



MAINTENANCE INFORMATION

MI21-87A

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

Revision: A

Application box VIN update

11-24-2021

APPLICATION

Model
2018 Volvo 9700 US/CAN
From 3CET2V928 <u>K5194257</u> (2019)

DESCRIPTION

Emergency window gasket replacement.

MATERIAL

include the following parts:

Part No.	Description	Qty
23663618	3M UNIVERSAL PRIMER UV	As needed
70363904	ADHESIVE TAPE	As needed
21331618	MOLDING, EMERGENCY WINDOW (EPDM)	As needed
23242281	SIKAFLEX-271	As needed
7775262	3M WEATHERSTRIP ADHESIVE	As needed
23620744	GASKET AS RAW MATERIAL (per meter)	5.5 m per window

NOTE

Material can be obtained through regular channels.

PROCEDURE

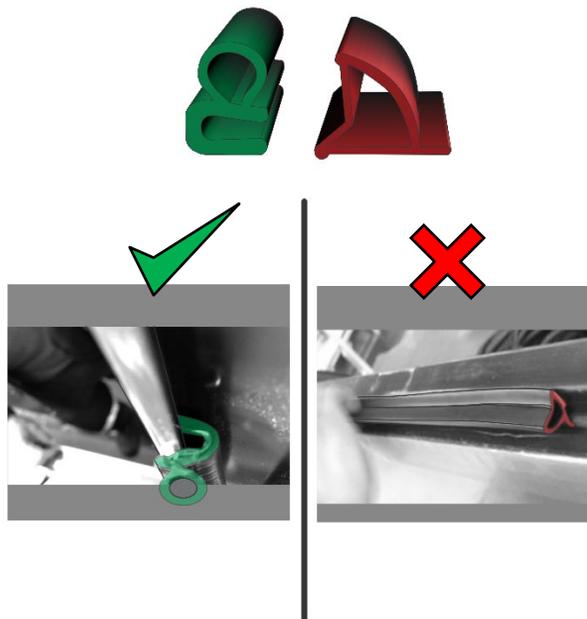


DANGER

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

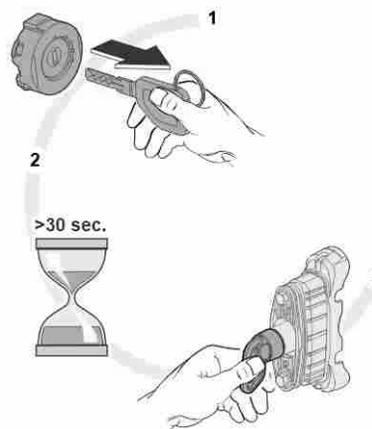
Lockout & Tag out (LOTO) must be performed during set-up, maintenance or repair activities. Refer to your local procedure for detailed information regarding the control of hazardous energy.

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

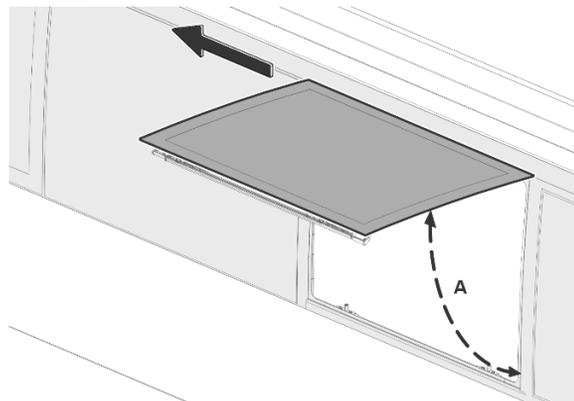


2. Make sure that the vehicle is OFF.

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. Route the **23620744** Gasket inserting it on the metal lip frame. Start at the bottom corner of the window's frame, radius at the corners as small and smooth as possible.

