

This field service bulletin replaces FSB 801-003, "Service Door Rust Prevention" released 08.2013.

Date 5.2014 Group **801** No. **003** Release **02** Page 1(7)

Service Door Rust Prevention  
VN, VHD, VT, VAH

## FSB 801-003, Service Door Rust Prevention

(May 2014)

This document provides the recommended procedure for preparing a VOLVO service door for use. The two step process involves applying a seam sealer to the lower hem flanges, and applying wax using an aerosol dispenser. Apply sealer only before a service door has been painted, and wax only after a service door has been painted and the paint has fully cured.

### Required Parts

| Door – Hem Sealer                                                        |                                                                    |
|--------------------------------------------------------------------------|--------------------------------------------------------------------|
| <b>Required Materials:</b> 1 tube – LORD Fuzor 800 DTM                   | <b>Recommended Materials:</b> Lord Fusor 703 Adhesion Prep/Cleaner |
| <b>Uncured Typical Properties:</b>                                       |                                                                    |
| Work Time, @ 21° (70 °F) for 25 minutes                                  |                                                                    |
| <b>Cured Typical Properties:</b>                                         |                                                                    |
| Paint Time, @ 21° C (70 °F) immediately or up to 30 days without a scuff |                                                                    |
| Full Cure, @ 21° C (70 °F) for 72 hours                                  |                                                                    |

**Note:** To order Fusor products, contact LORD at 1– 877 – ASK – LORD (275–5673). For MSDS and ordering information visit the LORD website at [www.lord.com](http://www.lord.com).

| Doors – Rust Prevention                             |                                                     |
|-----------------------------------------------------|-----------------------------------------------------|
| <b>Door P/Ns 85104984 and 85104985</b>              | <b>Door P/Ns 85136594 and 85136595</b>              |
| Plug, Door Drain (82731293) – 5 plugs per door      | Wax, Aerosol Spray (85135447) – 1 can per two doors |
| Wax, Aerosol Spray (85135447) – 1 can per two doors |                                                     |

**Note:** Information is subject to change without notice. Illustrations are used for reference only and can differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

Service personnel: Please circulate, read and initial

| Service Manager | Warranty Administrator | Workshop Foreman | Service Technicians |  |  |  |  |  |  |
|-----------------|------------------------|------------------|---------------------|--|--|--|--|--|--|
|                 |                        |                  |                     |  |  |  |  |  |  |

## Procedure

You must read and understand the precautions and guidelines in Service Information, Function Group 8, "General Safety Practices, Cab" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.



### **DANGER**

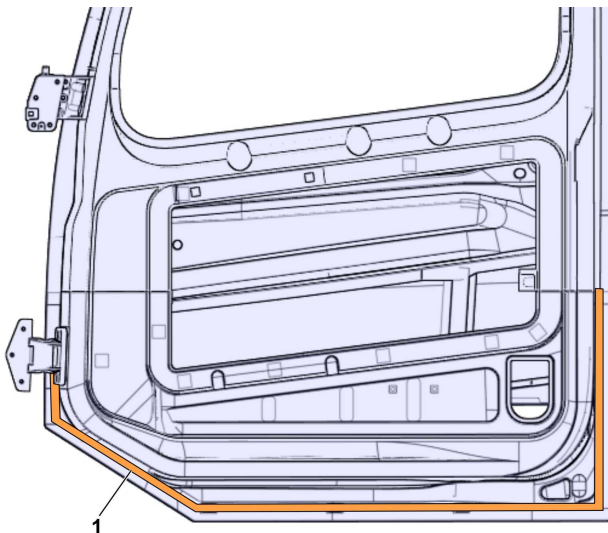
Do not attempt to repair or service a vehicle without the proper training, tools and service information. Failure to do so may result in component damage, serious injury or death.

### *Door Hem Sealer Application*

Perform the door hem sealer application procedure prior to painting the service door.

- 1 With the service door laying on a flat, level surface, lightly scuff the hem flange of the door in the areas as shown in the below illustration.

**Note:** Light scuffing serves to roughen the door surface to allow proper adhesion. Do not remove e-coat.



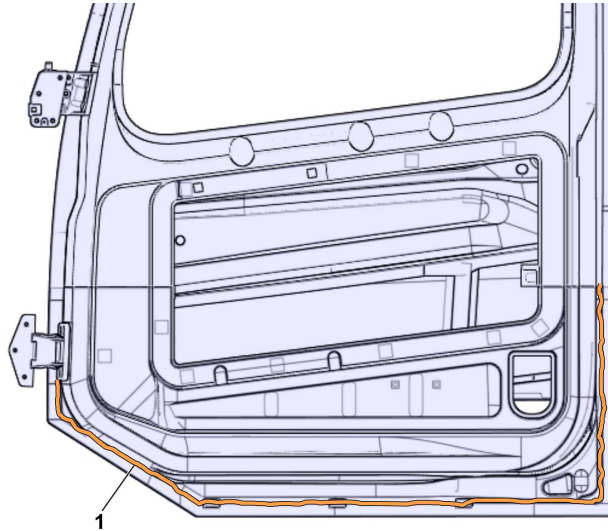
W8082460

1 – Sand/Scuff Area for Bottom of the Door

- 2 Clean the area to be sealed with Lord Fusor 703 Adhesion Prep/Cleaner.

