



MAINTENANCE INFORMATION

MI21-86A

DATE:	October 2021	SECTION: 18 BODY
SUBJECT:	EMERGENCY WINDOW GASKET REPLACEMENT	

Revision: A

Application box VIN updated

11-24-2021

APPLICATION

Model
Volvo 9700 US/CAN
Up to 3CET2V926 <u>K5194256</u> (2019)

DESCRIPTION

Emergency window Gasket maintenance.

MATERIAL

Part No.	Description	Qty
23663618	3M UNIVERSAL PRIMER UV	As needed
70363904	ADHESIVE TAPE	As needed
21331618	MOULDING, EMERGENCY WINDOW (EPDM)	As needed
23242281	SIKAFLEX-271	As needed
7775262	3M WEATHERSTRIP ADHESIVE	As needed
22040451	GASKET AS RAW MATERIAL (per meter)	5.5 m per window

Other parts that may be required:

Part No.	Description	Qty
22058431	GASKET (Prebuild)	As needed
22058433	GASKET (Prebuild) Wheelchair lift variant	As needed

NOTE

Material can be obtained through regular channels.

PROCEDURE

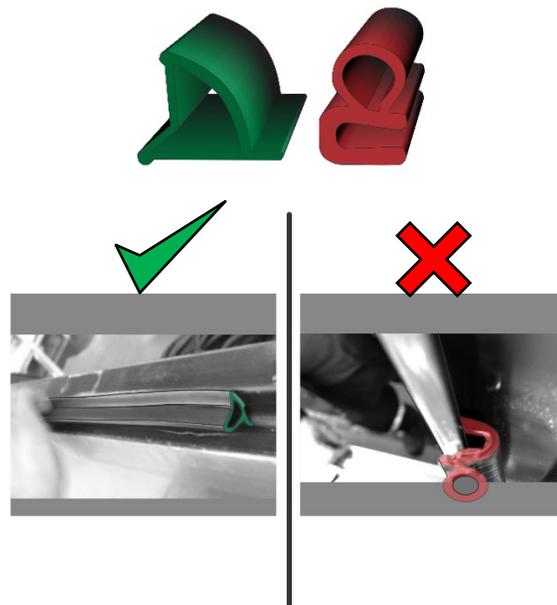


DANGER

Park vehicle safely, apply parking brake, stop engine. In the battery box, set the battery cut-off switch to the OFF position prior to working on the vehicle.

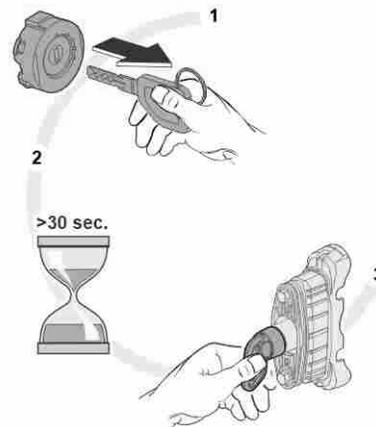
Lockout & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

1. Before beginning, confirm the cross section of the window seal on the frame, directly on the buses.

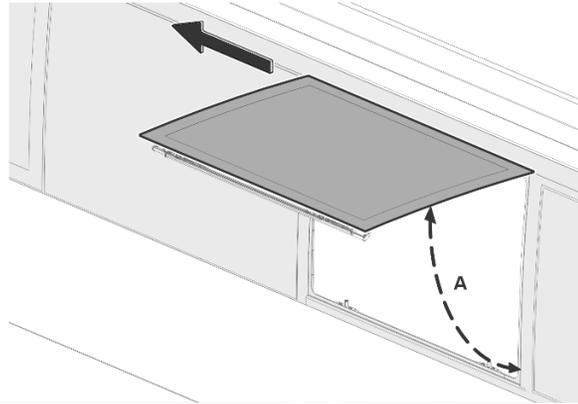


2. Make sure that the vehicle is OFF.

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1. Remove the key.
 2. Wait at least 30 seconds.
 3. Turn off the battery switch.



