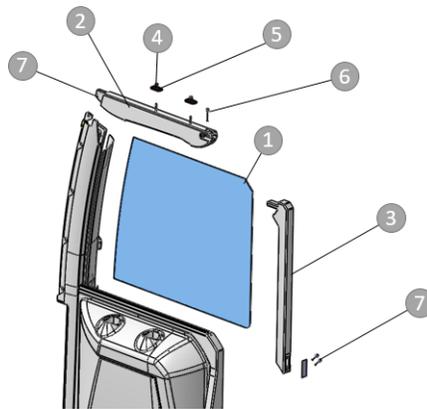


## GLASS PARTITION BEHIND DRIVER

Volvo 9700 from B13R-152266 (2011W22) to B13R-168569 (2014W25)

INITIAL RELEASE

18-03-2021



### MATERIAL

Kit # IS20921 contains the following parts:

Part No.	Description	Qty
22040894	GLASS, DOT FADING PRINT	1
21656508	SUPPORT, GLASS, FPW	1
21693935	SUPPORT, ASSY AND SEP	1
990950	FLANGE LOCK NUT, M8*9.4	4
N67354	RUBBER SPACER ELECTRIC CONDUCTIVE	4
959222	SIX POINT SOCKET SCREW, M8*25	1
60111166	HEX. SOCKET SCREW M8*25	4
948794	HEXAGON NUT, M8*6.68	2
IS-20921	Instruction Sheet	1

Other parts that may be required:

Part No.	Description	Qty
8714428	ADHESIVE SEALANT, SIKAFLEX 221-GREY	As needed

**NOTE**

Material can be obtained through regular channels.

**PROCEDURE**

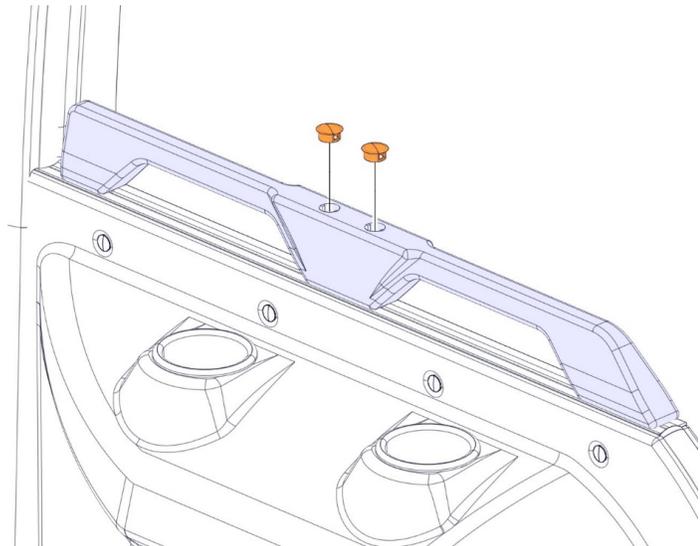


**DANGER**

Park vehicle safely, apply parking brake, stop engine. Prior to working on the vehicle, set the ignition switch to the OFF position and trip the main circuit breakers equipped with a trip button. On Commuter type vehicles, set the battery master switch (master cut-out) to the OFF position.

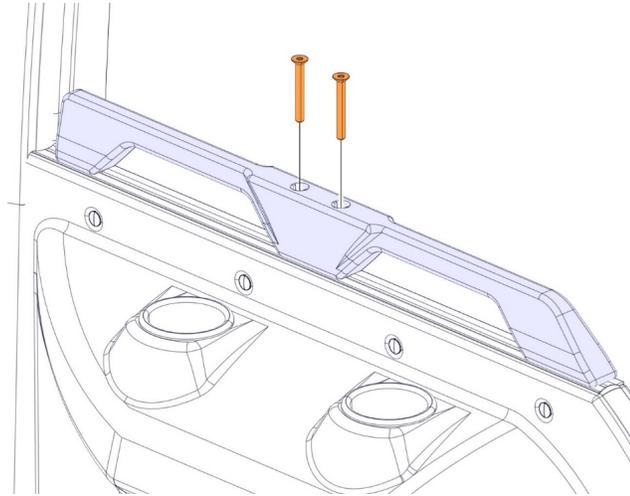
Lock out & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

