



Volvo Chassis - Cab Roof Leak Repair , Technical Service Bulletin V-812-002, Cab Roof Leak Repair - VN Models 740 And 760 ONLY, Model Year 2018 And Newer



> Internal Content

For more information regarding Technical Service Bulletin V-812-002 refer to [Impact](#).

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Cab Roof Leak Repair

V-812-002

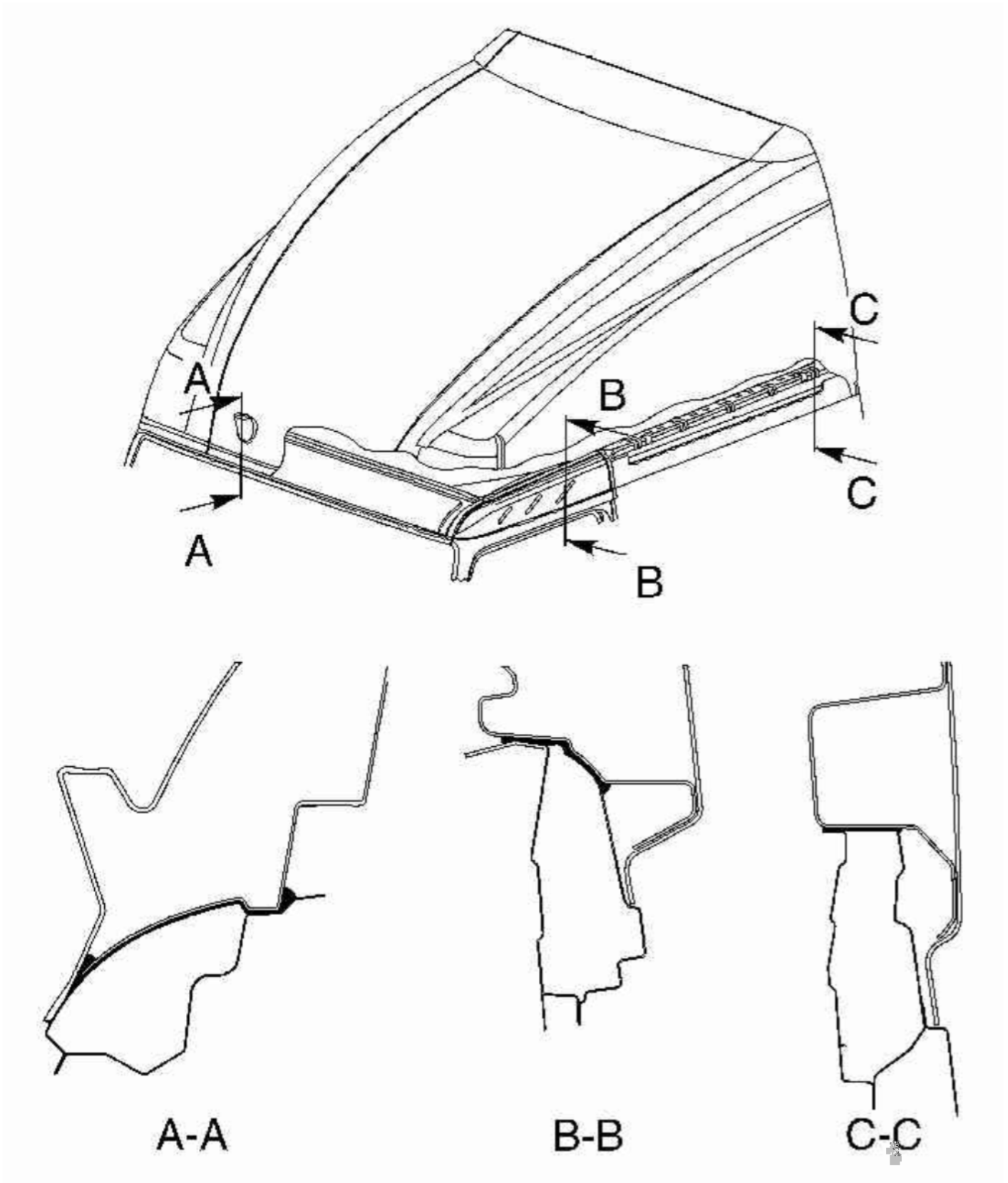
(May 2011)

Valid for

Volvo VN and VT trucks

Case description

To assist in the repair of cab to roof joint leaks the following procedure has been issued. For required parts and the instructions refer to Cab Roof Leak, Repair.



