



## **\*\*Waiting on More Info \*\*Volvo Chassis - Cab Roof Leaks, Water Intrusion At Roof Joints; Repair Instructions And Information; Supplement To FSB 812-002, Cab Roof Leak Repair - VN Models 740 And 760 ONLY, Model Year 2018 And Newer**



> **Internal Content**

The precautions and guidelines in Service Information, group 80, "General Safety Practices, Cab" must be read and understood before performing this procedure. If further training or certification is required, a supervisor should be consulted prior to proceeding with the steps below.

### **DANGER**

Do not attempt to repair or service this vehicle without having sufficient training, the correct service literature and the proper tools. Failure to follow this could make the vehicle unsafe and lead to serious personal injury or death.

### **Tools And Supplies**

<b>Tool</b>	<b>Description</b>
J-41764	Installation Rope
J-41765	Suction Cup
J-2189-32	Plastic Adjustment Knife

<b>Qty</b>	<b>Description</b>
2	Fusor® 141 Clear Bonding Adhesive
1+ (As needed)	Fusor® 803DTM Sealant (Black)
4	Fusor® 401 Cartridge Mixing Tips
1	Masking Tape

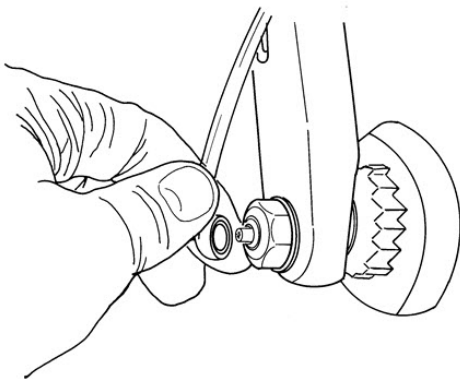
[www.lord.com](http://www.lord.com) To purchase products or for application information on the Fusor® products, call 1-877-ASK-LORD (275-5673). Also refer to the Lord Corporation website at



## WARNING

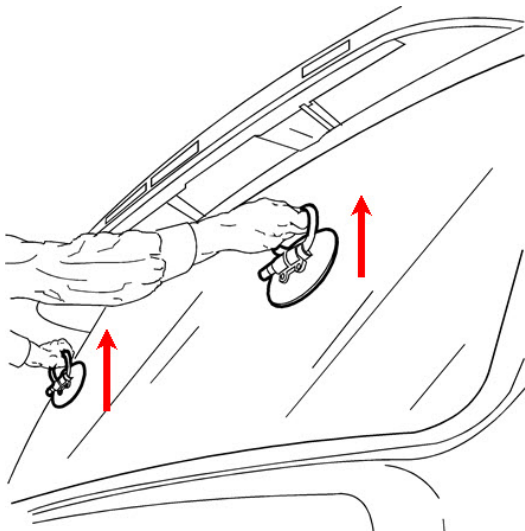
It is recommended that scaffolding or other suitable work platform be used when performing this procedure. If scaffolding or suitable substitute is not available, extreme care must be taken to ensure slippery surfaces are cleaned or avoided. Proper footwear must be used. Failure to do so may result in a fall causing serious personal injury.

1. Open the hood.
2. Remove the wiper arm retaining nut and the wiper arm.



3. Place the suction cups (J-41765) on the windshield with the handles turned up and apply suction.

- The cups should be placed above the mid-line of the windshield with the handles pointing up.



4. Start by pressing out a top corner of the windshield by putting the foot on the inside

and pressing steadily until the molding starts moving out. At the same time outside of the cab, begin working the molding loose. Push and pull the windshield the rest of the way out.

