

PREVOST

ENREGISTRÉ - REGISTERED
ISO 9001 & ISO 14001

**MAINTENANCE
INFORMATION**

Mi08-11A




DATE : NOVEMBER 2009	SECTION : 18 - Body
SUBJECT : SS SIDE PANEL OR UPPER FIBERGLASS SIDE PANEL REPAIR OR REPLACEMENT	

**REVISION : A THIS MAINTENANCE INFORMATION SUPERSEDES PREVIOUS VERSION.
ADDITION OF TEXT IN THE PROCEDURE TO LIMITED ACCESS TO BEHIND THE PANEL**

IMPORTANT NOTICE

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

APPLICATION

Model	VIN	
XLII MTH	All vehicles containing glued SS side panels or upper fiberglass side panels	
VIP-45	All vehicles containing glued upper fiberglass side panels	

DESCRIPTION

On the above-mentioned vehicles, it is possible to replace or repair a glued stainless steel side panel or fiberglass panel. The purpose of this procedure is to explain the steps to be followed in order to get a good adherence. These steps are of the uppermost importance to obtain 100 % adherence.

MATERIAL

Part No	Description	Qty
687957	Glue, Loctite 5590 400 ml Cartridge	A/R
687958	Mixer, Loctite Triangular Opening	A/R
684517	Glue, Simson ISR 70-03 Cartridge	A/R
685250	Mixer, Loctite Round Opening	A/R
685251	Cleaner, Desco DE-537	A/R
685252	Sealant, Loctite 5570 clear	A/R
562499	Tubing, Heat shrink	A/R

NOTE
 Material can be obtained through regular channels.

PROCEDURE

⚠ DANGER
 Park vehicle safely, apply parking brake, stop engine and set battery master switch(es) to the OFF position prior to working on the vehicle.

PART A: PARTIAL PANEL UNGLUING

FULL ACCESS TO BEHIND THE PANEL

If you have full access to behind the panel, clean using anti-silicone (Refer to section A).

Section A Anti-silicone

	<p>1. Apply</p> <p>CHIX cloth</p>		<p>2. Dry immediately</p> <p>Blue cloth</p>
<p>Note: Do not use over long distances. Turn cloth over. Clean until Chix cloth comes out clean.</p>			
<p>Unacceptable</p>		<p>Unacceptable</p>	
<p>Maximum acceptable</p>			
<p>3. Allow drying (Mandatory)</p>		<p>Minimum time: Wait for product to evaporate After 2 hours: Start cleaning operation again</p>	
<p>Before applying any other product</p>		<p>If surface seems dusty, greasy or with finger marks, start cleaning operation again.</p>	

LIMITED ACCESS TO BEHIND THE PANEL

1. Pull the panel enough to be able to insert a chix cloth soaked with anti-silicone around a spatula behind the panel. Wipe vehicle structure and behind panel.

NOTE

Remove former Sika bead if you have access and adhesion is poor.

- It is always better to try to have full access to behind the panel but making sure at the same time not to damage the panel.



WARNING



Desco DE-537 product (Prevost #685251) contains hydrofluoric acid, wearing impermeable protective clothing, gloves and safety glasses is strongly recommended. Contact with this product can cause serious burns not being able to be detected before an incubation period going up to 24 hours. Abstain from breathing the vapors and avoid any contact with the skin and the eyes. Harmful if swallowed.

NOTE

If the side of the panel is unglued at 2 or 3 places or if loss of glue adhesion is over more than 2-3 inches, it would be better to completely unglue the panel side to allow better cleaning and gluing while making sure of course not to damage the panel.



CAUTION

Use an Olfa type knife or a Multi-Function oscillating tool equipped with a flush-cutting blade to unglue the panel. **Make sure not to damage the panel.**

- As a last resort, if you have limited access behind panel and you cannot use a spatula, clean using Desco DE-537 product (Prevost #685251).
- Spray some Desco DE-537 behind the panel (use the supplied puller to move the panel away from the structure), allow working for 1 minute.
- Spray some water to neutralize the product.
- Use an air gun to blow off dirt and dry surfaces.
- Repeat cleaning operation at least twice then finish by rinsing with water twice.

NOTE

Cleaning operation is of the outmost importance. Repeat cleaning operation 2-3 times (steps 2 to 6). If cleaning operation is not performed correctly, glue adhesion may be impaired.



