

REFERENCE:	Nova Bus Manuals
SECTION:	01: Structure
RS N°:	MQR 7621-1030
EFFECTIVE IN PROD.:	L961 (2016MA)

APPLICATION DEADLINE:N/A

SUBJECT:	Right wall structure with 1:6 ramp
JUSTIFICATION:	Vertical beam might crack above front door, second post capping.

LEVEL	DESCRIPTION	DIRECT CHARGES		TIME
		LABOUR	MATERIAL	
1	Weld stiffening plates.	Client	Client	8h
2	-	-	-	-

MATERIAL

QTY	PART N°	REV.	DESCRIPTION	REPLACES PART N°
LEVEL 1				
1	N24104	-	BOLT M6 X 20 SS	-
1	N71118	-	PLATE FRONT DOOR (90°) ST STL UNS304 ASTM A240 3/16" (4.8mm) THK	-
1	N71119	-	PLATE FRONT DOOR ST STL UNS304 ASTM A240 3/16" (4.8mm) THK	-
1	N71120	-	BRACKET BETWEEN TUBES ST STL UNS304 ASTM A240 12GA (2.8mm) THK.	-
2	N30702	-	POP RIVET 3/16 X 0.440 X 0.125	-
LEVEL 2				
-	-	-	-	-

Materials will be available within 14 days. To order, please contact Prevost Parts by phone at 1-800-771-6682, by fax at 1-888-668-2555 or by email at prevostparts.commandes@volvo.com. Specify document number, quantity of parts required and shipping address.

DISPOSAL OF PARTS

REMOVED PARTS ARE:	DISCARDED *	RETAINED	* Dispose of the unused parts and the defective parts in accordance with local environmental standards in effect.
	-	-	

REVISION HISTORY

REV.	DATE	CHANGE DESCRIPTION	WRITTEN BY
NR	2017MR10	Initial release	André Pelletier

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
Airdrie Transit - Alberta	L664	—	—	L82U2B3000507	L82U2B3000507	1
Ames Transportation Agency - Iowa	L707	660	661	S92U5C4500159	S92U1C4500160	2
Austin - CMTA - Texas	L635	5001	5001	S92U7C4500163	S92U7C4500163	1
Austin - CMTA - Texas	L636	5002	5022	S92U1D4500306	S92U0D4500328	21
Austin - CMTA - Texas	L704	5051	5068	L82J7E4500471	L82J2E4500488	18
Barrie - Ontario	L878	1501	1504	L82JXF3001691	L82J6F3001719	4
BC Transit - BCT - British Columbia	L604	9434	9434	L82U5C3000597	L82U5C3000597	1
BC Transit - BCT - British Columbia	L735	9435	9440	L82U4C3000848	L82U8C3000853	6
BC Transit - BCT - British Columbia	L736	9441	9446	L82U8D3000854	L82U7D3000859	6
BC Transit - BCT - British Columbia	L858	9447	9481	L82JXE3001401	L82J5F3001436	35
BC Transit - BCT - British Columbia	L891	—	—	L82J5F3001565	L82J2F3001569	5
Belleville Transit - Ontario	L655	—	—	L82U3B3000385	L82U3B3000385	1
Belleville Transit - Ontario	L702	—	—	L82U4D3000706	L82U4D3000706	1
Bow Valley Transit - Alberta	L712	5	6	L82U6C3000804	L82U8C3000805	2
Brampton - Ontario	L789	—	—	L82J4E3001216	L82J1E3001223	8
Brampton - Ontario	L816	—	—	L82J3E3001224	L82J9E3001230	7
Brampton - Ontario	L864	1501	1510	L82JXF3001500	L82J6F3001509	10
Brampton - Ontario	L865	1511	1519	L82JXF3001514	L82J9F3001522	9
Brantford - Ontario	L663	10121	10121	L82U1B3000532	L82U1B3000532	1
Brantford - Ontario	L718	10123	10125	L82U5C3000826	L82U9C3000828	3
Brantford - Ontario	L775	10131	10132	L82U1D3000999	L82U2D3001000	2
Brantford - Ontario	L928	10151	10153	L82J7F3001793	L82J0F3001795	3
Burlington - Ontario	L887	7017-15	7025-15	L82J7F3001681	L82J8F3001723	9
Calgary Transit - Alberta	L637	8161	8180	L82U7B3000356	L82U2B3000376	20
Calgary Transit - Alberta	L709	8181	8200	L82UXC3000806	L82U3C3000825	20
Calgary Transit - Alberta	L733	8201	8202	L82AXD3000926	L82A1D3000927	2
Central Oklahoma Transportation Authority	L619	—	—	L82X7C3000367	L82X7C3000367	1
Chicago Transit Authority - CTA - Illinois	L773	—	—	L82JXD4500429	L82J6D4500430	2
Chicago Transit Authority - CTA - Illinois	L811	7902	7949	L82J6E4500509	L82J4E4500556	48
Chicago Transit Authority - CTA - Illinois	L837	7950	7999	L82J6E4500655	L82J1E4500708	50
Chicago Transit Authority - CTA - Illinois	L847	8000	8049	L82J1E4500773	L82JXE4500822	50
Chicago Transit Authority - CTA - Illinois	L848	8050	8099	L82JXF4500823	L82J1F4500872	50
Chicago Transit Authority - CTA - Illinois	L849	8100	8149	L82J5F4500874	L82J3F4500923	50
Chicago Transit Authority - CTA - Illinois	L850	8150	8199	L82J5F4500924	L82J6G9775013	28
Clemson Area Transit - South Carolina	L617	—	—	S92U5C4500002	S92U5C4500002	1
Clemson Area Transit - South Carolina	L769	—	—	S92U1D4500418	S92U1D4500418	1
CT Transit - Connecticut	L554	1041	1065	S92U1A4000139	S92U0A4000164	25
CT Transit - Connecticut	L571	1101	1110	S92YXB4000144	S92Y4B4000169	10
CT Transit - Connecticut	L815	1426	1429	S92L0E4500709	S92L0E4500712	4
CT Transit - Connecticut	L814	1462	1473	S92LXE4500717	S92L4E4500728	12
Demo CNG	L716	—	—	L82A5D3000896	L82A5D3000896	1

