

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

APPLICATION DEADLINE:N/A

SUBJECT:	Body panels joints on 60' 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°
<b>LEVEL 1</b>				
6	N81513-06	-	Trim, Lateral Panel	-
4	N93975-1	-	Trim, Roof	-
4	N93975-2	-	Trim, Roof	-
150 ml*	N66004	A	Glue Loctite H8000	-
<b>*150 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.</b>				
<b>LEVEL 2</b>				
-	-	-	-	-

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](mailto: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	2019MA27	Initial release	André Pelletier

APPROVED BY:

PAGE 1 OF 5

CLIENT	ORDER	ROAD NUMBER		VIN (2NVY/4RKY...)		QTY
		FROM	TO	FROM	TO	
Austin - CMTA - Texas	L635	5001	5001	S92U7C4500163	S92U7C4500163	1
Austin - CMTA - Texas	L636	5002	5022	S92U1D4500306	S92U0D4500328	21
Austin - CMTA - Texas	LA17	5101	5107	S92J2H9775763	S92J3H9775769	7

**WARNING**

FOLLOW YOUR INTERNAL SAFETY PROCEDURES.

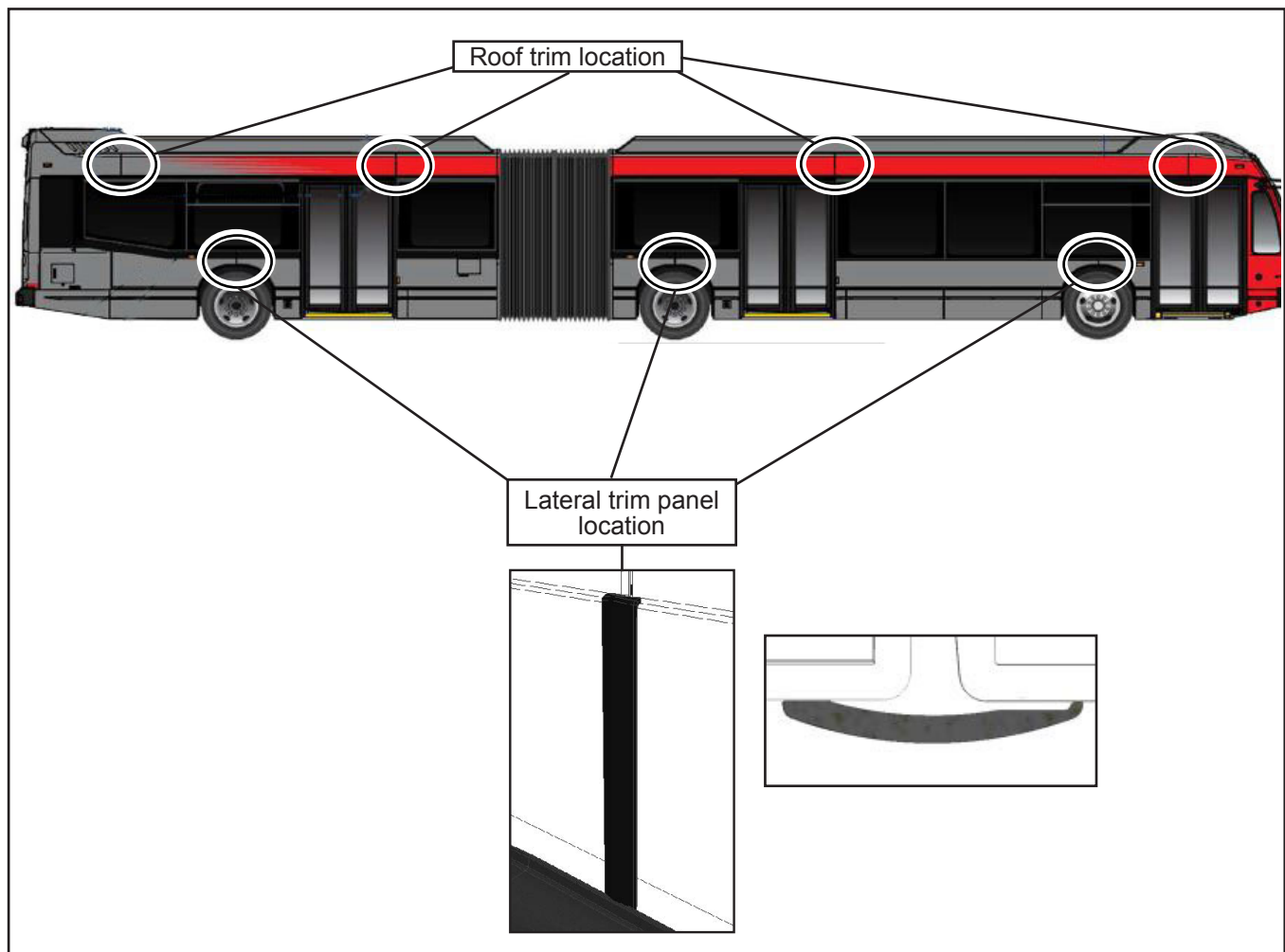
**PROCEDURE**

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.)