3. Remove the emergency windows needed.



4. Remove all seals on the bus frame in need of change.



5. Remove all seals on the bus windows in need of change.



6. In case of using **22040451 GASKET AS RAW MATERIAL** (per meter), make a correct window seal for the frame, cut the edges at 45°.

Note: *Measurements needed are presented on Appendix section.*

7. Glue the gasket using the **08008 3M WEATHERSTRIP ADHESIVE** gasket glue.

Specifications:

Curing time:

► **Min:** 24 hrs.



8. On the bus frame, scour around the frame surface with a heavy-duty scour pad to promote adhesion. To apply **23663618 3M UNIVERSAL PRIMER UV**; substrate must be clean, dry, free of oil and grease; thoroughly remove all loose particles and residues.

Wipe bond face with a clean, lint-free cloth moistened with PRIMER. Apply sparingly, wiping once only. Wipe off with a clean dry cloth or paper towel.

Note: *Allow drying 10 minutes but not more than two hours before applying adhesive. If adhesive cannot be applied within two hours of priming, repeat application.*



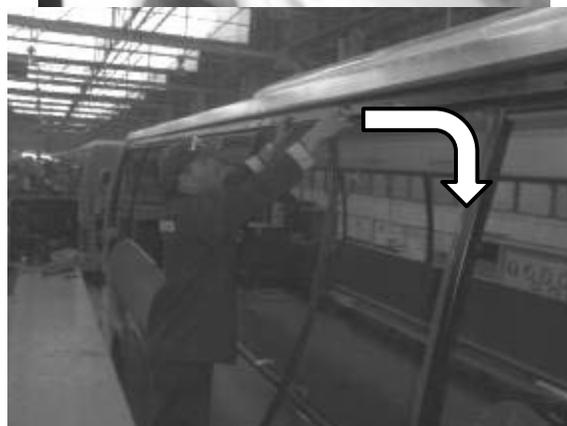
9. Stick double sided *ADHESIVE TAPE* **70363904** in the upper edge frame (only).



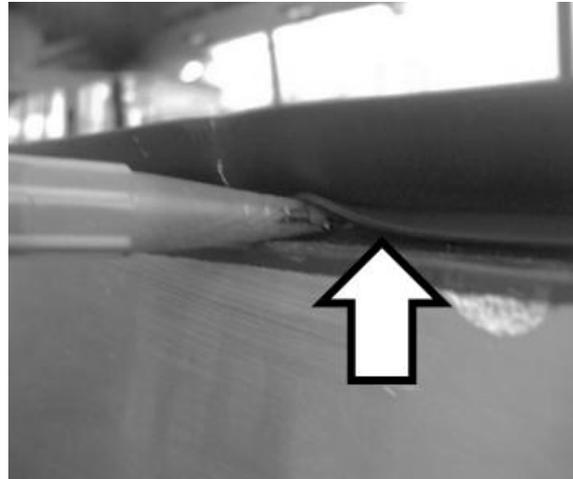
10. Remove the protective layer of the adhesive tape and stick the rubber molding all around the inner edge of the frame for emergency window.



11. Start at the middle of the bottom edge of the window's frame, radius at the corners as small and smooth as possible, check the good adhesion of the rubber molding.



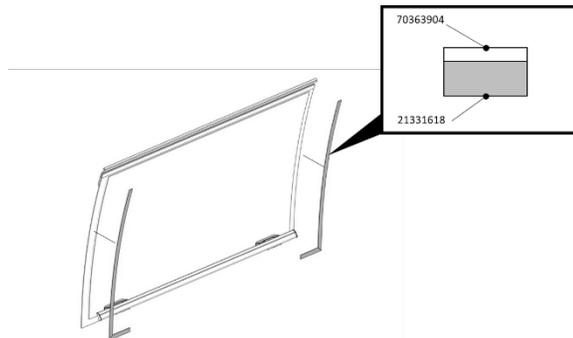
12. Apply adhesive **23242281** *SIKAFLEX-271* all around under the rubber molding as shown in the image.