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
Duke University - North Carolina	L651	—	—	S92Y1B4000145	S92Y3B4000146	2
Duke University - North Carolina (ref. L703)	L641	—	—	L82U9C4500012	L82U1C4500022	8
Durham Region Transit - Ontario	L872	8551	8553	L82J0F3001523	L82J4F3001525	3
Durham Region Transit - Ontario	L888	8554	8559	L82J2F3001703	L82J1F3001708	6
Fredericton - New Brunswick	L672	8111	8112	L82U0B3000540	L82U2B3000541	2
Fredericton - New Brunswick	L688	8113	8113	L82U8C3000643	L82U8C3000643	1
Fredericton - New Brunswick	L774	8131	8131	L82U7D3000960	L82U7D3000960	1
Fredericton - New Brunswick	L812	—	—	L82J4E3001202	L82J4E3001202	1
Fredericton - New Brunswick	L836	8143	8143	L82J9E3001390	L82J9E3001390	1
Fredericton - New Brunswick	L901	8151	8151	L82J7F3001602	L82J7F3001602	1
Grand River Transit - GRT - Ontario	L633	21101	21115	L82U7B3000289	L82U8B3000303	15
Grand River Transit - GRT - Ontario	L599	21116	21118	L82X9B3000465	L82X2B3000467	3
Grand River Transit - GRT - Ontario	L631	21119	21121	L82X4B3000468	L82X2B3000470	3
Grand River Transit - GRT - Ontario	L668	21201	21220	L82U6C3000737	L82UXC3000756	20
Grande Prairie Alberta	L834	—	—	L82J7E3001386	L82J2E3001389	4
Greater Toronto Airports Authority - GTAA - Ontario	L616	—	—	L82U4C4500001	L82U4C4500001	1
Guelph - Ontario	L669	225	228	L82U9B3000536	L82U4B3000539	4
Guelph - Ontario	L767	237	239	L82UXD3000967	L82U3D3000969	3
Guelph - Ontario	L835	240	243	L82J0E3001391	L82J6E3001394	4
Guelph - Ontario	L927	244	247	L82J1F3001756	L82J9F3001763	4
Halifax - Nova Scotia	L693	526	534	L82U8C3000657	L82U7C3000665	9
Halifax - Nova Scotia	L710	1160	1161	L82U7C3000780	L82U9C3000781	2
Halifax - Nova Scotia	L708	742	761	S92UXC3000782	S92U3C3000803	20
Hamilton - Ontario	L885	1501	1524	L82K3F4501093	L82K0F4501214	24
Honolulu - Hawaii	L559	201	224	L82U6A4000113	L82U7A4000136	24
Houston - Texas	L737	1510	1510	S92U4D4500297	S92U4D4500297	1
Houston - Texas	L755	1511	1579	S92U4D4500333	S92U8D4500402	69
Kingston Ontario	L880	1502	1502	L82JXF3001786	L82JXF3001786	1
Kingston Ontario	L925	1504	1510	L82J5F3001808	L82J5F3001811	4
Krapf's Coaches - Pennsylvania (ref. L833)	L754	—	—	L82U4D4500405	L82U4D4500405	1
Lethbridge - Alberta	L868	—	—	L82J2F3001510	L82J2F3001510	1
LYNX - Florida	L725	—	—	S92Y9D4500329	S92Y5D4500330	2
LYNX - Florida	L764	—	—	S92Y7D4500331	S92Y9D4500332	2
LYNX - Florida	L785	—	—	S92L6E4500505	S92L8E4500506	2
Marketing Sales Demo - MSD 6 Houston	L628	—	—	L82U8C4500003	L82UXC4500004	2
Moncton (Codiac) - New Brunswick	L569	—	—	L82U4B4000001	L82U4B4000001	1
Moncton (Codiac) - New Brunswick	L570	—	—	L82U6B4000002	L82U6B4000002	1
MTD - Santa Barbara, California	L730	—	—	S92J8E4500567	S92J1E4500569	3
NFTA - Buffalo, New York	L877	1501	1501	L82K0F4500984	L82K0F4500984	1
NFTA - Buffalo, New York	L897	1502	1520	L82K1F4501223	L82K1G9775008	1
Niagara Falls - Ontario	L652	—	—	S92U3C3000607	S92U6C3000617	11

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
Niagara Falls - Ontario	L653	—	—	L82U9C3000618	L82U9C3000621	5
Niagara Falls - Ontario	L771	1396	1397	L82U9D3000958	L82U0D3000959	2
Niagara Parks Commission - Ontario	L685	—	—	S92U9C3000644	S92U8C3000652	9
Niagara Parks Commission - Ontario	L656	—	—	L82U0C3000653	L82U2C3000654	2
North Bay - Ontario	L895	784	785	L82J7F3001678	L82J9F3001679	2
Oakville - Ontario	L874	—	—	L82J6F3001526	L82JXF3001531	6
Oakville - Ontario	L881	—	—	L82J2F3001717	L82J8F3001740	5
Peterborough - Ontario	L770	55	60	L82U0D3000993	L82UXD3000998	6
Peterborough - Ontario	L870	61	63	L82JXF3001612	L82J3F3001614	3
Peterborough - Ontario	L919	64	66	L82J6F3001767	L82JXF3001769	3
Red Deer - Alberta	L726	—	—	L82UXC3000840	L82U1C3000841	2
Red Deer - Alberta	L766	1104	1105	L82U7D3001025	L82U9D3001026	2
Red Deer - Alberta	L772	1106	1108	L82J2E3001120	L82J6E3001122	3
Red Deer - Alberta	L813	10008	10009	L82J2E3001361	L82J4E3001362	2
Red Deer - Alberta	L869	—	—	L82J9F3001570	L82J0F3001571	2
Red Deer - Alberta	L926	—	—	L82J2F3001796	L82J4F3001797	2
Regina - Saskatchewan	L639	645	654	L82U1B3000336	L82U2B3000345	10
Regina - Saskatchewan	L748	655	662	L82U3D3000874	L82U0D3000881	8
Regina - Saskatchewan	L776	663	669	L82U4D3001001	L82U5D3001007	7
Regina - Saskatchewan	L807	671	685	L82J8E3001137	L82J2E3001151	15
Regina - Saskatchewan	L892	686	691	L82J5F3001484	L82J4F3001489	6
San Joaquin County - California	L768	—	—	S92L4D4500422	S92L3D4500427	6
Sarnia Ontario	L873	151	152	L82J0F3001599	L82J0F3001600	2
Saskatoon - Saskatchewan	L568	—	—	S92U9B3000013	S92U9B3000013	1
Saskatoon - Saskatchewan	L618	—	—	S92U1C3000377	S92U1C3000377	1
Saskatoon - Saskatchewan	L690	1201	1204	L82U6C3000690	L82U1C3000693	4
Saskatoon - Saskatchewan	L831	1401	1405	L82J7E3001307	L82J9E3001311	5
Saskatoon - Saskatchewan	L894	1501	1510	L82J0F3001490	L82J7F3001499	10
Sault Ste-Marie Transit Services - Ontario (ref. L686)	L641	135	139	L82U7C4500008	L82U6C4500016	5
Sault Ste-Marie Transit Services - Ontario (ref. L751)	L754	—	—	L82U7D4500284	L82U7D4500284	1
SEPTA - Pennsylvania	L724	7300	7301	S92Y1D4500275	S92Y3D4500276	2
SEPTA - Pennsylvania	L728	—	—	L82W7D4500335	L82W7D4500335	1
SEPTA - Pennsylvania	L749	7302	7354	S92Y7D4500409	S92L2E4500470	53
SEPTA - Pennsylvania	L743	—	—	S92L1E4500489	S92L2E4500503	15
SEPTA - Pennsylvania	L741	—	—	S92L4E4500504	S92L4E4500504	1
SEPTA - Pennsylvania	L744	—	—	L82L7E4500570	L82LXE4500661	89
SEPTA - Pennsylvania	L742	7371	7414	S92L6E4500729	S92L7E4500772	44
SEPTA - Pennsylvania	L745	7415	7415	S92L0F4500873	S92L0F4500873	1
SEPTA - Pennsylvania	L746	7416	7454	S92L7F4500952	S92L8F4501012	39
St. Catharines Ontario	L879	1501	1504	L82J4F3001587	L82J4F3001590	4
St. Catharines Ontario	L898	1560	1560	S92J4F3001663	S92J4F3001663	1

