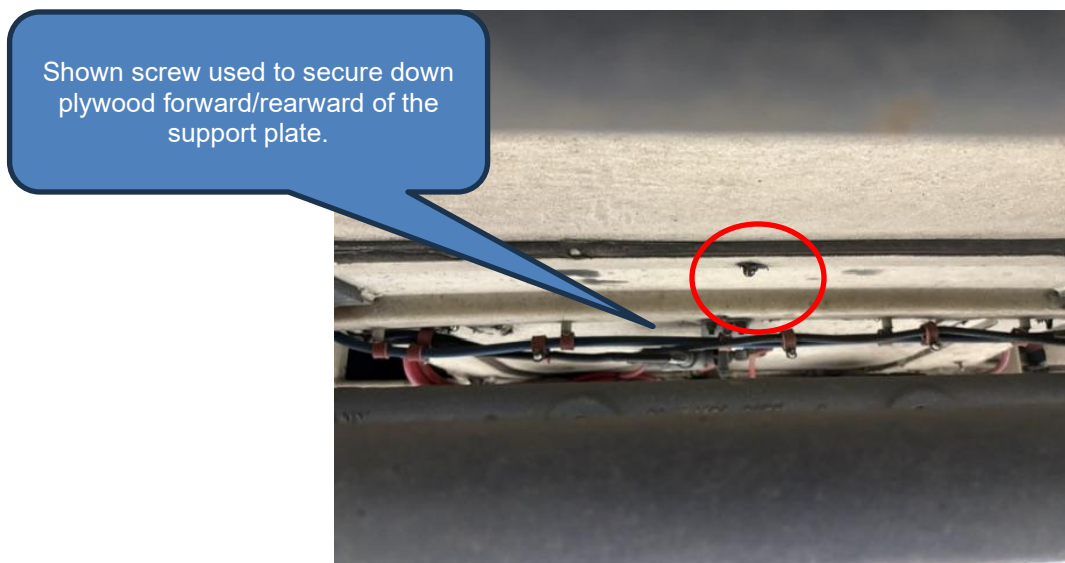
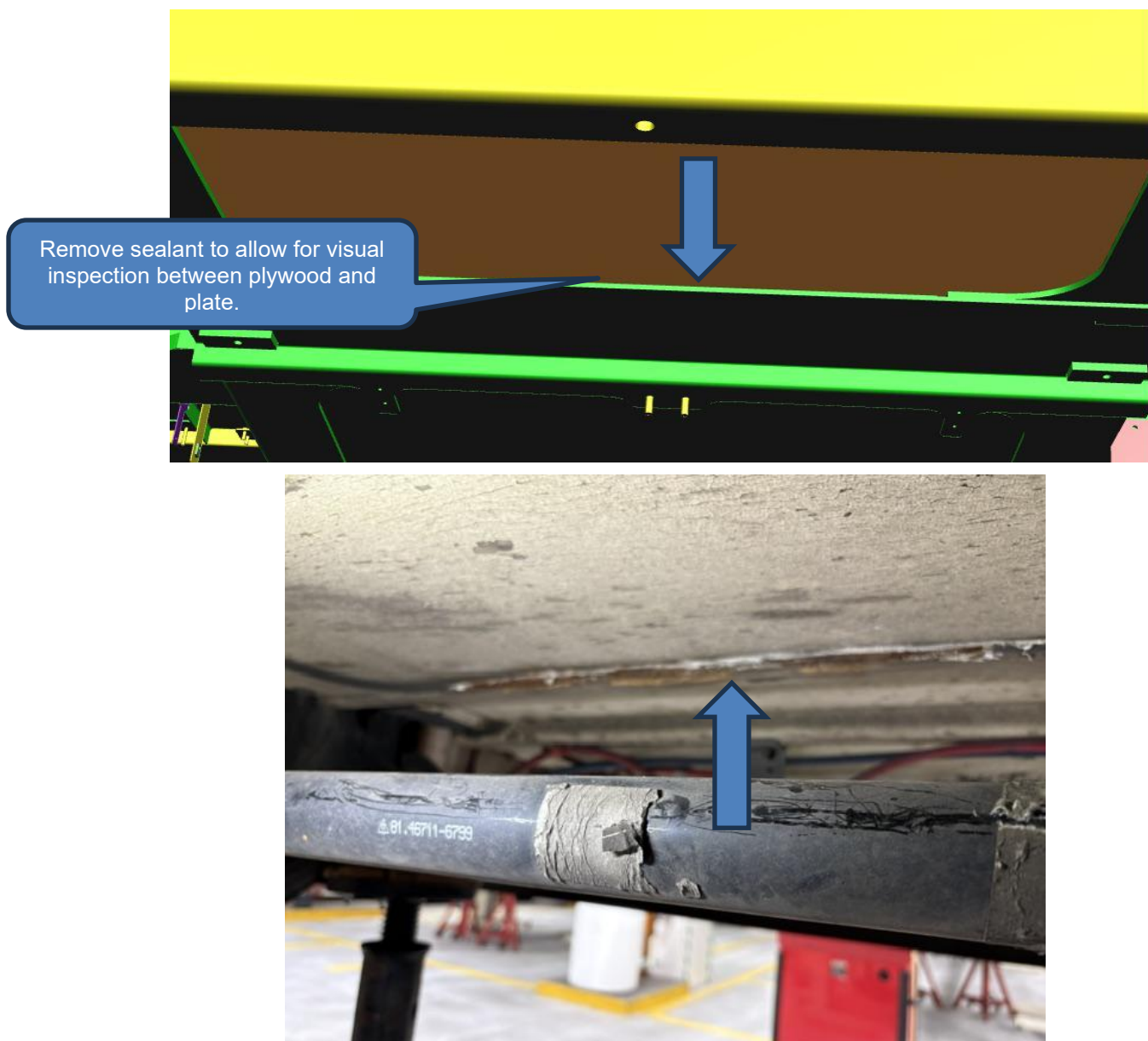


FIGURE 2A: SHOWN VIEW OF SCREW TIP PROTRUDING THRU PLYWOOD FROM UNDERBODY

If there are no screws found, cut open sealant between plywood and plate, remove sealant and inspect for any moisture or rust in the area. If there is no rust seen, then proceed to inside bus to peel back flooring to rear edge of the luggage racks. If rust is seen, then the section of the plywood will need to be removed (**refer to Part 3 repair**).



**FIGURE 2B: SHOWN VIEW OF THE AREA TO REMOVE SEALANT TO SEE
IF ANY VISIBLE MOISTURE OR RUST**

Note: Follow procedure in Appendix A for removing flooring, body filling floor surface, re-installing flooring, re-welding and sealing as a reference.

Part 2: Install screws, prep plywood floor to re-install flooring

6. From interior of the bus, pull back the flooring carefully from the standee line to the back edge of the front luggage rack. Carefully trim flooring along the edge of the luggage rack to the back edge – stop just before it goes to a corner. Be careful not to pull up the subfloor (plywood). See Figure 3.

