

RECALL 24V326 REMEDY INSTRUCTIONS



Make(s): NOVA
Model(s): NAB20C & NAB20D
Model Year(s): 2024 - 2025

Concern:
The solar panel may detach from the roof mounted pop-top in transit.

Repair Code: RC-689-09-00-004545
Allotted Time: 2.00 HRS.
Inspection Code: N/A
Allotted Time: N/A
Photo(s) Required: NO
Prior Authorization Required: YES
Part(s) Kit Number: F100604968
Part(s) Return: N/A

Turn off LP Gas at LPG Tank(s). Place vehicle in (P) Park and engage the Parking Brake. Disconnect the vehicles' battery Positive and Negative, disconnect any House battery(s) Positive and Negative, if equipped with a generator ensure it is off and lastly, ensure the vehicle is disconnected from shore power. Block any tires/wheels to prevent the vehicle from rolling. Failure to do so may result in electrocution, fire or other personal injury, property damage and/or death.

CERTAIN: 2024 – 2025 – NOVA: NAB20C & NAB20D

PART KIT CONTENTS:

SAND PAPER

BRUSH

SOLAR PANEL (190W)

SIKAFLEX PRIMER (*DROP SHIPS FROM SIKA*)

SIKAFLEX 255 (*DROP SHIPS FROM SIKA*)

REMEDY:

STEP 1: LOCATE THE SOLAR PANEL MOUNTED TO THE POP-TOP;

- USE A SHARPIE MARKER AND TRACE AROUND THE SOLAR PANEL (FIGURE 1);

STEP 2: REMOVE THE SOLAR PANEL MOUNTED TO THE POP-TOP ON THE ROOF OF THE VEHICLE;

- USE A SERATED BLADE TO CUT BETWEEN THE POP-TOP SHELL AND THE SOLAR PANEL (FIGURE 2);
- USE CAUTION AS TO NOT DAMAGE THE POP-TOP SHELL;
- DISCARD SOLAR PANEL;

STEP 3: SAND OFF THE PAINT (ON THE POP-TOP) INSIDE THE SHARPIE OUTLINE;

- SAND INTO THE POP-TOP SHELL INSIDE THE SHARPIE LINE TO PROMOTE SIKAFLEX ADHESION;
- CLEAN SANDED AREA WITH ISOTROPIC ALCHOHAL;

STEP 4: APPLY PRIMER/PROMOTER AS PERSCRIBED BY THE TECHNICAL DATA SHEET ("TDS") INCLUDED WITH THE SIKA PRIMER/PROMOTER (FIGURE 3);

STEP 5: APPLY SIKA 255 AS PERSCRIBED BY THE TECHNICAL DATA SHEET ("TDS") INCLUDED, AND IN THE LOCATIONS SHOWN ON THE ATTACHED DRAWING;

STEP 6: ATTACH THE SOLAR PANEL, AND PRESS UNTIL THE STOPS ON THE BACKSIDE OF THE SOLAR PANEL CONTACT THE POP-TOP;

- PARK VEHICLE IN SECURE LOCATION TO ALLOW SIKA TO CURE UNTIL THE NEXT DAY;

STEP 7: CHECK FOR PROPER FUNCTIONALLITY OF THE SOLAR PANEL SYSTEM;

STEP 8: CLAIM REPAIR CODE.

PHOTOS ON THE NEXT PAGE FOR REFERECE.

SEE ATTACHED PRINT FOR ADDITIONAL PROCEDURES.