1. Remove the bolt covers from the handrail.



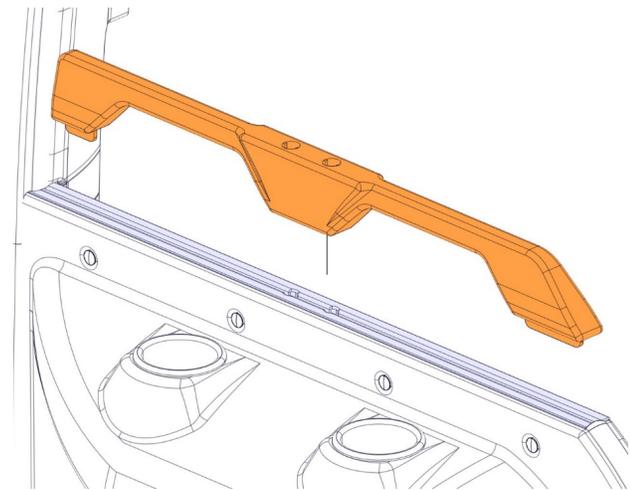
**FIGURE 1**

2. Remove the bolts from the handrail.



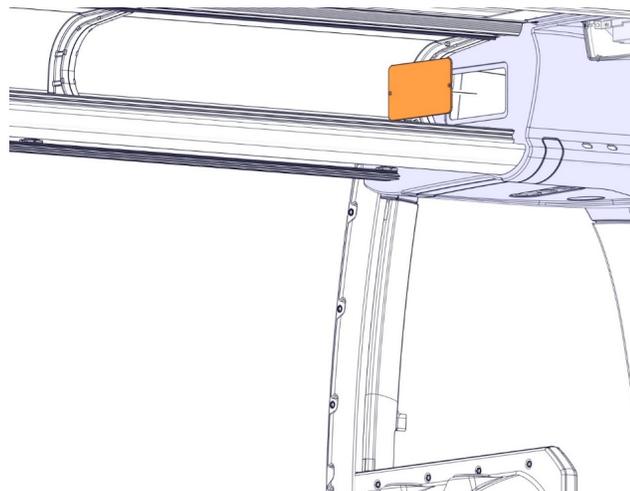
**FIGURE 2**

3. Remove the handrail.



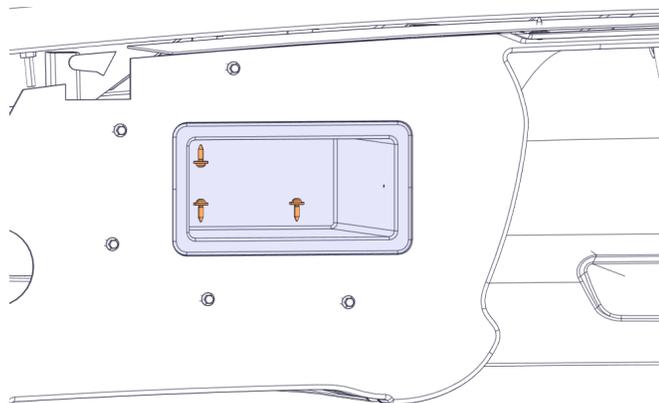
**FIGURE 3**

4. Open the hatch on the left hand side of the headliner.



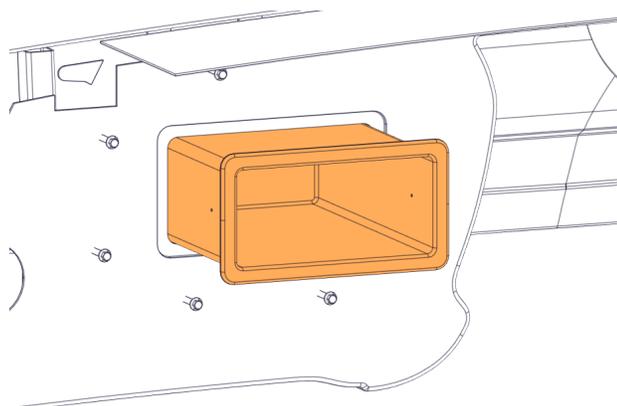
**FIGURE 4**

5. Remove the screws of the box, (if present).



