

Sleeper Side Ventilator Window Failure

VN670 VN780

On Volvo VN 670 and 780 model vehicles manufactured from February 9, 2009 through December 31, 2009, the upper sleeper side window glass may become loose and then fall out of the vehicle.

Important Note: Given the nature of the repair, Volvo recommends that the repair be subletted to a professional glass installer. Volvo and Sika have negotiated a standard price for these repairs with Safelite^(R) Auto Glass, a nationally recognized glass installer. Safelite can be contacted at (888) 800-4527 in the US, or their sister company, Belron Canada at (905) 669-7716. If the repair is subletted, the labor expense is to be filled under "other" in the warranty claim with a copy of the invoice from the glass installer.

Required Parts

Qty	Part Number	Description
1	21512736	Ventilator Window LH
1	21512737	Ventilator Window RH
1	VWK-5021	Adhesive Kit

For convenience, a kit (supplier part number VWK-5021) is available. The kit contains 1 can of Sika 209D primer, 2 cartridges of Sikaflex 255-FC adhesive and 4 Sika activator pads. The contents of this kit will address two windows or one vehicle, with the exception of the primer which is enough to do ten windows or five vehicles. Larger quantities of the individual materials (i.e. primer, adhesive, and activator) are also available.

The kit may be purchased through Industrial Supply Solutions Inc., a distribution facility for Sika brand product, or in individual material larger quantities from either Industrial Supply Solutions or your local Sika distributor.

Kit ordering information:
Industrial Supply Solutions Inc.
804 Julian Rd. Salisbury, NC 28147
Phone: (800) 849-9116
Fax: (704) 636-2093
Email: ssobataka@issimro.com
Alternate phone # if afterhours: (704) 647-1719

Important Notes:

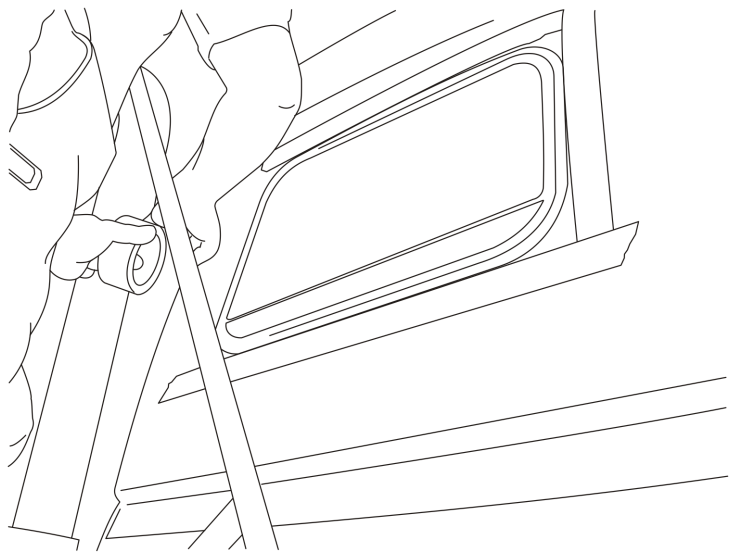
- Ground Transportation will be the primary means of distribution; material is not conducive to distribution by air. Please plan accordingly.
- MSDS Sheets will be provided with each shipment; these must be reviewed with the appropriate people within your organization and the precautions as specified must be adhered to.
- The materials listed above (i.e. Sika 209D primer, Sikaflex 255-FC adhesive, and Sika Aktivator) must be used for the repair! For technical support contact Sika at 800-688-7542.

