

REFERENCE:	Nova Bus Manuals
SECTION:	01: Body
RS N°:	MQR 7621-778

APPLICATION DEADLINE:N/A

SUBJECT:	Body panels joints on 40' vehicles
JUSTIFICATION:	Body panels joints may crack

LEVEL	DESCRIPTION	DIRECT CHARGES		TIME
		LABOUR	MATERIAL	
1	Paint and install a trim over the problematic joint.	Client	Client	–
2	–	–	–	–

MATERIAL

QTY	PART N°	REV.	DESCRIPTION	REPLACES PART N°
LEVEL 1				
4	N81513-06	–	Trim, Lateral Panel	–
3	N93975-1	–	Trim, Roof	–
3	N93975-2	–	Trim, Roof	–
125 ml*	N66004	A	Glue Loctite H8000	–
*125 ML OF N66004 IS REQUIRED PER VEHICLES. PLEASE ORDER THE NUMBER OF 490 ML CARTRIDGE REQUIRED ACCORDING TO THE NUMBER OF VEHICLES TO BE REPAIRED.				
LEVEL 2				
–	–	–	–	–

To order, please contact Prevost Parts by phone at 1-800-771-6682, by fax at 1-888-668-2555 or by email at prevostparts.commandes@volvo.com. Specify document number, quantity of parts required and shipping address.

DISPOSAL OF PARTS

REMOVED PARTS ARE:	DISCARDED *	RETAINED	* Dispose of the unused parts and the defective parts in accordance with local environmental standards in effect.
	Yes	–	

REVISION HISTORY

REV.	DATE	CHANGE DESCRIPTION	WRITTEN BY
NR	2019JU06	Initial release	André Pelletier

APPROVED BY:

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CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
Austin - CMTA - Texas	L704	5051	5068	L82J7E4500471	L82J2E4500488	18
Austin - CMTA - Texas	LA18	5151	5158	L82J0H9775770	L82J3H9775777	8

**WARNING**

FOLLOW YOUR INTERNAL SAFETY PROCEDURES.