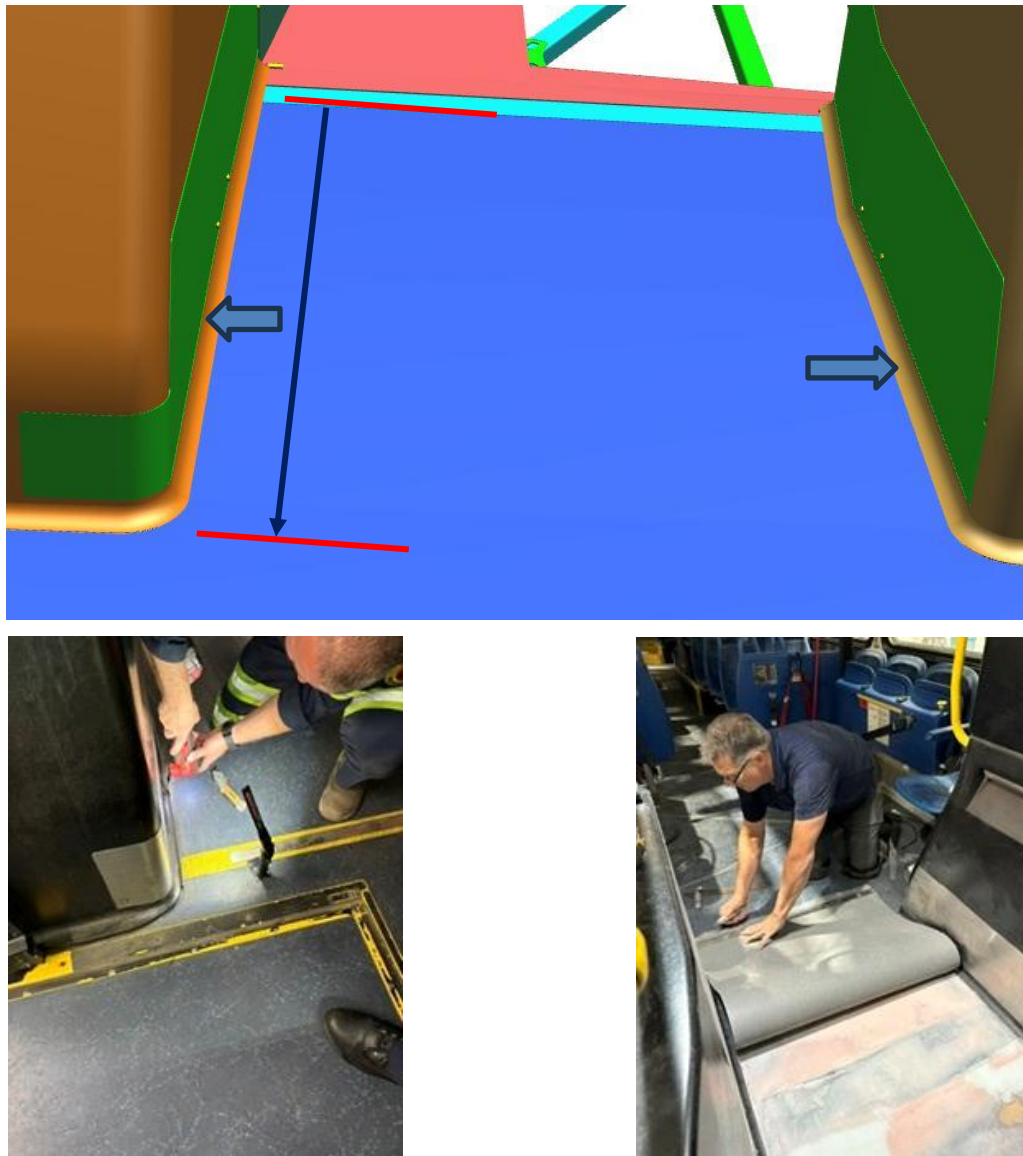


FIGURE 3: SHOWN FLOORING CUT ALONG EDGE OF LUGGAGE RACK AND PULLED BACK TO THE END OF THE LUGGAGE RACK.

7. Mark the location of the screws, forward edge on the rear plywood and rear edge on the forward plywood. 3/4" from the edge at 12" center (x2) per board. Pre-drill holes to (0.15") and install screws (PN: 30S00024). See Figure 4 below.



FIGURE 4: SHOWN INSTALLATION OF SCREWS (x2) PER PLYWOOD ON BOTH SIDES OF THE SUPPORT PLATE

8. For any high/uneven areas on the plywood, use an air powered sander with disc (80 grit or determined by technician completing the work), sand the areas down. For steps 8 & 9, see Figure 5.
9. Fill in the low spots with body filler that can be used on plywood. Gradually float area from the support plate onto the plywood -approximately 12" to so that there is an even transition to the support plate. **Note:** The entire plywood surface must be sanded down. Vacuum area once completed.



FIGURE 5 SHOWN FLOOR PREP BEFORE RE-APPLYING FLOORING

10. Clean backside of flooring so that flooring can be re-applied. Remove any kind of debris.
Apply adhesive – 3M 30 – H Green (**PN: 372691**) on both the backside of the flooring and the plywood surface.
Use a brush to apply. Wait till the glue is tack free on both areas – usually around 30 minutes depending on humidity. For steps 10 & 11, see Figure 6.



11. Apply a bead of sealant – Altro 73 (PN: 283255) along edge of luggage rack before re-applying flooring.



FIGURE 6: SHOWN APPLICATION OF THE 3M GLUE ON BACKSIDE OF FLOORING
AND PLYWOOD SURFACE

12. Re-adhere flooring back in place, roll out flooring using a hand roller. Ensure no air pockets or voids below flooring. Clean off all excess adhesive with denatured alcohol and ensure that all air bubbles are pushed out.

Note: This may require 2 people to lay down flooring, it can be determined by technician. See Figure 7.

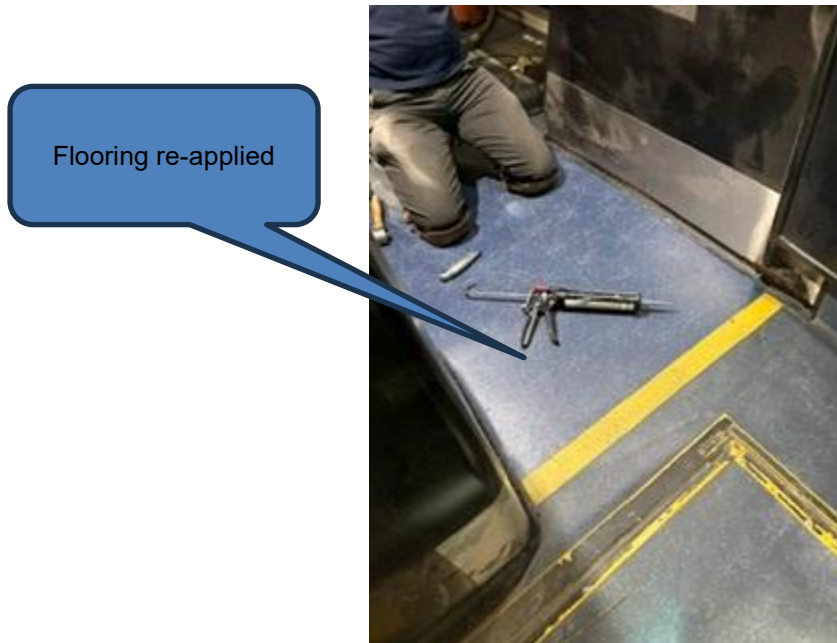


FIGURE 7: SHOWN FLOORING RE-APPLIED ON SURFACE

13. To weld the flooring to the standee line, weld thread – Altro # WR 231 (**PN: 356960**) to be applied to all floor covering butt joints. Ensure all joints are grooved evenly using grooving tool. Grooving minimum depth not to be less than 0.06" and max depth not to exceed 0.08". Acceptable deviation off center from the seam joint for grooving not to exceed 0.03". Minimum gap between flooring templates not to exceed 0.06". Intermittent gaps between flooring templates are allowed to vary up to 0.12" but the length of the variance cannot exceed more than 4" or accumulate to more than 20% the total length of the seam being welded. A straight edge should be used to ensure the grooves are cut straight. Do not attempt to heat seam weld until the adhesive has thoroughly set.