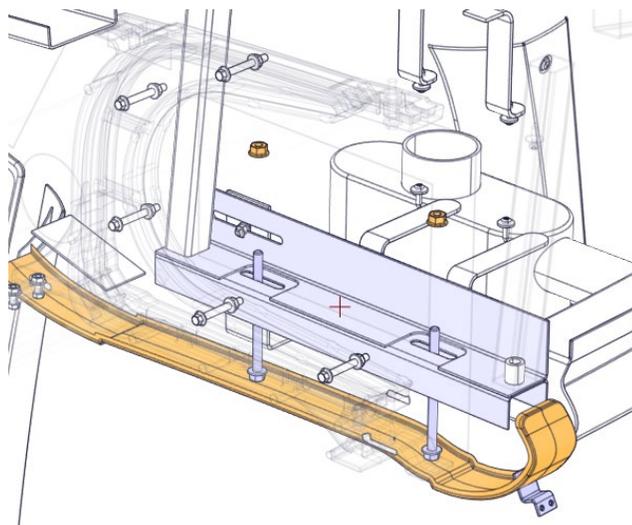
**FIGURE 5**

6. Remove the headliner box.



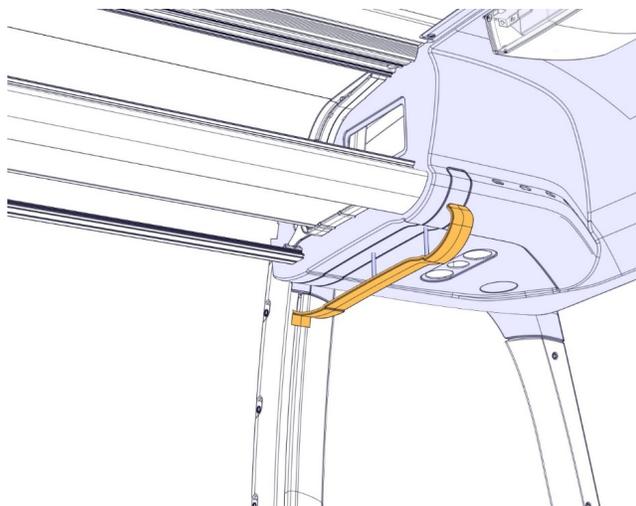
**FIGURE 6**

7. Remove the nuts of the headliner cover.



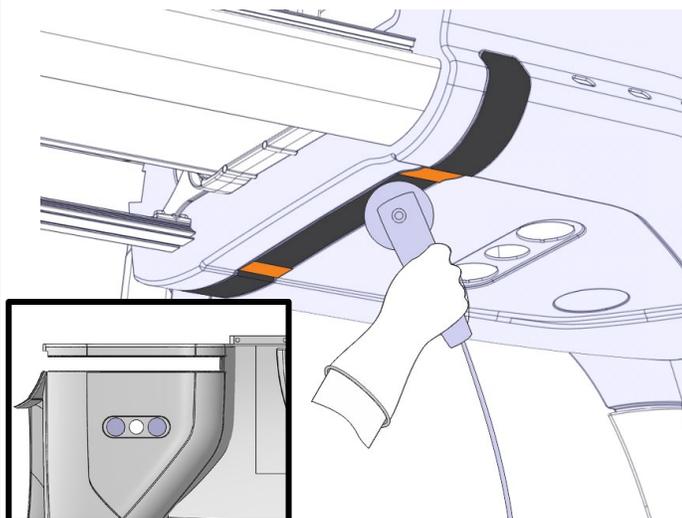
**FIGURE 7**

8. Remove the headliner cover.



**FIGURE 8**

9. Confirm that the slot for the upper support is clear of material. Otherwise, cut the remaining bridges in the headliner hole with a rotary tool.



