

## J Coach Drip Rail Rework

### **Description:**

This procedure outlines the rework to address water leaks through the drip rail  
The procedure applies to J4500 coaches.



***Read this entire procedure before beginning work.***

***Use Safe Shop Practices At All Times.***

***To avoid personal injury:***

- a. Proper Personal Protective Equipment (PPE) must be worn. Safety glasses and protective gloves are required for working with DEF Fluid.***
- b. Turn the main battery disconnect switch to the OFF position.***
- c. Ensure that both the front and the rear wheels are chocked.***
- d. Positioning the ENGINE RUN and ENGINE START switches on the engine compartment remote control box to the OFF position.***
- e. Allow enough time for components to cool down prior to working in the engine compartment.***

## 1.0 Material Requirements:

The service kit **T03-3016** contains following parts:

ITEM	PART NO.	QTY	U/M	DESCRIPTION
1	23-02-0116	0.001	OZ	Sealant Sikaflex -521 UV black
2	23-02-0015	1	EA	250ml primer-250ml container
3	19-13-0330	2	EA	Rivet-SST, 1/4 dia

T03-3010, Teroson primer, can also be used instead of 23-02-0015 primer

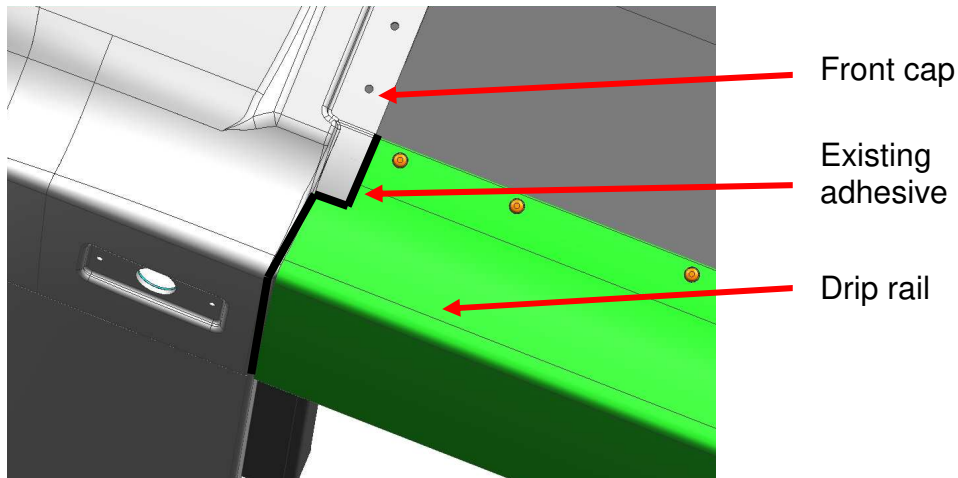
## 2.0 Special Tools:

1/4" Rivet gun

## 3.0 Rework instructions

### 3.1 Remove the existing adhesive

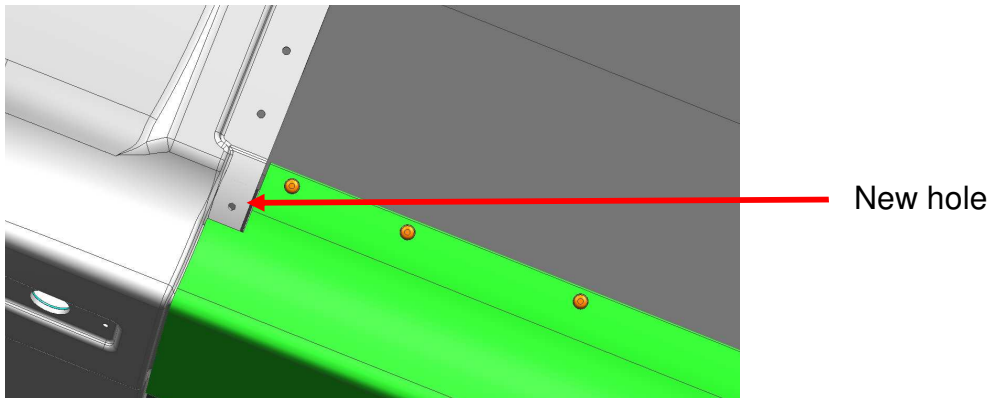
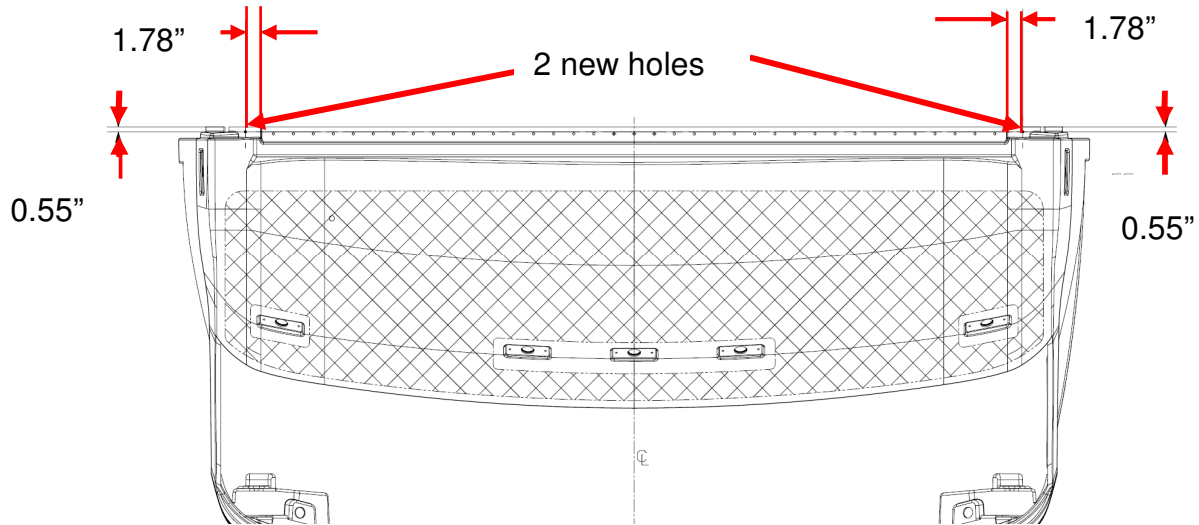
Scrape the existing adhesive between the front cap and the drip rail.



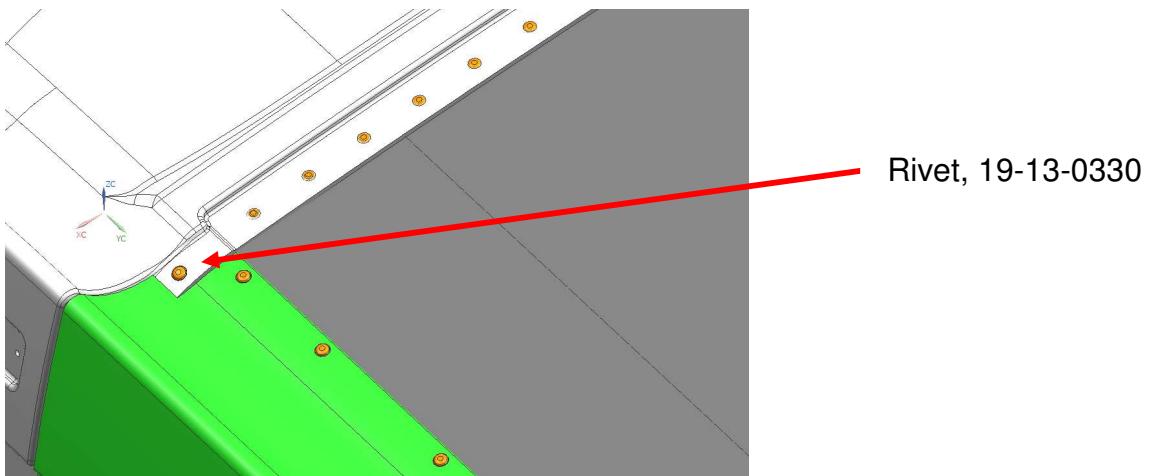
Repeat the process for the rear cap.