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
St. John - New Brunswick	L871	40585	40586	L82J8F3001592	L82JXF3001593	2
St. John's - Newfoundland	L687	1201	1209	L82U7C3000598	L82U2C3000606	9
St. John's - Newfoundland	L731	1310	1314	L82U3C3000842	L82U2C3000847	5
St. John's - Newfoundland	L808	1415	1419	L82J4E3001152	L82J1E3001156	5
St. John's - Newfoundland	L875	1520	1525	L82JXF3001478	L82J3F3001483	6
Stratford - Ontario	L634	—	—	L82UXB3000352	L82UXB3000352	1
Stratford - Ontario	L752	—	—	L82U9D3000863	L82U9D3000863	1
Stratford - Ontario	L893	—	—	L82J9F3001584	L82J0F3001585	2
Strathcona County Transit - Alberta	L659	2024	2028	L82U7B3000440	L82U4B3000444	5
Sudbury - Ontario	L632	811	817	L82U9B3000326	L82U4B3000332	7
Sudbury - Ontario	L740	831	833	L82U1D3000887	L82U5D3000889	3
Sudbury - Ontario	L890	851	855	L82JXF3001609	L82J6F3001641	5
Thunder Bay - Ontario	L662	20168	20168	L82U3B3000533	L82U7B3000535	3
Thunder Bay - Ontario	L739	—	—	L82U3D3000860	L82U7D3000862	3
Thunder Bay - Ontario	L806	—	—	L82J6E3001170	L82J8E3001171	2
Thunder Bay - Ontario	L863	—	—	L82J8F3001558	L82J6F3001560	3
Timmins - Ontario	L661	—	—	L82U9B3000486	L82U9B3000486	1
Timmins - Ontario	L720	12-98	12-98	L82U0C3000829	L82U0C3000829	1
Timmins - Ontario	L783	—	—	L82U8D3001017	L82UXD3001018	2
Timmins - Ontario	L839	—	—	L82J8E3001395	L82J8E3001395	1
Toronto Transit Commission - TTC - Ontario	L729	9000	9000	S92U9D3000905	S92U9D3000905	1
Toronto Transit Commission - TTC - Ontario	L738	9001	9026	S92J6D3001094	S92J7D3001119	26
Toronto Transit Commission - TTC - Ontario	L777	9027	9152	S92J7E3001123	S92J6E3001372	126
Toronto Transit Commission - TTC - Ontario	L859	8400	8400	L82J5F3001405	L82J5F3001405	1
Toronto Transit Commission - TTC - Ontario	L860	8401	8504	L82J0F3001554	L82JXF3001805	104
University of Alabama - Alabama	L671	7024	7025	L82U5C4500119	L82U1C4500120	2
University of Alabama - Alabama	L727	7026	7027	L82U4D4500310	L82U6D4500311	2
University of Alabama - Alabama	L787	7028	7029	L82J2E4500507	L82J4E4500508	2
University of Alabama - Alabama	L902	7030	7031	L82J2F4500993	L82J4F4500994	2
University of Colorado - Colorado	L627	—	—	S92UXB4000139	S92U6B4000140	2
Walt Disney World - Florida	L763	—	—	S92U0D3001019	S92U4D3001024	6
Welland Ontario	L866	—	—	L82J9F3001648	L82J9F3001648	1
Whitehorse - Yukon	L784	43	43	L82U9D3001057	L82U9D3001057	1
Woodstock - Ontario	L778	—	—	L82U2D3001014	L82U2D3001014	1
Woodstock - Ontario	L832	—	—	L82J9E3001342	L82J9E3001342	1
Woodstock - Ontario	L923	15-16	15-16	L82J9F3001746	L82J9F3001746	1
York Regional Transit - Ontario	L654	1370	1390	S92U1D3000946	S92U2D3000986	21
York Regional Transit - Ontario	L761	1391	1396	S92U6D3001008	S92UXD3001013	6
York Regional Transit - Ontario	L896	1501	1517	L82J2F3001619	L82JXF3001741	17

PROCEDURE



WARNING

Follow your internal safety procedures. Before performing any welding operation on the vehicle, sensitive electronic components must be disconnected. Ask a qualified electrician to place the main battery cut-off switch in the off position and disconnect the affected components per maintenance manual section 01: Structure.

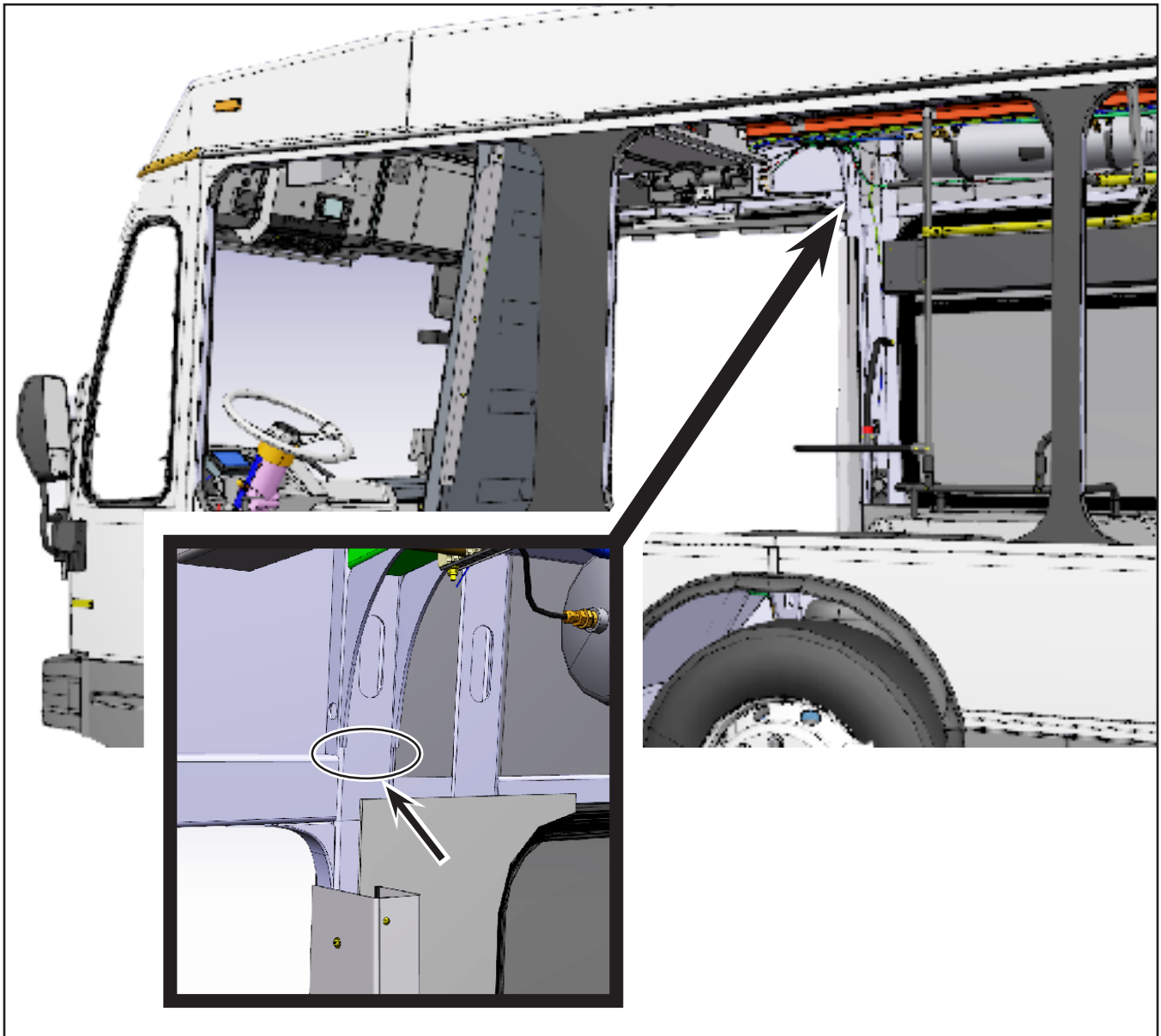


Figure 1 - Possible Crack Location

**NOTE**

Some of the parts shown in the document may not be applicable to your vehicle configuration.