- 3 Apply a bead of sealer to the door hem area. Ensure the cut edge of the hem flange is fully covered by the bead of sealant.

**Note:** If tooling, use the reducer from the paint system. Avoid using other solvents or water as this may inhibit the curing characteristics or performance of the product.



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1 – Sealer Application Area for Bottom of the Door

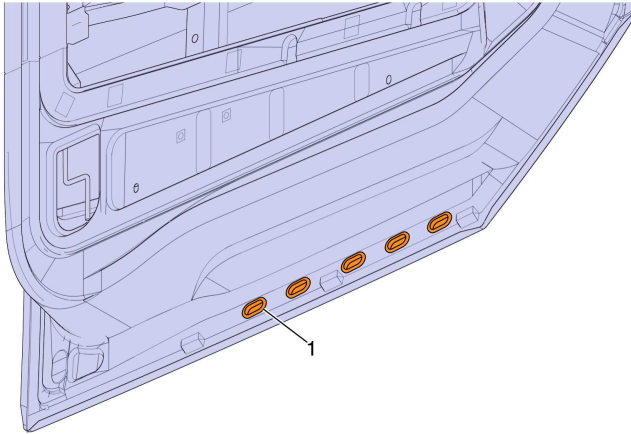
- 4 Prep and paint the door as required.

**Note:** The minimum paint time at 21°C (70°F) is immediately or up to 30 days without a scuff.

### *Rust Prevention, Installation*

Perform the door wax application procedure only after a door has had sealant applied and been painted and the paint is fully cured. For proper coverage, the door should be installed on the truck prior to application.

- 1 If applicable, install the door drain plugs (1) in the openings on the bottom of the door, ensuring proper seating.



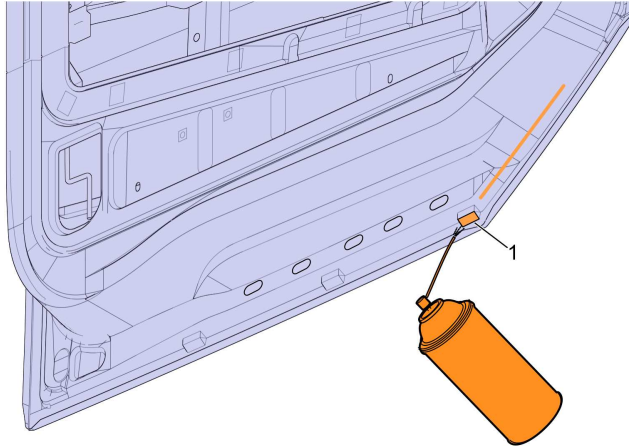
W8078462

1 – Door Drain Plug

- 2 Using an aerosol can, spray a liberal amount of cavity wax into the front and rear drain holes (1). In order to get full coverage in the door seam, spray at an upward angle, parallel to the edge of the door.

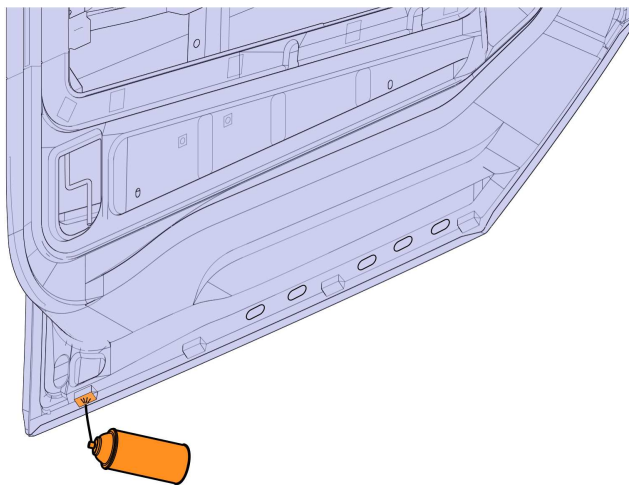
**Note:** In order to avoid a lack of coverage, it is important that only the tip of the straw is placed into the opening of the drain hole.