PROCEDURE

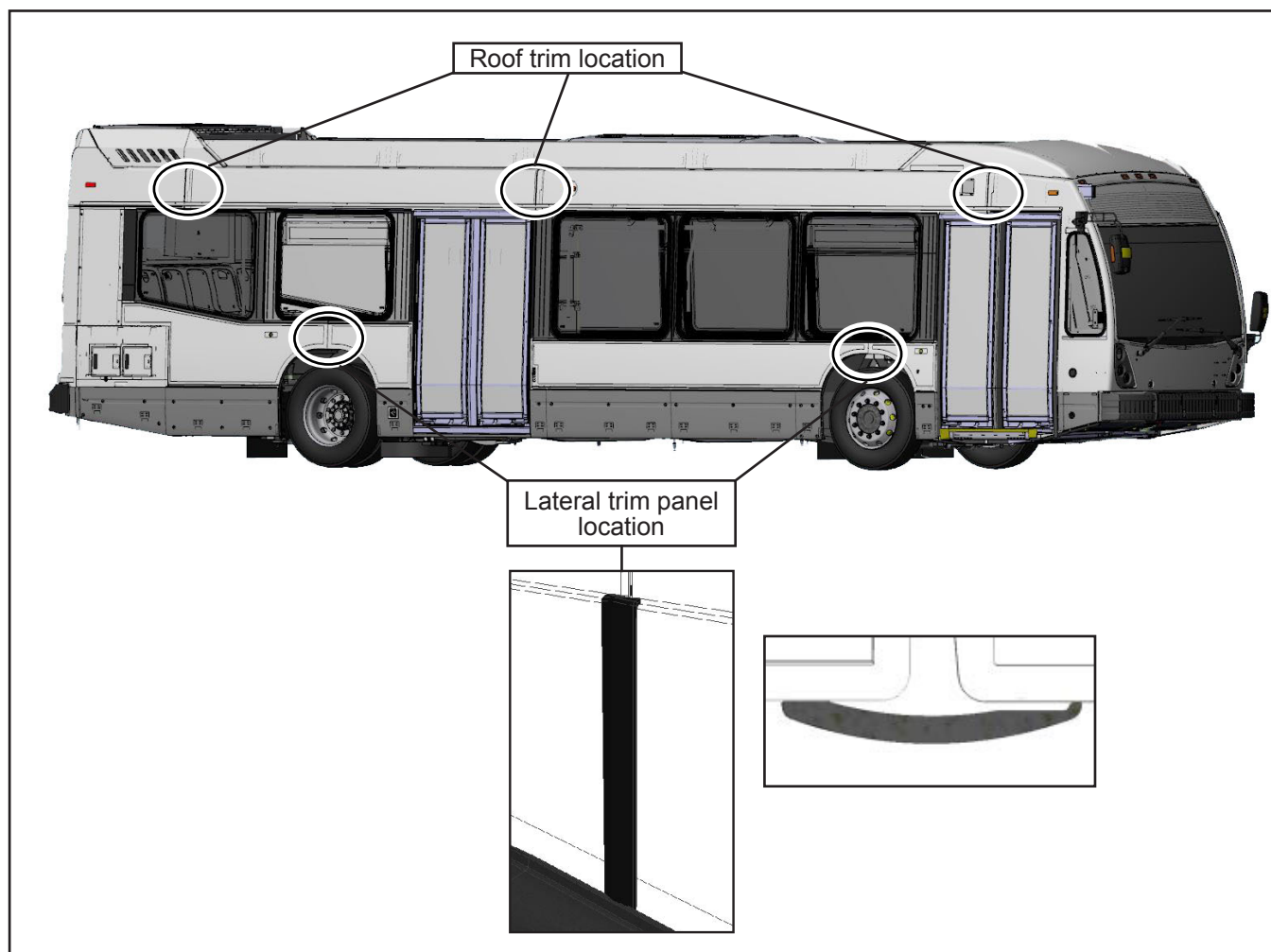


Figure 1 - Trim Location

- 1.1. It is recommended to paint the trims after installation.
- 1.2. Each trim needs to be cut separately for a proper fit on the roof panel radius and above the fenders for the side panels. Identify them on their backs to facilitate their installation later.
- 1.3. The gap between the trim and the fender must be 0 -0/+2 mm.

- 1.4. Make sure the seal is set back about 4 mm. Otherwise, remove some Sika from the joint. (Because when the panels will expand, the joint will pop out and will push on the trim.)

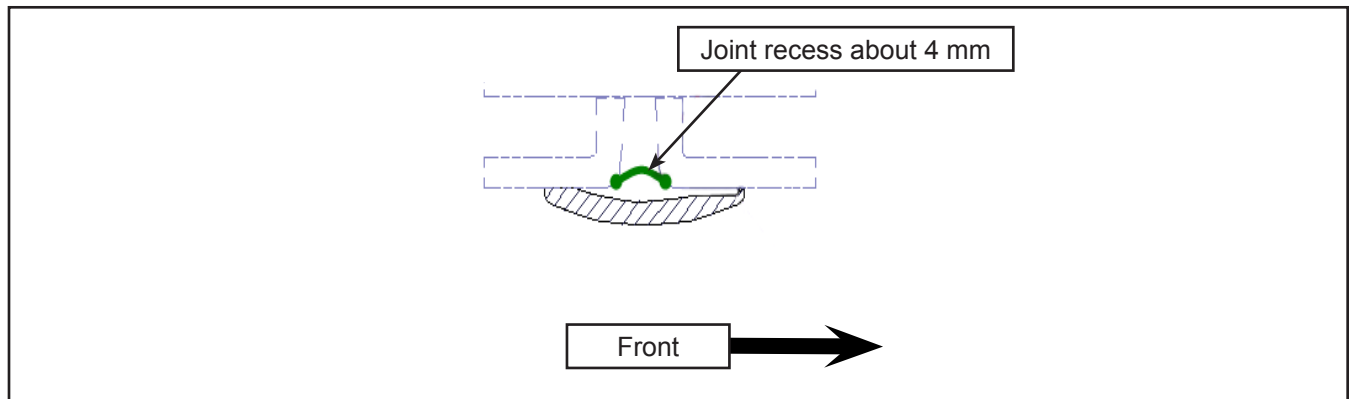


Figure 2 - Joint Preparation

- 1.5. The bonding area is always located on the side in front of the joint.
- 1.6. Use the trim to determine the area that needs to be prepared. It is recommended to apply a masking tape to make sure to protect the area that does not need to be sanded.
- 1.7. Sand the bonding surface using a Scotch-Brite #7447B pad or equivalent.
- 1.8. Remove the masking tape (if applicable) and clean the surface with isopropyl alcohol.
- 1.9. Let evaporate for at least 5 minutes.

