



Service Bulletin No. 1083

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| COACH MODEL | : C2045, T2145 and S2145 |
| BULLETIN TYPE | : Service Information |
| MANUAL & SECTION | : Maintenance Manual : Chapter 11 - Body & accessories Spare Parts Manual : Section 738209 - Rear bumper |
| DATE | : May 31st, 2001 |
| SUBJECT | : Thermoplastic bumper shell painting |
| TERMS & CONDITIONS | : No claims will be accepted with reference to this Bulletin. |

APPLICATION :

The procedure supplement to this Bulletin is applicable to C2045, T2145 and S2145 units.

DESCRIPTION :

The attached procedure explains how to prepare and finish Van Hool thermoplastic bumper shells.

SERVICE INFORMATION :

Service bulletins are issued to supplement or supersede information in the Van Hool manuals. Note Service Bulletin number, date and subject on the register at the end of the relevant chapter(s). File Service Bulletin separately for future reference.

Service personnel : please read, initial and circulate

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TO PAINT THERMOPLASTIC BUMPER SHELLS VH 10688470, VH 10688471, VH 10688475 & VH 10688477

APPLICATION :

The procedure below is applicable to C2045, T2145 and S2145 coaches.

DESCRIPTION :

As from the units indicated below, Van Hool have cut into production shock absorbing bumper assemblies featuring thermoplastic bumper shells. The present procedure describes how a factory supplied bumper shell should be painted.

PARTS :

| Model | VIN | Description | Part No. | Qty. |
|-----------------------------|-----------------|---------------------|-------------|------|
| C2045 Cummins | 45222 → 45225 | Bumper shell, front | VH 10688471 | 1 |
| | 45254→ | Bumper shell, rear | VH 10688470 | 1 |
| C2045 Detroit D. | 45686 ; 45687 ; | Bumper shell, front | VH 10688471 | 1 |
| | 45703→ | Bumper shell, rear | VH 10688470 | 1 |
| T2145 Cummins | 44253→ | Bumper shell, front | VH 10688477 | 1 |
| | | Bumper shell, rear | VH 10688475 | 1 |
| T2145 Detroit D. | 44566→ | Bumper shell, front | VH 10688477 | 1 |
| | | Bumper shell, rear | VH 10688475 | 1 |
| S2145 | 42226→ | Bumper shell, front | VH 10688477 | 1 |
| | | Bumper shell, rear | VH 10688475 | 1 |

PROCEDURE :

1. General :

- The time required to prepare, coat with primer and finish the painting of this type of bumper shell is approximately 3 hours, drying time in a paint booth included.
- It is recommended to use quality automotive products and paints, all of the same brand. Van Hool do not recommend a particular brand, but paints and products should be used having the same composition as the Sikkens line of paints and products referred to in this procedure.

CAUTION : Do not use etch primers containing acids for this application. Acids will alter the chemical properties of the bumper shell, making it loosen its shock absorbing capacity.

- Spraying should be done in a dust-free environment, preferably in a spray booth.
- Do not attempt to dry the paint using infrared lamps.
- Observe safe shop practices at all times. In addition to observing the safety instructions on the product and paint packaging, the following safety precautions should be taken :
 - No smoking in the paint room or any adjacent area exposed to residue fumes.
 - Only approved respirators should be used.
 - Adequate ventilation must be maintained.
 - Wash hands prior to eating.
 - Wear protective clothing and a safety mask during all phases of painting and chemical handling.
 - Operator-supplied air should be used, if available.
- Read the entire procedure before beginning to work.
- Park the coach on a level surface, apply the parking brake and shut down the engine.
- Switch off all systems and turn off the battery master switch.
- Put a "DO NOT OPERATE" tag on the instrument panel.

NOTE : The bumper shell may be painted either on or off the coach.

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| <i>On the coach</i> | <i>Undo the nuts securing the shell to the aluminum substructure to allow expansion while heat drying. Do not remove the nuts. Retighten nuts to a torque of 15 ft.lbf (20 Nm), when bumper assembly has cooled off.</i> |
| <i>Off the coach</i> | <i>Support the shell along its length with stands to prevent stretching and warping while heat-drying.</i> |

2. Preparation :

- 1) Degrease surface to be painted with Sikkens Antistatic Degreaser.
- 2) Roughen the surface with P100 grade sanding paper.
- 3) Rub down all sharp edges and corners with Scotch Brite red.
- 4) Clean surface with tackrag.
- 5) Apply two 10 μ coats of Sikkens Plastoflex Primer.
- 6) Allow to dry for 10 minutes at 50 °F (20 °C) between coats.
- 7) Allow to dry for 20 minutes at 50 °F (20 °C) after application of the second coat.

3. Finishing :

- 1) Spray with Sikkens Autocryl 3+1 Filler (80μ). Allow the filler to dry for 5 to 10 minutes at 50 °F (20 °C) between coats.
- 2) Allow to dry for 40 minutes at 120 °F (50 °C) after application of the final coat.
- 3) Flatten with wet and dry P600 grade sanding paper.
- 4) Clean with tackrag and Sikkens Antistatic Degreaser.
- 5) Finish paint with appropriate two-pack Sikkens Autocryl.

4. Drying :

Allow paint to dry for 1 hour at 120 °F (50 °C).

Procedure complete.

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