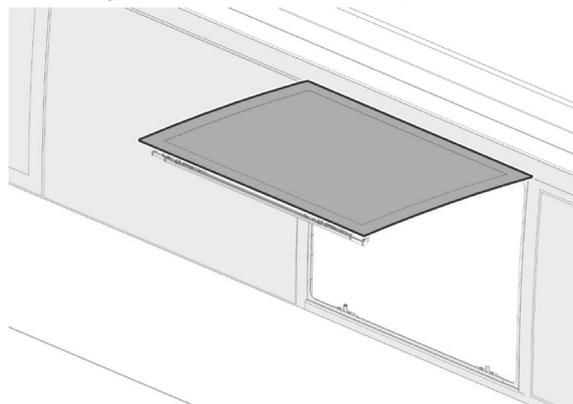
13. On the windows, clean the aluminum with isopropyl alcohol. Apply adhesion promoter **23663618** *3M UNIVERSAL PRIMER* on the aluminum, wait 10-minute cure time.



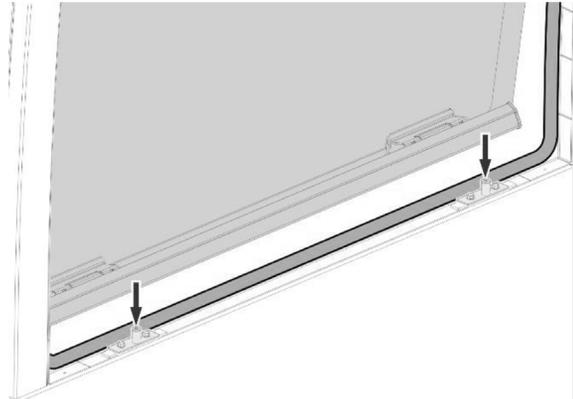
14.
15. Measure and apply double sided ADHESIVE TAPE **70363904**, subsequently neoprene trim **21331618** *MOLDING, EMERGENCY WINDOW (EPDM)* on the sides.



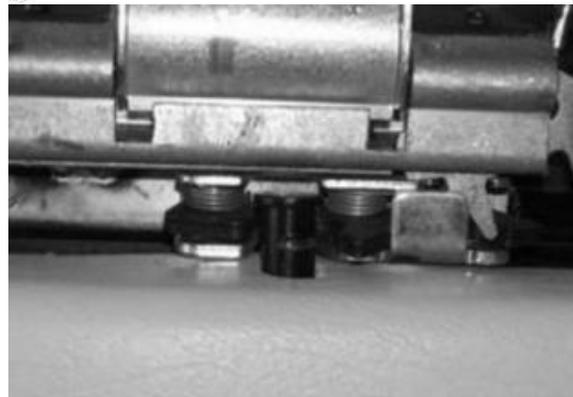
16. Install the window.