CAUTION

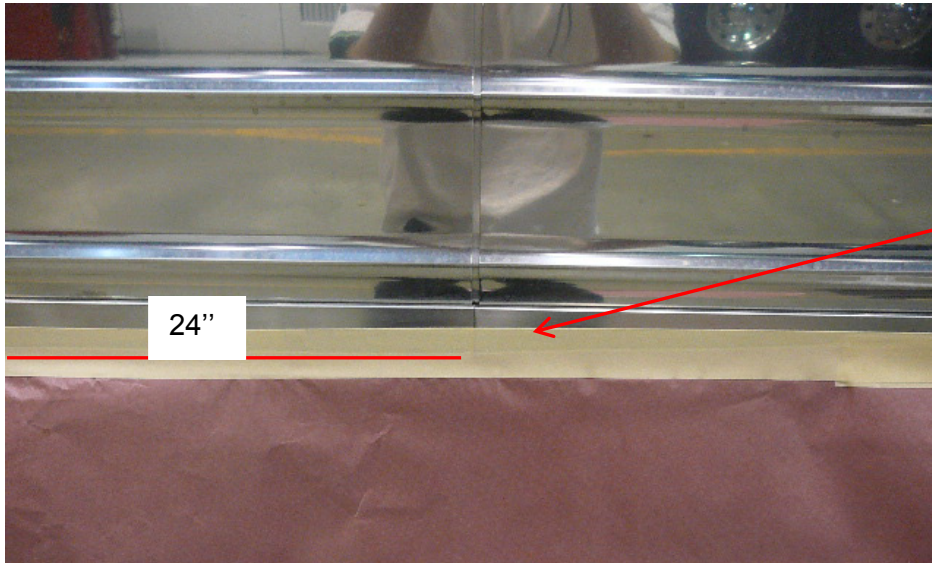
Desco DE-537 cleaner may leave some residue on the aluminum, protect adjacent SS or aluminum areas using masking tape or other protective material.

IMPORTANT NOTE

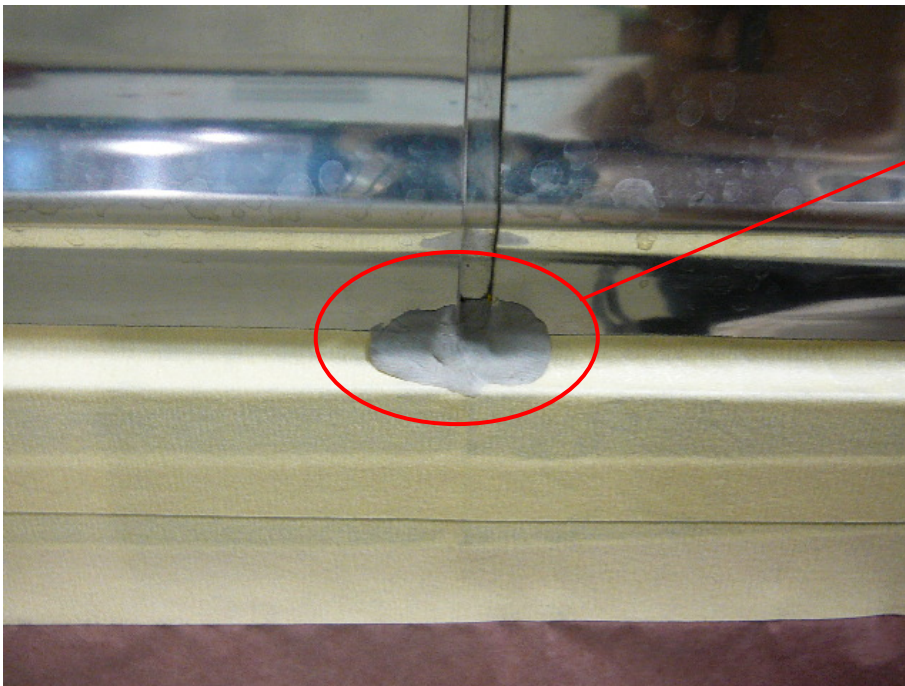
ANY SS SIDE PANEL OR UPPER FIBERGLASS SIDE PANEL REPAIR OR REPLACEMENT MUST BE WELL DOCUMENTED. THE LOCATION OF THE PANEL, IF IT IS THE FRONT OR THE REAR AND AT WHAT HEIGHT THE REPAIR WAS PERFORMED. IF THE SIDE OF THE PANEL WAS COMPLETELY OR PARTIALLY REGLUED AND ALSO WHAT PRODUCTS WERE USED FOR CLEANING AND GLUING. THIS DOCUMENTATION MUST BE ADDED TO THE VEHICLE RECORDS TO KEEP TRACK OF REPAIRS PERFORMED.

