

Subject: J Coach Lavatory Window Panel Retention			
Field Change Program: Procedure	Procedure Number: 03-277	Revision: A	Date: 12/18/2019
Coach Section: 03-Body	P/N: 17-03-2508		Type: Product Improvement

Application:

Coach Model	Model Year	VIN
J4500	2018 - 2019	68357, 68391-68397, 68418-68421, 68433-68434, 68436-68441, 68451-68452, 68488-68492, 68537-68540, 68578,68579, 68586, 68602, 68605, 68634-68648, 68652-68657, 68680, 68683-68685, 68711-68712, 68728-68729, 68741-68745, 68747-68760, 68800-68802, 68804-68807, 68807-68810, 68818, 68849, 68855, 68870-68871, 68878, 68885-68889, 68936, 68950-68951, 68953-68955, 68962-68964, 68966-68974, 68986-68991, 69002, 69008-69009, 69013, 69030, 69037, 69052-69058, 69128-69132
J3500	2018 - 2019	68877, 68909, 68935, 68965

WARNING

Read this entire procedure before beginning work.

Use Safe Shop Practices at All Times.

To avoid personal injury:

- a. Proper Personal Protective Equipment (PPE) must be worn. Safety glasses and protective gloves are required for working with DEF Fluid.*
- b. Turn the main battery disconnect switch to the OFF position.*
- c. Ensure that both the front and the rear wheels are chocked.*
- d. Positioning the ENGINE RUN and ENGINE START switches on the engine compartment remote control box to the OFF position.*
- e. Allow enough time for components to cool down prior to working in the engine compartment.*
- f. Wear rubber gloves and work in a well-ventilated area when using 23-02-0005 and 23-05-0005.*

1.0 Description

MCI observed that the dual lock tape retaining the lavatory window trim panel on the J4500 is coming loose. This procedure outlines steps to add mechanical fasteners to secure the panel.

2.0 Material requirements

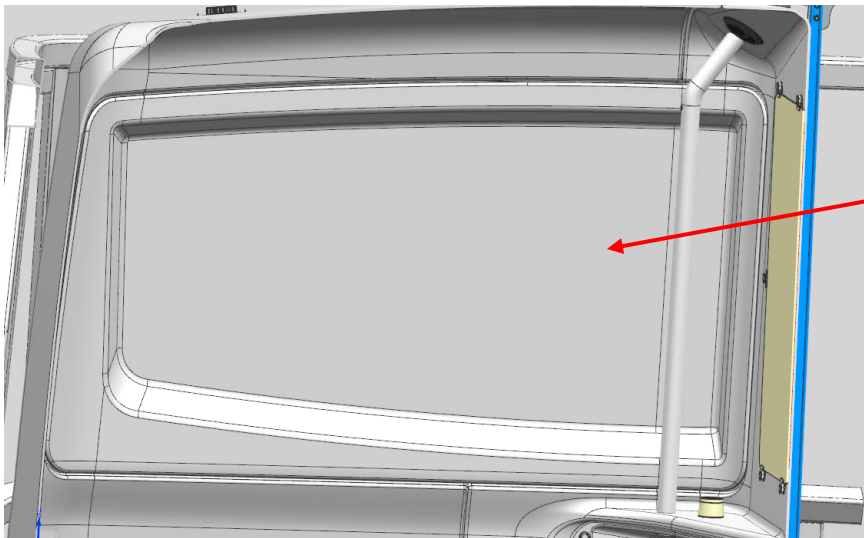
ITEM	PART NO	QTY	U/M	DESCRIPTION
1	17-03-2596	8	EA	Plate - Tapping, Lav Shell
2	19-01-1996M214	8	EA	Screw – 8-32 X 1, Self-Tapping

3.0 Special Tools

Methacrylate adhesive, MCI P/N: 23-02-0005 (Vendor: ITW, VPN: Plexus MA1020)