## 3.2 Adding a rivet

Drill a hole of 0.261- 0.276inch diameter at both ends of the front cap at below mentioned location.



Using a rivet gun, install a rivet, 19-13-0330, at each hole.



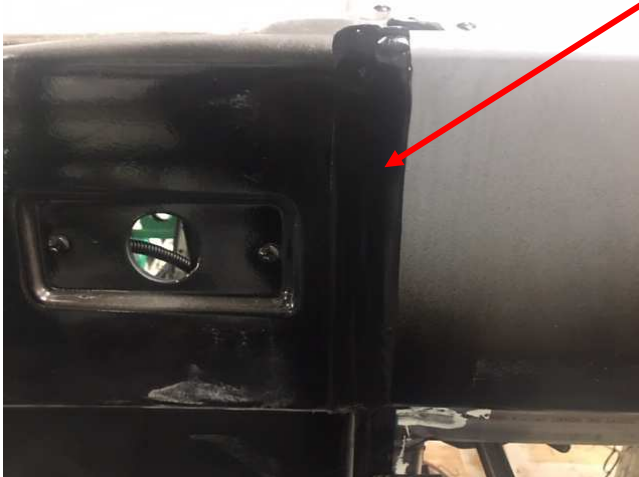
**3.3 Applying adhesive**

Clean the bonding surfaces in the front and rear of the coach with primer, 23-02-0015, and allow 20 minutes flash off time.

Then apply ½” bead of Sikaflex, 23-02-0116, on either side of the joining edge of front cap. The height of the bead should be 3/16”.



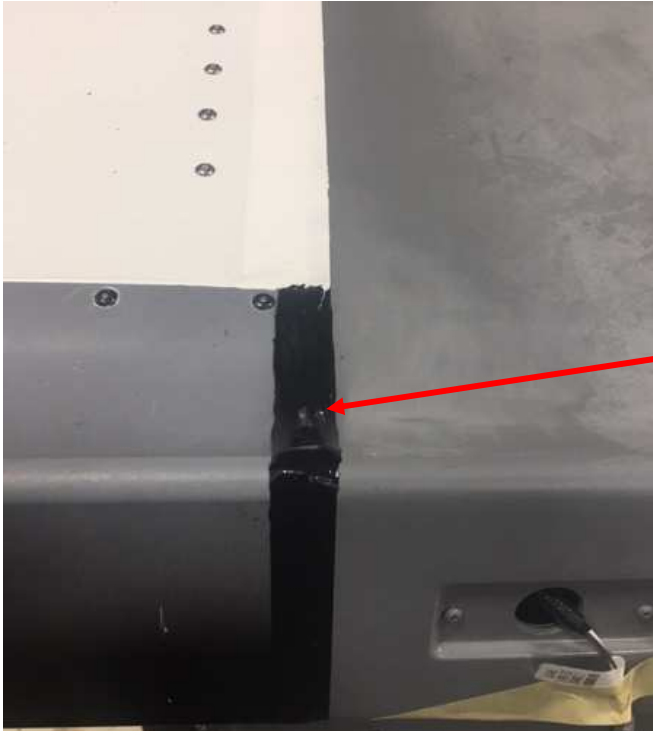
½” bead of 23-02-0116



Allow 5 minutes flash off.

## Procedure 03-265

Repeat the process for the rear cap with 1/4" bead on either side of the joining edge and 1/8" height



1/4" bead of 23-02-0116

Allow 5 minutes flash off time.

**End of the procedure**