Retain hardware removed during the procedure for later reinstallation.

1.1. Remove the access panel above the first curbside window. See Figure 2.

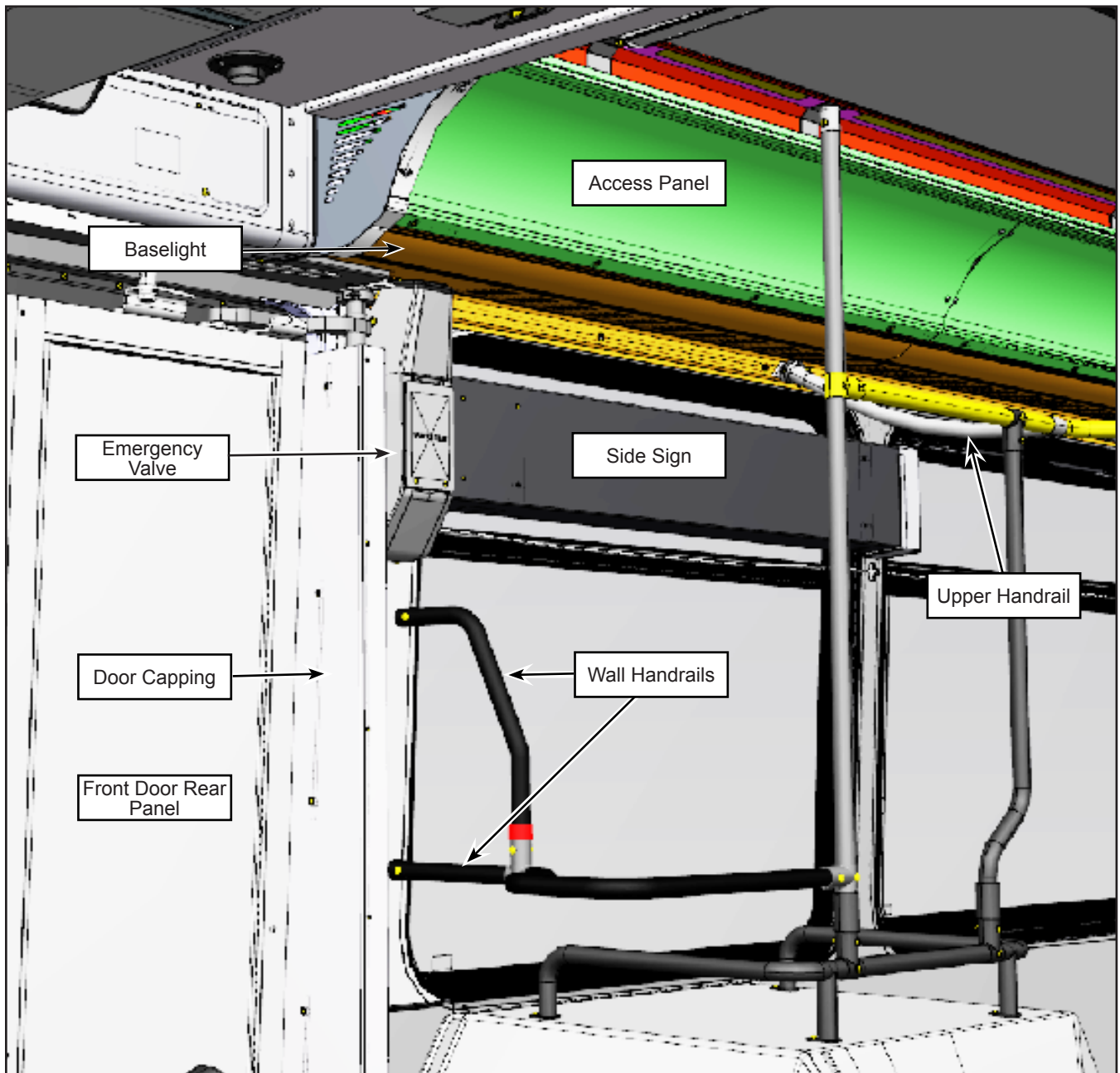


Figure 2 - Parts Identification

- 1.2. Remove the front door, rear panel only.
- 1.3. Remove the upper handrail and wall hand rails.
- 1.4. Mark the height position of the door second capping for later reinstallation. Remove door capping (2 pieces).
- 1.5. Remove the door operator connecting rod on top of the door shaft.
- 1.6. To remove the door shaft, remove the three bolts under the operator support plate. See Figure 3.



Figure 3 - Remove Door Shaft

- 1.7. Remove the emergency valve capping.
- 1.8. Disconnect the two chime cord wires and remove chime cord assembly. See Figure 4.

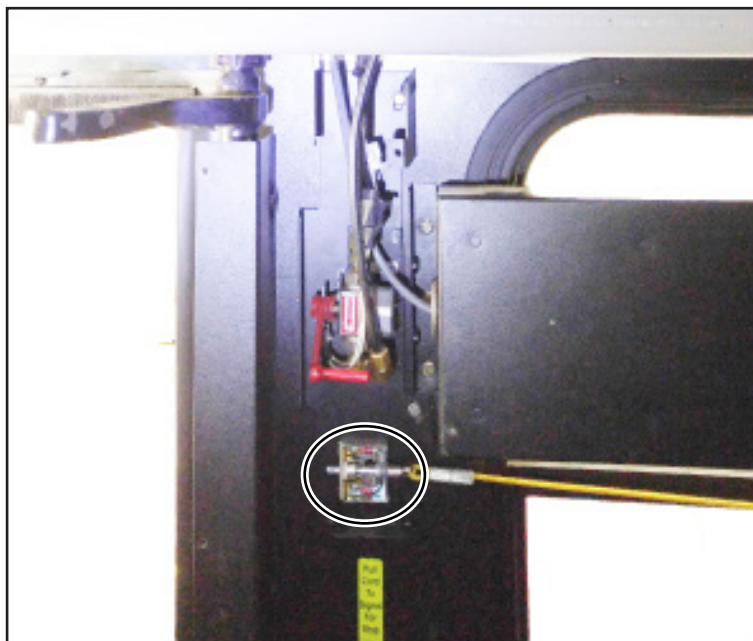


Figure 4 - Remove Chime Cord Assembly

- 1.9. Purge the air system, then disconnect the two pneumatic hoses and the connector at the emergency valve.
- 1.10. Remove the emergency valve assembly.
- 1.11. Disconnect the harness and remove the side sign with the help of an assistant.
- 1.12. Remove the window frame screws from the upper horizontal and the front vertical frame portions in order to facilitate the baselight and melamine removal.
- 1.13. To remove the first baselight, start by drilling out the two rivets at the joint of the second baselight. See Figure 5.