Repair Procedure

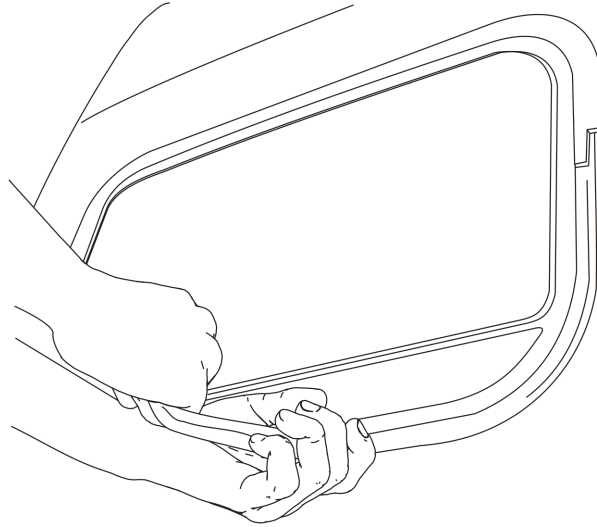
 DANGER	 WARNING
Scaffolding or other suitable work platform must be used when performing this procedure. Failure to do so may result in a fall causing serious injury or death.	The adhesive may cause skin and eye irritation. Prolonged or repeated contact with skin may cause an allergic reaction/sensitization. It may cause respiratory sensitization and respiratory tract irritation.
 WARNING	 WARNING
The cleaner is flammable and has a flash point of 56° F (14° C). Avoid breathing vapor. Use only with adequate ventilation. Avoid contact with eyes, skin or clothing. May cause dizziness, headache or other central nervous system effects. Use chemical resistant gloves and use of safety goggles recommended. Wash thoroughly after handling.	Gloves and safety glasses should be worn when removing the glass. Failure to do so could result in personal injury from broken glass.

NOTE: Illustrations are used for reference only and may differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

- 1. To protect the vehicles finish, tape off the body surface surrounding the window opening with auto grade tape.

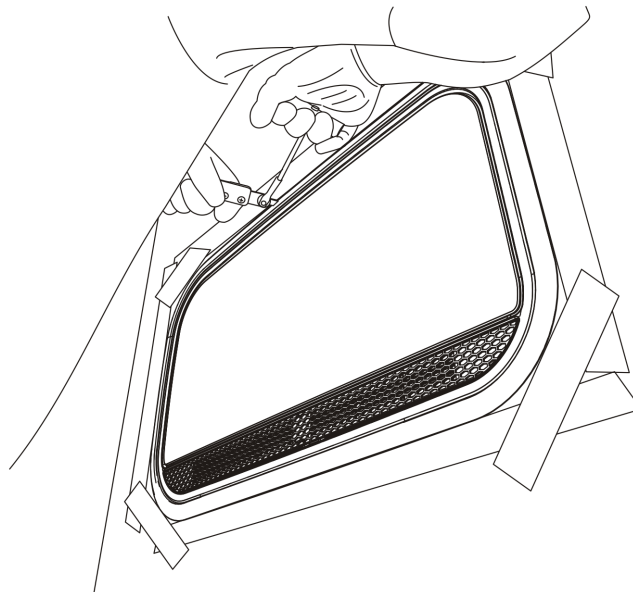


2. Using a cold knife, carefully cut the rubber molding surrounding the window. Make a small initial cut and then peel back the rubber by hand, separating it from the window.
Special tools: J-24402-A



3. Using the cold knife (half inch blade) or auto glass power tool carefully cut through the window bonding. When the bonding is cut all the way around the window, gentle pull outward and remove the window assembly.
Special tools: J-24402-A

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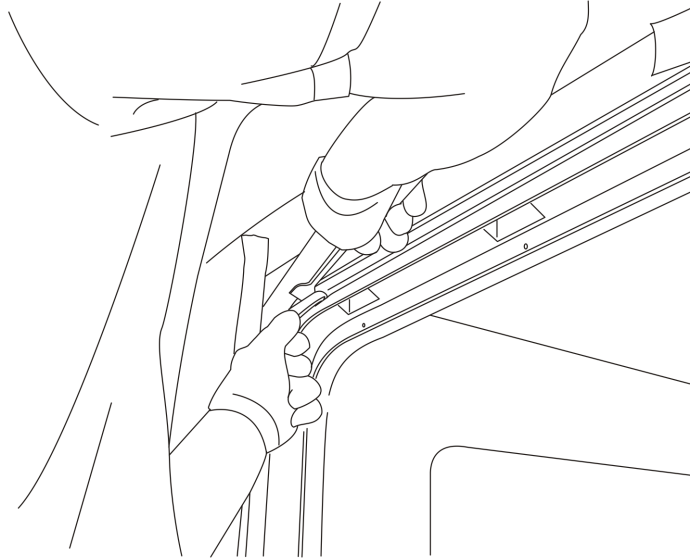


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4. Pull on the adhesive left on the window opening to check for good bonding.
If the excess sealant peels free easily, then clean the pinch weld area down to the painted surface and apply Sika Aktivator to the SMC flange area of to be bonded with a clean rag or dauber. Immediately wipe off the flange with another clean dry rag, turning frequently to ensure the rag is wiping off excess Sika Aktivator.