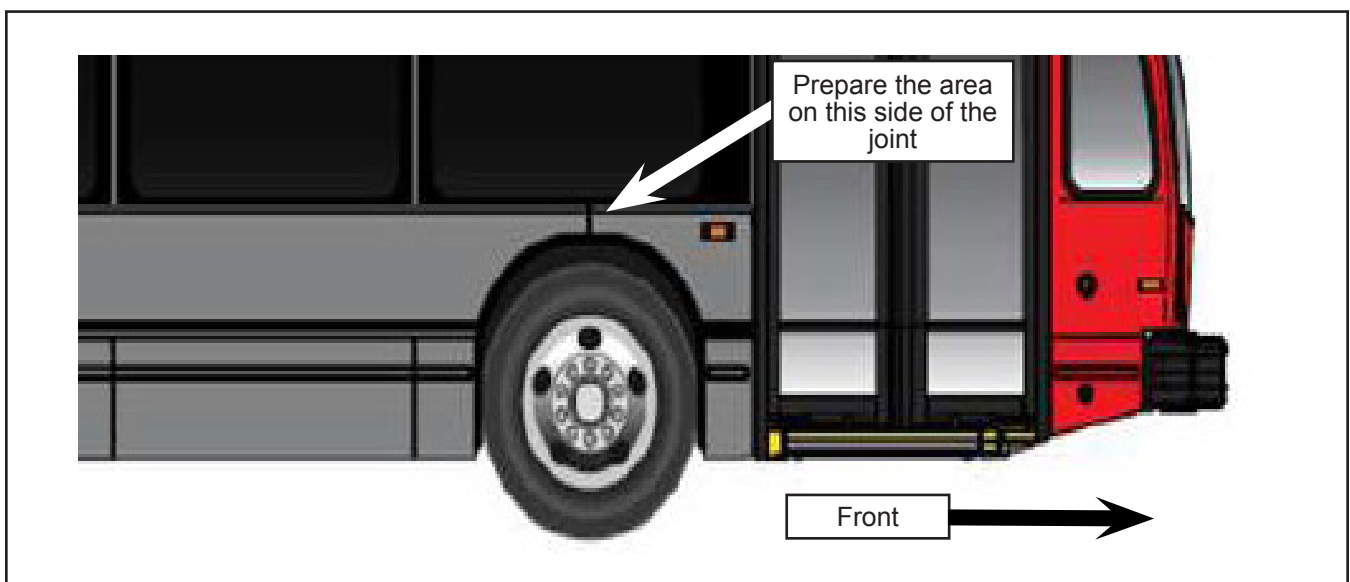


Figure 3 - Joint Preparation

- 1.10. Apply a bead of approximately 3 to 4 mm diameter of adhesive. Must be applied on the trim just beside the lip, in one shot to prevent air trap.

**NOTE**

The adhesive must be applied on forward contact surface (ledge side only).

Working time for N66004 is 30 minutes.

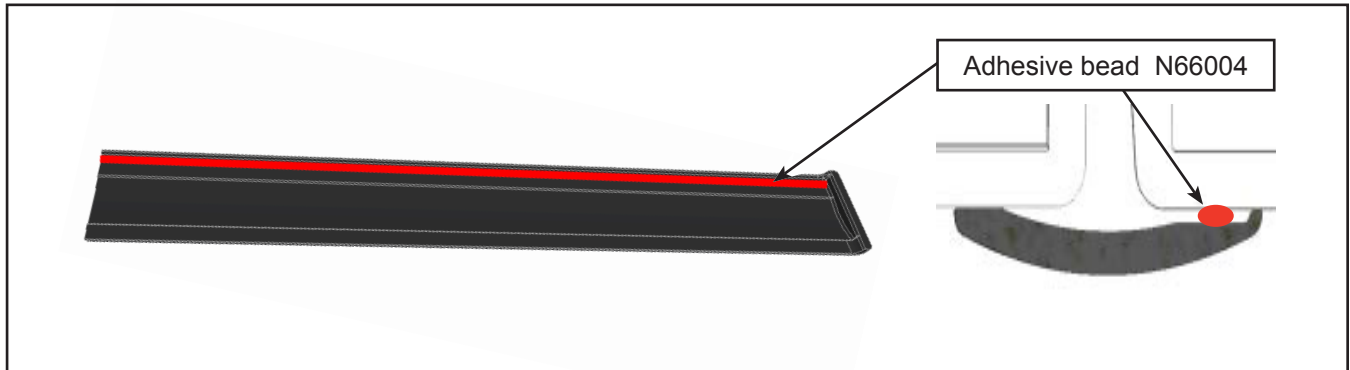


Figure 4 - Apply the Adhesive on the Trim

- 1.11. Bond the trim and centre it with the joint, press to remove any gap on the perimeter of the trim.
1.12. Remove the adhesive excess.
1.13. Isopropyl alcohol can be used for surface cleaning.
1.14. Apply masking tape on trim for at least 2 hours to hold it in place during curing period.
1.15. Repeat for the other joint.
1.16. The vehicle can return into service.