**Note:** To promote even flow and application of the cavity wax, shake the can regularly.



W8078953

1 – Front Drain Hole

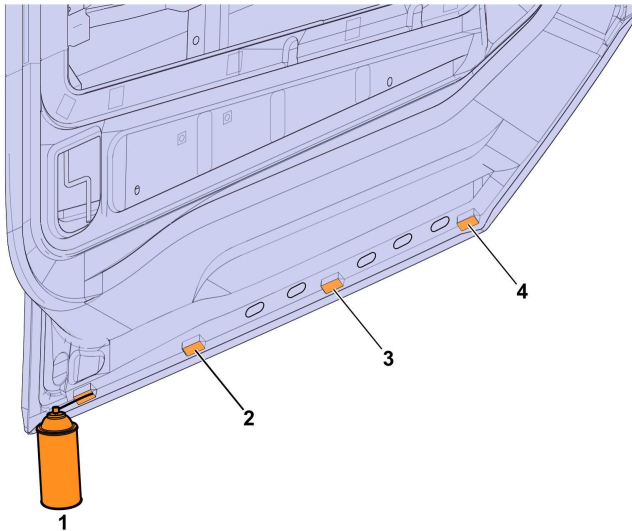


W8078954

Rear Drain Hole

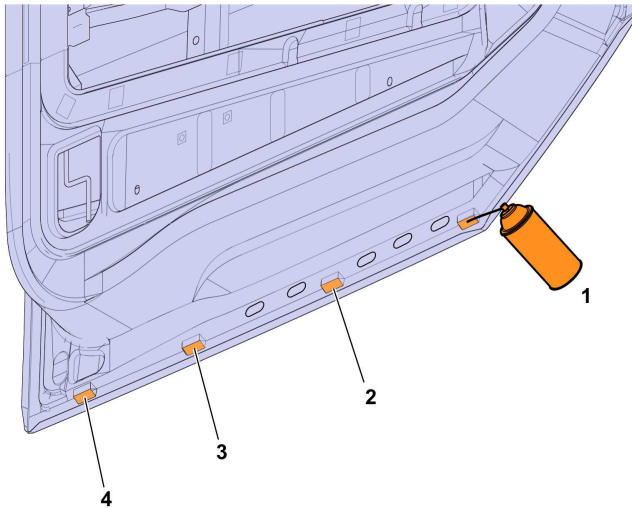
- 3 In order to get full coverage along the bottom door seam, spray cavity wax at a horizontal angle in the bottom drain holes. While applying the cavity wax, spray for five to fifteen seconds until the wax seeps from the next adjoining drain hole. Normally, wax should seep from the next drain hole within this time period.

**Note: For even coverage, spray in the bottom drain holes from both directions, front and rear.**



W8079487

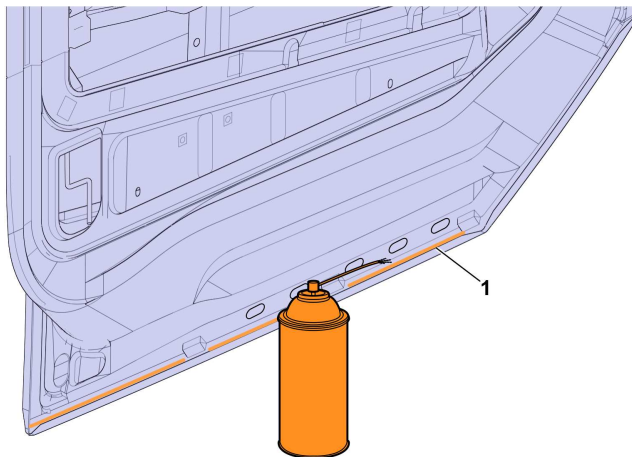
Drain Well Spray Sequence from Front to Rear of Door



W8079488

Drain Well Spray Sequence from Rear to Front of Door

- 4 Spray a light coat of cavity wax on the cut edge of the door skin crimp (1). Lightly wipe any excess cavity wax from the door skin crimp and drain holes.



W8079489

1 – Door Skin Crimp Edge

#### Reimbursement

|                                                                                                                                                                                                                         |                                               |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|
| This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process. |                                               |
| Claim Type (used only when uploading from the Dealer Bus. Sys.)                                                                                                                                                         | W                                             |
| Labor Code                                                                                                                                                                                                              |                                               |
| Primary Labor Code                                                                                                                                                                                                      | 80120-2-00<br>0.8 hrs.                        |
| Causal Part                                                                                                                                                                                                             | 85104984 (Left Hand)<br>85104985 (Right Hand) |

Volvo Trucks North America engages in a continuous program of testing and evaluating to provide the best possible product. Volvo Trucks North America, however, is not committed to, or liable for updating existing chassis.