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FIGURE 1



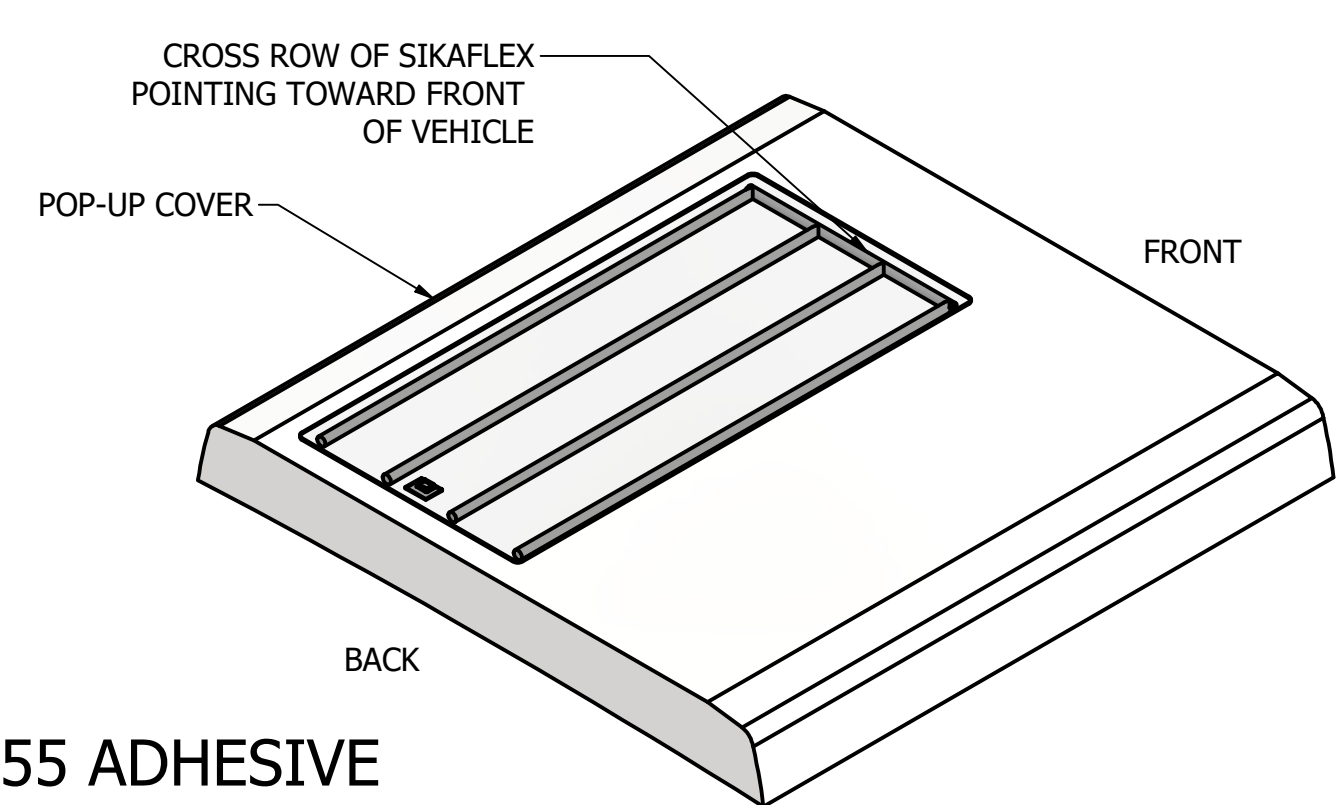
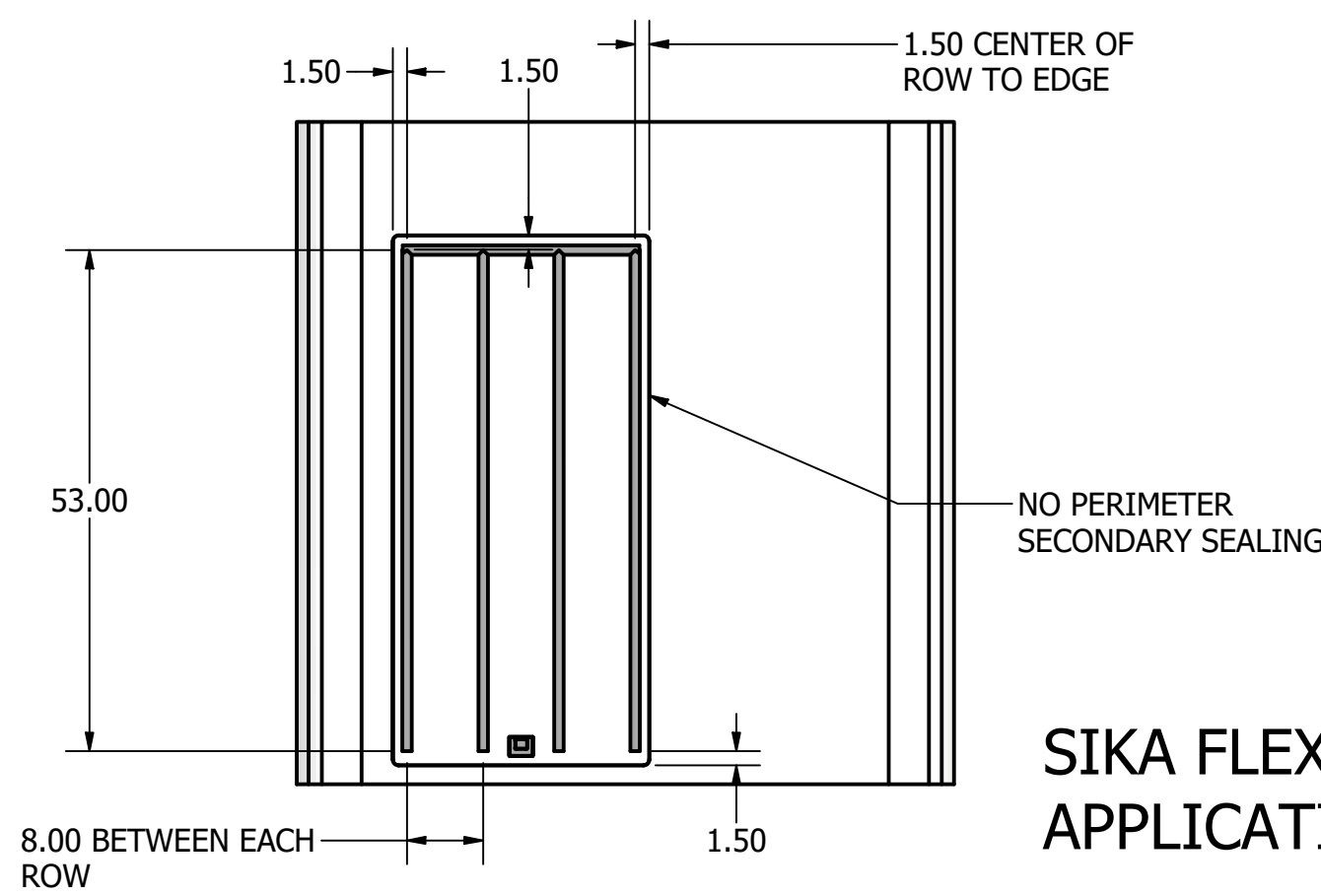
FIGURE 2