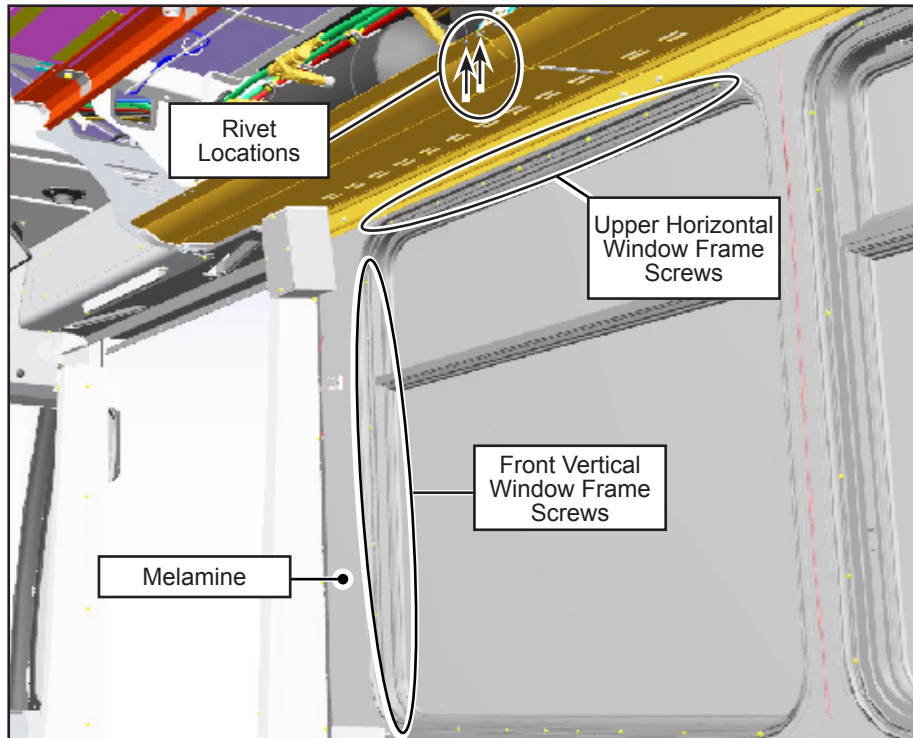


Figure 5 - Drill Out the Two Rivets and Remove Window Frame Screws

- 1.14. Disconnect the harness and remove the baselight.
- 1.15. Remove the melamine using a utility knife to cut the double face tape between the wall and the melamine. The melamine will be reinstalled after the repair, be careful to not damage it. See Figure 6.

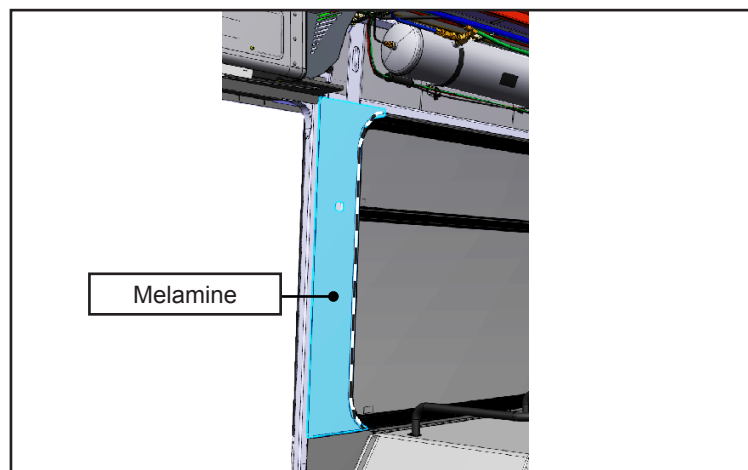


Figure 6 - Remove Melamine

- 1.16. Remove the wires and the pneumatic hoses from the wall structure, including the pneumatic drain hose into the vertical tube (see Figure 7) and attach them temporarily away from the area to be reworked. Remove and keep the u-channel edge protector.

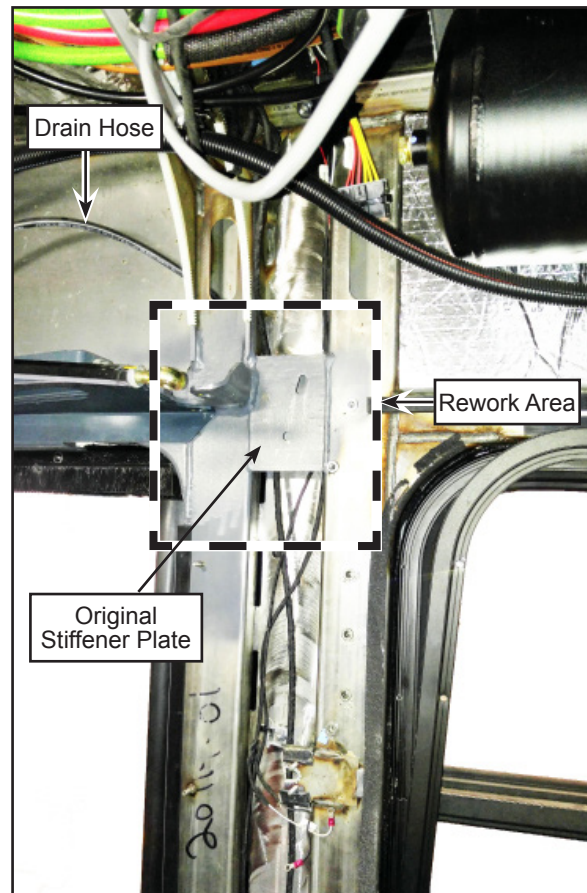


Figure 7 - Secure All Hoses and Wires Away From the Rework Area

- 1.17. Inspect the area shown in Figure 1. If a crack is found, make 1/8 in. stop holes at one or both ends if possible.



NOTE

All components and surfaces must be protected from cutting or grinding during the repair process.

- 1.18. With a cut-off wheel, remove the original stiffener plate between the two vertical tubes, see Figure 7. This plate will be replaced by N71120, see Figure 8.

- 1.19. Surface preparation is very important. Grind as required to get smooth flat surfaces without wobbles. Remove existing welding spatters. The area to prepare has to be approximately 2 in. wider than the area covered by the new stiffening plates. See shaded area in Figure 8 for preparation area to be covered.

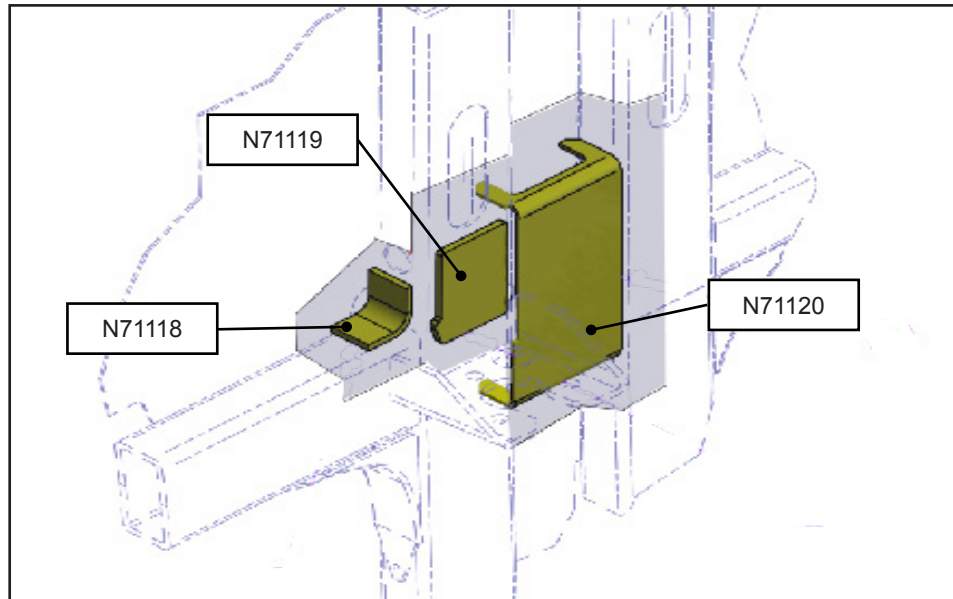


Figure 8 - Surface Preparation Area

- 1.20. If there is a ground stud in the area, cut it. See Figure 9.