Cab Roof Adhesive Application Diagram

Note: Information is subject to change without notice.

Illustrations are used for reference only and may differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

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Parts

Description	Quantity
Mixing Tips	4
Tubes FUSOR #141	2

Note: 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 www.lord.com.

Procedure

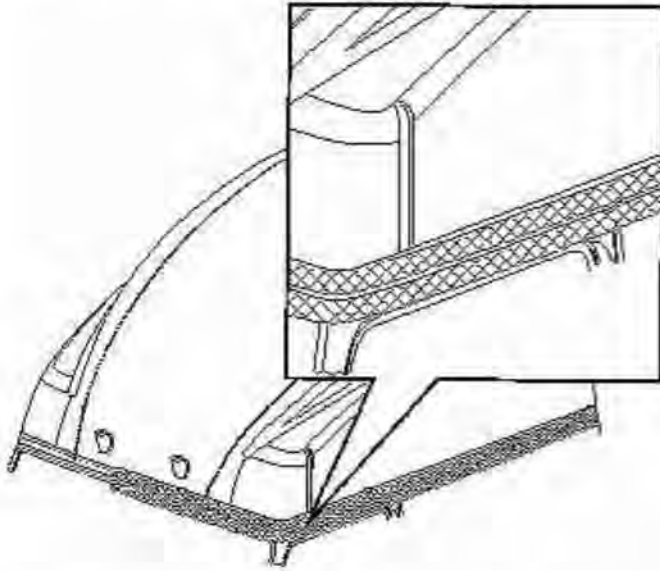
You must read and understand the precautions and guidelines in Service Information, group 80, "General Safety Practices, Cab" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.



Danger

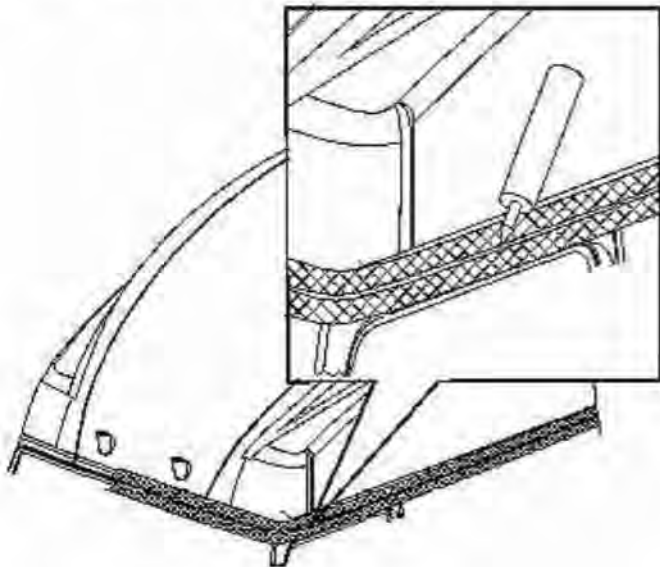
Do not attempt to repair or service this vehicle without having sufficient training, the correct service literature and the proper tools. Failure to follow this could make the vehicle unsafe and lead to serious personal injury or death.

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. 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 a void areas (see section drawings in Fig. 1) 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.
4. 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.
5. Remove the external sun visor and fairing attached to the fiberglass roof.
6. Inspect the seams where the fiberglass roof is bonded together for any cracks.
7. Clean the entire joint area between the roof and the cab around the front, rear and down both sides. Use a damp cloth to remove any dirt, follow with an alcohol wipe and a dry cloth to remove any moisture.
8. 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.



9. Using FUSOR # 141 Clear Adhesive start sealing at the corner of the cab working around the entire perimeter in one fluid motion. Make sure there are no gaps in the sealer. Along the rear of the cab fill the drip edge completely with 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 # T803 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 ledge between the roof and cab with no voids.



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

Warranty information

Reimbursement

This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	W

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Labor Code	
Primary Labor Code	81215-2-00 — 1.4 hrs.
Causal Part	N/A

Issued by

Technical Service

Volvo Trucks North America engages in a continuous program of testing and evaluating to provide the best possible product. Volvo Trucks North America however, is not committed to, or liable for updating existing chassis.