

INSTALLING REPLACEMENT BUS POPOUT HINGES

1. The first thing you'll need to do is remove what's left of the original popout hinge by drilling out the spot welds that attach it to the body. Try not to drill all the way through the hinge, just remove most of the metal, that is, the spot weld. This is easier said than done.
2. The next step is to prep the area where the hinge was once attached. Remove the old paint, rust, etc.
3. Now screw the new hinge to your popout frame using the 3.5 mm counter sunk screws.
4. Install the body to frame seal on the bus. **Do not** install the frame to body lip seal on your popout window yet. If the original lip seal is still on your popout frame, it will need to be removed.
5. Place the frame with hinge attached into the window opening, the hinge leaf with the oblong holes needs to point outward, as the original one did.
6. At this time make sure the frame is seated against the body seal and set the spacing top and bottom. This spacing should be approximately $\frac{1}{4}$ inch and can be done using some shim material of wood, metal, plastic, etc.
7. Once you are satisfied with the frame alignment, scribe a line at the top and bottom of the hinge and a line vertically along the edge of the hinge.
8. Now remove the hinge from the frame and realign it to your scribed marks. Mark the center of the oblong holes and drill a small hole at each of these points.
9. Using sheet metal screws, fasten the hinge to the body. Reattach the frame to the hinge and double check the alignment. Further adjustment can be done at this point if necessary.
10. Once spacing and alignment is correct, remove popout frame from the hinge and weld through the three small holes to the body. Then remove your two sheet metal screws and weld through the oblong holes. Grind to your liking, paint, etc. and you are ready to repeat the procedure on all hinges to be replaced.

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