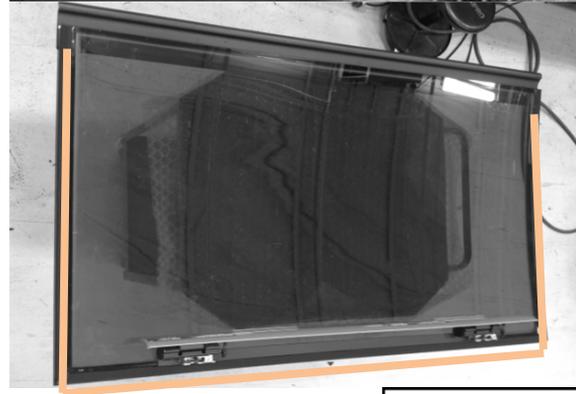


7. Glue the gasket on the bottom corner using the **08008 3M WEATHERSTRIP ADHESIVE** gasket glue.

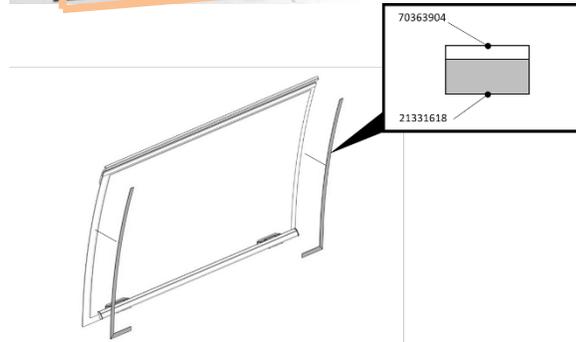


Specifications:
Curing time:
► Min: 24 hrs.

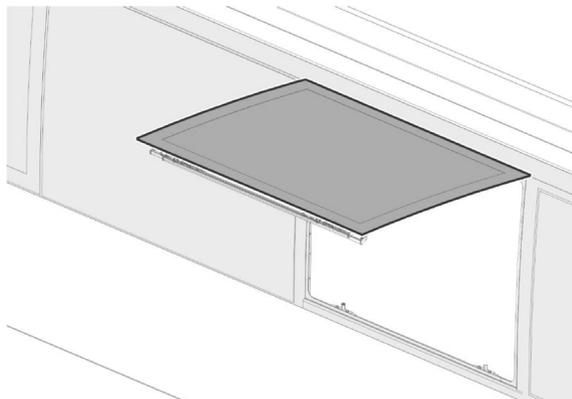
8. On the windows, clean the aluminum with isopropyl alcohol. Apply adhesion promoter **23663618 3M UNIVERSAL PRIMER** on the aluminum, wait 10-minute cure time.



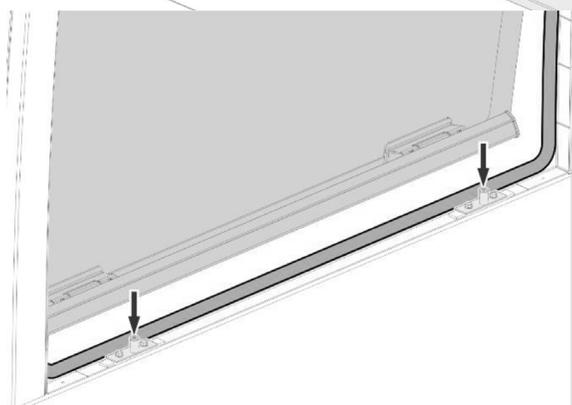
9. Measure and apply double sided **ADHESIVE TAPE 70363904**, subsequently neoprene trim **21331618 MOLDING, EMERGENCY WINDOW (EPDM)** on the sides.



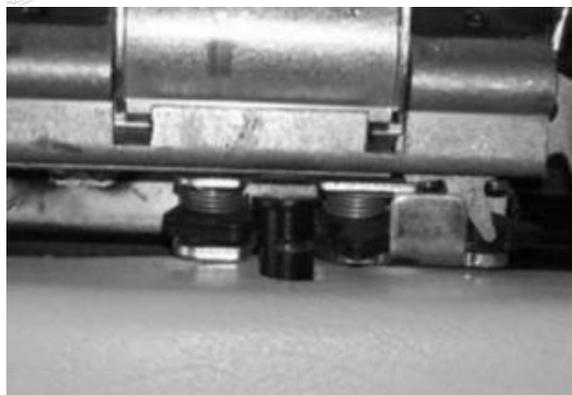
10. Install the window.