Begin welding by ensuring the welding thread is cut to the correct length. Refer to lengths by measuring the area but allow for extra few inches. Move the heat welding gun along the grooved seam with the thread feeding through the nozzle at a predetermined speed and temperature. Make certain the speed nozzle is kept perpendicular to the surface. Do not lean the gun to the right or left. After the welding thread has cooled it can be trimmed flush with the surface in 2 stages. The first stage involves placing the trimming plate over the weld rod and trimming off the top layer of the thread with the spatula knife. This can be done while the thread is still

warm or when cooled. Second, when the remaining thread has cooled, the excess weld should then be trimmed with a spatula knife. **See Appendix A regarding floor welding, sealing and application of nosing.**

14. Apply sealant along edge of luggage racks to flooring. Neatly tool in sealant. Remove any excess sealant with denatured alcohol. See Figure 8.



FIGURE 8: SHOWN FINAL FLOOR SEALING ALONG BOTTOM OF LUGGAGE RACKS

15. From underneath, re-apply sealant (**PN: 055701**) along the area that the sealant was removed. Touch up undercoating as required.

Part 3: If Plywood section has to be removed to treat rust or plywood is damaged, then add screws, prep surface and then re-apply flooring.

16. After Part 1 (inspection is completed and rust is found at the bottom or the top), this will also include if the plywood piece is damaged. This section will need to be cut out and replaced. See Figure 9.

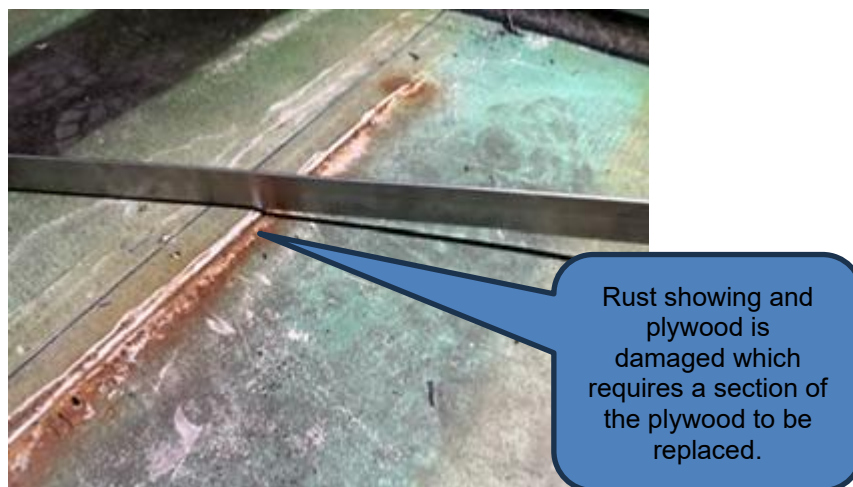


FIGURE 9: SHOWN RUST AND DAMAGED PLYWOOD – REQUIRES PLYWOOD SECTION TO BE CUT OUT.

17. When the flooring is either pulled back or if the flooring section is damaged. Then a new piece of flooring (**PN: 594515**) will need to be cut out from the roll of flooring. You can use the existing piece as a template. When trimming from the roll, make it a little bigger to allow for some trimming inside the bus.
18. If the plywood section needs to be replaced, from underneath the bus, drill pilot holes in all 4 corners to edge of structure plate to allow for plywood. Reference edge (from the inside) by going inward $\frac{3}{4}$ " to allow for the plywood cutout to be on top of the structure. You want a structure edge so that new piece of plywood can be fastened to the structure. For steps 18 & 19, See Figure 10 & 11.

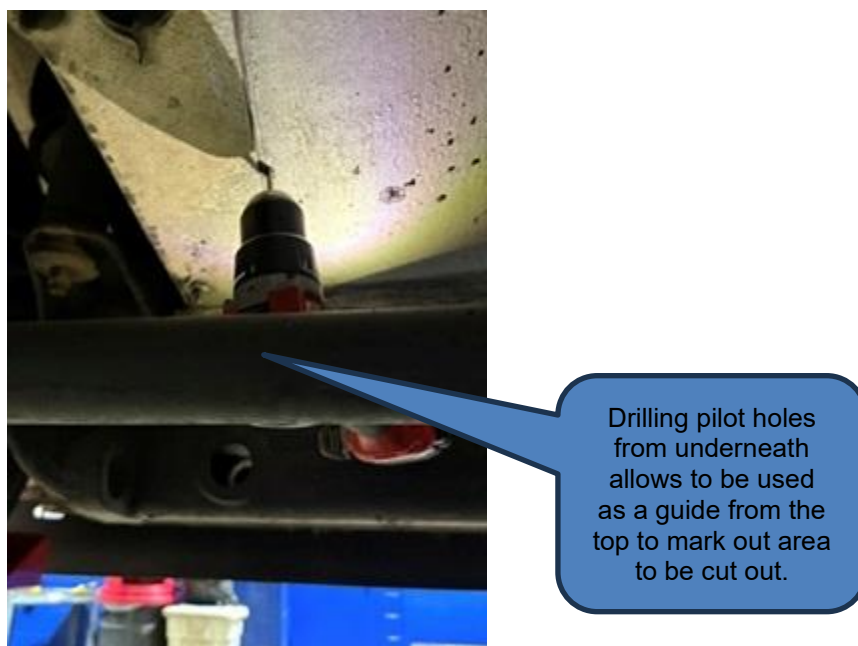


FIGURE 10: PILOT HOLES DRILLED FROM UNDERNEATH

19. From the top (using the corner pilot holes that were drilled from under the bus), go inward $\frac{3}{4}$ " and mark out area.