17. Verify that the gasket does not interfere with the locks.

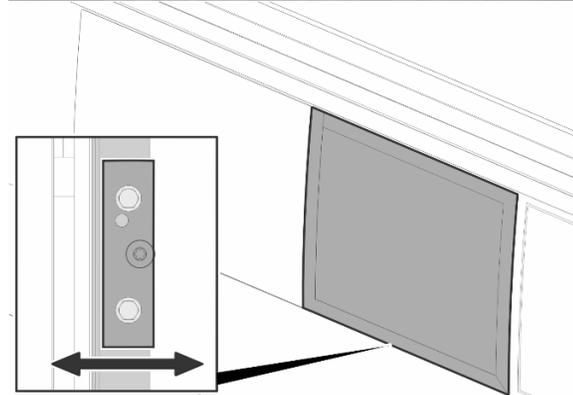


18. Adjust the lock mechanism from the inside if necessary.



19. Loosen the lock screws and slide forward or backward as needed, later apply torque to screws

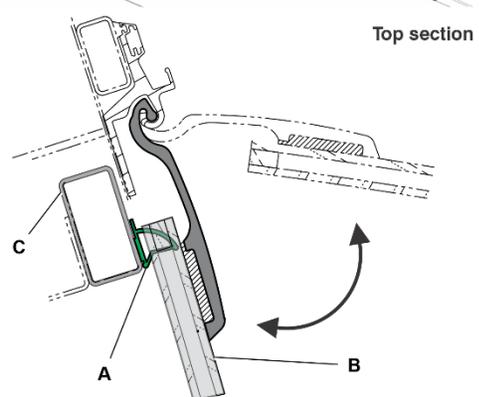
Torque: 110 ±15 Nm



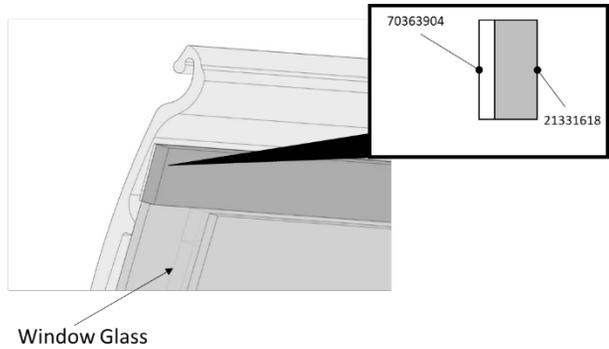
20. Check the correct seal of the window on the top.

- A. Gasket
- B. Window glass
- C. Frame

The gasket should seal against the window glass.



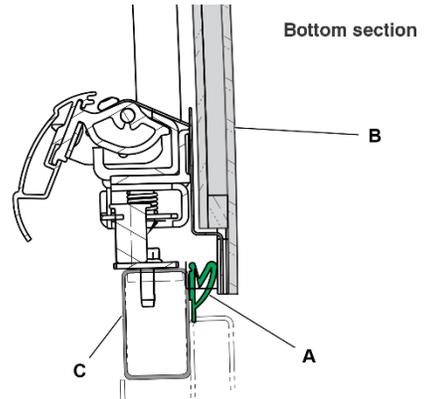
21. Only if necessary, measure and apply double sided ADHESIVE TAPE **70363904**, subsequently neoprene trim **21331618** MOLDING, EMERGENCY WINDOW (EPDM).



22. Check the correct seal of the window on the bottom.

- A. Gasket
- B. Window aluminum frame
- C. Frame

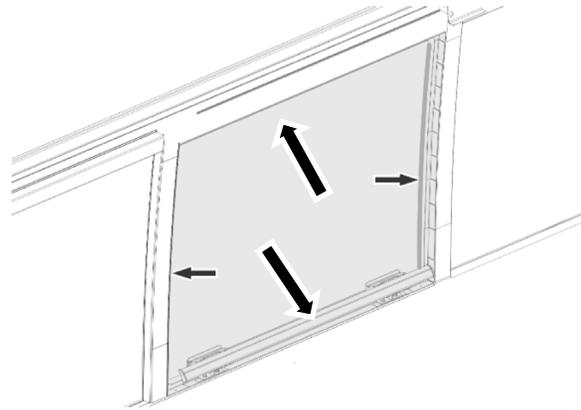
The gasket should seal against the window aluminum frame.



23. If necessary, measure and apply double sided ADHESIVE TAPE **70363904**, subsequently neoprene trim **21331618** MOLDING, EMERGENCY WINDOW (EPDM) on the bottom.

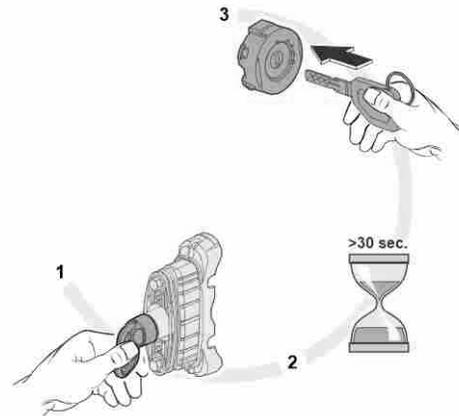


Check the correct sealing of the window, on the inside all around. If necessary, measure and install more **ADHESIVE TAPE 70363904**, subsequently neoprene trim **21331618 MOLDING, EMERGENCY WINDOW (EPDM)** on the window where the seal is not achieved.