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

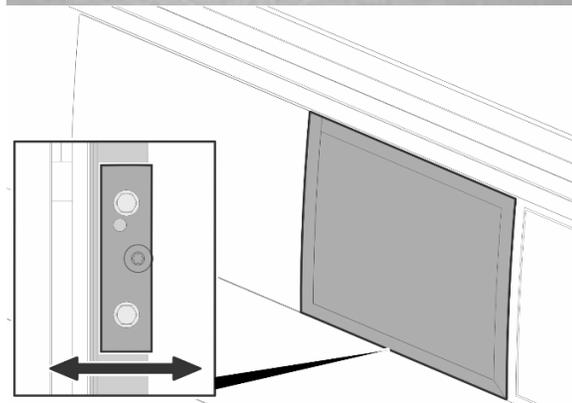


12. Adjust the lock mechanism from the inside if necessary.



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

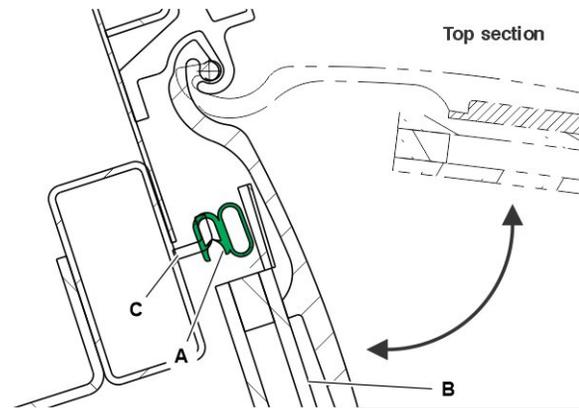
Torque: 110 ±15 Nm



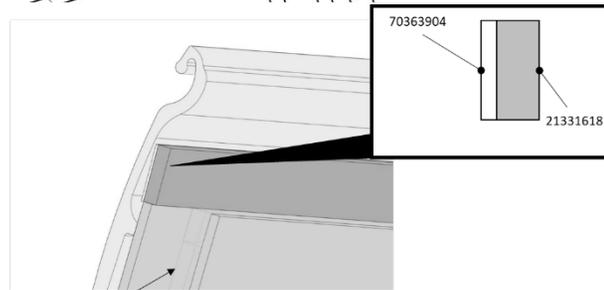
14. Check the correct seal of the window on the top.

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

The gasket should seal against the window glass.



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

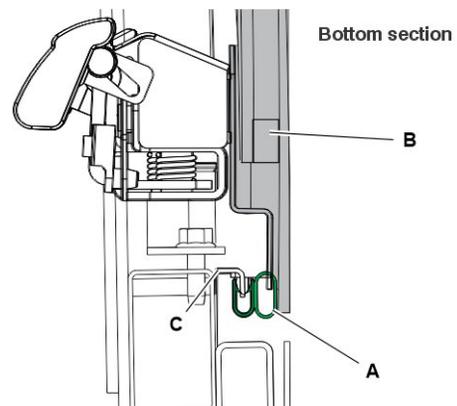


Window Glass

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

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

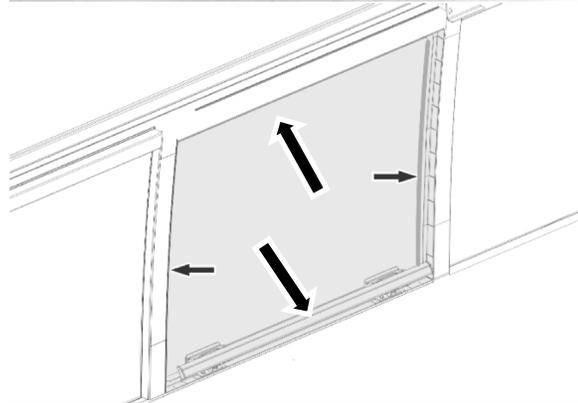
The gasket should seal against the window aluminum frame.



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

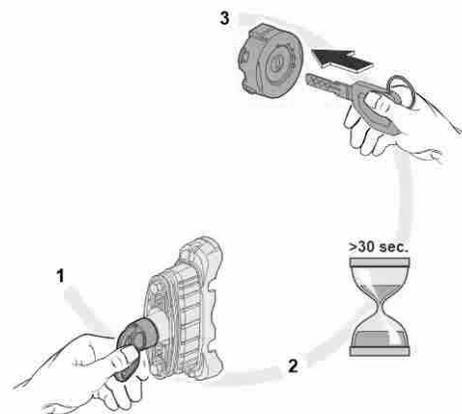


Check the correct sealing of the window, on the inside all around. If necessary, measure and install more ADHESIVE TAPE **70363904**, subsequently neoprene trim **21331618 MOLDING, EMERGENCY WINDOW (EPDM)** on the window where the seal is not achieved.



18. Turn on the vehicle.

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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)