



Title: Corner repair door rubber

1. Purpose:

This work instruction describes how to repair the corners of the mid. rubber on the U-Rubber.

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 work instruction can be applied on all Ventura doors with mid-rubber + U-rubber.

6. Materials/Tools:

- 6.1. Knife
- 6.2. Sandpaper
- 6.3. Lint-free cloth
- 6.4. Loctite 406 Glue
- 6.5. Loctite 770 Primer
- 6.6. Loctite 7063 Cleaner
- 6.7. Simson Cleaner I
- 6.8. Simson STR 360 + Kit gun

Revision no.	Date:		
1	12-12-2011	Description of the change:	First release
		Name & function:	Menno Coehoorn Service Engineer

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7. Execution:

- 7.1. Clean both sides of the rubber and remove the old glue residues with sandpaper as shown on below pictures.



Cleaning rubber with sandpaper



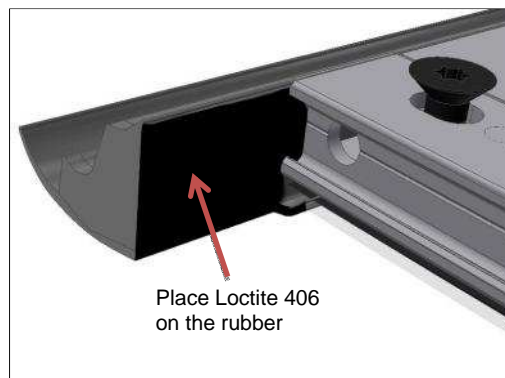
- 7.2. Clean the rubber with Loctite cleaner 7063.

- 7.3. Use Loctite primer 770 and a lint-free cloth to primer both sides of the rubbers. Do this in one single movement (don't rub).



Primer the rubber with Loctite primer 770

- 7.4. Use the tip of the knife to place the Loctite glue 406 on the rubber. First glue the corner of the rubber (red part). Then push the 2 sides together and wait a view seconds till the rubbers are glued. Now glue the blue part the same way.



Loctite glue 406



Glue the corner

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- 7.5. Turn the door around and glue the backside.



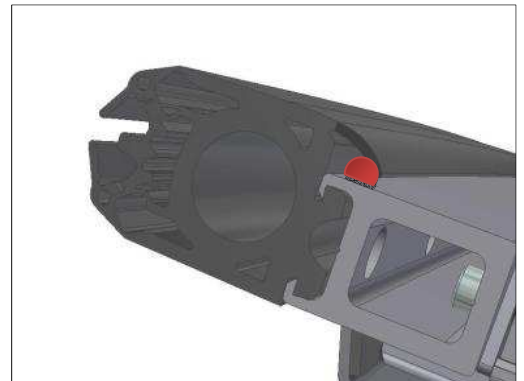
Glue back side

- 7.6. Use Simon Cleaner I to clean the glass and the rubber flap.



Cleaning before sealing

- 7.7. Place on both sides 10cm Simson STR 360 between the rubber and the glass to ensure that the rubber will not move.



Placing Simson STR 360

- 7.8. Push the edge of the rubber on the glass so the excess sealant comes out.
Remove the excess sealant. The Simson STR360 needs to dry for 2 hours.