5. Remove the old molding from the windshield. Inspect it for any damage. Look for dry-rot, cracks and cuts.

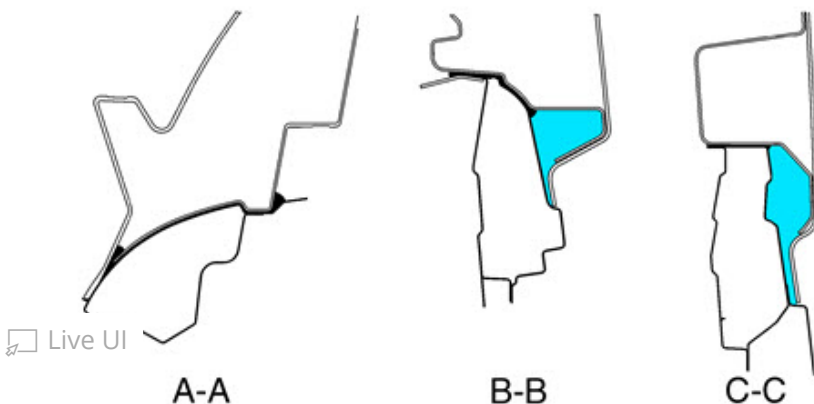
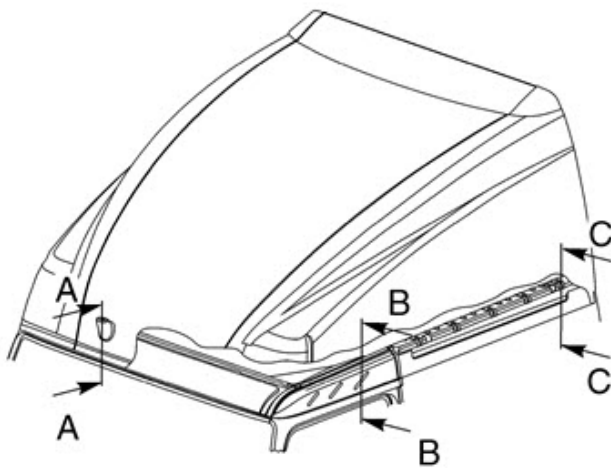
**Note:** The windshield drip molding is not a separate component, it is an integral part of the windshield molding.

- **If the molding is intact**, clean it for reuse.
- **If wear or damage is found**, replace as is necessary.

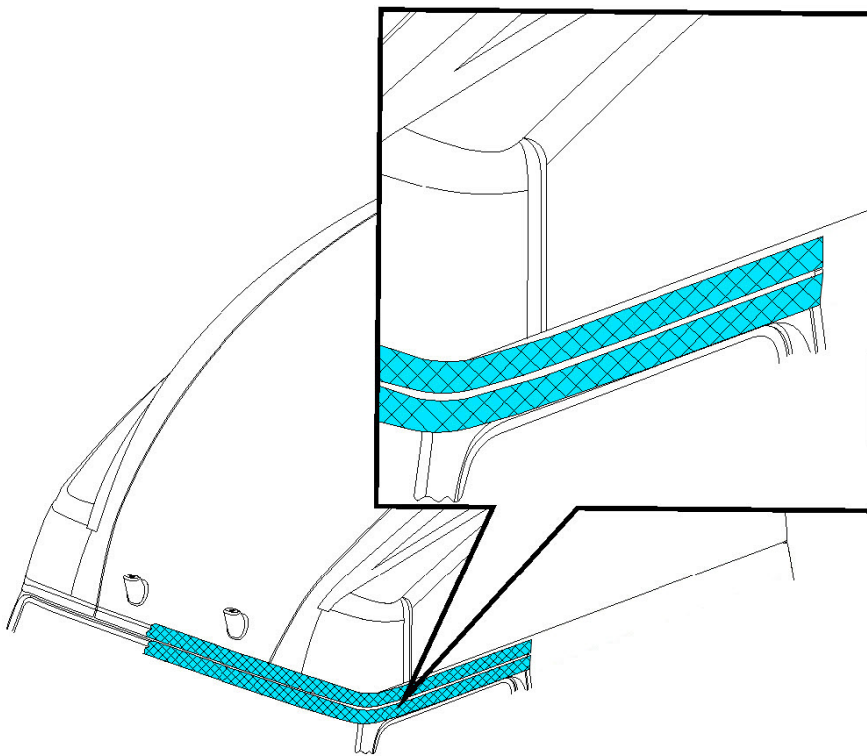
## Resealing Procedure

**Note:** All repairs require roof and cab to be at least 16° C (60° F). If necessary bring truck inside and let it warm up several hours before beginning repair.

