



# PREVOST

## MAINTENANCE INFORMATION

**MI25-12**

DATE :	April 2025	SECTION :	18 BODY
SUBJECT :	<b>REPLACE RIVETED HATCH BY GLUED HATCH</b>		

First Release

04-23-2025

### APPLICATION

Model	
All Prevost vehicles 2005 to 2024	

### DESCRIPTION

This maintenance information explains how to install a glued roof escape hatch.

### MATERIAL

Order the hatch model you need (only gray color is available):

Hatch without ventilation

Part No.	Description
950725	HATCH ASSY / GRAY / ENGLISH
950722	HATCH ASSY / GRAY / ENGLISH & FRENCH
950724	HATCH ASSY / GRAY / ENGLISH & SPANISH



## Hatch with ventilation

Part No.	Description
950727	HATCH ASSY / GRAY / ENGLISH
950728	HATCH ASSY / GRAY / ENGLISH & FRENCH
950726	HATCH ASSY / GRAY / ENGLISH & SPANISH



## Other parts that may be required:

Part No.	Description	Qty
684685	GLUE SIMSON ISR 70-03 BLACK, CARTRIDGE 310ml	1
682989	SILICONE REMOVER	1
506191	FOAM TAPE AD1 PE CC BK 1/8"X1/4"X60'	1

**NOTE**

*Material can be obtained through regular channels.*

***IMPORTANT NOTICE***

*This modification is recommended by Prevest to increase your vehicle's performance. Note that no reimbursement will be awarded for carrying out this modification.*

## SAFETY PRECAUTIONS

- Eye protection should always be worn when working in a shop.
- Rules for Personal Protection Equipment should always be respected. Wear your PPE including but not limited to the following:



# Safety First!



## PROCEDURE



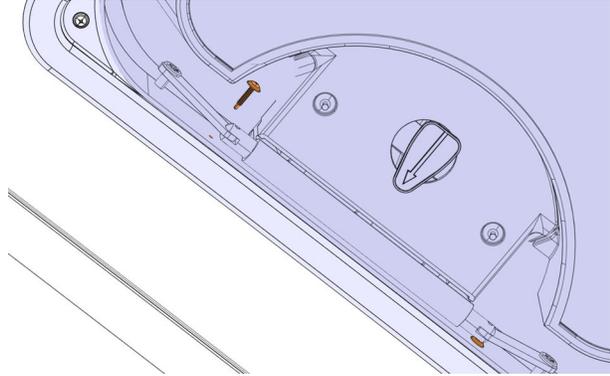
### DANGER

Park vehicle safely, apply parking brake, stop the 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.

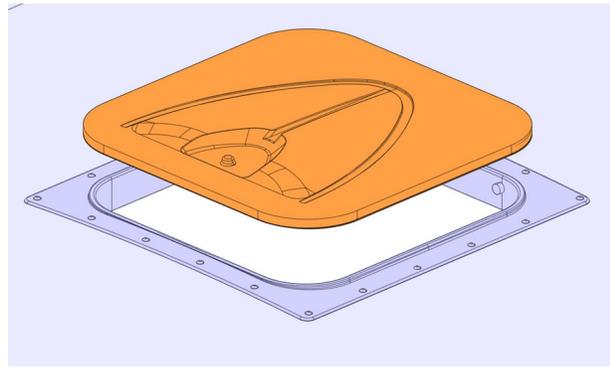
Lock out & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

**REMOVE OLD HATCH**

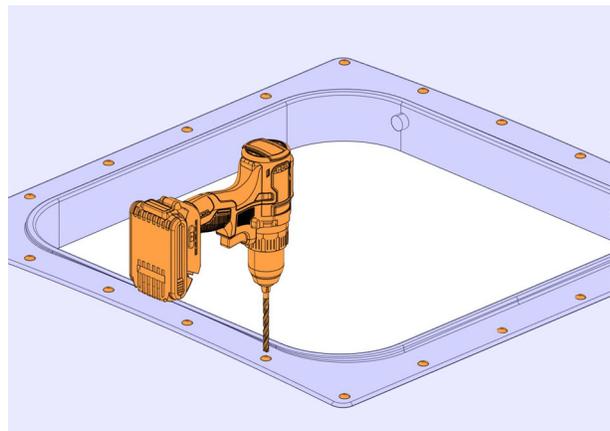
1. Remove the screws (4x) that secure the hatch to the interior finishing molding.