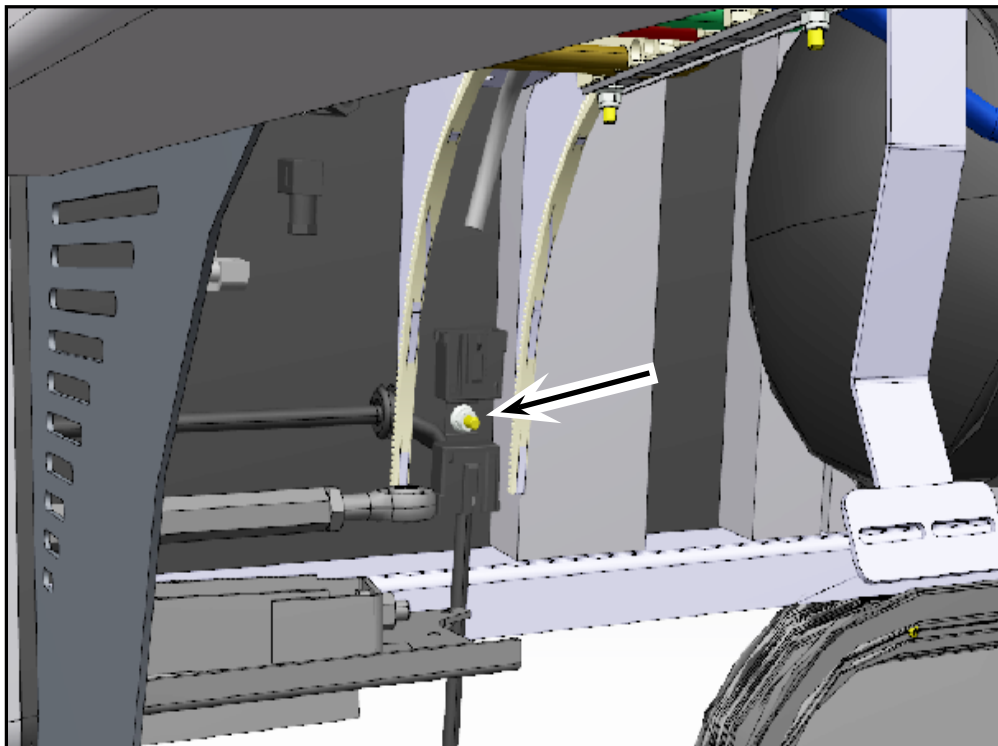


Figure 9 - Cut the Stud

- 1.21. If there are existing protruding bumps greater than 1/16 in. from the existing weld beads, grind them flush with the weld bead. The weld on the existing structure should not be more than 1/2 inch, if it is, it should be ground down to insure that the maximum of 1/2 inch is respected. The minimum weld size to respect shall remain equivalent to the thickness of the plate being welded and respecting a maximum weld size of a 1/4 inch. See Figures 10 and 11

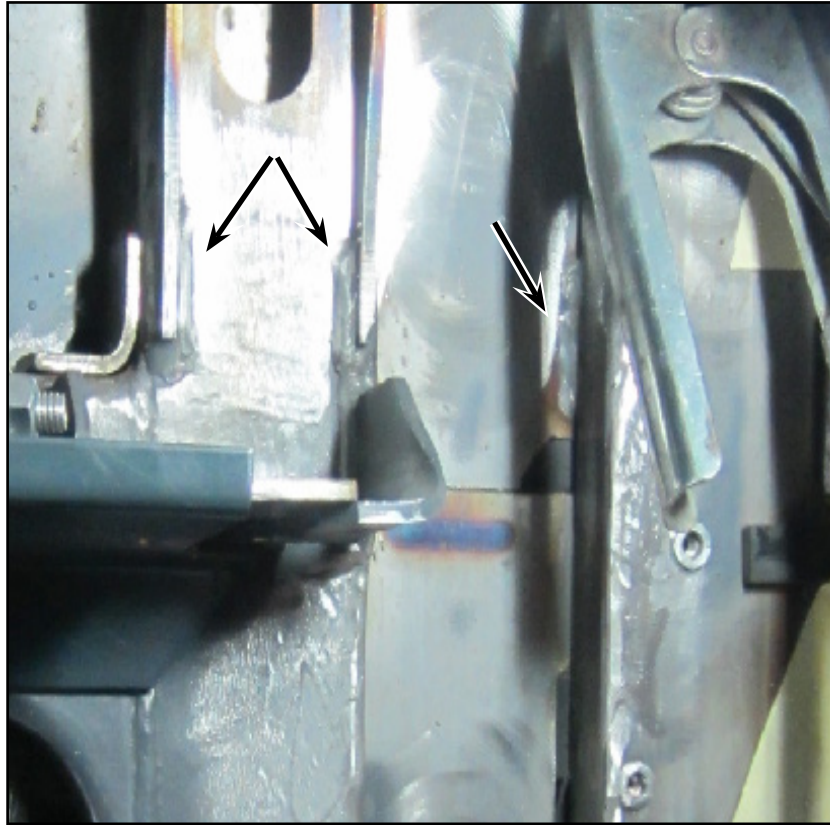


Figure 10 - Examples of Weld Beads that May Need to be Ground (Not Limited to These)

