



SB-0025 NG Front Defroster Sealing

Bulletin Number:	SB-0025	Revision:	NR	EIC Number:	N/A	Std. Repair Time:	N/A
Application:	Orion VII NG						
<u>Classification:</u>							
Information Letter	☒	Parts Bulletin	☐	Recall Letter	☐		
Service Manual Update	☐	Operator's Manual Update	☐				

NOTE: For more information, please contact the Orion Service Line at 1-800-71-ORION (1-800-716-7466).

1.0 INTRODUCTION

This Service Information Letter outlines the steps to seal the Orion VII NG front defroster cover.

2.0 PARTS REQUIREMENTS

PART NO.	DESCRIPTION	QTY.
BS-8200224	BUTYL TAPE	AS NEEDED
BS-8200732	SIKAFLEX 252 BLACK	AS NEEDED
BS-8200713	SIKA TOOLING AGENT N	AS NEEDED

3.0 PROCEDURE

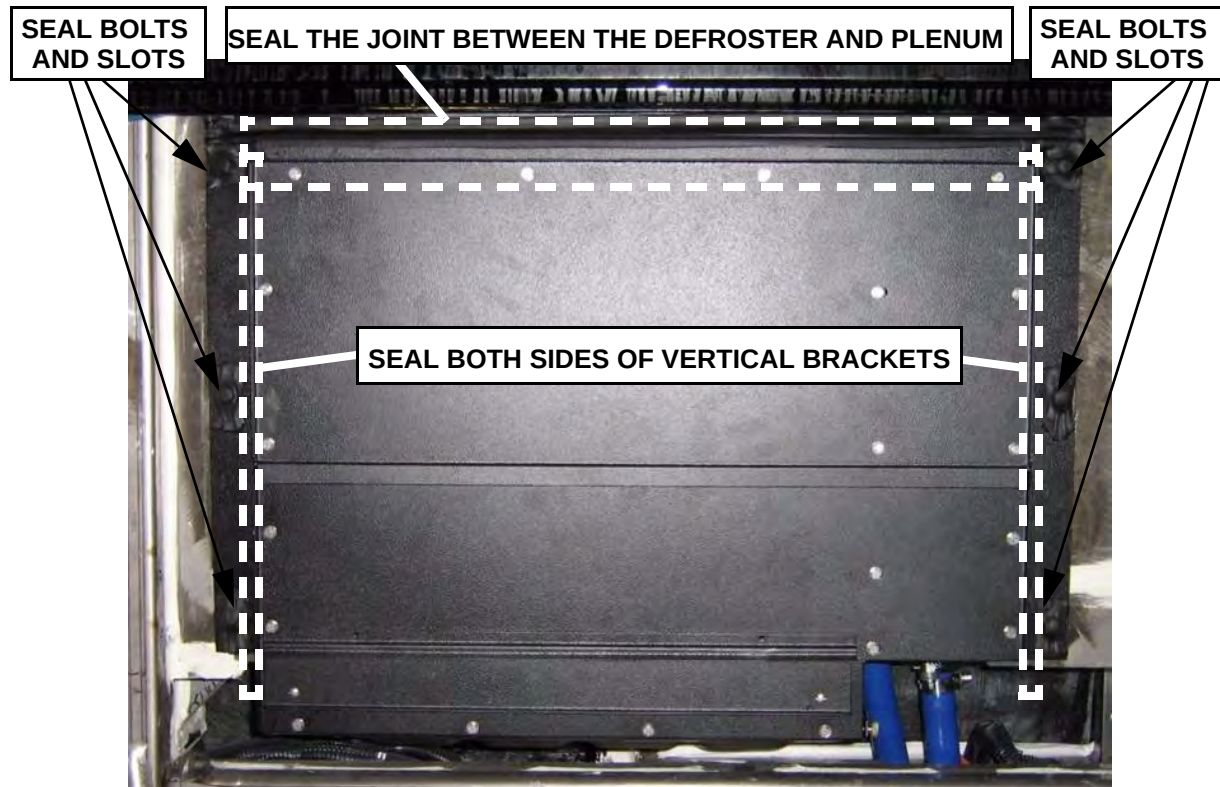


Figure 1-1 Orion VII NG Front Defroster

1. Seal the joint between the defroster and plenum on the top with butyl tape. See [Figure 1-1](#)
2. Seal all bolts and slots with butyl tape. See [Figure 1-1](#)
3. Seal both sides of the vertical brackets with Sikaflex 252. See [Figure 1-1](#)
4. Seal the top bracket with Sikaflex 252.

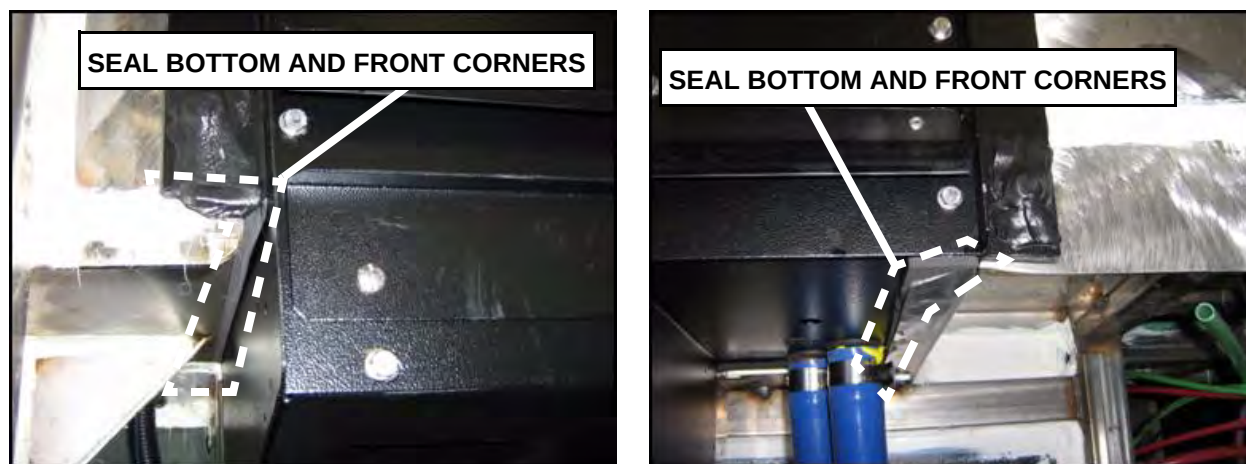


Figure 1-2 Sealing of Bottom and Front Corners

5. Seal bottom and front corners with Sikaflex 252. See [Figure 1-2](#)
6. Smooth out all Sikaflex with Sika Tooling Agent N.