

 <p>[X] Safety Recall  [ ] Field Campaign  [ ] Service Information  [ ] Product Improvement</p>	<p><b><u>FIELD SERVICE BULLETIN</u></b></p>	<p><b>FSB_2019-001</b>  <b>Revision: 1</b>  <b>Issue Date: 1/9/19</b>  <b>Manual Section: N/A</b>  <b>Author: N.Reno</b>  <b>Approval:</b>  <b>E. Krekewich</b></p>
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**UNITS AFFECTED:** Federal Spirit with front observation window

**DESCRIPTION:** Front observation glass is made with tempered glass, new glass is laminated

**WARRANTY INFORMATION:** Champion will cover the parts and labor.

**LABOR ALLOCATION:** 6 hours per unit.

**CAMPAIGN EXPIRATION DATE:** N/A

**MATERIALS NEEDED:**

- WINDOW LAMIN. FRNT OBS SPIRIT 2018
- WINDOW ADHESIVE SIKA 255FC 10OZ
- SIKA ACTIVATOR 100
- SIKA PRIMER 206 G & P
- SIKAFLEX 221 BLACK
- Windshield removal tool
- 50/50 Water/Isopropyl alcohol mixture
- Masking tape
- Glass (razor) scraper
- Caulk gun
- Windshield suction cups
- Step ladder
- Lint free rags

**DISCLAIMER:**

The procedures contained herein are not exclusive. Champion Bus, Inc. cannot possibly know, evaluate, or advise the transportation industry of all conceivable ways in which a procedure may be undertaken or of the possible consequences of each such procedure. Other procedures may be as good, or better, depending upon the particular circumstances involved.

Each carrier who uses the procedures herein must first satisfy itself thoroughly that neither the safety of its employees or agents, nor the safety of any products, will be jeopardized by any procedure selected.

## **PROCEDURE:**

### **RECOMMEND TAKING VEHICLE TO A BODY SHOP OR GLASS INSTALLER FOR REMOVAL AND INSTALLATION OF OBSERVATION WINDOW**

#### **REMOVAL:**

1. With windshield removal tool cut through seal and adhesive paying attention not to damage fiberglass flange.
2. Using suction cups carefully remove window and discard.
3. With window removed use razor scraper to remove leftover adhesive from fiberglass flange.
4. Clean fiberglass with 50/50 mixture of water and isopropyl alcohol with a lint free rag.

#### **INSTALLATION:**

1. Clean all mating surfaces with water/alcohol mixture with a lint free rag.
2. Apply the Sika-Activator around the edge of the glass and the section of fiberglass the glass will make contact with. Apply using lint free rag. **Note: Wait five minutes before applying primer.**
3. Apply Sika-Primer 206 to the edge of the fiberglass that will contact the glass. **Note: Wait five minutes before applying adhesive.**
4. Using masking tape, tape around the outside of the fiberglass opening to prevent adhesive from contacting the fiberglass exterior.
5. Apply a solid 3/8" bead of SikaFlex-255 FC to the inside edge of the glass. Start in the bottom center of window and work around in one solid bead until you come to the start.
6. Lift glass from the outside surface with suction cups and press firmly into place. Smooth out and excess adhesive with lint free rag.
7. Remove masking tape used in step 4.
8. Apply new masking tape to hold window in place as adhesive cures. **Note: Allow adhesive to cure for minimum 12 hours before removing tape.**
9. Before removing tape be sure window is firmly adhered to the fiberglass.
10. With tape removed, seal gap between outside edge of window and fiberglass with SikaFlex 221 sealant. Wipe smooth with lint free rags. **Note: Allow sealant to cure for 1 hour before moving on to next step.**
11. Once sealant has cured use a garden hose to test for water leaks.