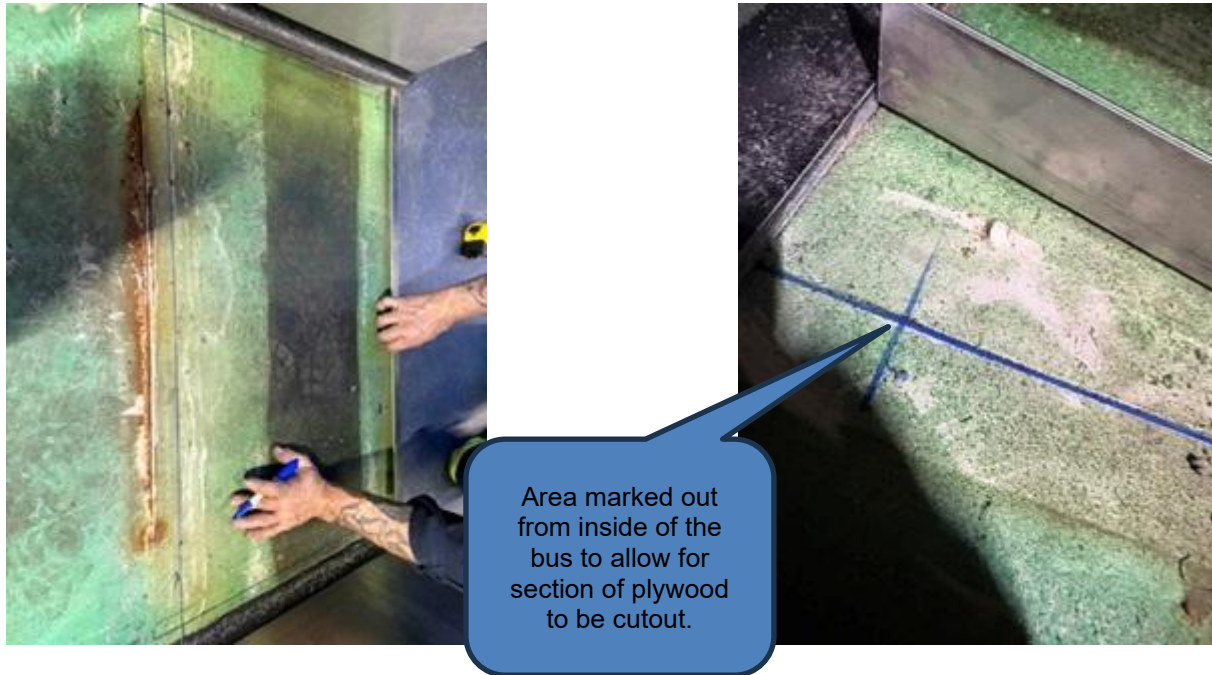


FIGURE 11: MARK OUT LINES AT THE TOP OF PLYWOOD TO CUTOUT SECTION

20. Using an oscillation blade or equivalent tool, cut out the perimeter section of the plywood. Remove plywood piece. See Figure 12.

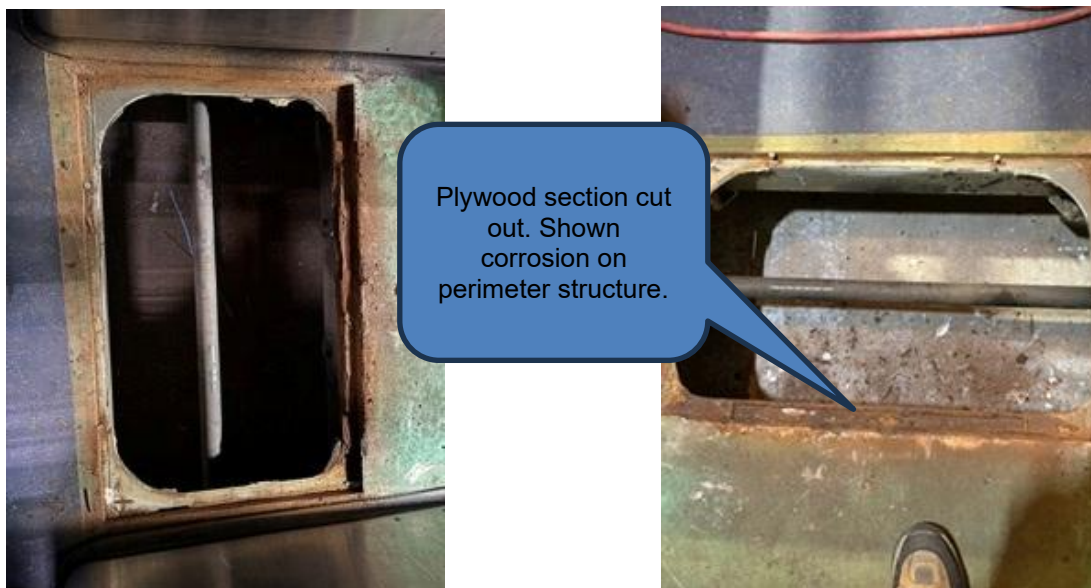


FIGURE 12: PLYWOOD SECTION REMOVED

21. Rust scaling and staining seen on structure. To remove rust, use a de-scaler first on the surface. Next sand blast area to remove all rust. Blow off area to remove all dust. Wipe down surface with lint cloth. See Figure 13.

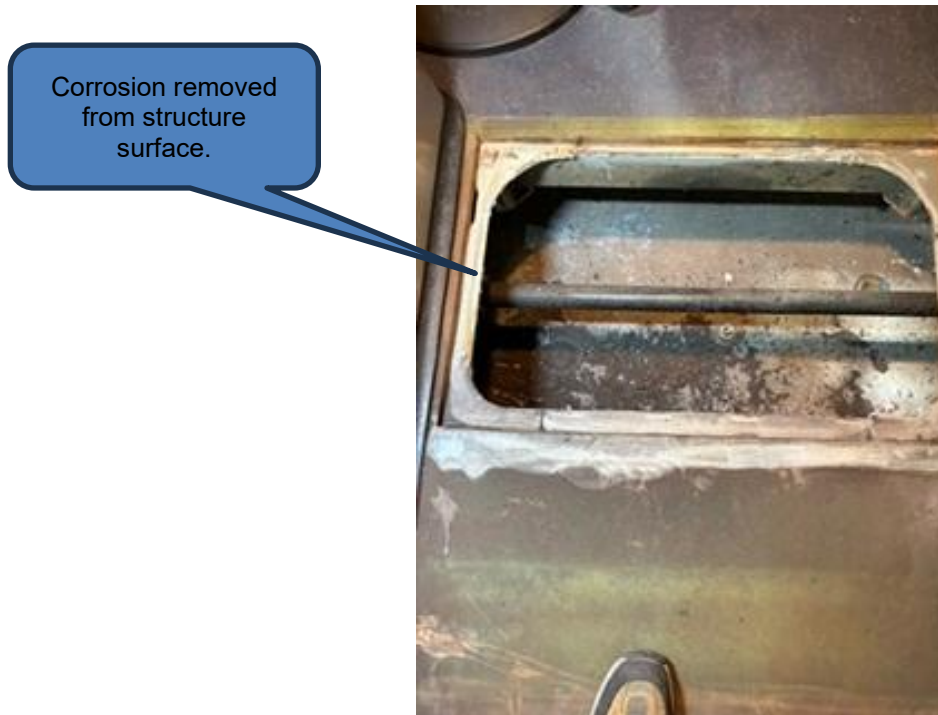


FIGURE 13: RUST REMOVED FROM STRUCTURE SURFACE

22. Apply zinc primer (**PN: 606945 & 638699**) to the surface area. Apply 2 light coats. See **Appendix B** for application details. Mix 2 parts powder to 1 part urethane for the zinc primer. Picture below shows a black corrosion primer used (can be used as an equivalent). See Figure 14.