24. Turn on the vehicle.

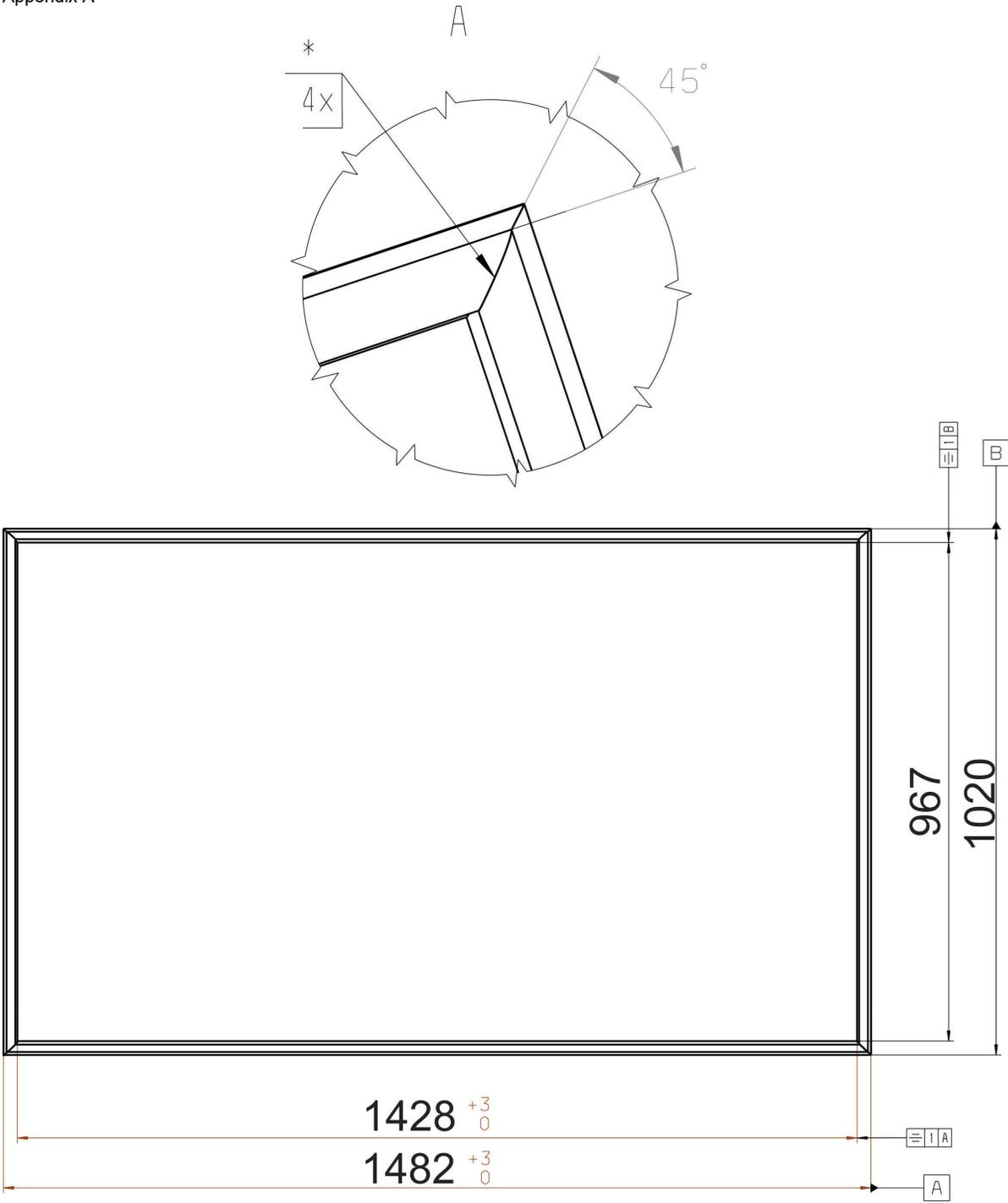
1. Turn on the battery switch.
2. Wait at least 30 seconds.
3. Insert the key.



