



## INSTRUCTION TO SERVICE

<b>ITS: 5401</b>	
<b>SECTION:</b>	460 Windows
<b>WRITTEN BY:</b>	Troy Stutsky
<b>SUBJECT:</b>	Remove and replace windshields on LFR coaches.

# ITS5401

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**PROCEDURE:**

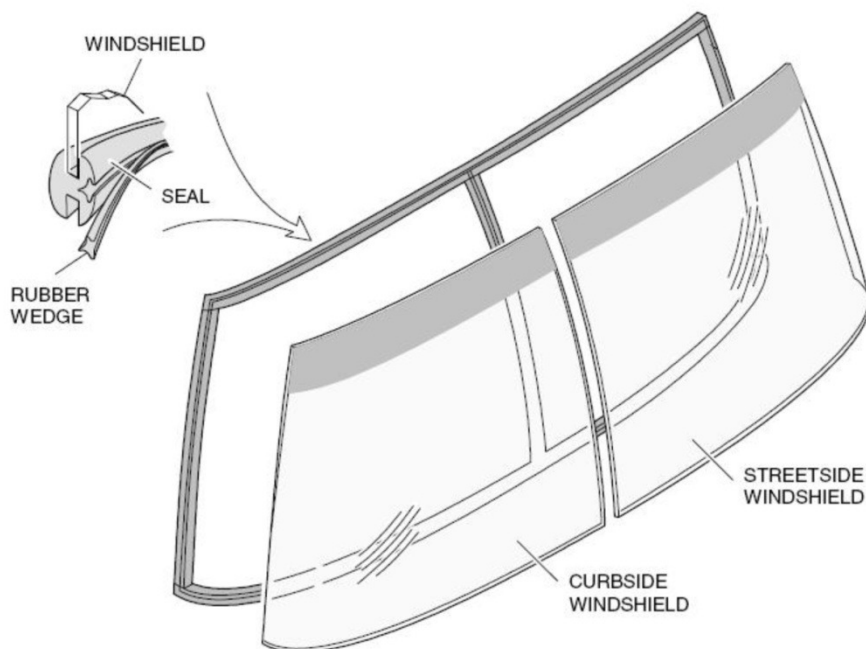
1. Turn the main battery disconnect switch to the “OFF” position.

**⚠ WARNING: Ensure that the proper safety equipment is worn:**

- Always use safety glasses when working on the coach
- Use ty-vek suit and full face respirator with 3m cartridge (2094 or equivalent) when cutting/sanding and building up fiberglass
- Use rubber gloves when handling cleaners and using products to build up fiberglass

**👉 NOTE: Two people should be used when removing and re-installing windshield glass.**

2. From the exterior of the coach, prepare to remove the windshields.
3. When removing windshield glass, raise one end of locking wedge of the window seal and pull the wedge out of the seal. For steps 3 & 4, **refer to Figure 1.**

