

## SERVICE BULLETIN

**TITLE:** Improve joint strength under the driver side window

**TO:** Micro Bird distributors

**PRODUCT:** G5 School vehicles, 2008-2009, 158"/159" Wheelbase

**FROM:** Micro Bird After Sales and Warranty department

Reference : recall 10-039-JSC

### PLANNING

#### Description

This document contains procedures to strengthen, with adhesive, the joint of the embossed aluminum panel underneath the driver side front window in school vehicles with 158"/159" wheelbase.

#### Compliance

The warranty claim must be placed with Micro Bird within 45 days from the date of repair.

#### Manpower:

.75 hour per vehicle will be allowed to make modifications.

***Note: It is recommended to read the entire procedure before performing repairs.***

***Note: It is assumed that all of the procedures required to embody this modification will be performed according to professionally accepted standards.***

#### Material required to perform repairs

- Drill (1)
- Drill bit 13/64" (1)
- Isopropyl alcohol
- Rag (1)
- Spatula (1)
- Loctite adhesive H8600 (50ml)
- Adhesive applicator (1)
- Manual riveter (1)
- Rivets (6)
- Ratchet, socket 1/2" diameter (1)
- Wrench 1/2" diameter (1)



Material required

## MATERIAL INFORMATION

Product number	Description	Qty per vehicle	NOTE
827562	Loctite H8600	12 ml	Provided by Micro Bird
720228	50ml Dual Cartridge Applicator	<b>(reusable)</b>	Provided by Micro Bird
833940	50ml Mix Nozzle	1	Provided by Micro Bird
1641-0621	Aluminum rivets dia. 3/16" x .80"	6	Provided by Micro Bird

## REPAIR INSTRUCTIONS

1- Before proceeding with the repair of the joint, remove the barrier by taking off all hardware that holds it to the wall and floor (Figure 1).

Use a ratchet, socket and ½" diameter wrench.



Figure 1

2- Locate the joint and check to see if adhesive was applied between the panels using a small spatula (Figure 2)

The aluminium panel joint affected by this recall is located on the left side (driver side) under the first window.

Easily identifiable by six (6) rivets;  
 (3) Rivets located in the bow.  
 (3) Additional rivets join both panels together. (Figure 2).

If the spatula can be inserted beyond the left rivets, there is no adhesive. Follow the steps below to correct the situation.

\*\* If there is adhesive, fill in and return the reply sheet indicating that the repair is not required.

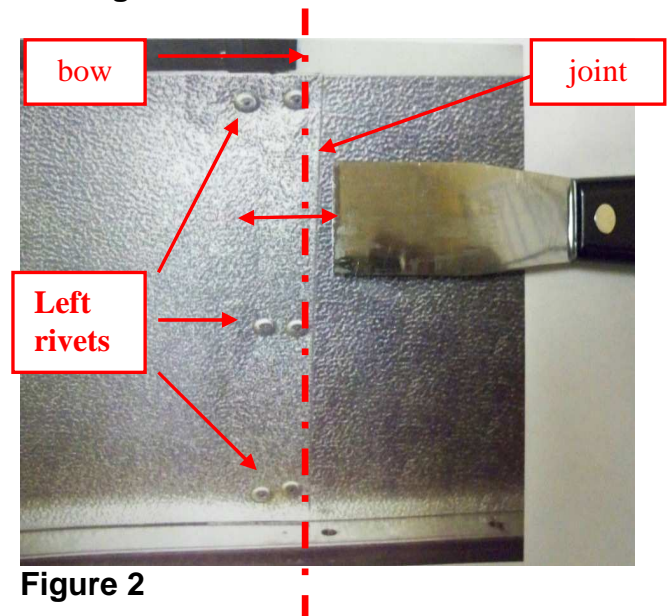


Figure 2

3- Remove the six (6) rivets

**Caution:** Do not use a bit larger than 13/64" to make sure not to enlarge the holes in the panel and install the replacement rivets properly

Using a drill and drill bit 13/64", place the bit in the center of the rivet and drill it to remove it's head (Figure 3). The six (6) rivets must be removed (Figure 4).