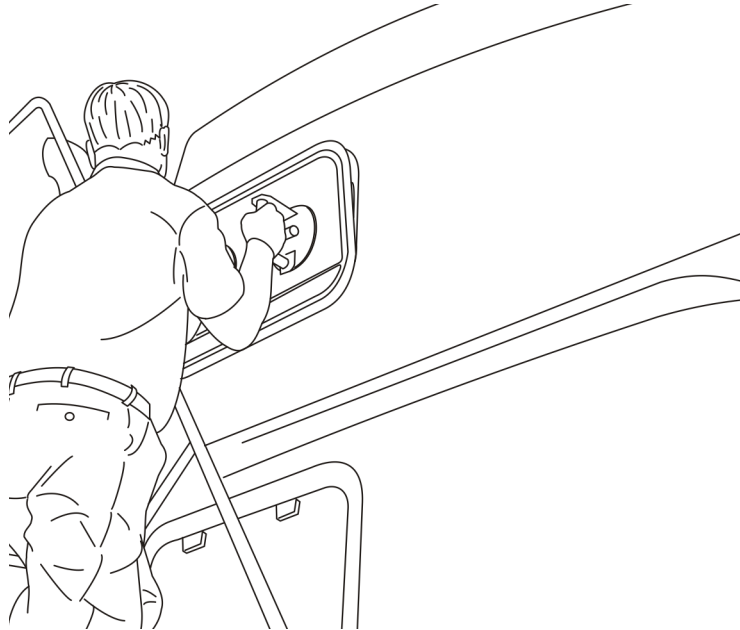
Note: Drying time minimum 10 minutes, maximum 2 hours. If the two hour maximum is exceeded, repeat Aktivator application.

If good bonding exists with the excess adhesive then strip excess sealer from the window frame using a cold knife and/or scrapers. Leave 2 - 3 mm (0.1 in.) of old adhesive, to act as the base for the new adhesive to window opening bonding.



5. Using suction cups, dry fit the window to ensure proper fit.
Special tools: J-2189-32

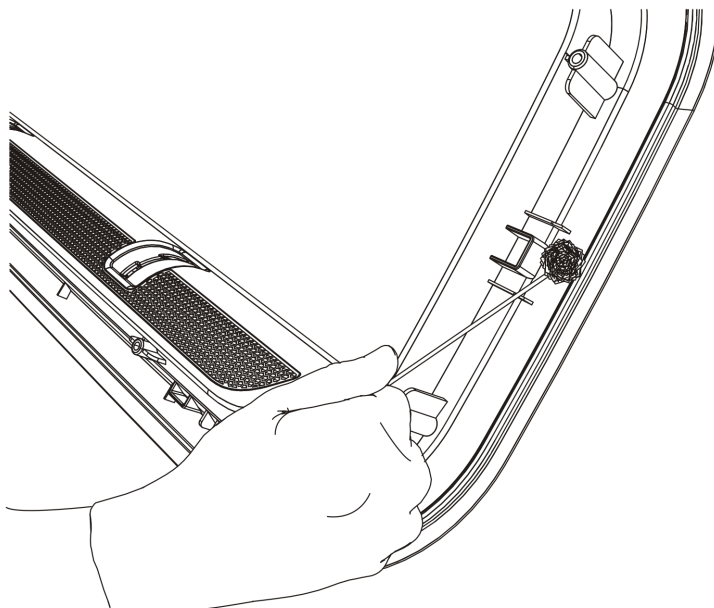
NOTE: Do Not completely seat the window or the clip will lock into place. If this happens the window will not come out without damaging the retainer clips.



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6. Slowly and gently peel back the masking tape from the surrounding window opening surfaces. Care must be exercised to preserve the vehicles finish.
7. Using a 50:50 mixture of isopropyl alcohol and water, clean the new window frame to prepare the surface. Allow at least 2 minutes dry time before proceeding.