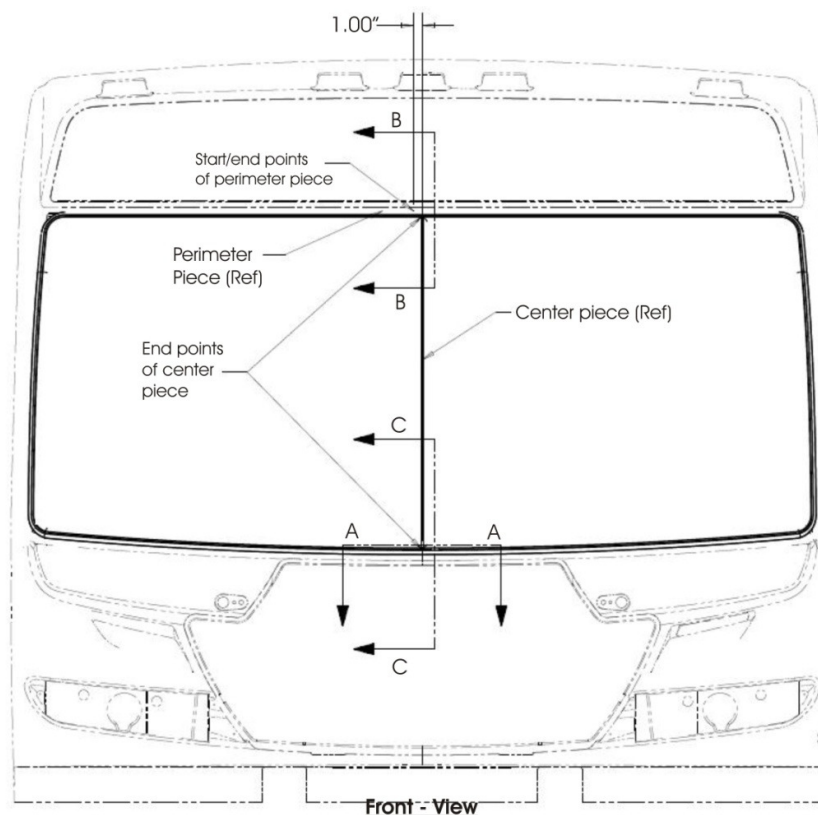


**FIGURE 1: SHOWN VIEW OF WINDSHIELD ALONG WITH THE SEAL AND FILLER STRIP THAT REQUIRES TO BE REMOVED TO ALLOW REMOVING WINDSHIELDS.**

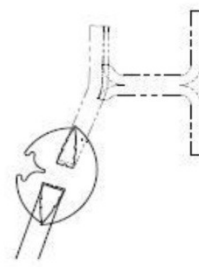
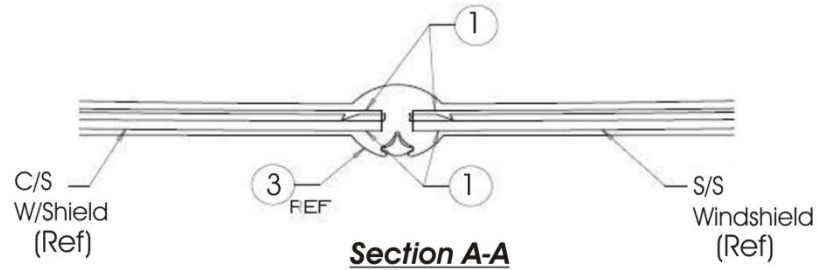
4. With the help of an assistant, carefully work the glass out of the seal and remove and discard the windshield.
5. Remove the seal. Set aside to re-install later.
6. Remove all the old sealant (butyl) from around the edge of the fiberglass at the windshield opening.

**⚠ CAUTION: Do not lubricate the seal or windshield opening with soapy water, as this may seep in between the windshield interlayer's and cause fogging of the glass.**

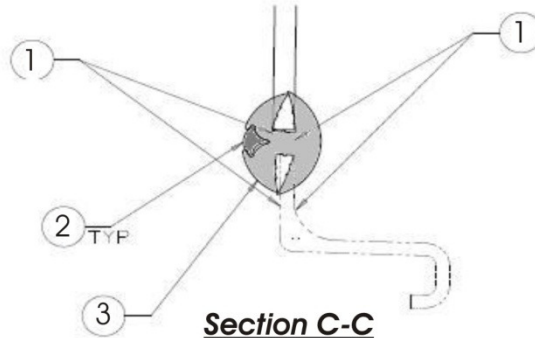
7. Apply butyl sealant (**NF PN: 061837**) in the channel of the existing seal (**NF PN: 322125**) which goes over the windshield surround. Install seal on fiberglass surround. Quantity of sealant used should be sufficient such that a small bead of sealant extrudes out at bottom of rubber on both inner and outer surfaces. **Refer to Figure 2.**