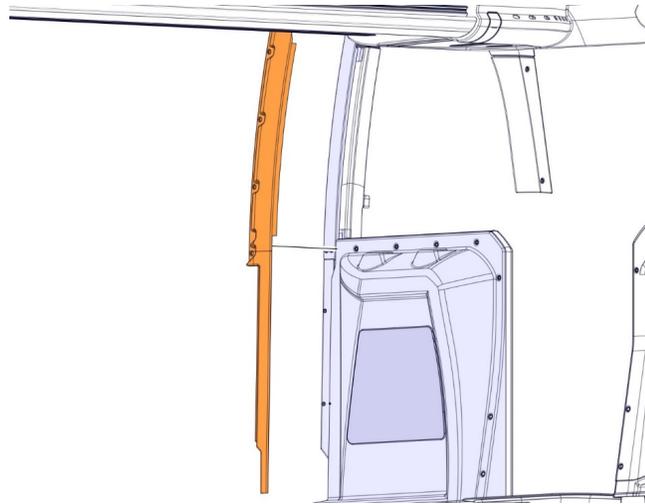
**FIGURE 9**

10. Remove the plugs and screws of the Pillar Cover.



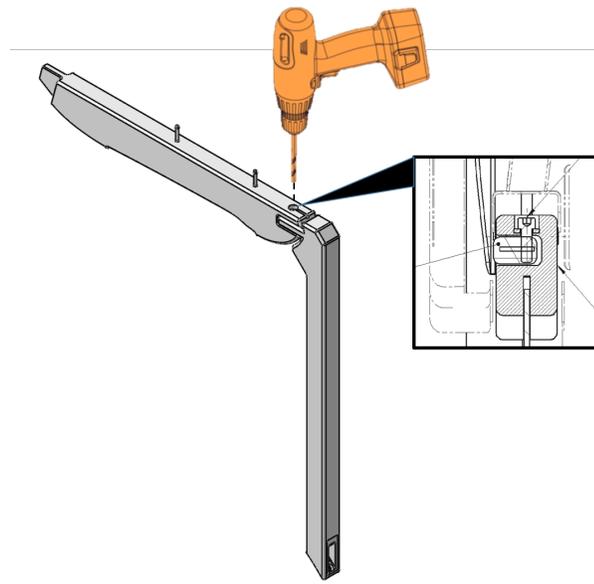
**FIGURE 10**

11. Remove the Pillar Cover.



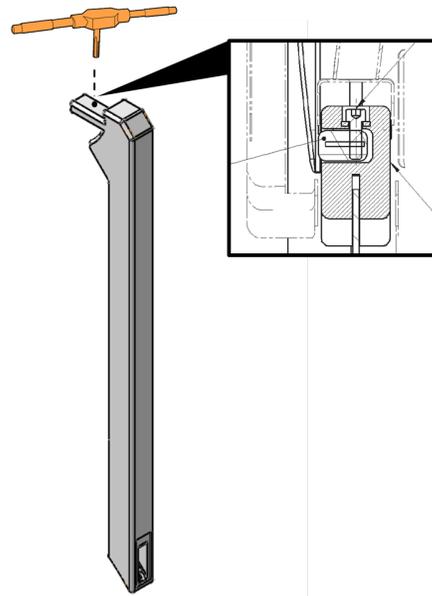
**FIGURE 11**

- 12. Match the glass support #21656508 and the vertical support #21693935;
- 13. Transfer the hole using a  $17/64"$  = 6.9mm drill bit.



