

PREVOST

Instruction Sheet

IS-93055

FRONT ENTRANCE DOOR STAINLESS STEEL PANEL INSTALLATION ON XL VEHICLES

MATERIAL

Part No.	Description	Qty
682444	Glue, Methacrylate MA 550	1
680025	Caulking Strip	1
506225	Foam 1/4" X 1/16" thick (self-adhesive) approx. 10 ft long. Replace only if necessary	0,1
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Tools:

- Hammer
- Large Flat Screwdriver or Equivalent Prying Tool
- Vise grip
- Portable grinding wheel

PROCEDURE

Warning: Park vehicle safely, apply parking brake, stop engine and set battery disconnect switch(es) to the **OFF** position prior to working on the vehicle.

- **NO SMOKING** during isopropyl alcohol application.
- Contaminated material should be discarded as per applicable regulations (mun. / State/Prov. / Fed.).

1. Draw reference marks on door frame in order to install new plate at same location.
2. With the use of a large flat screwdriver and hammer, pry out and lift up one lower corner of plate (Fig. 1).
3. Install vise grip on lifted lower corner and tear away from door frame.

Warning: The upper side of the plate is not glued and is inserted behind fiber panel. To avoid fiber breaking, slide the plate downwards until disengaged.

4. Remove leftover glue from door frame with portable grinding wheel.
5. Wash (with isopropyl alcohol) the area of the door frame and the stainless steel plate where the glue is to be applied..

Note: If replacing upper stainless steel plate, also clean section of plate that will go underneath fiber glass section of door.

Warning: This cleaning process is absolutely necessary for the glue to stick properly. WIPE ONLY IN ONE DIRECTION, NOT TO & FROM.

6. If necessary, replace foam 1/16" X 1/4" (Prévost #506225) within door frame.

Note: If replacing both upper and lower stainless steel plates, join it together using three (3) stainless steel screws and nuts (Fig. 1).

7. Apply a 3/16" dia. line of glue (Prévost #682444) to door contour surface and on "U" shaped transversals located at the upper end of stainless steel plate.

8. Place stainless steel plate(s) over door frame and underneath fiber glass section of door; then adjust with reference marks.

Note: If replacing the upper plate only, join it together with the lower plate using three (3) stainless steel screws and nuts (Fig. 1).

9. Apply pressure to plate and structure with strips of adhesive tape (Prévost #680415) affixed in between all ribs. Ensure adequate pressure from tape installation then remove excess with a spatula.

10. Let stand for at least four (4) hours.

11. Plug rib end holes using caulking strip (Prévost #680025).

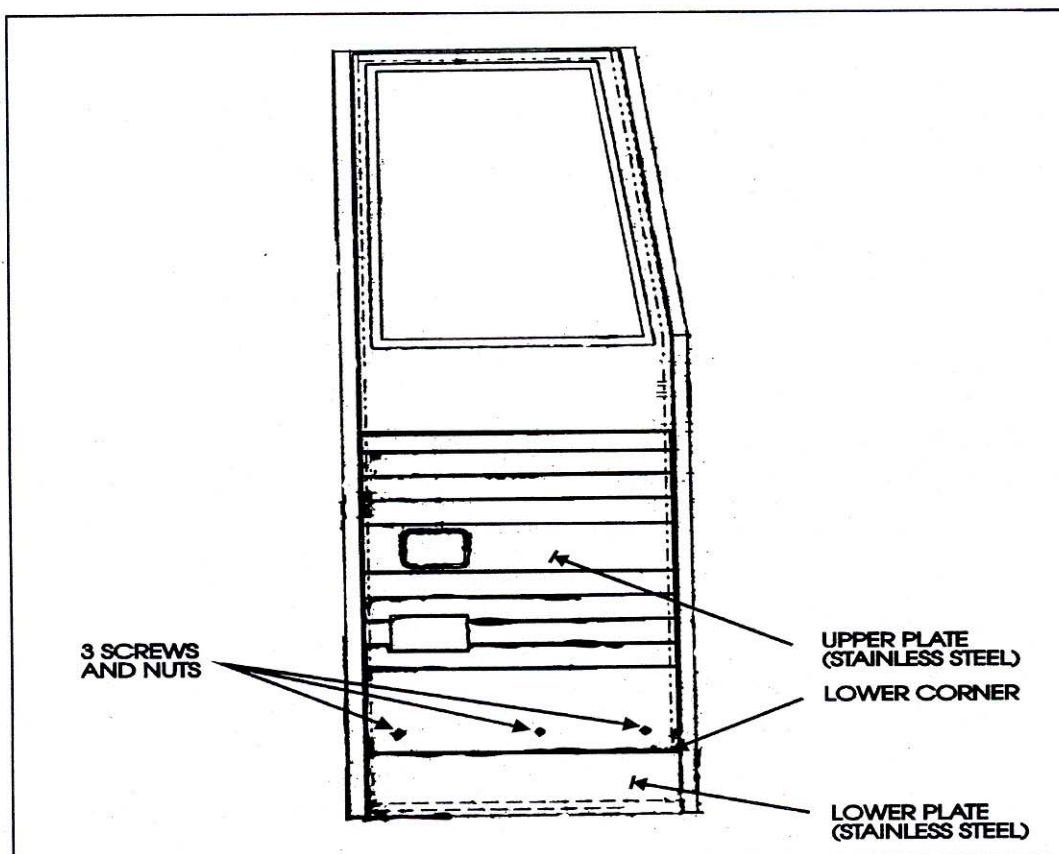


FIGURE 1: FRONT ENTRANCE DOOR ON XL VEHICLE SERIES