PROCEDURE TO PROTECT THE COACH TO AVOID HAVING DESCO PRODUCT BEHIND THE LOWER FINISHING TRIM

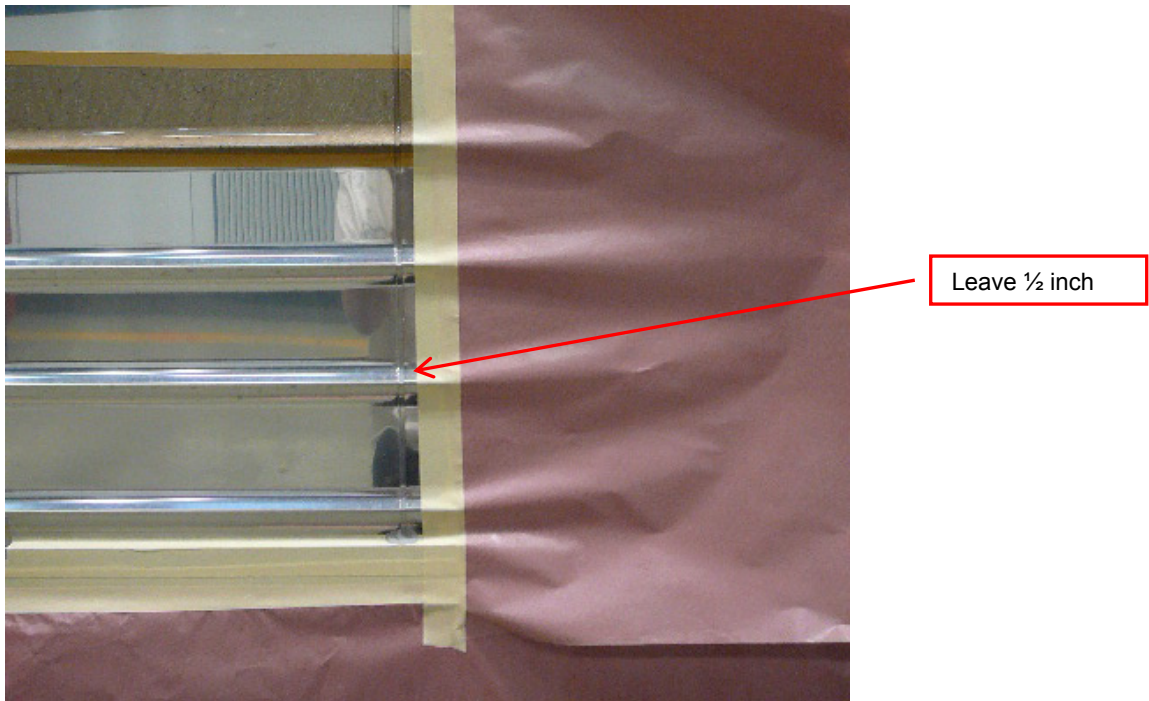
1. Apply tape in the middle of the finishing trim and protect down to the bottom of the baggage door.