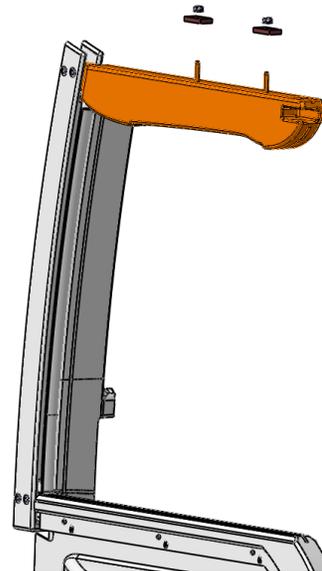
**FIGURE 13**

14. Create the M8 x 1.25 thread on the hole using a Tap.



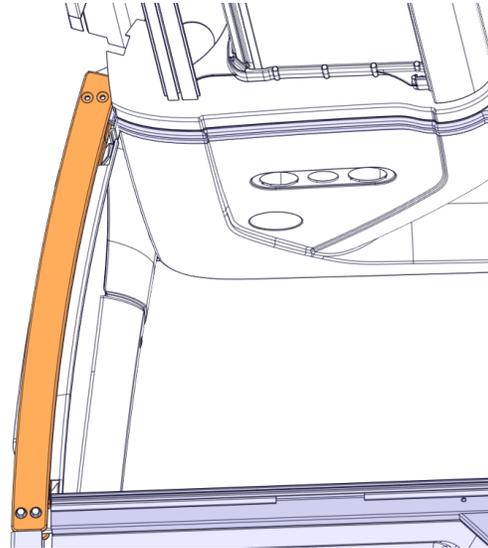
**FIGURE 14**

15. Install the top glass support #21656508, using RUBBER SPACERS #N67354 and two FLANGE LOCK NUT #990950.



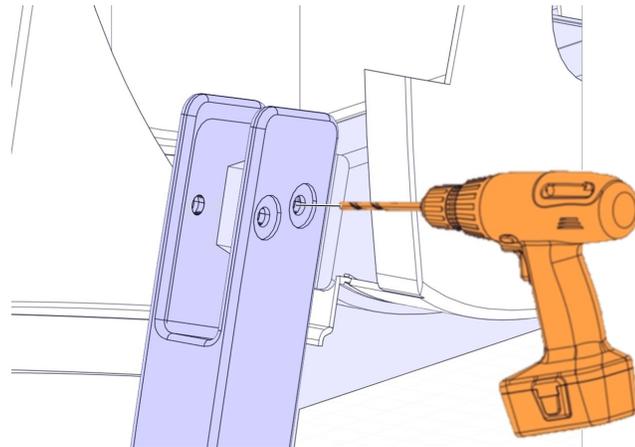
**FIGURE 15**

16. Locate the vertical support next to the window.



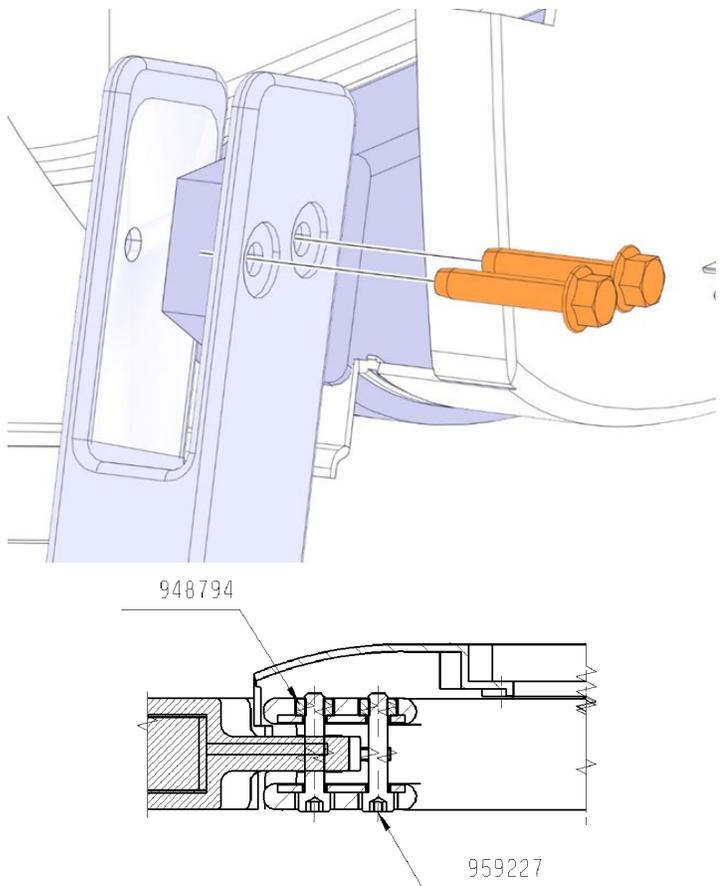
**FIGURE 16**

17. Drill a hole on the edge of the support, using a 9mm drill bit.