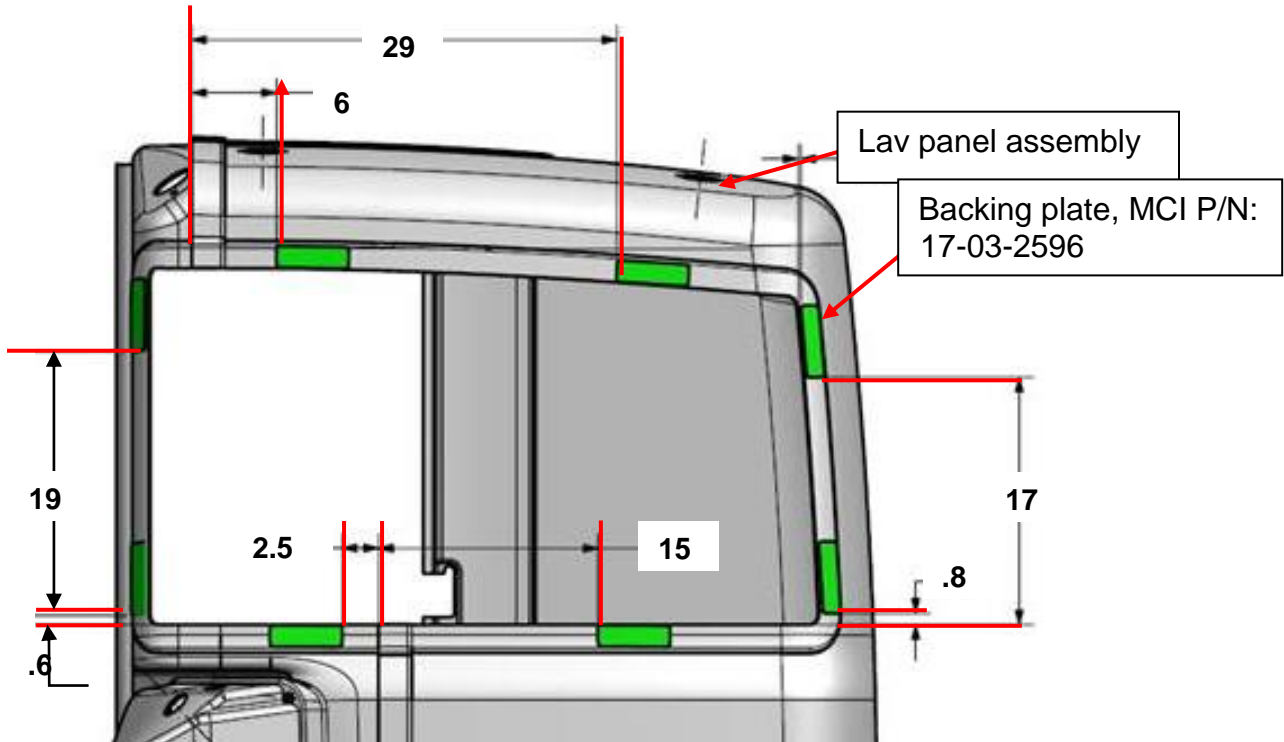
4.0 Procedure

Remove and save the lavatory window trim panel.



