



Service instruction: SM038E  
Revision: 1  
Date: 04-06-2014  
Page no.: 1

**Title: Construction of a PS door frame box spare kit**

**1. Purpose:**

The purpose of this service instruction is to describe the construction of a new PS door frame for replacement of an existing one.

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1	04-06-2014	Description of the change:	First release
		Name & function:	K. Slager Technical Documentation Specialist

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**2. References:**

- 2.1. ISO 9001 (2008) §7.5.1 Control of production and service provision

**3. Definitions:**

- 3.1. None

**4. Forms:**

- 4.1. None

**5. Scope:**

- 5.1. This service instruction applies to the VA1798 "Box spare P480" replacement kit for a left PS door frame (part no. P480) and the VA1803 "Box spare P481" replacement for a right PS door frame (Part no. P481).

**6. Material/Tools:**

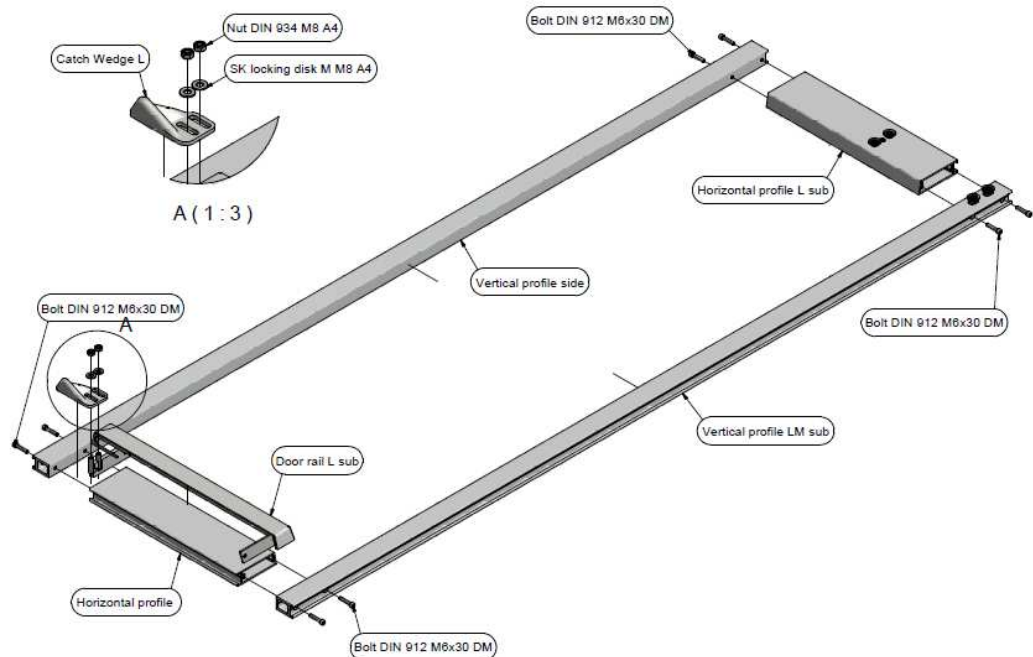
- 6.1. Torque wrench (3/8 in. Adjusted to 12Nm)
- 6.2. Hex bit socket 5mm (3/8 in.)
- 6.3. Allen key 6mm
- 6.4. Ty-rap 3.6x140 (metric)
- 6.5. Plastic hammer

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**7. Execution:**

**(This instruction shows a left door leaf situation, the right door leaf is mirrored)**

- 7.1. Lay down the two vertical profiles, top “Horizontal profile (L or R) sub”, “Horizontal profile” and the “Door rail (L or R) Sub” as shown in the following picture:



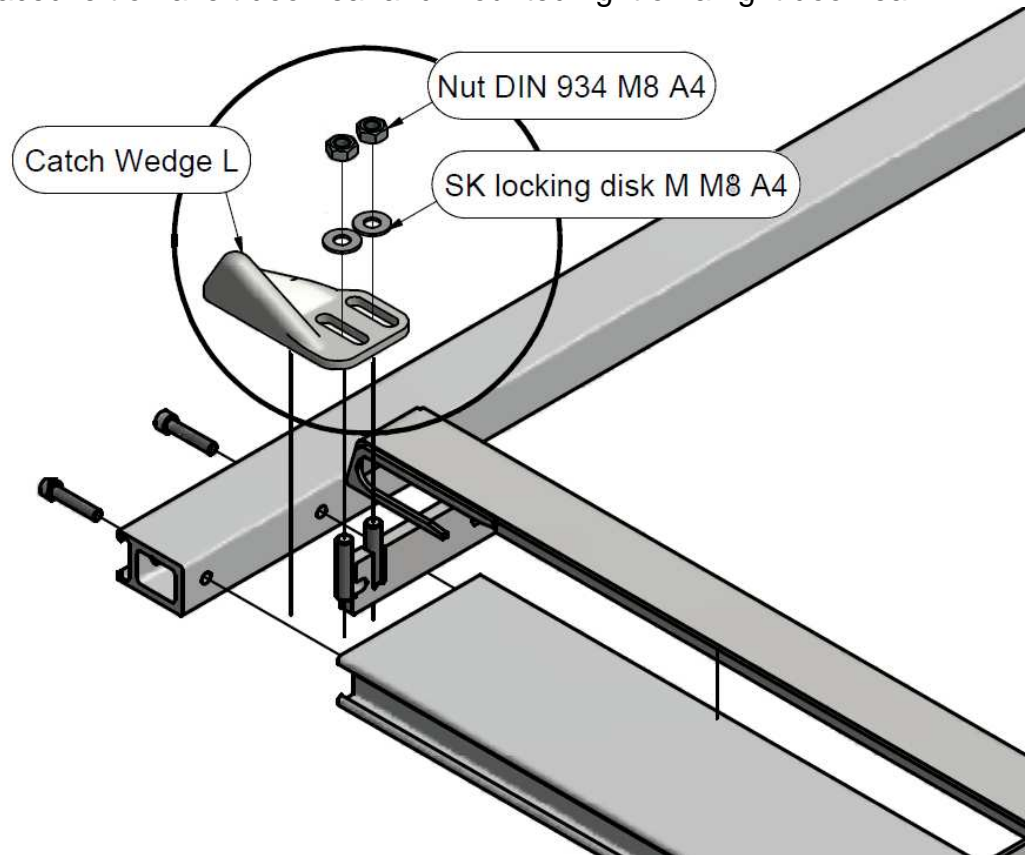
*The picture shows a frame of a left door leaf, the right door leaf is mirrored.*

*Note: The two vertical profiles are not identical.*

- 7.2. Bolt the vertical profiles to the top horizontal profile using M6x30 bolts provided in the mounting kit bag with small material. Also bolt the vertical profiles to the bottom “Horizontal profile”. Make sure the “Door rail (L or R) sub” sides are between the vertical profiles. All M6 bolts for bolting the frame together should be tightened at 12Nm.

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- 7.3. Mount the "Catch Wedge (L or R)" using an M8 nut and an SK Locking disk M8 provided in the mounting kit bag. The catch wedge should be placed left on a left door leaf and mounted right on a right door leaf.



- 7.4. Install the glass onto the door leaf frame (See *Ventura Document No. SM035E latest revision*).
- 7.5. Mount the side seal onto the door frame (See *Ventura Document No. SM014E latest revision*).
- 7.6. Connect the "Cable loom adapter" provided in the mounting kit bag to the socket of the sensitive edge. Ty the cable loom adapter to the wire of the sensitive edge using a ty-rap (3.6x140mm).