It is recommended to stop drilling as soon as the head of the rivet is removed on your drill. Do not drill more than 1/2" (Figure 4)

**It is very important** to do this step very carefully.

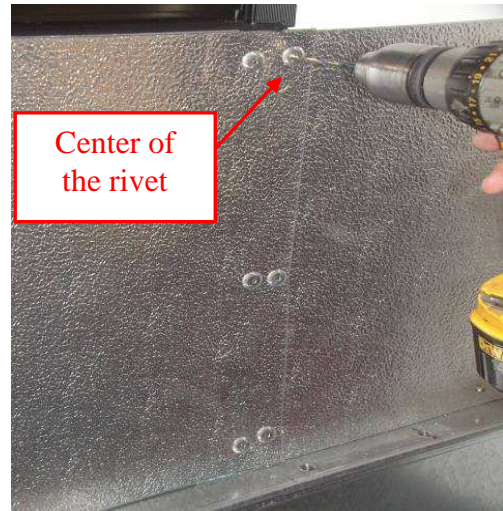


Figure 3



Figure 4

4- Lift the aluminum panel and clean, with a cloth dampened with isopropyl alcohol, both surfaces that will be in contact with the glue, to obtain optimal adhesion (Figure 5)



Figure 5

5- Apply an adhesive strip of at least ¼" (Figure 7).

Apply the strip vertically between the rivet holes to ensure that the adhesive does not overflow (Figures 6 & 7).

**Attention:** As soon as the adhesive is applied, you have a maximum of 15 minutes to complete the repairs before the adhesive loses its effectiveness.



Figure 6

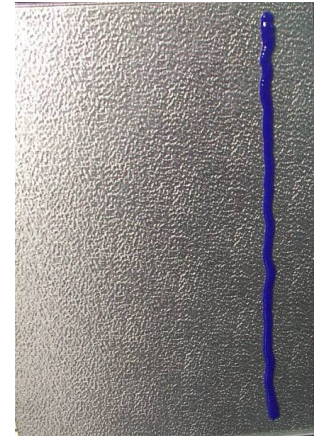


Figure 7

6- Install six (6) aluminum rivets with a hand riveter (Figure 8).

Method to insert the rivets in the manual riveter (Figure 9).

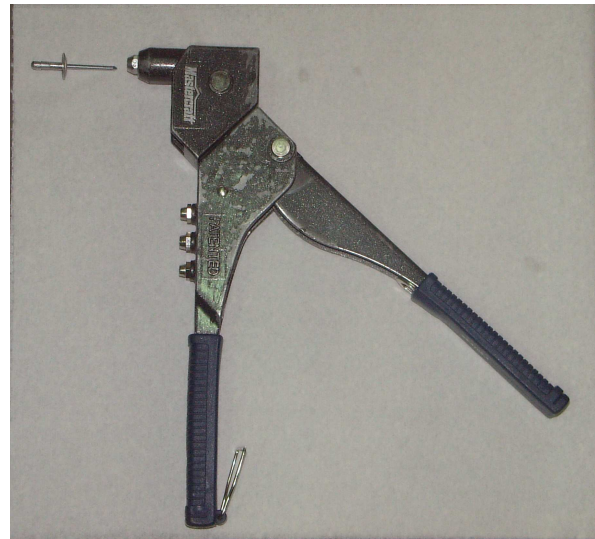


Figure 8

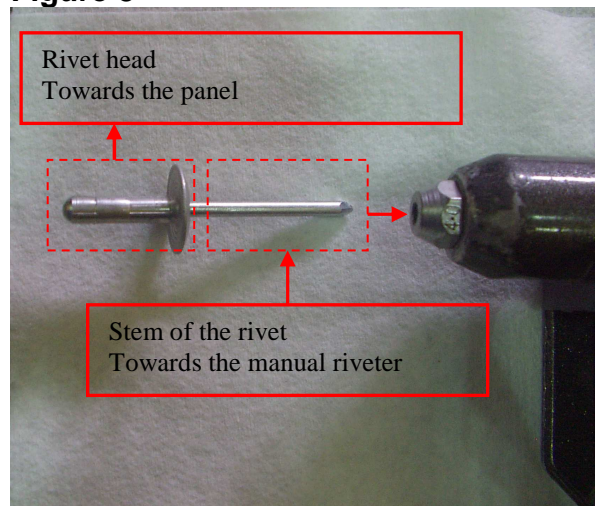


Figure 9

7 - Insert the six (6) rivets heads in the existing holes of the panel. Then, insert the riveter in the stem of each rivet and secure them in place (Figure10).

Make sure to install the six (6) rivets.

To finish, clean surfaces as needed and reinstall the barrier.



**Figure 10**