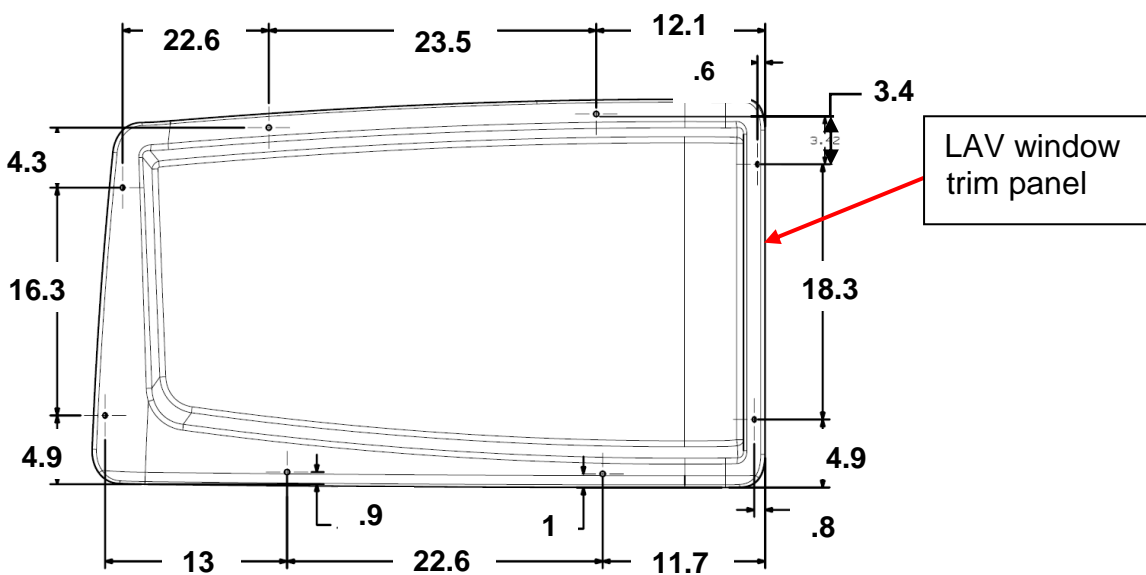
lav window trim panel

Clean lav panel assembly and bonding surface of the backing plate with isopropyl alcohol and allow 5 minutes flash off time. Apply .25" dia bead of methacrylate, MCI P/N: 23-02-0005 in a zig-zag pattern to the backing plate and clamp it to the lav panel at the location shown below for 20 minutes.

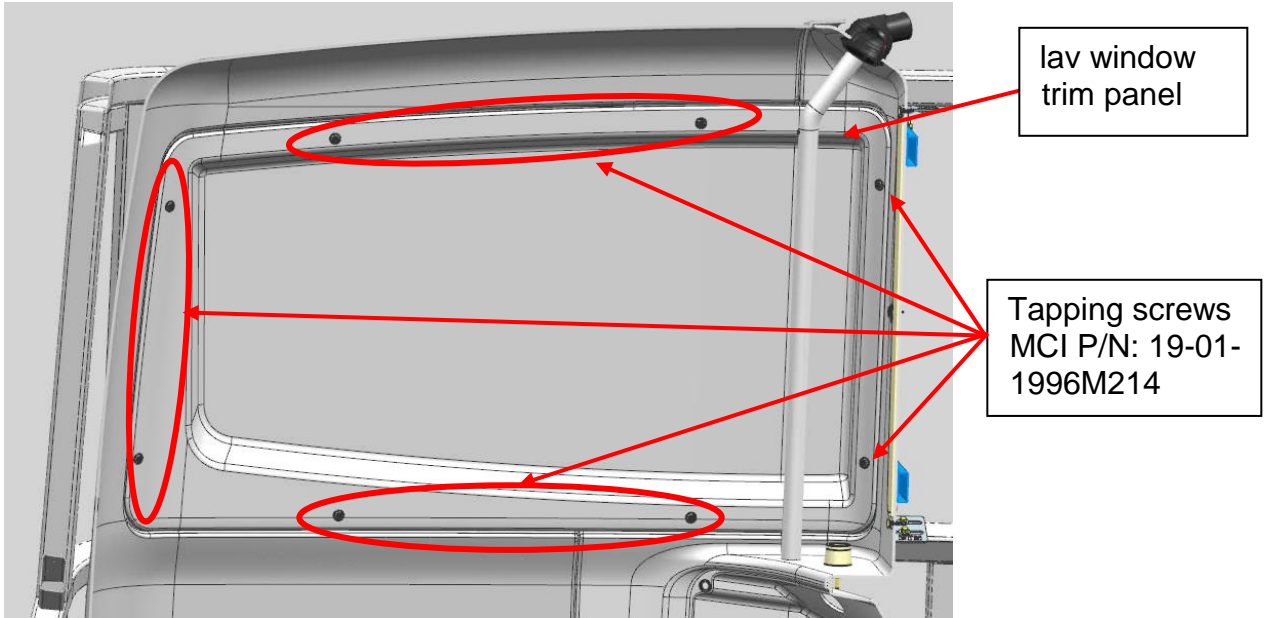


Reinstall the lav window trim panel.

Drill eight holes of .136" dia through the window trim, backing plates and lav panel assembly using #29 drill bit.



Secure the trim panel to lav panel assembly using tapping screws, MCI P/N: 19-01-1996M214.



End of the procedure