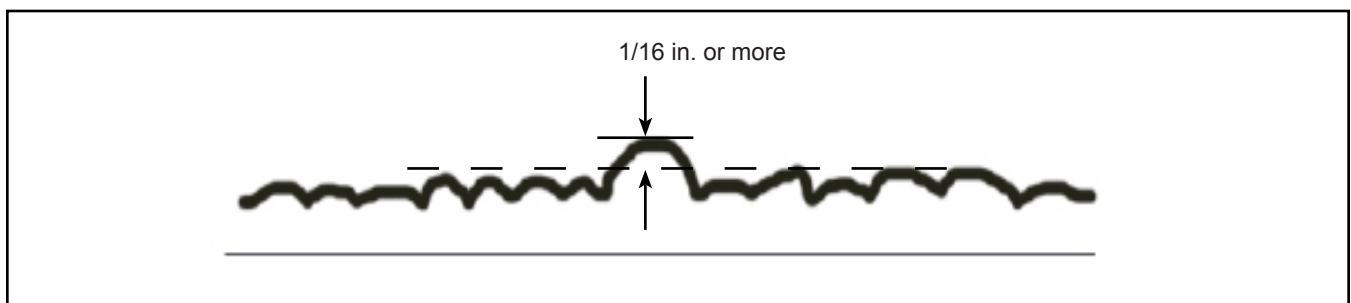
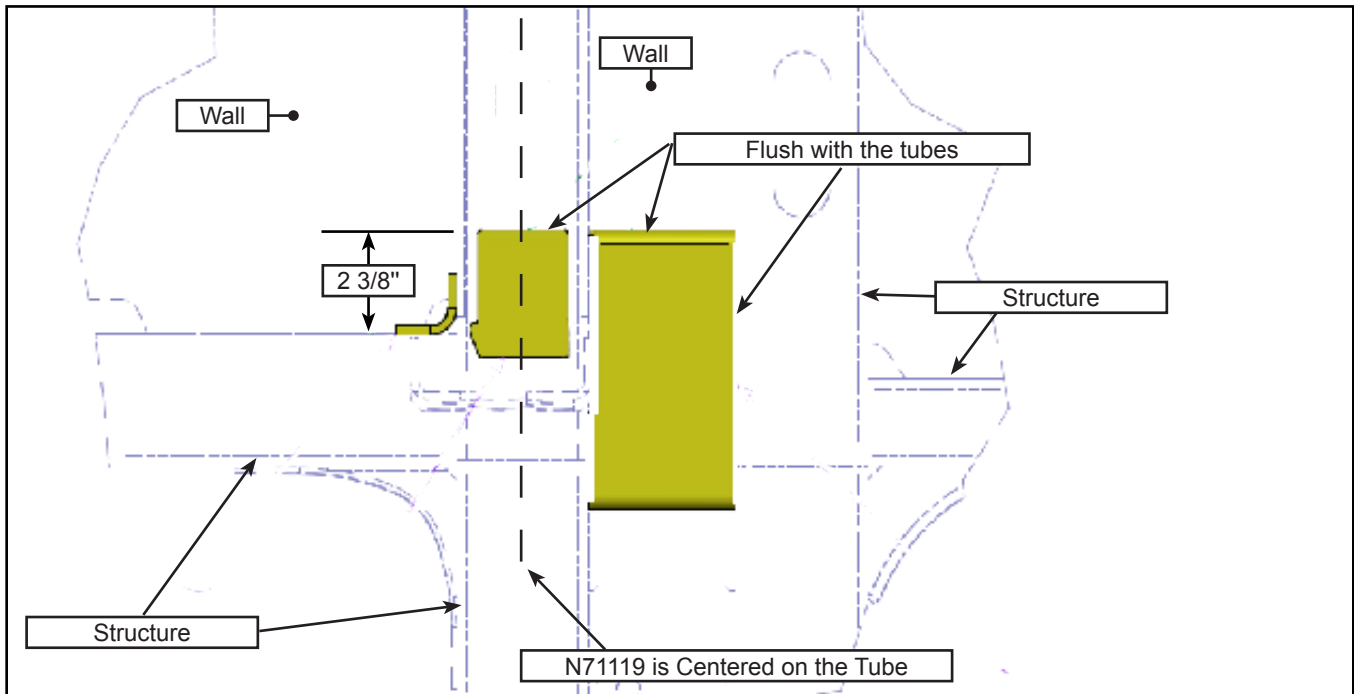


Figure 11 - Grind Protruding Bumps of More Than 1/16 in.

1.22. Verify the plates position prior to welding. See Figure 12. It may be required to grind or modify the parts.



1.23. A 1/8 in. gap is required between N71119 and the existing weld on the structure, grind if necessary. Press fit is not acceptable. See Figures 10 and 13.



**CAUTION**

All components must be protected from heat, spatter and flame during the welding process. Refer to maintenance manual section *01: Structure* for welding procedure. Given the heat transfer to the wall, take care not to damage the parts in the surrounding area, such as the outside fiberglass panel.

- 1.24. Plate N71119 must be centered with the vertical tube. N71118 and N71120 must be flush with the inside face of the tubes. Make a full weld on every edge, represented by the dashed lines in Figure 14. Weld to the structure tubes only, not to the wall.

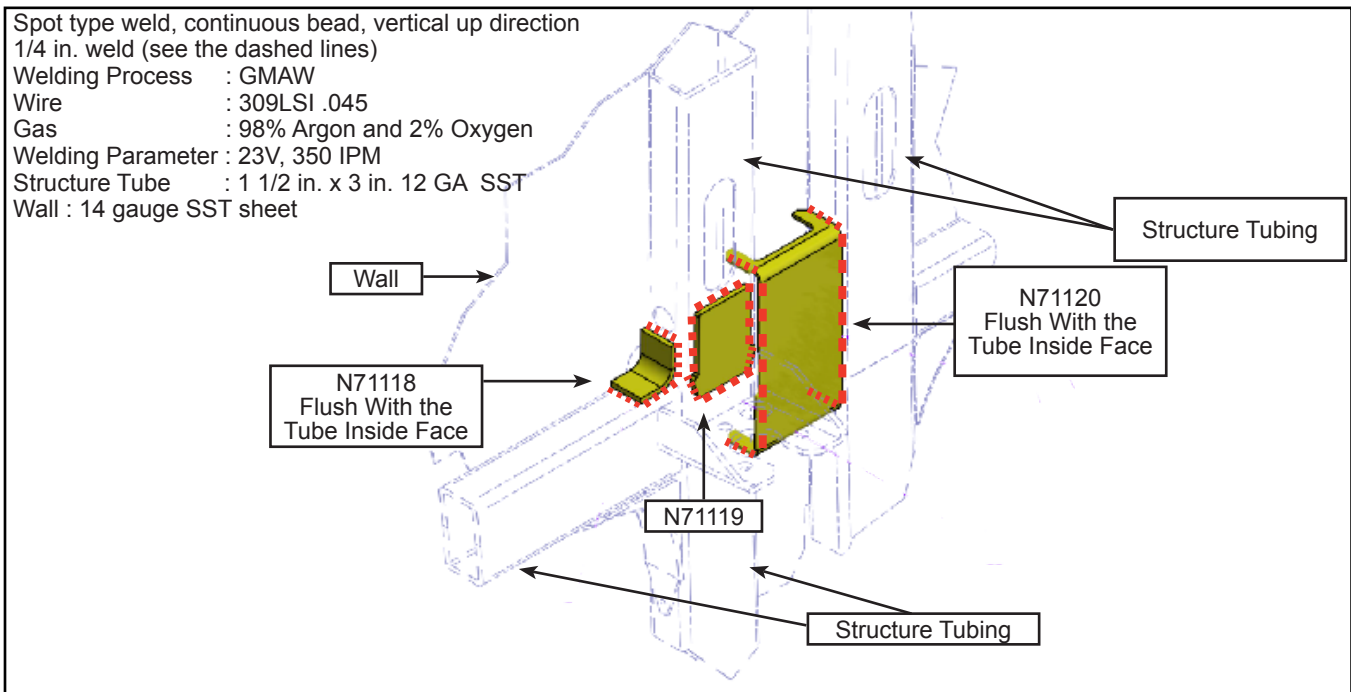


Figure 14 - Weld the Parts in Place

- 1.25. Fill the corner gap between the structure and N71118. See Figure 15.

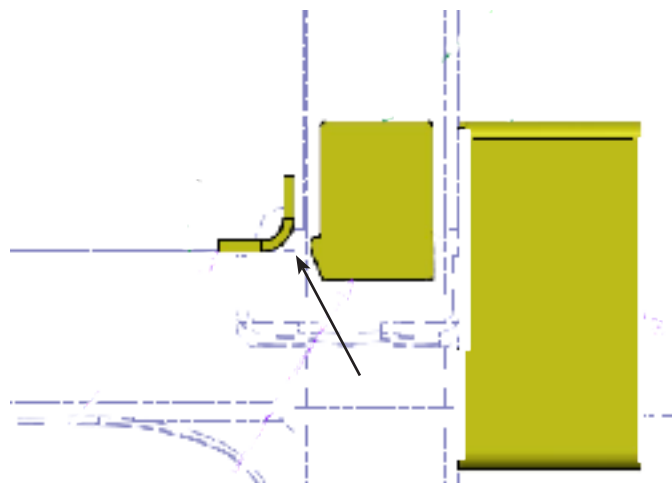


Figure 15 - Fill the Gap for N71118

- 1.26. Make tack welds on the head of bolt N24104 to replace the previously cut ground stud. See Figures 16 and 17. The position shall be approximately 1 in. above the plate N71119 and centered on the tube. The tack welds should be on alternate corners of head bolt. This gives a total of 3 tack welds. During the tack weld operation the dimension from opposite corners should not be reduced by more than 20%.

