



SERVING THE BUS TRANSPORTATION INDUSTRY  
4121 Eastland Dr  
Elkhart, IN 46516  
Phone: (574) 522-5000 FAX: (574) 522-9099

## Actuator Arm Replacement

1. Disconnect power from door system. (Note: Steps 1-3 with newer boards are done by simply disconnecting the 4-pin connector on the PC Board)
2. Disconnect coach wiring feeding the header PC board.
3. Disconnect ground wire.
4. Remove attaching hardware attaching header to door frame.
5. Remove the set screws located in the bottom of the Actuator Arms.
6. Lift header assembly off door hex engaging points.
7. Remove snap ring from bottom of actuator arm (if present).
8. Inspect mount bushing for wear. Replace and ream to size as required.
9. Install new actuator arm into bushing and install snap ring.  
Note: Actuator arms may not be interchangeable, left to right. See illustrated parts for correct installation.
10. Apply anti-seize to engaging hex of door leaf.
11. Actuate emergency release lever and position header actuator arms to the full open position. Re-engage emergency release lever.
12. Rotate door leaves to the full open and position header onto door engagement hex assemblies.
13. Replaced set screws removed in step 5.
14. Reattach mounting hardware.
15. Reconnect coach electrical connections and ground.
16. Actuate emergency release lever and check for binding, correct as required.
17. Restore power to door system and test door operation.