**FIGURE 17**

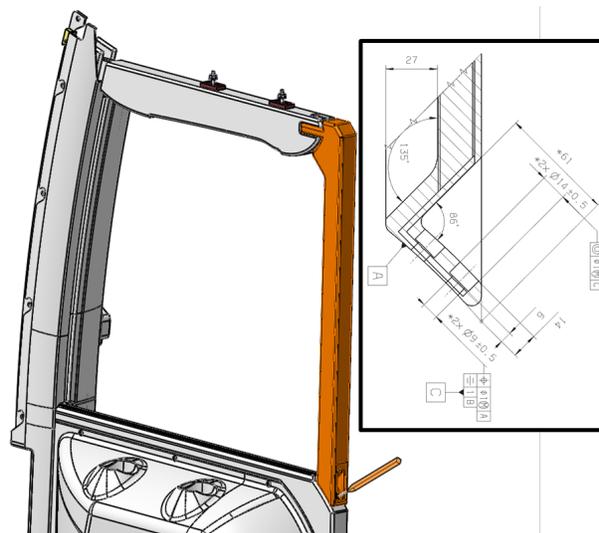
18. Install two screws #959227 and two nuts #948794.



**FIGURE 18**

19. Present the Vertical support #21693935 in order to transfer the fixation holes to the partition wall pillar.

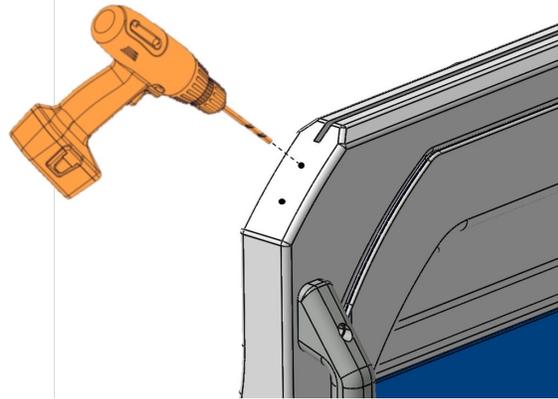
After marking the holes on the pillar, remove the vertical support.



**FIGURE 19**

20. Drill the marked holes using a  $17/64" = 6.9\text{mm}$  drill bit.

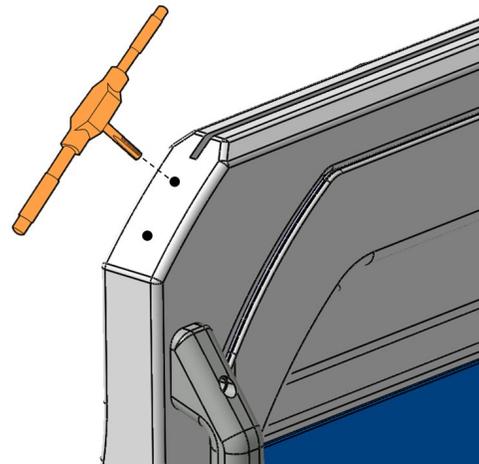
**Note.** Keep the drill perpendicular to the surface.