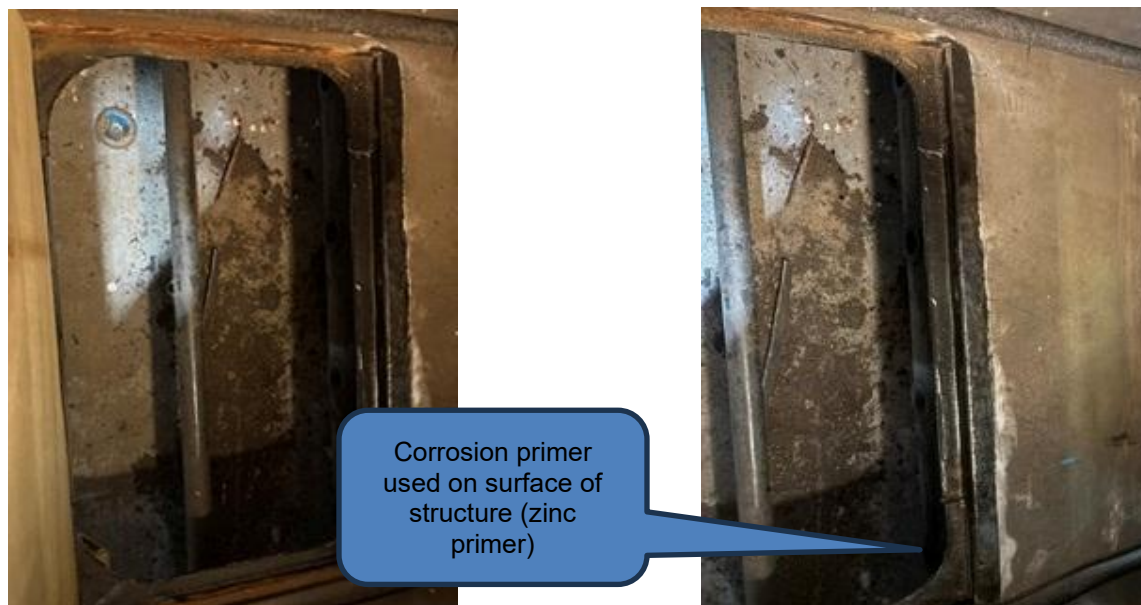
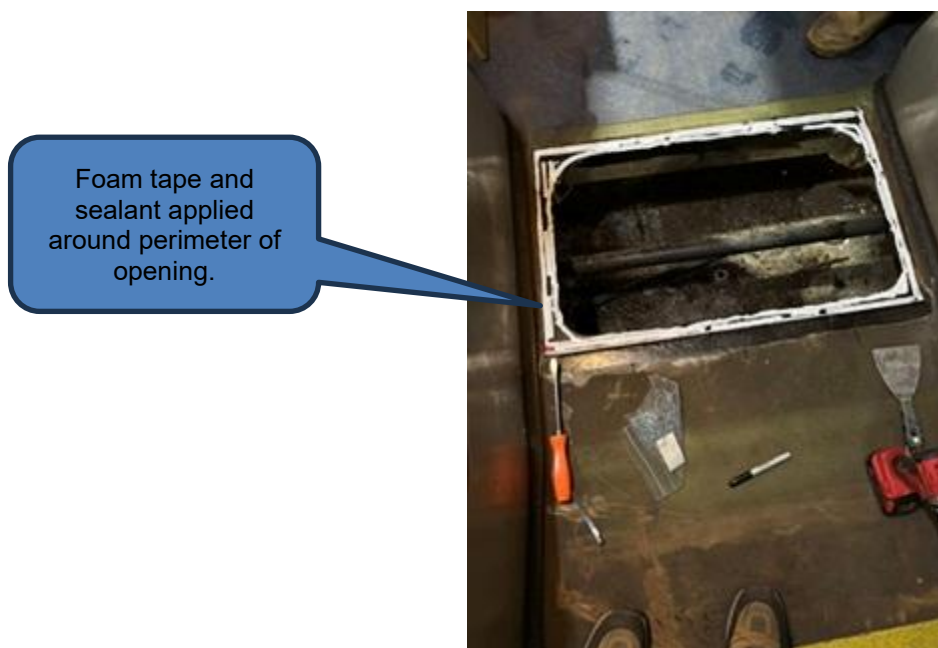


FIGURE 14: STRUCTURE TREATMENT APPLIED BEFORE INSTALLATION OF PLYWOOD PIECE

23. Apply sealant (**PN: 055701**) and double-sided tape (**PN: 420041**) around the perimeter before installation of the plywood piece. Remove the blue film tape from double sided tape before installation of the plywood. See Figure 15.



**FIGURE 15: APPLY SEALANT AND DOUBLE SIDED
TAPE ON STRUCTURE BEFORE INSTALLING PLYWOOD PIECE.**

24. From a 4x8' sheet of pressure treated $\frac{3}{4}$ " THK plywood, measure out the plywood piece. Leave a $\frac{1}{10}$ " gap around perimeter. Cut out piece of plywood. Set aside the remaining piece to use for any additional buses that require the plywood piece to be replaced.
25. Re-install the plywood piece and apply screws around the perimeter of the plywood. Ensure gap of $\frac{1}{10}$ " around the opening. See Figure 16.



FIGURE 16: INSTALL PLYWOOD PIECE

26. Follow steps 6 - 15, to install screws and prep surface. Re-install flooring. Either if rolled back or if new piece of flooring that was required to be installed. If new flooring piece is required to be installed, an additional weld line will be required at the end of the luggage racks to the existing flooring.
27. Lower coach in accordance with the New Flyer Service Manual.
28. Remove all tools and debris from work area to return coach to service.
29. Turn the main battery disconnect switch to the "ON" position.



Appendix A:

Altro Flooring Installation

11. Heat welding

- All seams of Altro flooring must be heat welded. Applying caulking or sealant in the seams instead is not an approved method.
- Do not heat weld the same day the floor covering is being installed.
- The adhesive must set for 8 - 24 hours to allow the adhesive to complete the initial cure otherwise the wet adhesive will contaminate the weld causing failures at a later date. Contact type adhesive can be welded after 1 - 4 hours.
- Tools required:



Heat welding gun



4mm heat welding tip



Welding tip for HB weld



Heat welding tip cleaning brush



Trimming knife straight handle



Metal trim plate



Speed groover



Groover blade "U" shape

- Apply the tip to the heat gun.
- The heat gun will require a 15 minute warm up period. Preheat the heat gun by setting the temperature dial to 4 as a starting point and test heat setting on a scrap of material before proceeding. This may require fine adjustments once a test is performed.
- Groove the seams.

11.1 Grooving the seam

When installing the flooring make sure both sides of the seam are cut straight and butted together to form a straight seam with no gaps.

Groove the seams using a hand groover following a straight edge, center the grooving tool blade over the seam removing material from both sides of the seam. The groove depth should be $\frac{1}{2}$ - $\frac{3}{4}$ the thickness of the floor covering.



Sweep out the groove to remove any debris.

Ensure the color of weldrod is correct then cut to the desired length.

Starting at one end of the seam, lower the heat gun tip to the flooring while inserting the weldrod into the tip.

Move the heat gun down the seam in a backwards motion keeping the heel of the tip off the flooring approximately $\frac{1}{8}$ " to ensure there is no contact between the metal tip and the floor covering.

Apply light pressure.

11.2 Welding the seam

Watch for the "wash" to form on both sides of the weldrod. If you don't see a wash slow down and/or turn up the heat.



If you're scorching the floor move slightly faster or turn down the heat. The rate of speed should be about three lineal feet per minute.