**FIGURE 2: SHOWN INSTALLATION OF WINDSHIELD SEAL AND GLASS.**



**Section B-B**



**FIGURE 2A: SHOWN SECTION A, B & C VIEWS SHOWING THE SEALS AND 5/16" GAP.**

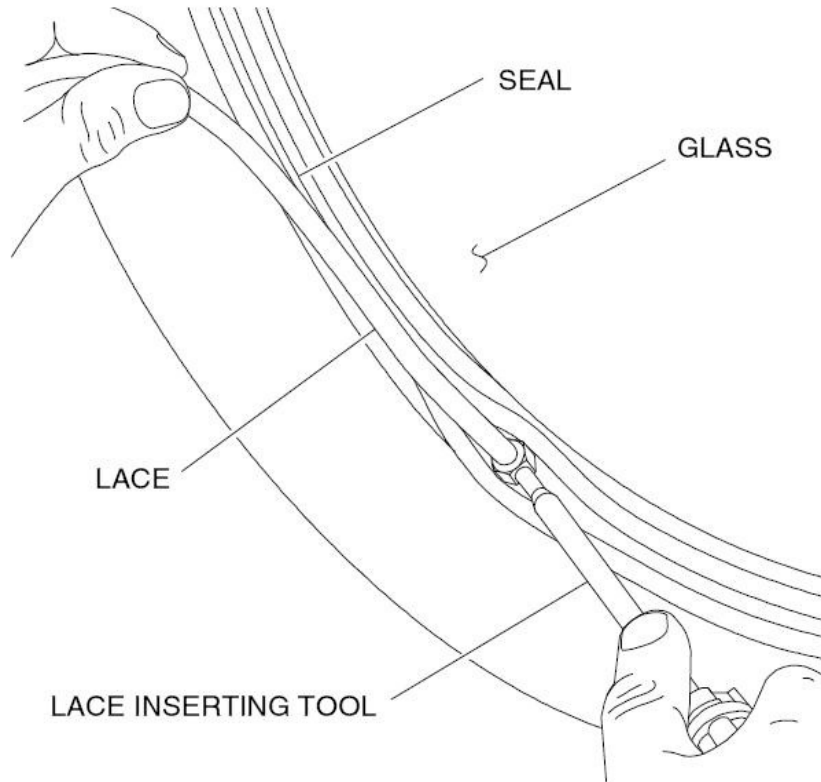
8. Apply butyl sealant (**NF PN: 061837**) in the channel of the seal which the windshield fits into, to a depth of approximately 1/4" before installing the windshield.
9. Install windshields, curbside (**NF PN: 476982**) and street side (**NF PN: 476983**). Pull back inside and outside lip of seal and run a bead of sealant around the inner and outer edges of the glass.



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☞ **NOTE: All voids between windshield and seal are to be filled with Butyl sealant.**

10. Install seal lace (**NF PN: 215138**). A minimum 1/8" bead should appear all around at the inner and outer edges. If not, remove lace and start again. **Refer to Figure 3.**



**FIGURE 3: INSTALL LACE INTO NEW WINDSHIELD SEAL.**

11. Windshield seal edges should not separate from the windshield or fiberglass.

12. After the sealant vulcanizes, use a sharp knife to make a cut line separating excess sealant from rubber molding. Peel off excess sealant.

☞ **NOTE: Do not peel off excess sealant without first making a cut line completely penetrating sealant to glass.**

13. Remove all tools and debris from work area to return coach to service condition.

14. Turn the main battery disconnect switch to the "ON" position.



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<b>LABOUR ESTIMATE</b>				
	Operation	Men	Hours	Labour Time M X HR
1	R &R windshields.	2	0.75	1.5

<b>PARTS REQUIRED</b>					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	061837	Sealant – Butyl Blk 300ml	0.75	EA	
2	215138	Lace – Seal Windshield	27	FT	
3	322125	Seal – Windshield	1	EA	*
4	476982	Windshield – Curbside	1	EA	
5	476983	Windshield – Streetside	1	EA	

\*Note: Only order if required (damaged or cannot be used)