

Instructions for Baggage Door Inspection and Repair

RSB 619 - Recall # 25V 431 – TC # 2025-349

Inspect each compartment door on the coach, and check for loose outer door skin or voids/gaps in the tape adhering the door skin to the door frame.

Potential Scenarios

Depending on the findings, repair the baggage doors using the instructions outlined in the potential scenarios below:

⚠ IMPORTANT

All Sikaflex®-252 unclamped applications require a minimum of six hours of curing time. After six hours have elapsed, check the door for any voids. If any voids exist, clean the Sikaflex®-252 from the affected area, and apply a new bead.

Scenario #1 – If there are no voids or loose skins found:

1. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
2. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.

Scenario #2 – If any voids are found between the skin/tape and door/frame:

1. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
2. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.
3. Apply a bead of Sikaflex®-252 along the hinge side of the door between the top and bottom hinges, as well as between the bottom hinge and the bottom of the door.

Scenario #3 – If loose skin is found on the hinge side:

1. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
2. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.
3. Apply a bead of Sikaflex®-252 along the hinge side of the door between the top and bottom hinges, as well as between the bottom hinge and the bottom of the door.

Scenario #3A – If loose skin is found on the latch side:

1. Remove old tape from the loose area.
2. Apply a bead of Sikaflex®-252 between the skin and the door frame.
3. Clamp the skin to adhere it to the door frame for 24 hours.

⚠ IMPORTANT

Use something between the clamp and the paint to avoid damaging the paint.

4. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
5. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.
6. Apply a bead of Sikaflex®-252 along the hinge side of the door between the top and bottom hinges, as well as between the bottom hinge and the bottom of the door.

Scenario #4 – If the skin has completely separated from the door frame:

If the coach owner has the door skin and it is not damaged, reattach it to the door frame.

1. Remove old tape from the frame and/or skin.

2. Apply a bead of Sikaflex®-252 between the skin and the door frame.
3. Clamp the skin to adhere it to the door frame for 24 hours.

▲ IMPORTANT

Use something between the clamp and the paint to avoid damaging the paint.

4. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
5. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.
6. Apply a bead of Sikaflex®-252 along the hinge side of the door between the top and bottom hinges, as well as between the bottom hinge and the bottom of the door.

If the coach owner does not have the original door skin or if it is damaged beyond reuse, order a new one from Newmar and attach it to the door frame.

1. Remove any old tape from the frame
2. Apply Sikaflex®-252 between the skin and the door frame.
3. Clamp the skin to adhere it to the door frame for 24 hours, leaving the clamp in place.

▲ IMPORTANT

Use something between the clamp and the paint to avoid damaging the paint (if painted).

4. Add three 3/16” rivets along the top (no rivets are needed on top-hinge doors).
5. Apply a bead of Sikaflex®-252 along the bottom of the door frame/skin.
6. Apply a bead of Sikaflex®-252 along the hinge side of the door between the top and bottom hinges, as well as between the bottom hinge and the bottom of the door.

Adhering the Skin to the Frame

▲ IMPORTANT

Depending on the requirements for each compartment door, clean the hinge side and/or the bottom at the corner where the outer skin and inner frame meet, making sure it is dry and free from dirt and road grime. If loose tape is present between the door skin and the door frame, remove as much as possible.

After cleaning the door frame and skin, apply the Sika® Aktivator-205 to the area(s) you plan to apply Sikaflex®-252.

Apply the Sika® Aktivator-205 using a lint-free paper towel, allowing it to flash off for a minimum of 10 minutes, but no more than 2 hours.



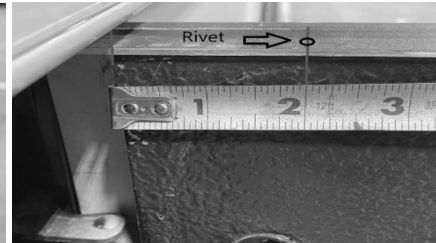
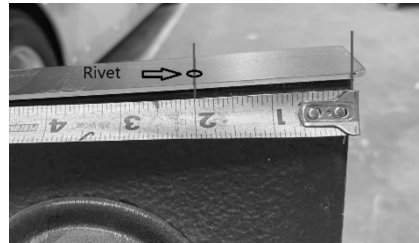
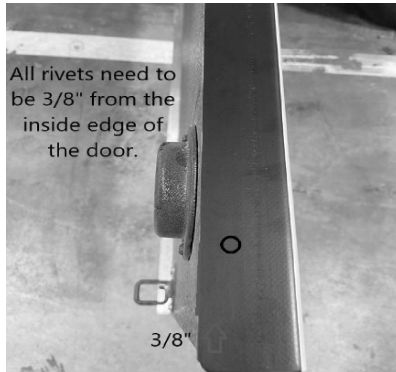
Apply a 3/16” bead of Sikaflex®-252 to the hinge side (if needed). Spray Sika® Slick on the bead of Sikaflex®-252 and tool it with a finger, making sure the bead is bonded to the door skin and frame with no voids.

Apply a 5/16" bead of Sikaflex®-252 to all compartment doors at the bottom, leaving a one-inch gap near the corners for drainage should any water get between the skin and door frame.



Spray Sika® Slick on the bead of Sikaflex®-252, tool it with a finger, making sure the bead is bonded to the door skin and frame with no voids, except the one-inch at each end.

Using a 3/16" drill bit, drill and add three 3/16" rivets along the top (no rivets are needed on top-hinge doors) of each compartment door two inches from the top edge of each side and one evenly spaced in the middle of the two outer ones (measurement will vary based on size of door) and 3/8" from the inner edge of the door frame.



After six hours, inspect all new Sikaflex®-252 to ensure no voids are present (see example below).



⚠ IMPORTANT

All Sikaflex®-252 unclamped applications require a minimum of six hours of curing time. After six hours have elapsed, check the door for any voids. If any voids exist, clean the Sikaflex®-252 from the affected area, and apply a new bead.

⚠ IMPORTANT

All Sikaflex®-252 clamped applications require a minimum of 24 hours of curing time. After 24 hours have elapsed, the clamps can be removed.

⚠ IMPORTANT

Use something between the clamp and the paint to avoid damaging the paint.