Note: Weldrod should fuse without burning or discoloring. Local voltage and gun condition can affect temperature output so make sure to test each time you weld. Heat gun usually requires 15 minutes to heat up.

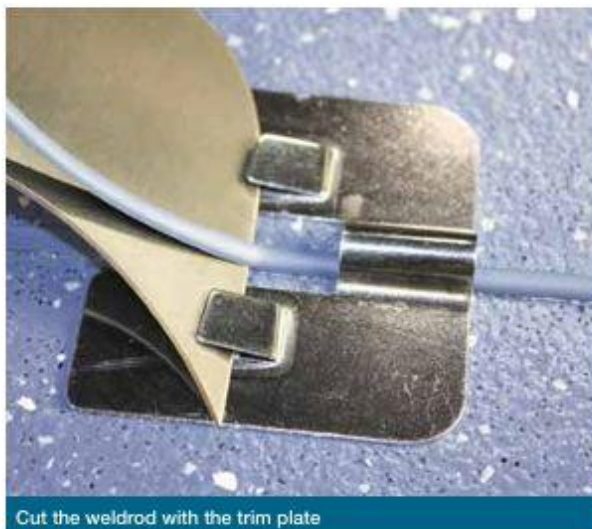
Allow the weld to cool for 5 minutes or more before moving to the next step.

11.3 Trimming the seam

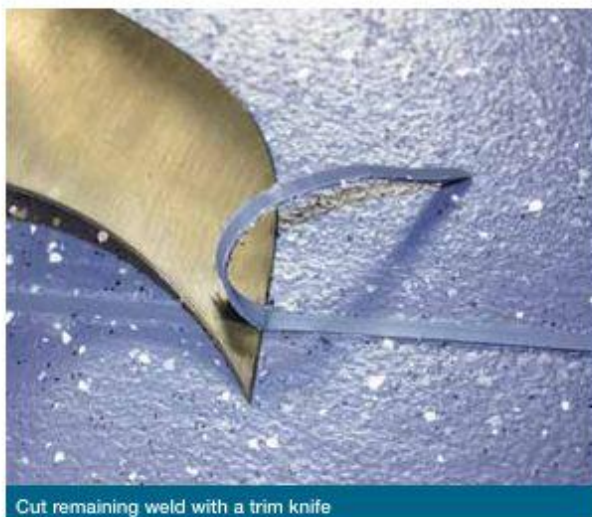
Ensure the trim knife is sharpened with a 35° beveled edge on one side of the blade only. This beveled edge rests flat against the flooring.

Trim the weld in two stages, first with the trim plate under the trim knife, then with just the knife flat against the floor.

1. Insert the knife blade into the trim plate with the beveled edge downward and trim off the top portion of the weldrod.



2. Place the beveled edge of the trim knife directly against the floor and trim the remainder of the weld flush with the surface of the flooring.



wall, use the X-acto blades in the Altro tool catalog to trim the weldrod flush in the coved radius areas.

Note: When a wall is present at both ends of the seam, it will require starting at opposite ends and overlapping the welds in the middle of the seam. Once the first pass is complete, trim the end of the seam back 2" so you can overlap the second pass from the opposite side and blend the seam together.



Overlapped weldrod in middle of seam

12. HB welding

When the floor covering is installed on both the floor and vertical surfaces such as on step wells, wheel wells, side walls, or the like, heat welding is the preferred method to seal the corners.

The HB weldrod is specially profiled for these areas and requires an HB welding tip to weld the two surfaces together.

Prior to welding the HB rod, clean both surfaces to be welded with denatured alcohol removing all adhesive and any contaminating residue and foreign matter. **Do not skip this step or the HB weld will not bond properly.**



Prep surface with denatured alcohol

Attach the HB weld tip onto the heat gun and increase the heat setting by one number setting higher than what was used with the 4 mm weld tip (usually #5). Allow to heat up for five extra minutes.

Measure out the length of HB weldrod needed and cut slightly longer than the seam that will be welded, usually in one piece.

Unlike welding the flat seams, grooving is not necessary, however it is critical the area to be welded is cleaned with denatured alcohol.

into the HB tip and position it into the corner.



Starting point

Moving the heat gun in a slow, consistent, backwards motion, ensure that the tip stays centered on the HB rod. Ensure the weldrod is applied straight and uniform.

A wash will develop on both edges of the HB weldrod which demonstrates fusion is taking place. No trimming is required with the HB weldrod.



Welding the HB rod

Inspect the entire weld to ensure permanent fusion has occurred. Do not continue until an acceptable weld is achieved.



Example of HB weld installed



Note: HB welding to Altro Transflor Wood requires additional processes. Please consult Altro's Technical Department for further information at 800 382 0333.

14. Caulking/Sealant

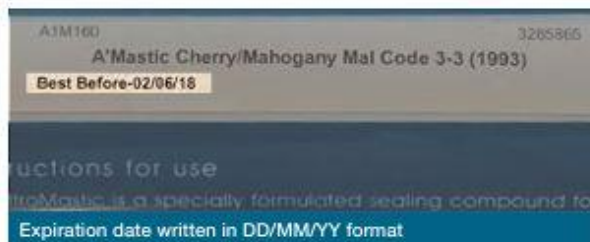
In places where a watertight seal or joint is necessary but where it is impractical to use the hot weld method, care should be taken in selecting a good quality water-resistant mastic in a suitable color.

Altro supplies such a product called AltroMastic 100, readily available from Altro.

AltroMastic 100 is a specially formulated sealing compound for use around the flooring edges, wall surfaces, or where the flooring is cut around pipes, door frames etc. for a waterproof finish, and where the heat weld method is impractical.

AltroMastic 100 is color coordinated designed to match each of our full range of floor colors and the codes can be found on the flooring sample cards.

AltroMastic 100 should be stored or applied at 60-80°C (15-25°C) and has a 9 month shelf life. The best before date is printed on the label, written in DD/MM/YY format.



Confirm shelf-life of sealant has not expired.

The use of a sealant/mastic is not a suitable substitute for a heat weld and should never be used as a substitute.

- Clean area to be sealed with denatured alcohol prior to applying AltroMastic.



- Surfaces must be dry and free from dirt, oil, or grease, all areas to be sealed should be masked with tape.



- Cut tube nozzle to allow 3mm/1/8" bead and insert tube into caulking gun.
- Use steady pressure on trigger applying sealant in desired location.



- Smooth AltroMastic 100 before it dries.



- Remove masking tape within 5-10 minutes.
- AltroMastic dries to the touch within 1 hour and curing takes 24-48 hours
- Clean surrounding area from unwanted sealant while it's still wet with denatured alcohol.



20. Tools

Altro offers a wide variety of tools for the installation of its products. Please consult with your local Altro supplier for an updated tool catalog.