**Note:** When the roof is installed at the factory the adhesive bonding areas are located at the upper edge on the cab structure not the lower edge of the roof, this leaves voids along both sides of the cab but not in the front or rear. When bonding the lower edge of the roof to the cab with Fusor®, **do not attempt to completely fill the void areas along the sides.** A diagram of the voids can be seen below:

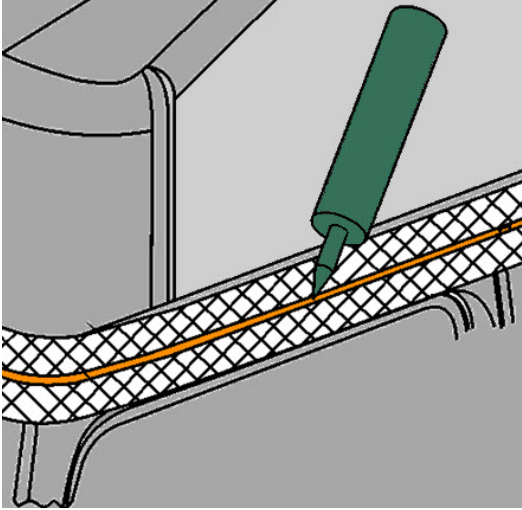


1. Disconnect all cables from the negative (ground) battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
2. Apply the parking brake.
3. Remove the external sun visor and fairing attached to the fiberglass roof.
4. Inspect the seams where the fiberglass roof is bonded together for any cracks.
5. Clean the entire joint area between the roof and the cab around the front and down both sides to the B Pillars behind driver and passenger doors. Use a damp cloth to remove any dirt, follow with an alcohol wipe and a dry cloth to remove any moisture.
6. Apply masking tape above and below the joint to keep sealant from getting on painted surfaces. Above the windshield, apply tape all the way to the rubber seal under the roof's edge. See the picture below for correct placement:



7. Using Fusor® 141 Clear Adhesive, start sealing at one B pillar, working around the perimeter to the other B pillar in one fluid motion. Make sure there are no gaps in the sealer.

- **Note:** If there is a gap at the front of the roof between the cab and the roof center panel of more than 10 mm (0.4 in). Apply Fusor® 803DTM sealer to fill the entire gap area and spread it out evenly and smoothly with a putty knife. Be careful not to let the sealant drip onto the windshield. When finished, the sealer should form a smooth black   
 between the roof and cab with no voids.

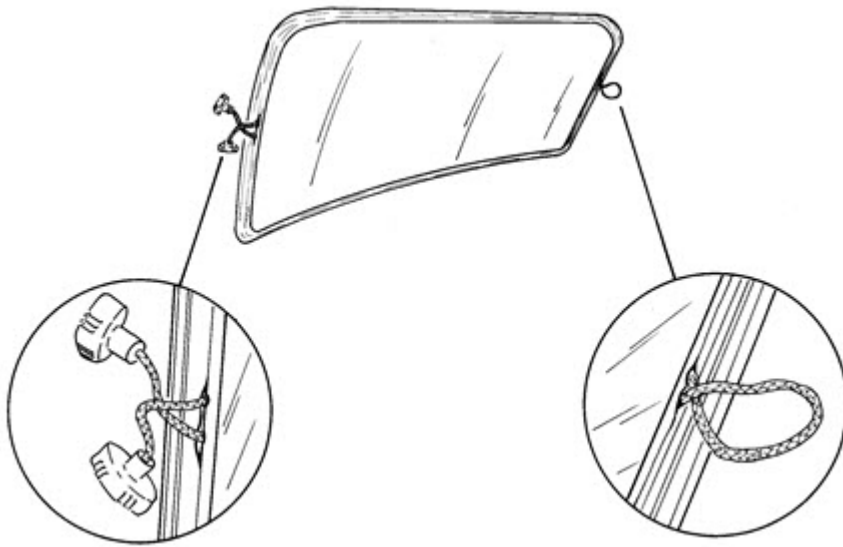


8. Remove the masking tape **as soon as the sealer application is completed.**
9. Reconnect all previously removed cables to the negative (ground) battery terminals.