**FIGURE 20**

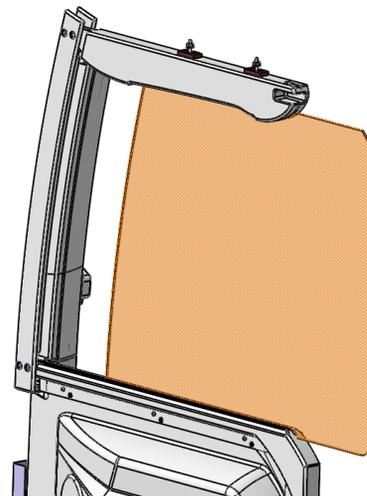
21. Thread the holes using a 8mmX1.25 Tap.

**Note.** Keep the drill perpendicular to the surface.



**FIGURE 21**

22. Slide the glass #22040894 in the rails.



**FIGURE 22**

23. Install the vertical support #21693935 using two screws #60111166.

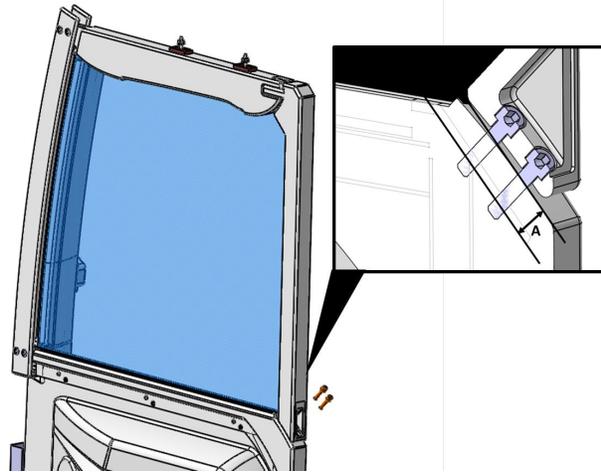


FIGURE 23

24. Fix together the supports using one screw #959222.

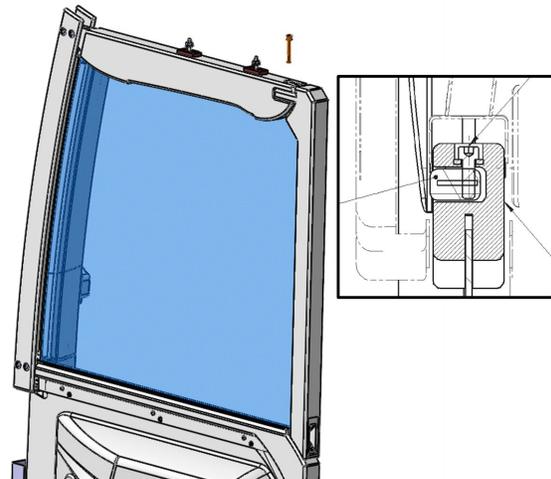


FIGURE 24

25. Reinstall the cover pillar.

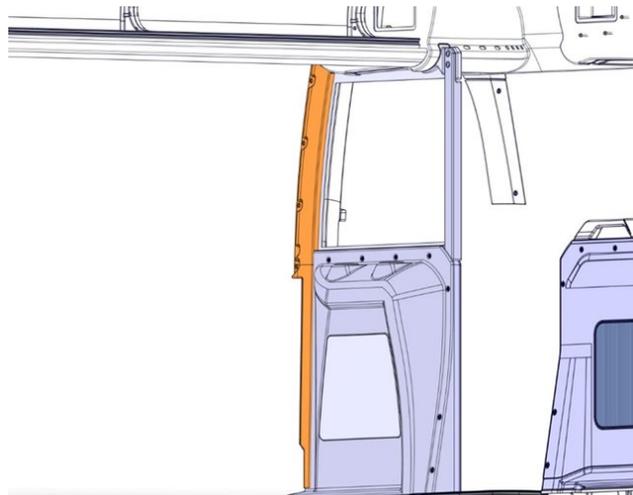
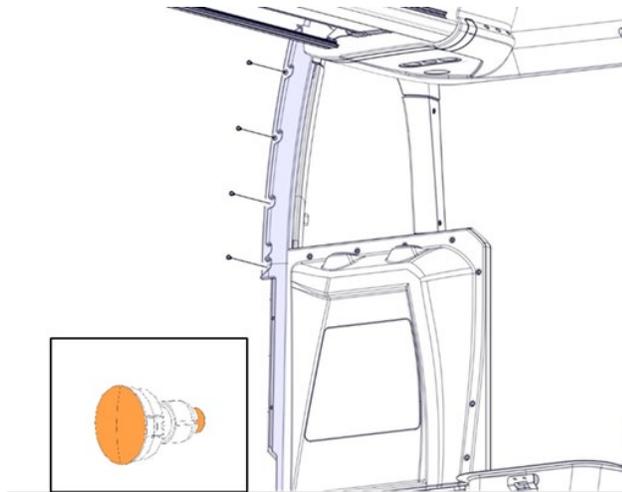