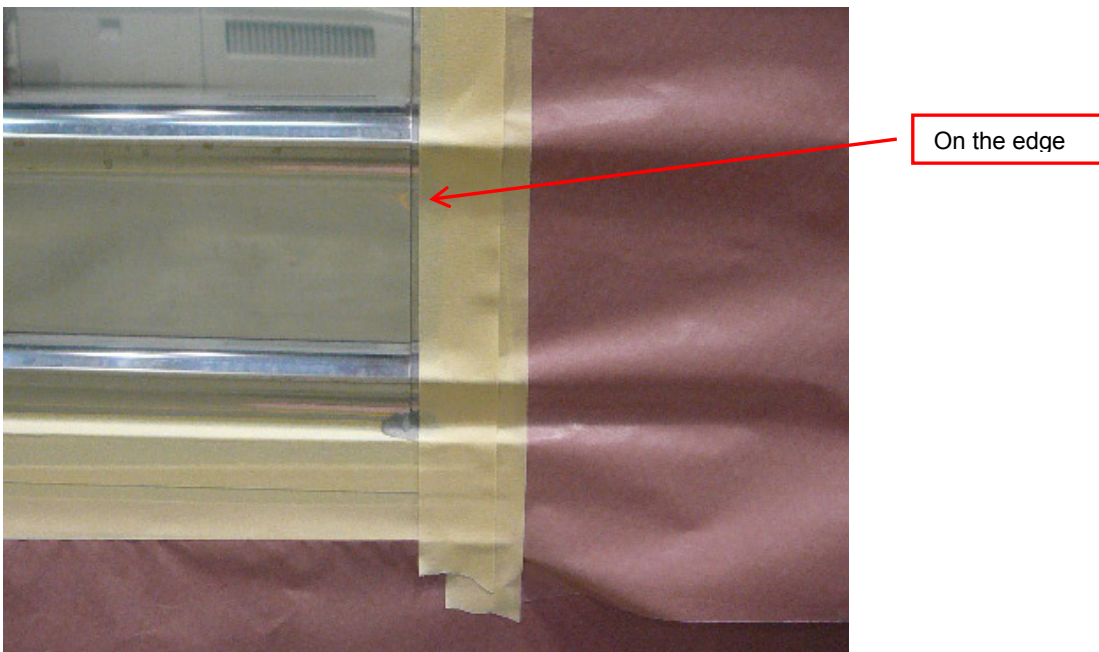
2. Apply masking tape to cover the rest of the finishing trim and put Caulking Strip in the hole



3. Apply tape and plastic or paper ½ inch from the edge.



4. Put the other tape over



5. Do step 3 and 4 on the other side
6. Before cleaning, remove the double sided tape to avoid having glue on it.
7. When using an air gun to dry surfaces, use a small nozzle with slow flow.
8. After the cleaning operation, immediately remove all tapes and papers from top to bottom and wipe the liquid with blue cloth and glass cleaner or Acrysol.

SIDE PANEL REGLUING

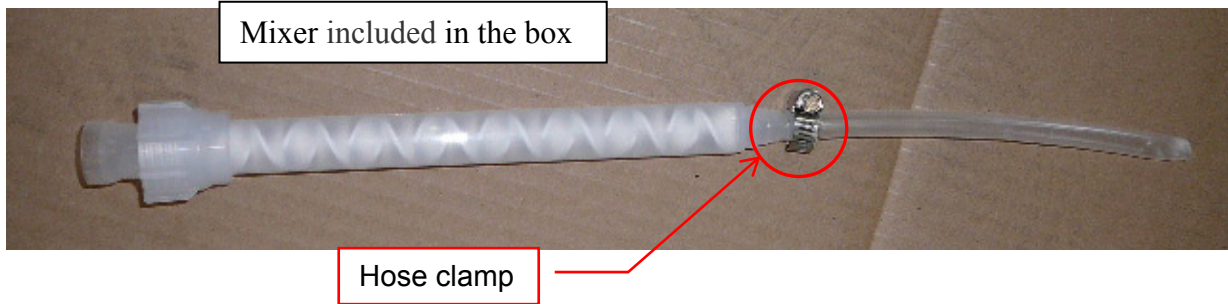
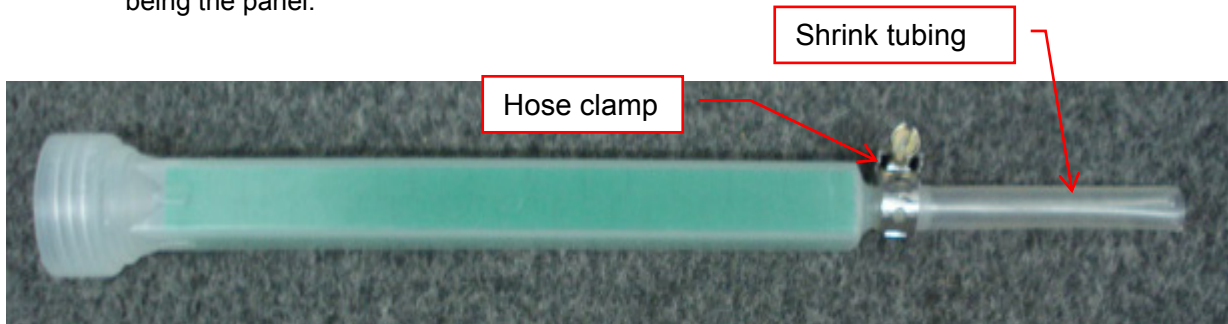
NOTE
 How much time is available will determine what type of glue is used. Refer to TABLE A.