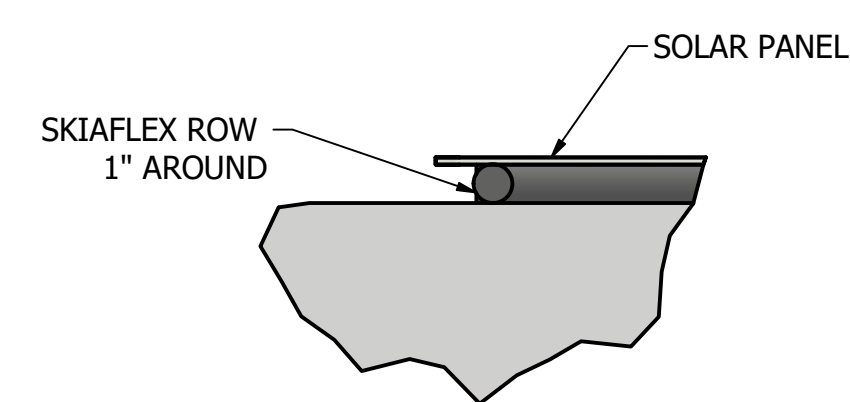
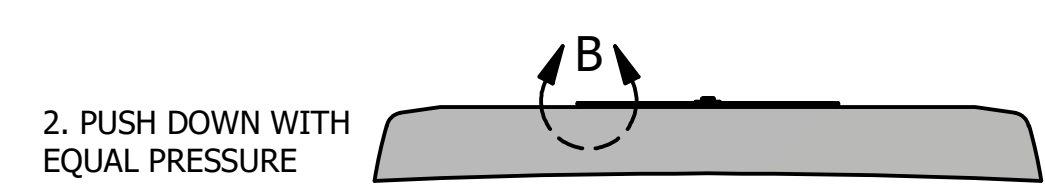
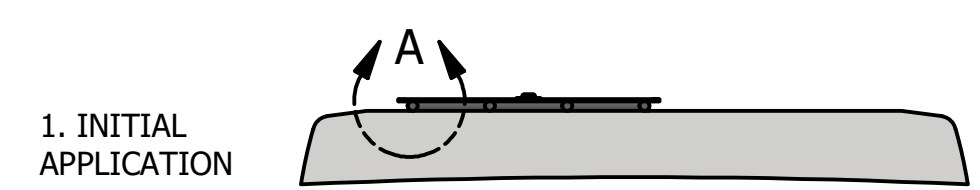
FIGURE 3