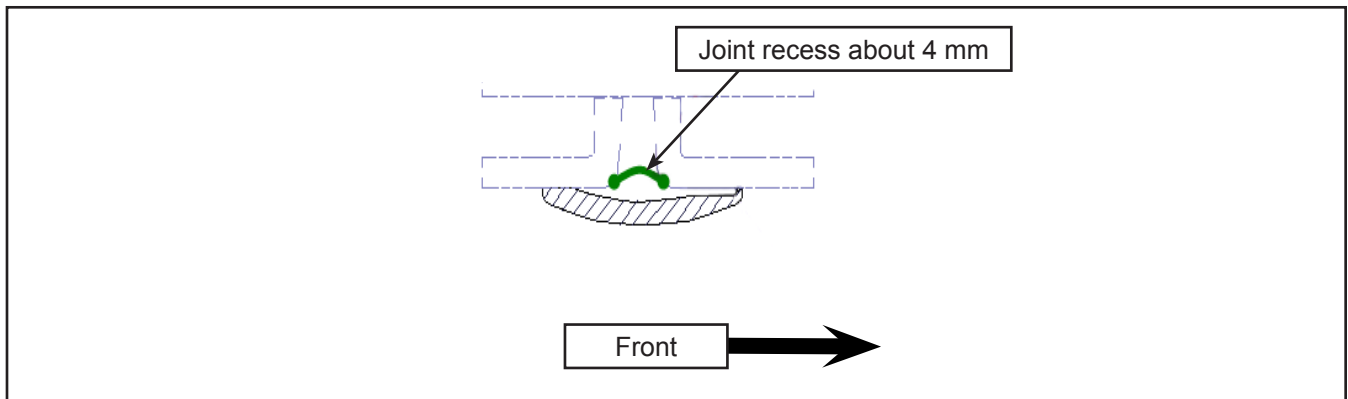


Figure 2 - Joint Preparation

- 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.

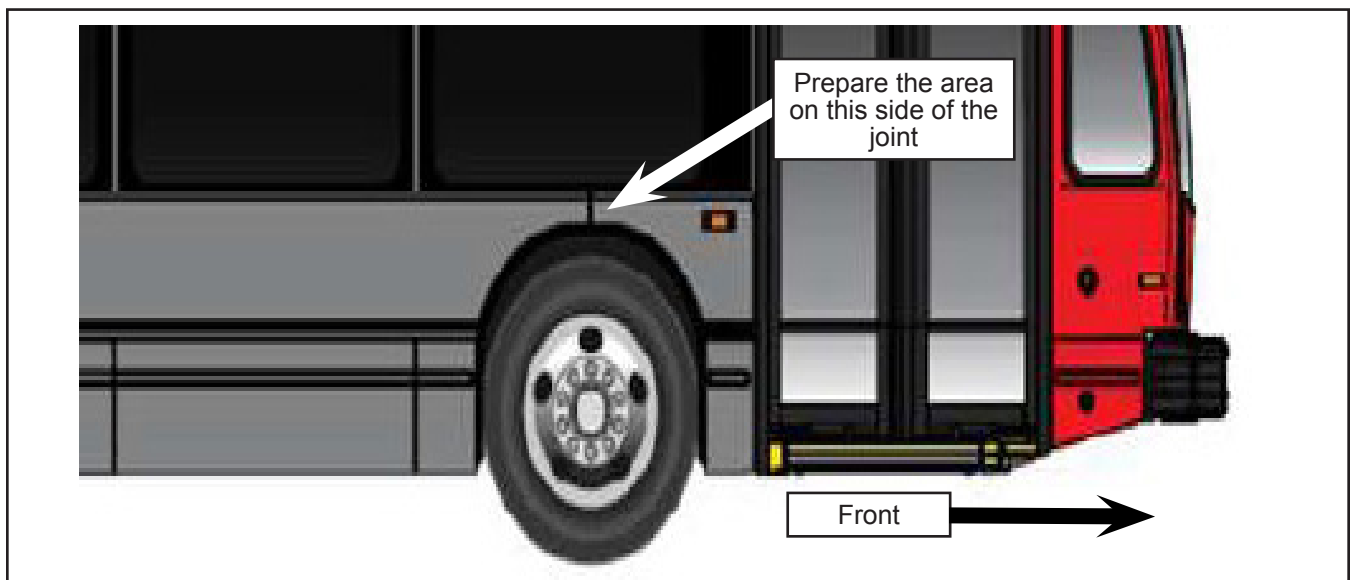


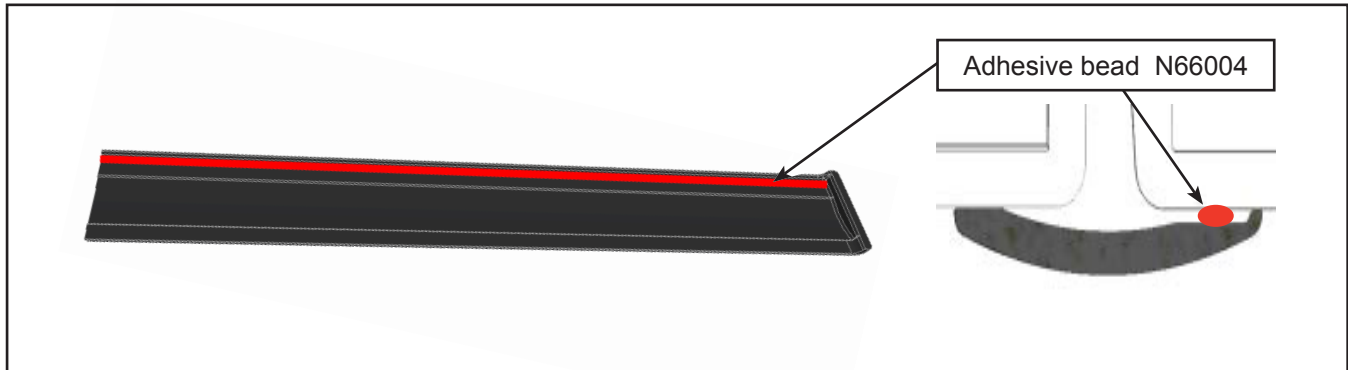
Figure 3 - Joint Preparation

- 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.