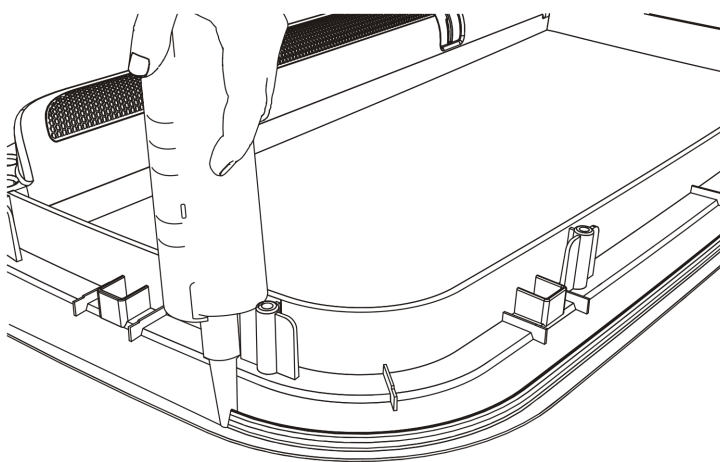
8. Apply 209D primer around the entire new window frame sealing surface. Allow 10 minutes flash time after application of the 209D primer.



9. Using a caulk gun, apply a continuous V shaped bead of Sika 255-FC adhesive. Starting at the bottom center of the window, the bead should be centered in the new window sealing surface and should measure 15 ± 3 mm (0.6 in.) high by 8 ± 2 mm (0.3 in.) wide.

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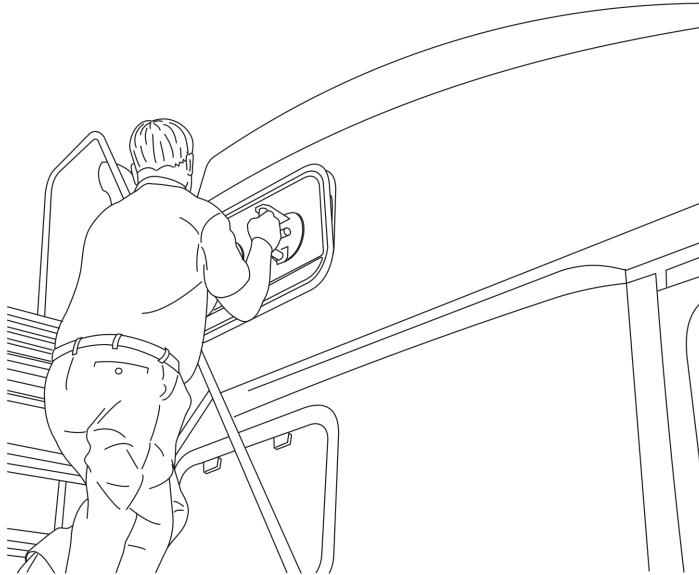
NOTE: Sika 255-FC is the required adhesive for proper adhesion and sealing.



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10. With the suction cups attached, carefully position the window in the opening and install the window. Apply pressure inward on the window until it snaps into place.
Special tools: J-2189-32

NOTE: If the vehicle must be moved before the adhesive has had time to cure, be sure to secure the window in place with auto grade tape.



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11. Clean and water test the glass.
12. Allow at least 2 hours for the adhesive to cure before returning the vehicle to service.

Reimbursement

This repair is covered by an authorized Safety Recall campaign. Reimbursement is obtained through the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	R
Recall Status	
Vehicle repaired per instructions	2-Modified per instructions
Labor Code	
Primary Labor Code	84423-0-02 - 2.0 hr. Time allowed to replace 2 widows per recall RVXX1001
Time to take charge of vehicle and determine campaign status	17003-0-01 - 0.3 hr.
Causal Part	20582366
Parts Disposition	Scrap Local
Authorization No.	RVXX1001

Take-charge time is not included in the labor code for this operation. Take charge may be eligible, but can only be used once per vehicle repair visit. If the vehicle is having other warranty repairs performed, take-charge should be charged to the warranty repair, otherwise take-charge can be charged to this Safety Recall campaign.

NOTE: Dealers are to perform Safety Recall Campaigns on all subject vehicles at no charge to the vehicle owner regardless of mileage, age of vehicle or ownership (original purchaser or subsequent purchasers). Whenever vehicles are subject to a safety recall are brought to your dealership for service, or taken into your dealership vehicle inventory, it is strongly recommended that every effort be made to perform the recall correction before the vehicle is sold or released to the owner.