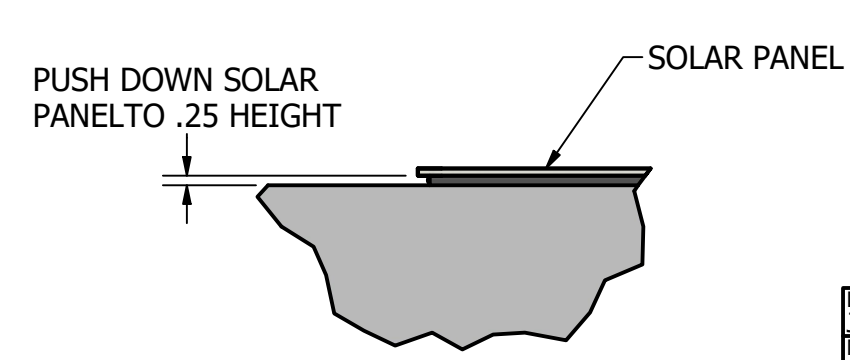
4 3 2 1



SIKA FLEX 255 ADHESIVE APPLICATION INSTRUCTIONS



DETAIL A
SCALE 1 / 5



DETAIL B
SCALE 1 / 5

REVISION HISTORY			
REV	DESCRIPTION	DATE	BY

DRAWN JDC	6/4/2024	COACHMEN DIVISION 225 CLASS B A FOREST RIVER COMPANY, INC		
MODEL				
PER UNIT		TITLE		
TOLERANCE UNLESS OTHERWISE SPECIFIED		SOLAR PANEL APPLICATION		
WOOD	OTHER	SIZE	DWG NO	REV
± 1/8"	± 1/16"	B		
±.125"	± .06" ± .015"	SCALE		
±1°	± .5°	1 / 20	SHEET 1 OF 1	

4 3 2 1

PRODUCT DATA SHEET

Sika® Primer-207

Pigmented, solvent-based Primer for various substrates

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Solvent-based Polyurethane solution
Color (CQP001-1)	Black
Solid content	27 %
Application temperature	5 – 40 °C
Application method	Brush, felt or foam applicator
Consumption	depending on substrate porosity 50 ml/m ²
Flash-off time	above 5 °C 10 minutes ^A maximum 24 hours ^A
Shelf life	1000 ml 9 months ^B smaller packagings 12 months ^B

CQP = Corporate Quality Procedure ^{A)} for specific application, temperature and flash-off time may be different
^{B)} stored in sealed container in up-right position in a dry place ≤ 25 °C

DESCRIPTION

Sika® Primer-207 is a solvent-based black primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.

Sika® Primer-207 is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component Polyurethanes. This primer might provide excellent adhesion without previous activation step on many substrates. Sika® Primer-207 fluoresces under long-wave UV light for a limited period of time. This feature is used for in-process control.

PRODUCT BENEFITS

- Enhanced adhesion on a wide variety of substrates
- Visible under UV light
- Easy to use

AREAS OF APPLICATION

Sika® Primer-207 is used to improve adhesion on a very broad range of different substrates such as float glass, ceramic-coated glass, plastics, pre-coatings, painted surfaces, E-coats and metals.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-207 on materials prone to stress cracking.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

PRODUCT DATA SHEET

Sika® Primer-207

Version 05.01 (03 - 2023), en_US

014761012070001000

METHOD OF APPLICATION

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating.

Application

Shake the Sika® Primer-207 can very thoroughly until mixing balls rattle freely. Continue shaking for another minute and apply a thin but covering coat with a brush, felt or foam applicator.

Ideal application and surface temperature are between 15 °C and 25 °C.

Sika® Primer-207 has to be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Consumption and method of application depend on the specific nature of the substrates. Tightly reseal container immediately after each use.

IMPORTANT NOTE

If Sika® Primer-207 is used below 5 °C further testing under expected conditions are mandatory.

Sika® Primer-207 is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed, the cap has to be screwed on.

Dispose of product one month after opening if used frequently or after two months in case of infrequent use.