TABLE A		
TIME AVAILABLE	1 DAY (24 HOURS)	3 DAYS OR MORE (72 HOURS)
Product used	Loctite 5590	Simson ISR 70-03
Example of application	Baggage Compartment Door (6 hours) Ridged Side Panel (24 hours)	Baggage Compartment Door (24 hours) Ridged Side Panel (72 hours)

PROCEDURE TO AVOID USING THE ADAPTER (1/8 PLASTIC LINE) WITH 90 PSI AND HEATING THE LOCTITE 5590 IN THE OVEN.

With that tip we use around 20 PSI and we didn't need to heat the glue in the oven.

1. Remove the double sided tape behind the panel
2. Clean with Anti-silicone, if you can wipe use Desco product.
3. Apply the glue with these tips (shrink tubing). Press the end of the shrink tubing to insert it being the panel.



Use a shrink tubing 3/8"
 Shrink tubing Part number 56 2499 (clear)

CAUTION
 When you use this procedure, don't put too much glue behind the panel or you will get a gap.

- Using Loctite 5590 Double Cartridge



WARNING

Glue is warm and cartridge may burst or crack, it is strongly recommended to wear rubber gloves when gluing. Panels may also have sharp or cutting edges that may cause injury to the hands. To prevent contact with sharp edges it is strongly recommended to wear rubber gloves when handling panels.

1. Heat Loctite 5590 double cartridge (Prévost #687957) to $\pm 60^{\circ}\text{C}$ for 1½ hours to 2 hours in an oven.

NOTE

Heating glue up is necessary when the access is limited and a regular triangular mixer adapter cannot get behind the panel; therefore the special adapter is required.



DANGER

Excessive heat may cause the cartridge to burst or crack. Do not heat cartridge up too rapidly or over the recommended temperature.

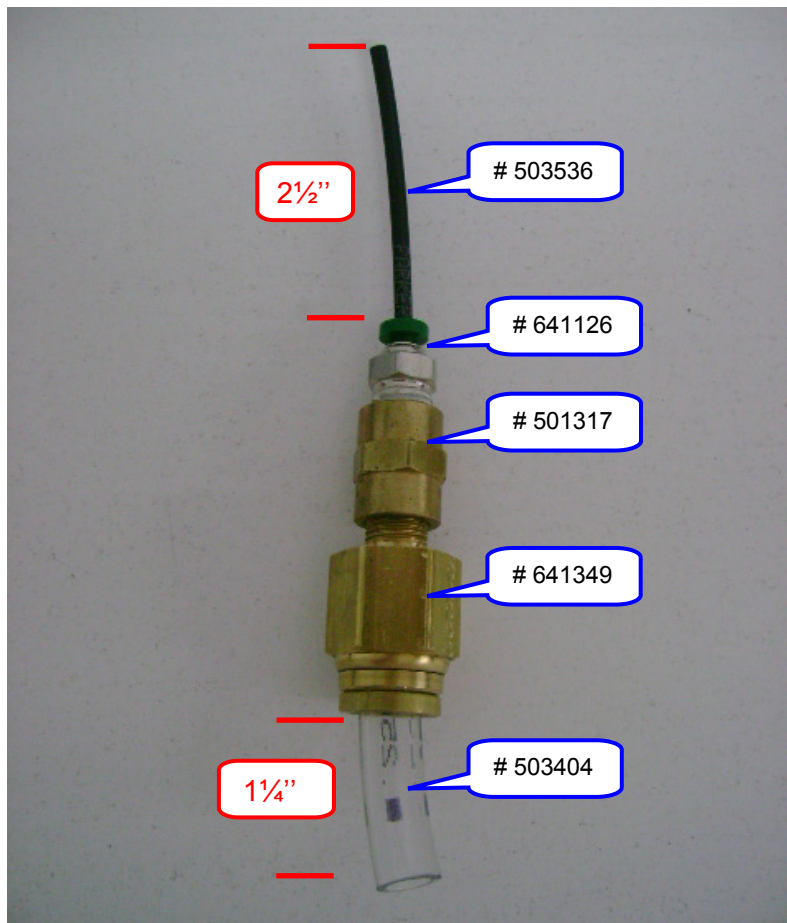


FIGURE 1

2. Install mixer (Prevost #685250) complete with special adapter onto Loctite double cartridge.

NOTE

Refer to figure 1 for assembling special adapter parts.