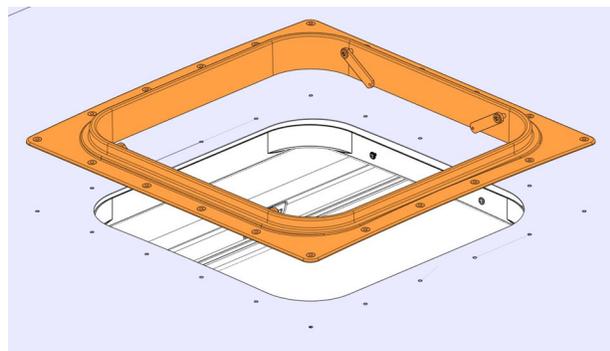
2. Remove the hatch lid.



3. Drill all the rivets(20x).

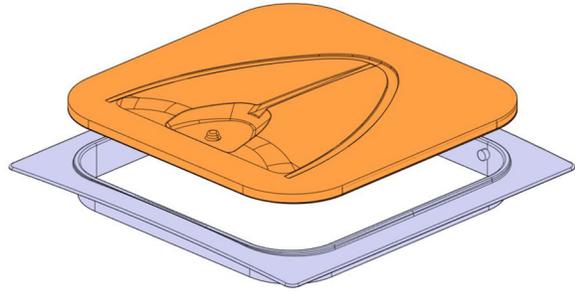


4. Remove the old hatch.

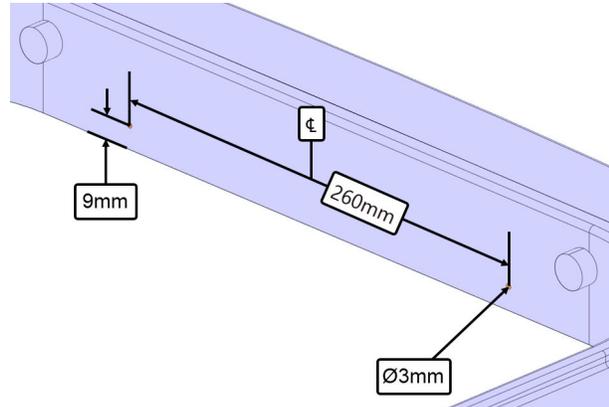


## PREPARE THE NEW HATCH

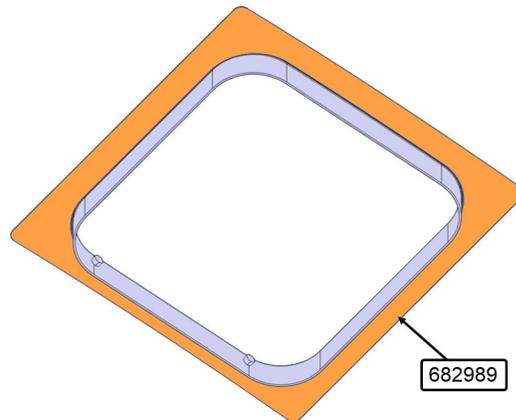
1. Remove the lid of the new hatch.



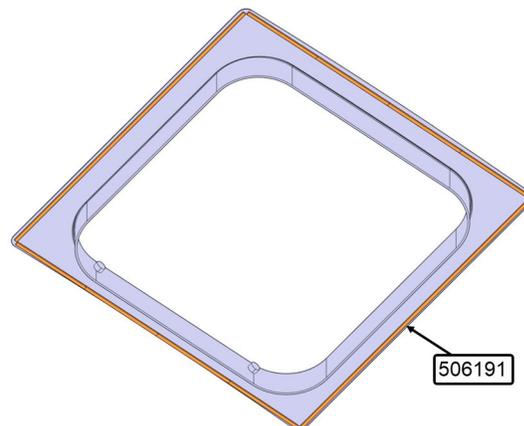
2. Mark the location of four holes on the hatch frame.
3. Drill four holes  $\text{Ø}1/8''$  in the hatch frame.