Heat welding kit
HWKTF



Heat welding gun
HWG



Heat welding nozzle
HWNT



4mm heat welding tip
HWT4MM



Welding tip for HB weld
HWT HB



Heat welding tip cleaning brush
HWCBB



Trimming knife straight handle
TKSH



Metal trim plate
TP



Grooving tool handle
GH



Grooving tool blade
GTB



Speed groover
GSPEED



Groover blade "U" shape (10 pc)
GB



Xacto Handle
XH



Xacto blades (8 pc)
XB8



Straight blades (100 pc)
HDB1



Hooked blades (100 pc)
HDB2



Concave blades (100 pc)
HDB3



2" seam roller
RSH



3 section floor roller
R3



Trowel blade 1/32 x 1/16 x 5/64 U
TBWHA



Trowel blade 1/32 x 1/16 x 1/32 U
TBFFA



Trowel handle
TH



Electric groover
GE



Electric groover diamond blade
GEDB

Appendix B

Axalta Zinc Primer



NF PN: 606945 & 638699

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General Industrial

Technical Data Sheet

GANICIN™ 2.8 MC-U™ MOISTURE-CURED ZINC-RICH PRIMER

Ganicin™ 2.8 MC-U Moisture-Cured Zinc-Rich Polyurethane Primer

GENERAL DESCRIPTION

A high solids, two-component, 2.8 lbs/gal VOC conforming, moisture-cured organic zinc-rich coating based on Axalta polyurethane technology. The resulting coating is designed to be highly durable and to deliver outstanding corrosion resistance.

SUGGESTED USES

As a high performance primer on carbon steel or as a touch-up for inorganic zinc coatings where:

- A coating with 85% zinc in the dried film with low VOC is required
- Spray application, or by brush when touch-ups may be necessary
- Application is recommended down to 35°F (2°C)
- No induction time and long pot life may improve productivity

Ganicin 2.8 MC-U is intended to be used as a primer and should be topcoated.

COMPATIBILITY WITH OTHER COATINGS

Ganicin 2.8 MC-U Moisture-Cured Zinc-Rich Primer may be topcoated with Corlar® epoxies and/or Imron® polyurethane Primers. Do not apply Imron polyurethane topcoats, directly to Ganacin 2.8 MC-U. Ganacin 2.8 MC-U may also be used to touch up inorganic and organic zinc-rich coatings. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your Axalta representative for specific recommendations.

NOT RECOMMENDED FOR

- Immersion service
- Exposure to acid or alkali environments without suitable topcoats

PERFORMANCE PROPERTIES

Chemical Excellent

Humidity Excellent

Water spray Excellent

Weather Excellent with durable topcoat

(will chalk if left untopcoated)



COLOR

Grey green

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

63P1500 primer base 1 short fill gallon container (0.46 gallon)

347YB1500™ zinc dust 1 gallon container (13.4 lbs.)

MIX RATIO

Component Part by Volume

63P1500 primer base 1 container short fill (0.46 gallon)

347YB1500 zinc dust 1 container (13.4 lbs.)

NOTE: Mixed amount will make 0.70 gallon.

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Technical Data Sheet

GANICIN™ 2.8 MC-U™ MOISTURE-CURED ZINC-RICH PRIMER

ACTIVATION

Thoroughly stir 63P1500 primer, then slowly add 347YB1500 zinc dust with consistent agitation. After mixing, filter through a 40 mesh screen. Filter into an agitated spray pot. Constant agitation during application is recommended to prevent settling of zinc dust. Minimize contact with humid air.

Reduction

No reduction should be necessary. However, if conditions require thinning, Axalta 8685S™ may be used up to 5 oz./gal. To remain @ 2.8 lbs/gal VOC, use no more than 2 oz/gal.

APPLICATION THINNERS

Spray or brush: Axalta 8685S up to 2 oz./gal. may be added and still remain conforming at 2.8 lbs/gal VOC. Amounts up to 5 oz./gal. Max can be used if required for various application conditions. Use no alcohol-containing thinners.

POT LIFE

At least 8 hours if moisture is excluded, shorter in high humidity and temperature.

APPLICATION

SURFACE PREPARATION

An SSPC-SP 6 Commercial Blast Cleaning is preferred for optimal performance. For touchup over inorganic zinc, Hand Tool Clean to an SSPC-SP 2 or Power Tool Clean to an SSPC-SP 3 can be used. Note: You can prep surface by using 100 – 150 grit sand paper.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 35°F (2°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

For best results, apply by spray. Product can be brushed for small spot applications or repairs. Note that in high humidity, the coating will gradually accumulate on the brush.

BRUSH APPLICATION

Manufacturer: Wooster China Bristle - 3" - 4" brush

SPRAY APPLICATION

Manufacturers listed below are a guide. Others may be used. Changes in tip size or pressure may be required to achieve proper application.

Conventional Spray

Binks DeVilbiss

Spray Gun: 2001 JGA

Fluid Nozzle: 67SS FF (1.4)

Air Cap: 67PR 704

HVLP Spray

Binks DeVilbiss

Spray Gun: Mach 1 GTi

Fluid Nozzle: 94 (1.4) 1.4

Air Cap: 94P 2000

Airless Spray

Pump: Graco Extreme 33:1

Airless Gun: Graco 946853



Fluid Hose: 3/8" x 100' max.

Tips: 415-517RAC

Minimum pressure to avoid fingering: 2400 psi min.

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Technical Data Sheet

GANICIN™ 2.8 MC-U™ MOISTURE-CURED ZINC-RICH PRIMER

Application Notes

- Must be agitated during application.
- For conventional air spray, fluid lines should be 0.5" inner diameter and 25-50' long maximum.
- For best results, keep pressure pot at the same height as the work.
- Apply a full, wet coat. Try not to exceed specified film build thickness.

CLEAN UP THINNERS

Axalta 8685S

DRY TIMES

Cure time at recommended thickness 3 mils DTF @ 50% RH

77°F (25°C)

To touch 30 minutes

Re-coat 2 hours

Handle 3-4 hours

Note: May be overcoated with itself up to 3 days (72 hours) after initial application.

PHYSICAL PROPERTIES

Maximum Service Temperature 250°F (121°C) in continuous service

350°F (177°C) in intermittent service

Volume Solids 62% ± 2%

Weight Solids 89% ± 2%

Theoretical Coverage Per Gallon 994 ft² (24.4 m²/L) @ 1 mil DFT

330 ft² (8.1 m²/L) @ 3 mils DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Weight Per Gallon 24.8 lb average | 11.2 kg. average

Shipping Weight (approximate) 1 gallon container: liquid 3.8 lbs | zinc 13.4 lbs

Suggested Film Thickness 5 mils (125 µm) wet

3 mils (75 µm) dry

Application by brush and roller may require additional coats to achieve recommended films thickness.

Flash Point: (Tag Closed Cup) 100°F (38°C)

Gloss Flat

Package Size 1 container

Shelf Life 1 year minimum

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between -30°F (-34°C) and 120°F (48°C).

Moisture-cured zinc-rich primer liquid may settle. Agitate before each use. To prevent pressure build-up after mixing, do not store in sealed containers.

VOC REGULATIONS

VOC (Theoretical, varies with color).

Moisture cured zinc-rich primer; unredacted 2.76 lbs/gal (332 g/l)

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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GANICIN™ 2.8 MC-U™ MOISTURE-CURED ZINC-RICH PRIMER

ASTM INFORMATION

Physical properties are for Ganicin 2.8 MC-U Moisture-Cured Zinc-Rich Primer. For other



system results, contact Axalta Coating Systems.

