

PREVOST

Instruction Sheet

IS-07028A

X3 COACHES PASSENGER EMERGENCY EXIT WINDOW BONDING FRAME AND RUBBER SEAL INSTALLATION

Revision A

2018-12-10

MATERIAL

Kit #294048 includes the following parts:

Part No.	Description	Qty
297267	Rubber Seal	1
299090	Bonding Frame	1
682989	Anti-silicone Standox (5 liters)	1
684743	Glue, Plexus MA 832 (490 ml)	1
680808	Mixer 10-24, 10:01 ratio	1
684685	Glue, Simson 70-03 Black (290 ml)	2
IS-07028A	Instruction Sheet	1
FI-07028A	Feuille d'instructions	1

OPTIONAL MATERIAL

Part No.	Description	Qty
680951	Gun, manual for applying Plexus MA 832 glue	A/R

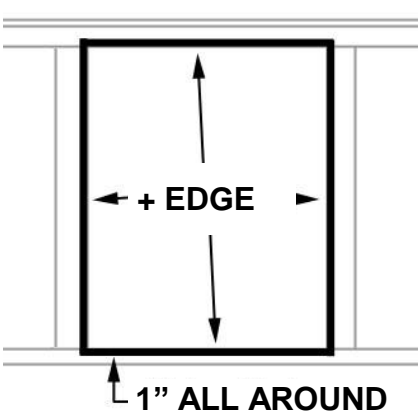
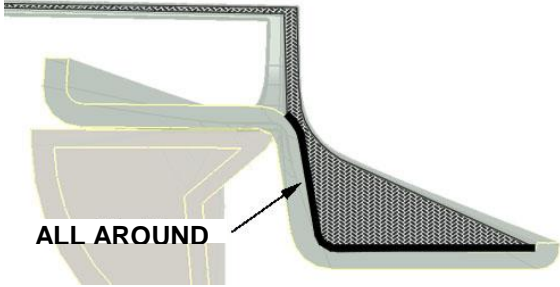
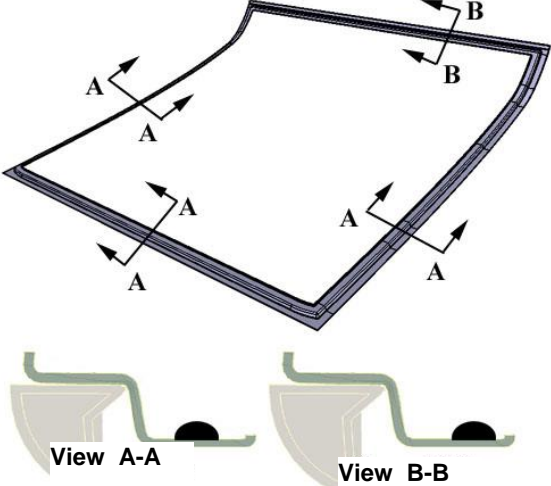
PROCEDURE

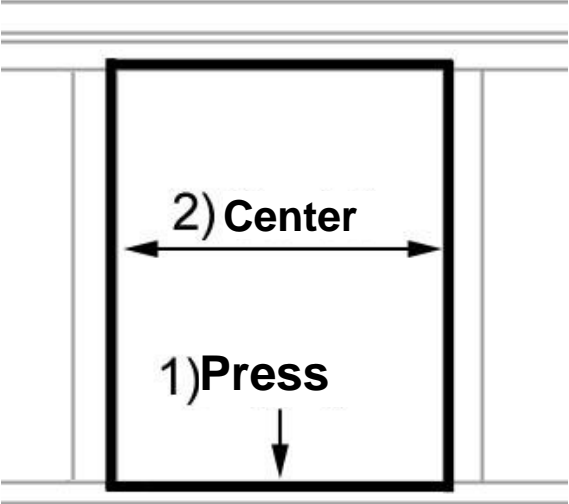
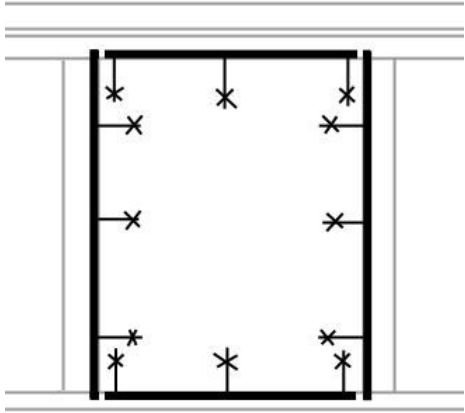
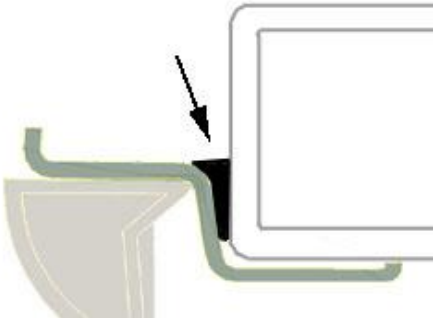


DANGER

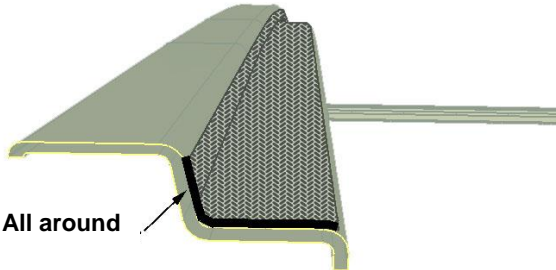
Park vehicle safely, apply parking brake, stop engine and set battery master switch(es) to the OFF position prior to working on the vehicle.