4. Clean the hatch frame with silicone remover 682989.

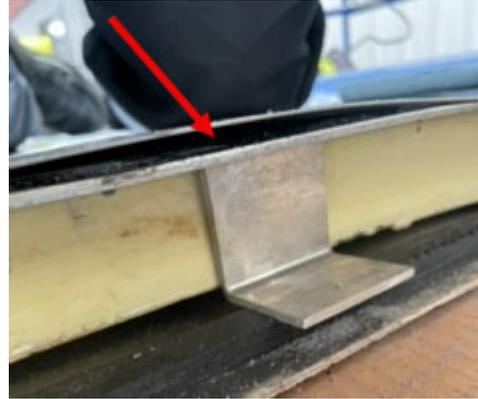


5. Install foam tape 506191 on the hatch frame.

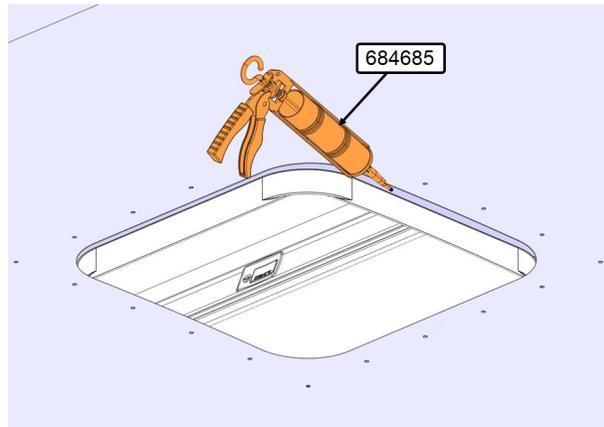


## INSTALL THE NEW HATCH

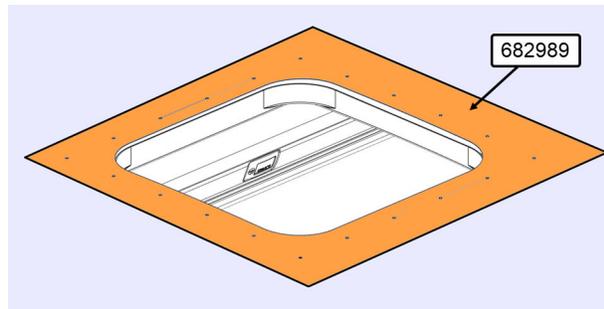
1. Clean the surface between roof panel and structure with silicone remover 682989.



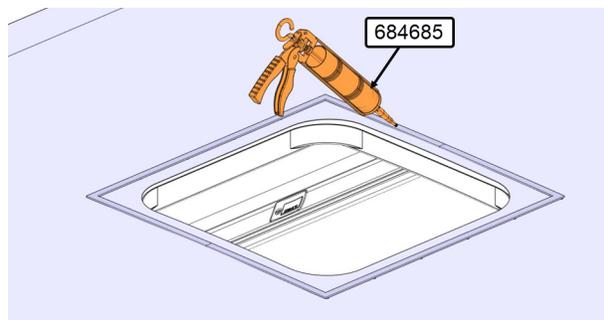
2. Apply glue 684685 between roof panel and structure.



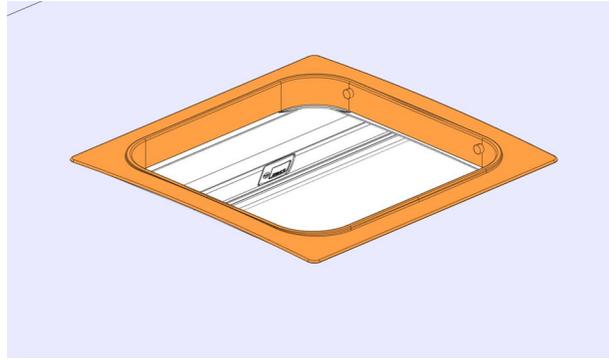
3. Clean the roof panel with silicone remover 682989.



