

Subject: J-Coach Rear Window Trim Panel Retention			
Field Change Program: Procedure	Procedure Number: 03-276	Revision: A	Date: 01/16/2020
Coach Section: 03-Body	P/N: 03-16-7338		Type: Product Improvement

Application:

Coach Model	Model Year	VIN
J4500	2018 - 2020	68377 - 69871
J3500	2019 - 2020	21000 - 21064

⚠ 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 rear 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	03-19-0786	4	EA	Plate – Tapping, Interior Cap
2	19-01-1996M214	4	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)

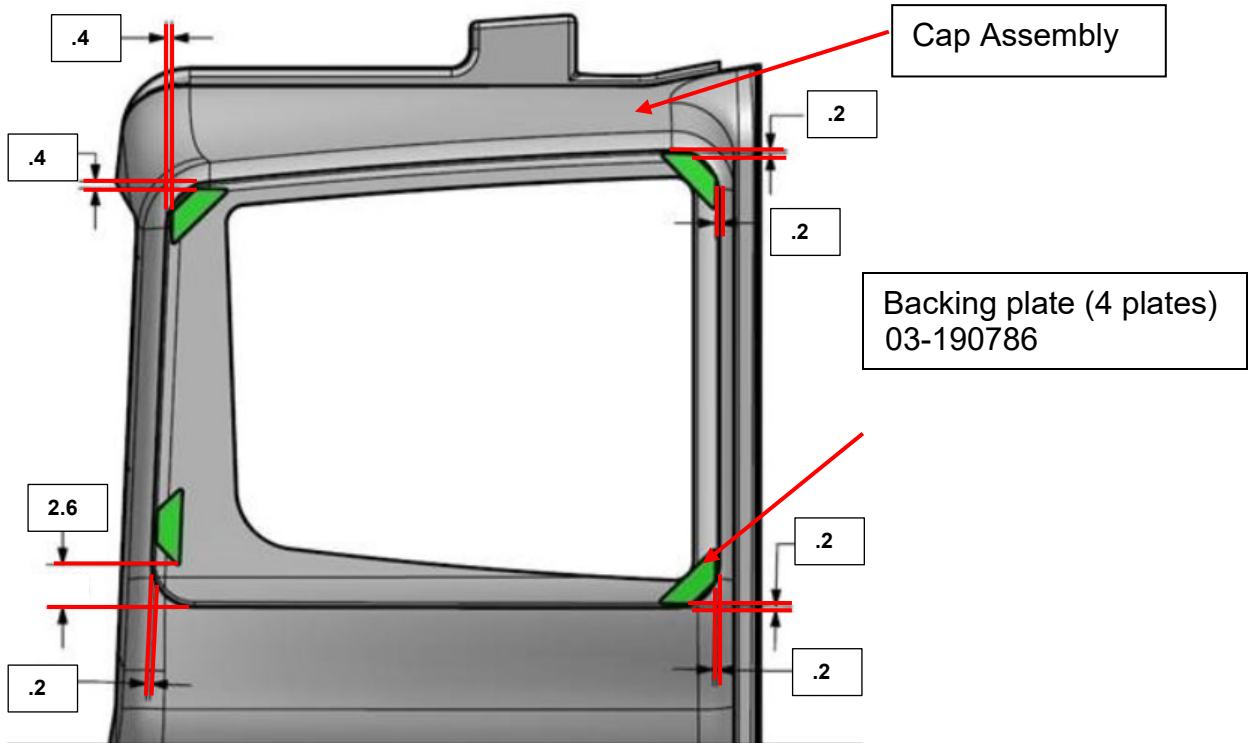
4.0 Procedure

Remove the rear window trim panel and save.