Paint System: Ganicin 2.8 MC-U

Type | Color: Moisture-cure organic zinc-rich | Gray green

DFT: 2.8 mils

Salt Fog (ASTM B117) 1000 hours no rusting, no blisters

2000 hours no rusting, no blisters

3000 hours no rusting, few #8 blisters at

the scribe, no undercutting

at the scribe

Relative Humidity (ASTM D2247) 1000 hours no rusting, no blisters

2000 hours no rusting, no blisters

3000 hours no rusting, no blisters

Dry Heat (ASTM D2485) 250°F for 24 hours no cracking, no blisters,

moderate loss of

adhesion, no discoloration

Electrical Resistance: 1×10^{10} (OHMS)

Adhesion (ASTM D4541): 2406 psi cohesive failure within the coating

Cleveland Cond (ASTM D4585): 1000 hours no rusting, no blisters

UV Con (ASTM D4587)* 3000 hours Gloss before exposure: 2

Gloss after exposure: 0.9

Evaluation no rusting, no blisters,

no delamination

Mandrel Bend (ASTM D522): % Elongation – 5-10% (on smooth eCoat)

Taber Abrasion (ASTM D4060): weight loss in grams - 0.14

*8 hr UV @ 122°F (50°C), 4 hr condensation @ 104°F (40°C), gloss readings @ 60°

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

Revised: June 2015

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Appendix C

Undercoating



NF PN: 606947

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Transportation
Technical Data Sheet
TUF-COTE™ UC-1000™

Tufcote™ UC-1000™

Waterborne Chip Resistant Undercoat

GENERAL DESCRIPTION

A single-component, waterborne, zero VOC, semi-firm coating designed to deliver premium performance to resist chipping, scratches and gravel marks for use on the underbody of truck, trailer, bus, body builder and other transit vehicles. It is formulated to provide excellent adhesion, hardness and may be applied at film thickness up to 15 mils. It is available in three factory packaged colors: black, off-white, and grey.

SUGGESTED USES

- Recommended for use on underbody of truck, trailer, bus, body builder and other transit vehicles where premium quality attributes for corrosion prevention and chip resistance are desired.
- Formulated to provide excellent adhesion, hardness and durability to most substrates including primers, e-coat and oily steel.

COMPATIBILITY WITH OTHER COATINGS

- Compatible with most urethane, acrylic or alkyd resin formulated transportation quality topcoats

COLOR

UC-1001™ Black
UC-1003™ Grey
UC-1006™ White

MIXING

COMPONENT

Tufcote UC-1000 Waterborne Chip Resistant Undercoat

MIX RATIO

Mixing or thinning not required. Mild agitation is recommended prior to use.

ADDITIVES

None recommended.

DO NOT THIN. Incorrect thinning will affect film build, dry time and product performance.

APPLICATION

SURFACE PREPARATION

The maximum performance of Tufcote UC-1000 can be achieved only when the metal surfaces to be protected are clean, dry, and free of rust, oil, and mill scale.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above



95°F (35°C) at the time of product application.

APPLICATION EQUIPMENT

Airless spray

Dip

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Transportation

Technical Data Sheet

TUFCOTE™ UC-1000™

APPLICATION

- Tufcote UC-1000 is formulated to be used as supplied.
- Ensure uniform consistency prior to use. Continued stirring is generally not required.
- If the product thickens due to cold storage or loss of water and coalescing solvent during use, contact an Axalta representative.
- DO NOT THIN. Incorrect thinning will affect film build, dry time and product performance.
- Recommended ambient and product temperature should be 50 - 95°F (10 - 35°C) at time of application.
- Product can be airless spray or dip applied.

RE-COAT

- Tufcote UC-1000 may be recoated with most urethane, acrylic or alkyd resin formulated transportation topcoats.

REMOVAL

The dry film is not normally intended for removal. The product can be repainted after the film is cured. Citrus or alkaline cleaner will remove fresh residue accumulated on application equipment. If removability is a factor, contact an Axalta representative.

CLEAN UP SOLVENTS

Citrus or alkaline cleaner

DRY TIMES

Approximate Dry Time At Recommended Thickness @ 77°F (25°C)

Air dry 30 – 60 minutes

Cure Time 72 hours

- Adequate ventilation is required for cure and to ensure against formation of a combustible liquid atmosphere.
- THE PARTIALLY CURED FILM SHOULD NOT BE EXPOSED TO IGNITION SOURCES SUCH AS FLARES, FLAMES, SPARKS, EXCESSIVE HEAT, OR TORCHES.
- Refer to product Material Safety Data Sheet for additional handling and first aid information.

PHYSICAL PROPERTIES

UC-1001 UC-1003 UC-1006

Black Grey White

Density, Weight/Gallon @ 77°F (25°C) 10.5 ± 0.1 lbs 10.9 ± 0.1 lbs 10.9 ± 0.1 lbs

Recommended Dry Film Thickness

over Metal Profile 10 - 15 mils 10 - 15 mils 10–15 mils

Dry Film Thickness Over Primed Steel 6 – 8 mils 6 – 8 mils 6 – 8 mils

Theoretical Coverage @ Rec. DFT 48-73 ft²/gallon 75-95 ft²/gallon 80 ft²/gal

Non-Volatile % by Weight 55 ± 2 56 ± 2 54 ± 2

Non-Volatile % by Volume 45 ± 2 42 ± 2 50 ± 2

Gloss Matte

Shelf Life 12 months minimum

Gravelometer, -20°C, SAE J-400, Pass, Excellent Rating

GM-998-4247, GM9508P No Adhesion Loss

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Technical Data Sheet

TUFCOTE™ UC-1000™

STORAGE CONDITIONS



Store in a dry, well-ventilated area. Storage conditions should be between 50°F (10°C) and 95°F (35°C). Mild agitation is recommended prior to use.

Do not allow product to freeze.

ASTM INFORMATION

5% Salt Spray (Hours) at 15 mils DFT

ASTM B-117 @ 6 to 10 Recommended DFT 2000

(2x4x1/8 in. CRS Panels)

100% Relative Humidity (Hours)

ASTM D-1748 @ Recommended DFT 1000

(2x4x1/8 in. CRS Panels)

VOC REGULATIONS

Volatile Organic Content (VOC) 0 lbs. / gallon

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LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Inspect flooring and below the bus from underneath.	1	0.5	0.5
2	Add screws on plywood and re-install flooring.	1	3.5	3.5
3	Replace damaged section of floor, treat corrosion and re-install flooring (as required).	1	7.5	7.5

Note: Rework will either be for a standard repair (item 1 & 2) -Total 4 hours

Or if the plywood is required to be removed & treat corrosion, along with standard Repair (Item 1 & 3) Total: 8 hours

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	372691	Adhesive – 3M 30 – H Grn.	0.25	GA	
2	356960	Weld Thread – Altro No. WR 231	8	FT	
3	283255	Sealant – Altro 73	0.25	EA	
4	594515	Flooring – Altro Laser TFF G2703F	0	EA	Do not order, 1 roll of flooring onsite.
5	NPN	4x8' ¾ THK Pressure treated plywood	0	EA	Can be used for many buses. Purchase locally onsite as required.
6	420041	Spacer – Foam 3/16 x 3/8 BL	30	FT	
7	055701	Sika 221 White adhesive	2	EA	
8	424883	Standee Line – Altro Yellow	0	EA	Only order if replacement required
9	606945	PRIMER-ZINC RESIN POLYURETHANE	0.01	GA	
10	638699	PRIMER-ZINC POWDER GREY/GREEN	0.02	GA	
11	606947	UNDERCOATING	0.1	GA	