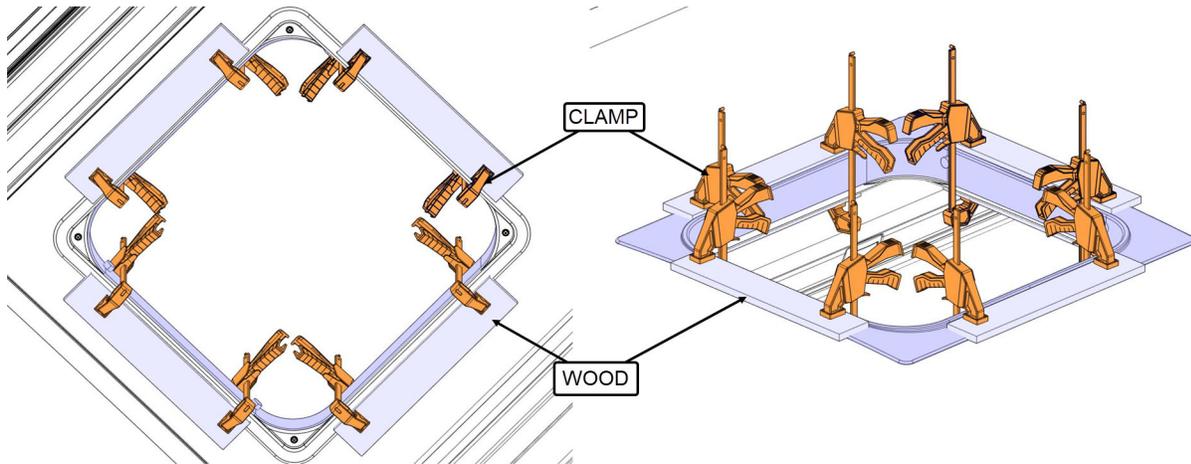
4. Apply glue 684685 on the roof panel.



5. Install the hatch frame on the roof.

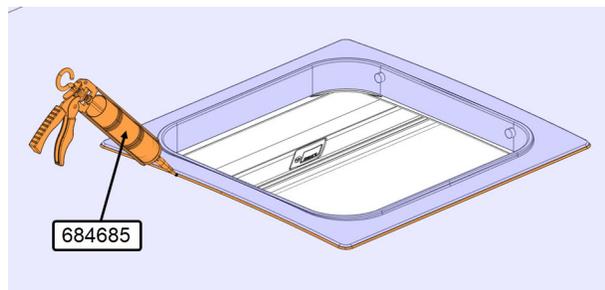


6. Secure the hatch frame with clamps (8x) and use pieces of wood between the clamp and the roof and ceiling finishing as a protection. **The clamps must remain in place for three hours.**

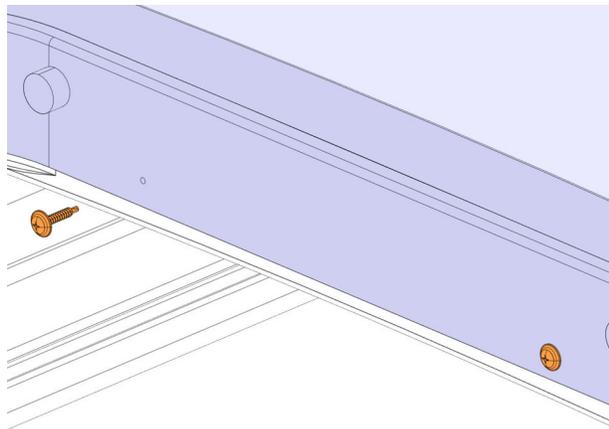


7. Remove the clamps.

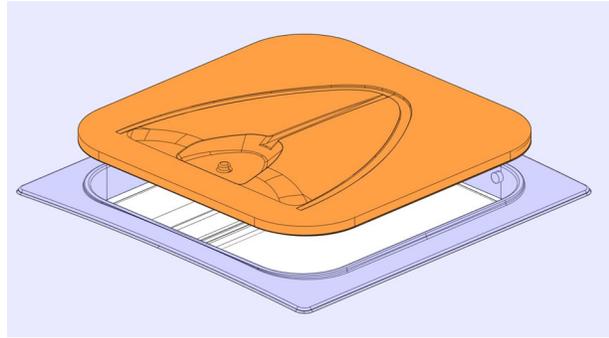
8. Apply a 3/8" bead of glue 684685 around the hatch frame.



9. Reinstall the screws (4x) that secure the hatch to the interior finishing molding.



10. Reinstall the lid on the hatch frame.
11. The coach must remain in place for 24 hours before being moved.



## PARTS / WASTE DISPOSAL

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

Access all our Service Bulletins on <http://techpub.prevostcar.com/en/>  
Or scan the QR-Code with your smart phone.

**Are you a Vehicle owner?**

E-mail us at [technicalpublications\\_prev@volvo.com](mailto:technicalpublications_prev@volvo.com) and type "ADD" in the subject to receive warranty bulletins applicable to your vehicle(s) by e-mail.