If gelling, separation or a significant increase in viscosity is noted, discard the primer immediately.

Never dilute or mix this product with any other substances.

If used on transparent or translucent substrates such as float glass, plastics, etc., an adequate UV protection is mandatory.

DETECTION OF THE LUMINESCENCE

Sika® Primer-207 can be visualized by using a light source with a wavelength of 320 to 420 nm as inline control. By reducing foreign light such as sunlight or artificial light during the detecting process the quality of the detection can be increased significantly.

Note: The luminescent effect will degrade with time.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Can	250 ml
	1 000 ml

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

PRODUCT DATA SHEET

Sika® Primer-207
Version 05.01 (03 - 2023), en_US
014761012070001000

Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
U.S.A.
Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com



PRODUCT DATA SHEET

Sikaflex®-255 FC

Fast curing direct glazing adhesive for commercial vehicles

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured)	1.2 kg/l (10.0 lb/gal)
Non-sag properties	Very good
Application temperature	10 – 35 °C (50 – 95 °F)
Skin time (CQP019-1)	40 minutes ^A
Open time (CQP526-1)	20 minutes ^A
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	3 %
Shore A hardness (CQP023-1 / ISO 48-4)	60
Tensile strength (CQP036-1 / ISO 527)	6 MPa (870 psi)
Elongation at break (CQP036-1 / ISO 527)	450 %
Tear propagation resistance (CQP045-1 / ISO 34)	12 N/mm (70 pli)
Tensile lap-shear strength (CQP046-1 / ISO 4587)	4 MPa (580 psi)
Service temperature (CQP509-1 / CQP513-1)	-40 – 90 °C (-40 – 194 °F)
Shelf life	cartridge / unipack drums
	9 months ^B 6 months ^B

CQP = Corporate Quality Procedure

^{A)} 23 °C (73 °F) / 50 % r.h.^{B)} storage below 25 °C (77 °F)
DESCRIPTION

Sikaflex®-255 FC is a 1-component, high-strength adhesive for commercial-vehicle glazing and glass replacement applications. It provides a long open time and ensures safe application even in warm conditions.

Sikaflex®-255 FC is compatible with Sika's black-primerless bonding process.

PRODUCT BENEFITS

- Fast-curing
- Very good processing properties
- Wide adhesion range on most relevant substrates

AREAS OF APPLICATION

Sikaflex®-255 FC is designed for direct glazing applications with mineral glass-based windows in the Transportation OEM and vehicle glass replacement markets.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

PRODUCT DATA SHEET

Sikaflex®-255 FC

Version 03.01 (04 - 2023), en_US

012001212553001000

CURE MECHANISM

Sikaflex®-255 FC cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

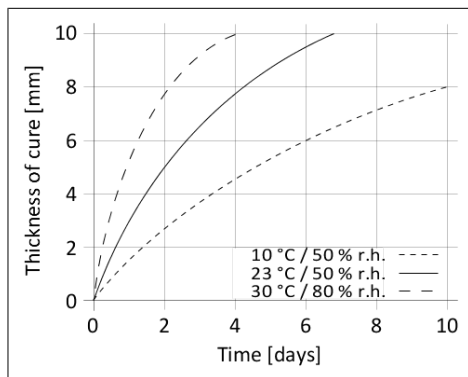


Diagram 1: Curing speed Sikaflex®-255 FC

CHEMICAL RESISTANCE

Sikaflex®-255 FC is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-255 FC can be processed at temperatures (climate and product) between 10 °C and 35 °C (50 °F and 95 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C (59 °F and 77 °F).

Consider the viscosity increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

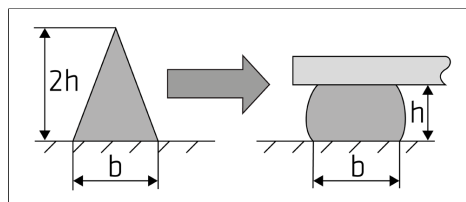


Figure 1: Recommended bead configuration

Sikaflex®-255 FC can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment. The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the adhesive has built a skin.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured Sikaflex®-255 FC can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water.

Do not use solvents on skin.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart
 - For 1-component Polyurethanes
- General Guidelines
 - Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Drum	200 l

BASIS OF PRODUCT DATA

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Sika Corporation

30800 Stephenson Highway
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Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com