PARTS / WASTE DISPOSAL

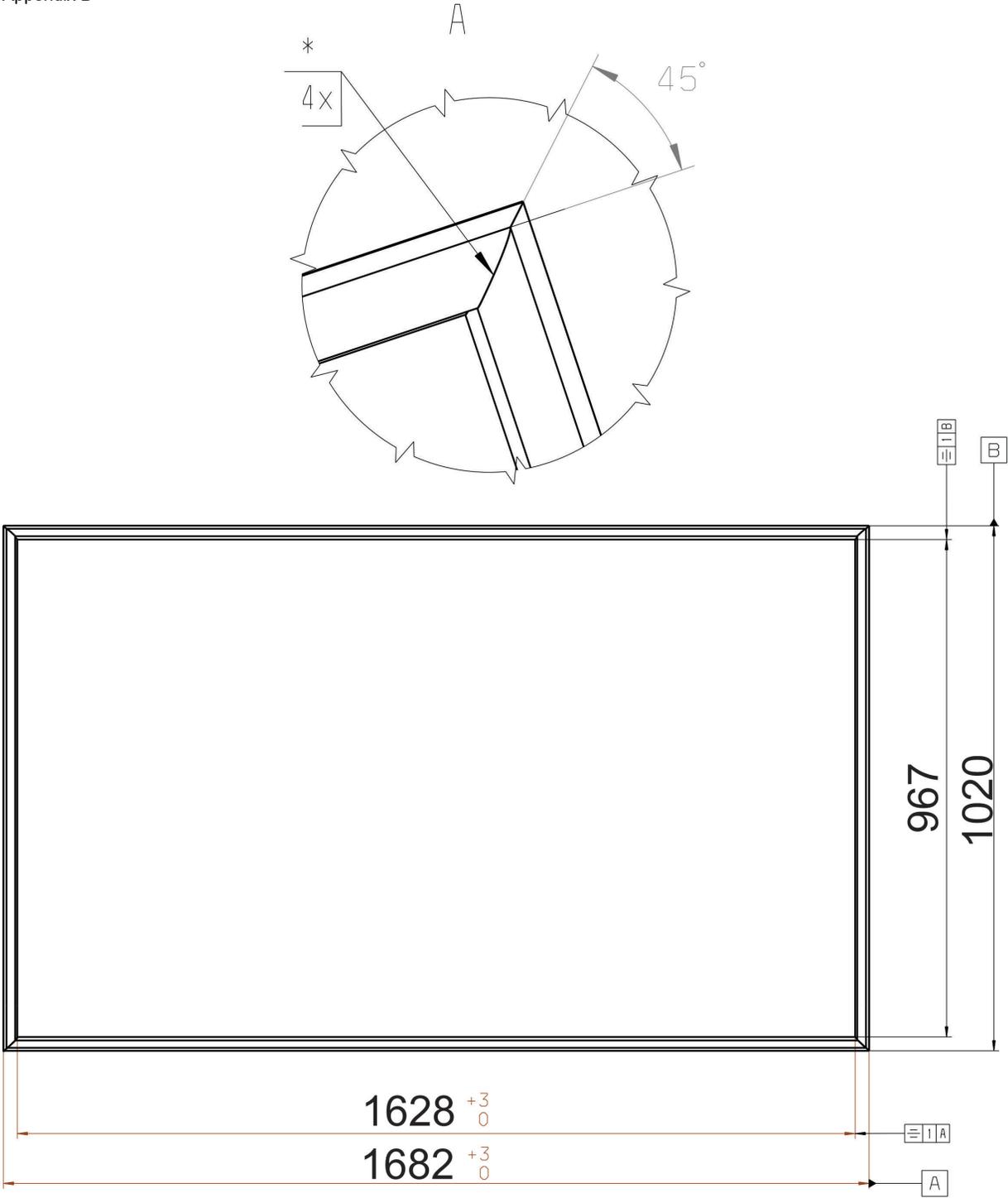
Discard according to applicable environmental regulations (Municipal/State[Prov.]/ Federal)

Appendix A



22058433 For wheelchair lift variant

Appendix B



22058431 standard