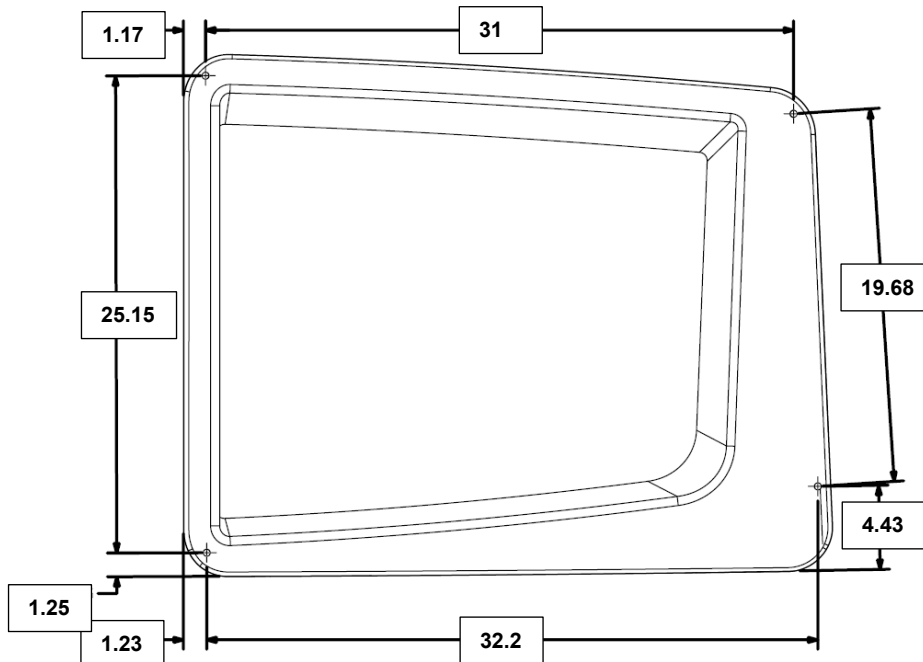
Rear Window trim
03-16-7338

Clean the bonding surfaces of the components being bonded using 23-05-0005. Allow 5 minutes for the alcohol to flash off. Apply .25" dia bead of 23-02-0005 in a zig-zag pattern to the bonding surfaces and clamp until the methacrylate is fully cured.

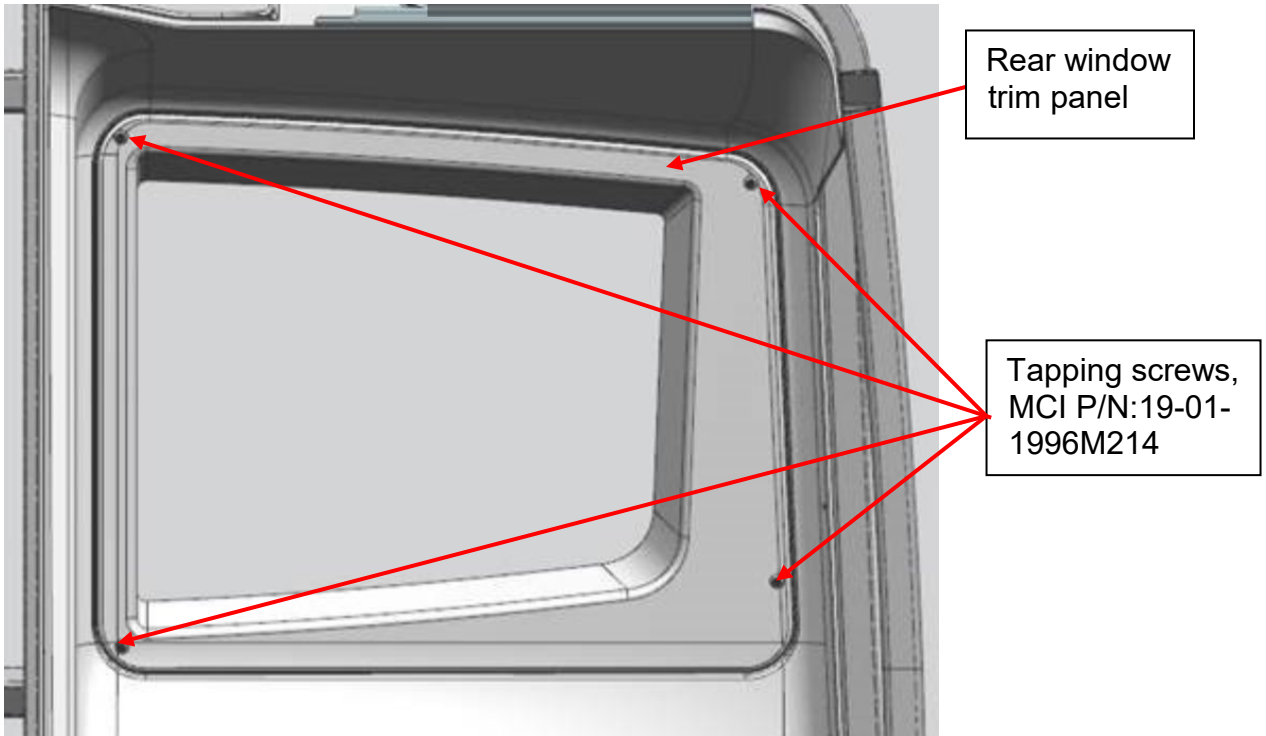


Reinstall the rear window trim panel.

Drill four holes of .136" dia through the window trim, the cap assembly, and the backing plate using #29 drill bit.



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



End of the procedure