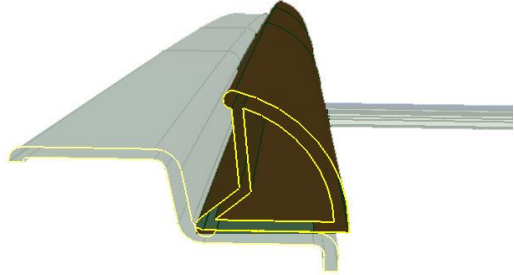
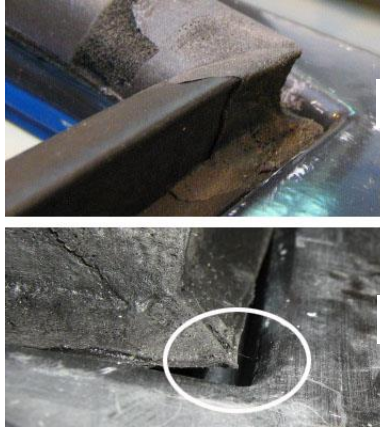
Remove all damaged rubber seal sections from structure. Remove as much glue and residue as possible using a razor scraper, belt sander or wire brush.

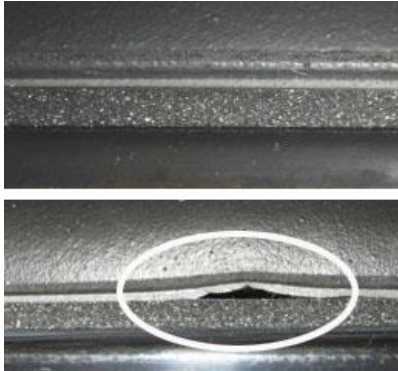
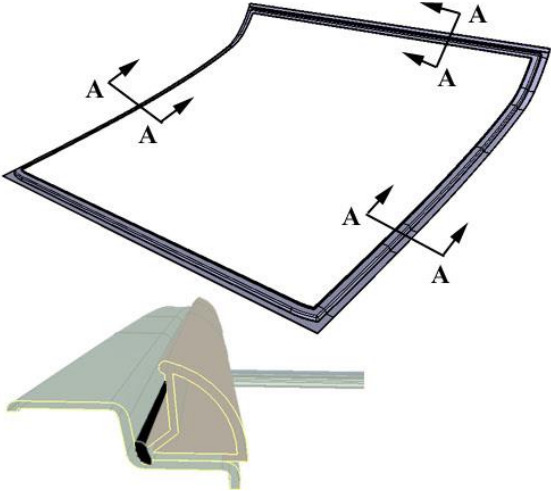
<p>1.00</p>	<p>Preparing Structure</p> <p>Clean using anti-silicone (682989).</p>	
<p>1.05</p>	<p>Preparing Bonding Frame</p> <p>Clean using anti-silicone (682989).</p>	
<p>1.15</p>	<p>Applying Glue</p> <p>Using glue gun (680951) and mixer (680808), apply Plexus glue MA 832 (684743) onto frame.</p> <p>Diameter: 6 to 8mm.</p>	

1.20 Gluing Bonding Frame		
A)	Position bonding frame onto structure Center frame into opening. Maximum difference 1.5 mm	
B)	Fix bonding frame using straight edges and clamps the time for the glue to set. Fixing time: 60 minutes minimum	
C)	Remove fixing tools	
1.25	Using a caulking gun, apply Simson glue MS-Polymer 70-03 black. (684685 – 290 ml) Smooth down with a finger. Do not use water or soap, which could damage foam tape. Make a sealed joint.	

Preparing Already Glued Bonding Frame

11	Clean using anti-silicone (682989).	
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Gluing Rubber Seal		
20	Position rubber seal onto bonding frame. "X" mark at the back onto protective film indicates top and bottom parts.	
21	Start by gluing the 4 corners (remove protective films).	
22	<p>If one corner starts to curl up after gluing, glue it onto the frame again using Loctite (680066).</p> <p>Do not apply Loctite onto double-face tape.</p> <p>*Caution, make sure not to stretch out of shape rubber seal, it should not hollow out in the corners.</p>	
23	<p>Afterwards, glue the sides. Start by the top section so as not to stretch the rubber seal in this area.</p> <p>Hint; Remove the two protective films at the same time to prevent making creases.</p>	

<p>24</p>	<p>Compress rubber seal using a roller.</p> <p>Check that rubber seal rests perfectly against bonding frame all around, compress again if needed.</p>	
<p>25</p>	<p>Using a caulking gun, apply a thin Ø4mm bead of Simson glue MS-Polymer 70-03 black.</p> <p>CAUTION: Do not apply too much for it would prevent rubber seal from working properly.</p> <p>(684685 – 290 ml),</p> <p>Smooth down with a finger. Do not use water or soap, which could damage foam tape.</p> <p>Make a sealed joint</p>	
<p>26</p>	<p>A slight overflow onto the bonding frame is allowed (not esthetically pleasing) but an overflow with lumps is not acceptable.</p>	