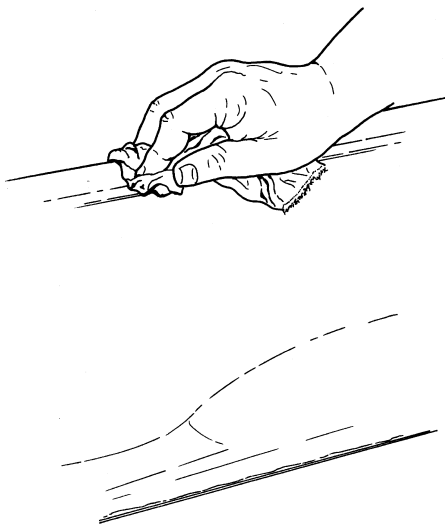
## Windshield Installation

1. Install the windshield molding onto the windshield.
2. Make a loop in one end of installation rope (J-41764) on one side of the windshield and begin inserting the rope into the groove in the molding. Continue to push the rope into the groove around the windshield until the rope ends meet at the other side. Overlap the ends as shown below.

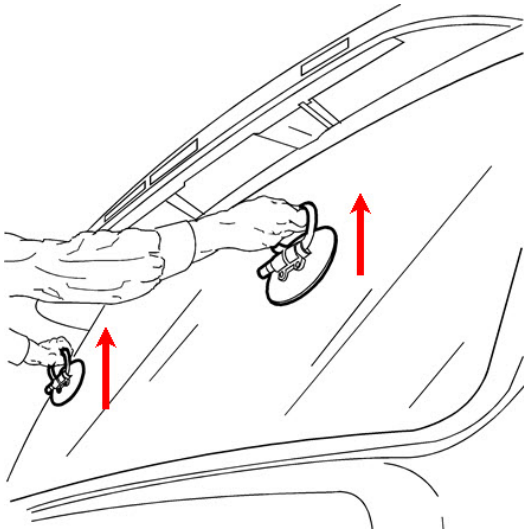
- **Note:** To help with the installation, presoak the installation rope in soapy water.



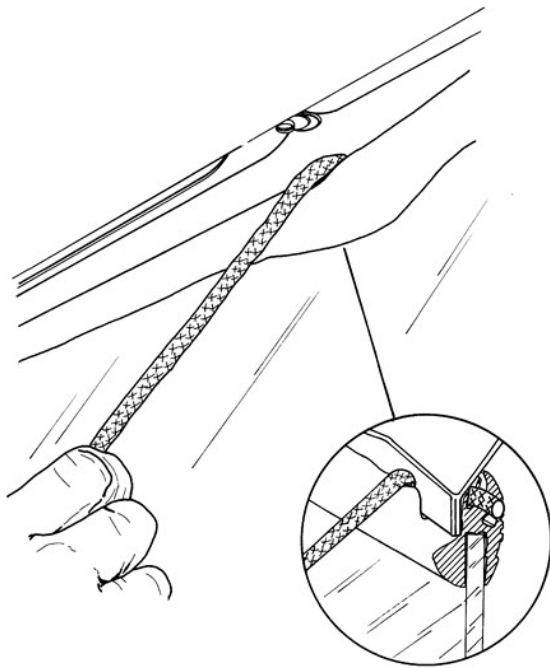
3. Clean the window opening in the cab.



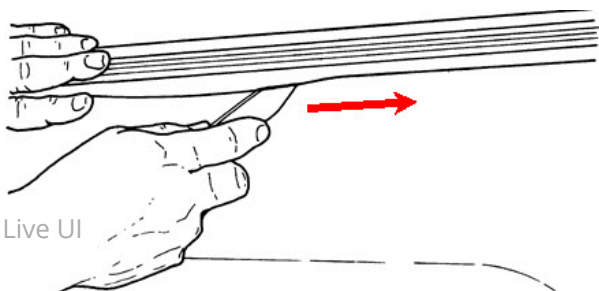
4. Place the suction cups (J-41765) on the outside of the windshield towards the outer edges and with the handles turned upward. Apply suction. Lift the windshield up into position in the window opening.



5. Press the windshield against the cab opening. From the inside, begin pulling the rope. This works the inner edge of the molding over the body flange. Start on one side, move to the other side and do top and bottom last.



6. Using the plastic knife, carefully work the outside of the rubber molding completely over the body flange.



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7. Clean the windshield.

8. Install the wiper arms.

- Tighten the wiper arm nuts to a torque of  $23 \pm 3$  Nm ( $17 \pm 2$  ft-lb). Connect the windshield washer hoses.

9. Water test and check for leaks.

- Direct a low pressure stream of water from the top of the cab so water runs in an even stream across the windshield. If any leak develops, check the seal for proper installation. If the seal is installed correctly, run a seal bead between the seal and body.



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