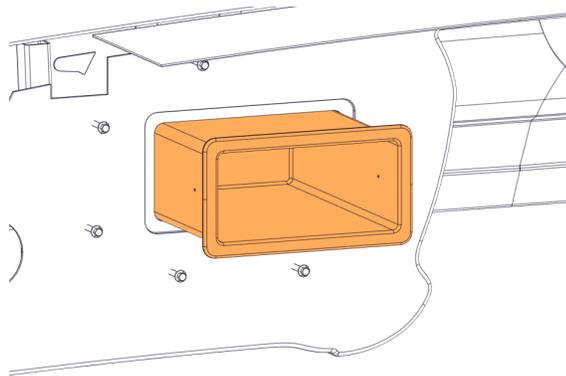
FIGURE 25

26. Reinstall the plugs and screws of the Pillar Cover.



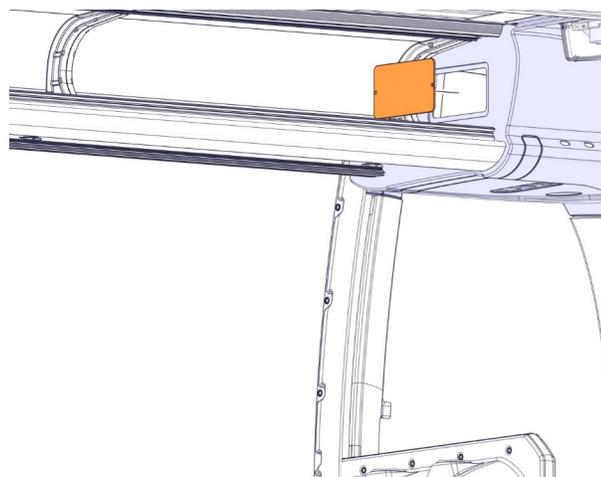
**FIGURE 26**

27. Reinstall the headliner box. (If present)



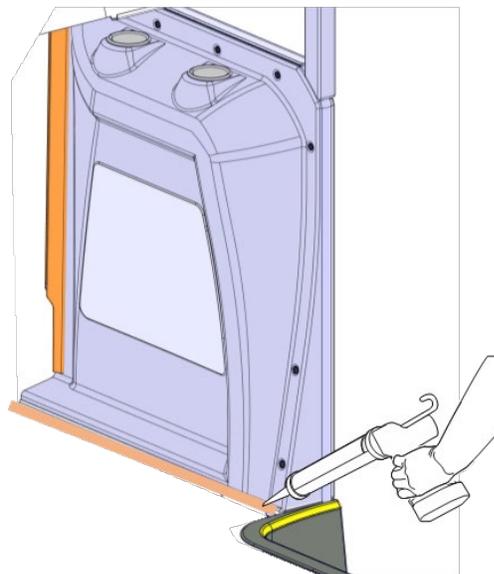
**FIGURE 27**

28. Reinstall the hatch on the left hand side of the headliner.



**FIGURE 28**

29. Apply sealant as needed.  
Sikaflex 221 Grey #8714428



**FIGURE 29**

**ESTIMATED TIME**

The time required to perform this instruction sheet is approximately 1.5 hours per vehicle, not including curing time for adhesives and sealants.

**PARTS / WASTE DISPOSAL**

Discard waste according to applicable environmental regulations (Municipal/State[Prov.]/ Federal)