3. Adjust "Mixpac" DP400 gun regulator to 90-100 psi, apply a bead of Loctite 5590 between panel and structure in a zigzag pattern.



CAUTION

You only dispose of a few minutes to apply the glue, if the flow gets too slow, it might be necessary to change the mixer and special adapter.

4. Install conforming jig if required.
5. Curing time for all non-structural side panels such as baggage compartment doors or compartment doors is 6 hours. Curing time for ridged side panel is 24 hours.



CAUTION

Curing time is 24 hours in the case of ridged side panel.

- **Using Single Component Simson ISR 70-03 grey or black**

NOTE

Remove former Sika bead if you have access and adhesion is poor.

1. Heat "Simson" single cartridge (Prevost #684517) for 45 min to 1 hour in an oven.

NOTE

Heating glue up is necessary when the access is limited and a regular nozzle cannot get behind the panel; therefore the special adapter is required.



WARNING

Glue is warm and cartridge may burst or crack, it is strongly recommended to wear rubber gloves when gluing. Panels may also have sharp or cutting edges that may cause injury to the hands. To prevent contact with sharp edges it is strongly recommended to wear rubber gloves when handling panels.

2. Install special adapter onto Simson single cartridge.

NOTE

If special adapter is installed onto cartridge, the threads will be damaged and you will not be able to screw another regular nozzle on.

NOTE

Refer to figure 2 for assembling special adapter parts.



DANGER

Excessive heat may cause the cartridge to burst or crack. Do not heat cartridge up too rapidly or over the recommended temperature.



FIGURE 2

3. Apply a bead of Simson 70-03 between panel and structure in a zigzag pattern.
4. Install conforming jig if required.
5. Curing time for all non-structural side panels such as baggage compartment doors or compartment doors is 24 hours. Curing time for ridged side panel is 72 hours.



CAUTION

Curing time is 72 hours in the case of ridged side panel.

SIDE PANEL SEALING

- Protect panel sides where Loctite 5570 clear will be applied (Prevost #685252) using masking tape or plastic film.
- Cut cartridge nozzle tip to a 45° angle.

NOTE

Also cut nozzle tip to a 90° angle.

- Apply Loctite 5570 clear onto the side panel edges to seal panels.
- Push glue underneath the panel using a small spatula.

Waste disposal:

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

PART B: COMPLETE PANEL UNGLUING AND REPLACEMENT

NOTE

Remove former Sika bead.

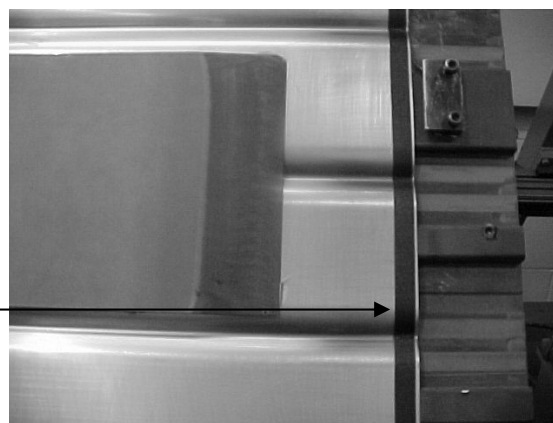
If side panel must be replaced, clean vehicle surface and new panel using anti-silicone (Refer to section A).

REPAIR USING LOCTITE 5590 DOUBLE CARTRIDGE

1. Scrape and sand vehicle structure in order to remove former glue and primer. Make sure that there is no residue onto stainless steel vehicle structure.

Apply foam tape 1/16 x 1/4 at each side panel end.
Make sure foam tape reaches bottom of creases

Install foam tape
1mm+1/-0 from
side panel edge.



2. Install triangular opening mixer (Prevost #687958) onto Loctite double cartridge.
3. Adjust "Mixpac" DP400 gun regulator to 90-100 psi, apply a triangular bead of Loctite 5590 onto panel.
4. Install panel onto structure.

5. Install conforming jig if required.
6. Curing time for all non-structural side panels such as baggage compartment doors or compartment doors is 6 hours. Curing time for ridged side panel is 24 hours.

**CAUTION**

Curing time is 24 hours in the case of ridged side panel.

Waste disposal:

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