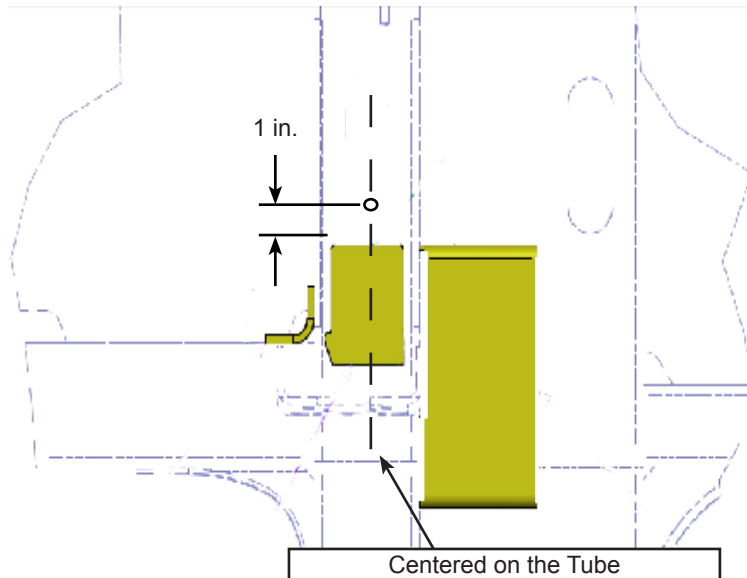


Figure 16 - New Ground Location

- 1.27. If the tack welds are higher than the head of the bolt, grind them flush to allow for a proper ground contact. See Figure 17.

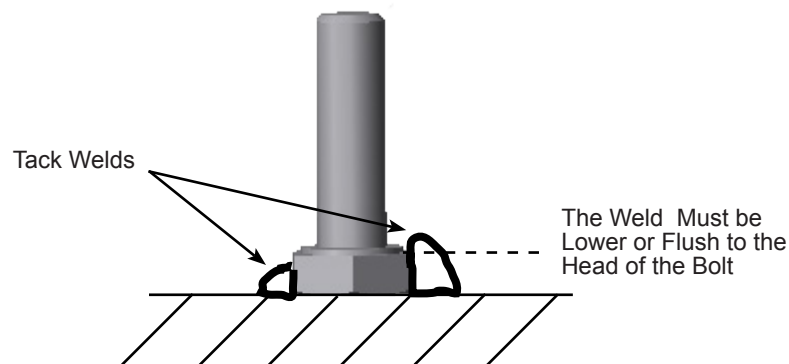


Figure 17 - Tack Weld the Bolt

- 1.28. Install the door shaft and apply a torque of 4.4 lb-ft to the three bolts. Use thread locker 9985283 or equivalent and anti-tamper seal. See Figure 18.
- 1.29. Install the door mechanism rod to the top of the shaft, torque to 13.3 lb-ft and apply thread locker 9985283 or equivalent and anti-tamper seal. We recommend applying grease N24412 or equivalent to the pivot, if needed. See Figure 9.

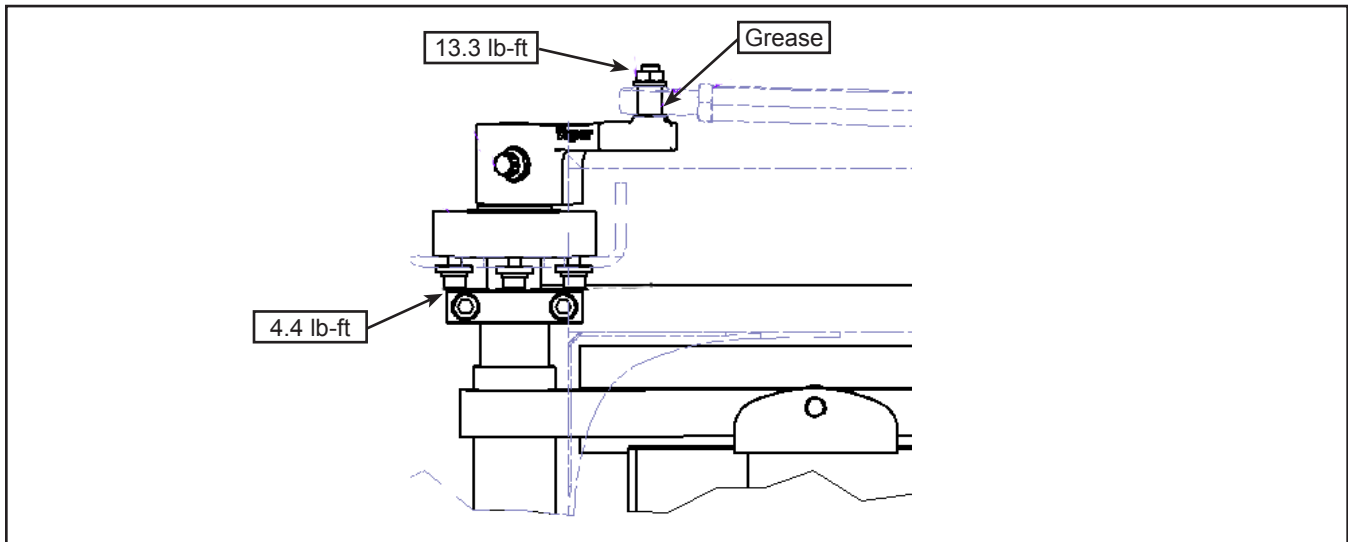


Figure 18 - Torque Door Shaft

- 1.30. Check that there is enough space between the new plate N71119 and the door mechanism. Grind the plate if necessary.
- 1.31. Put the drain hose back in place in the vertical tube and the wires on the structure like they were before.
- 1.32. Install the original U-channel edge protector on plate N71120.
- 1.33. Install the melamine and route the chime wires through the hole.
- 1.34. Install the door shaft capping at its original height.
- 1.35. Install the baselight and two new N30702 rivets. Connect the baselight harness.
- 1.36. Install the window frame screws.
- 1.37. With an assistant, connect and install the side sign. Torque the six bolts to 6.3 lb-ft.
- 1.38. Install the emergency handle assembly. Connect the hoses and harness.
- 1.39. Install the chime cord assembly. Connect the two wires.
- 1.40. Install the emergency handle capping.
- 1.41. Install the wall and upper hand rails.
- 1.42. Install the access panel.
- 1.43. Ask a qualified electrician to connect the components that were disconnected as per maintenance manual section 01: *Structure*. Place the main battery cut-off switch in the ON position.
- 1.44. Prior to returning the vehicle to service, validate the proper functioning of:
 - 1.44.1. The door
 - 1.44.2. Chime cord
 - 1.44.3. Destination sign
 - 1.44.4. The baselight
 - 1.44.5. The emergency valve ❖