

Title: Replacing of a sensitive edge

1. Purpose:

The purpose of this service instruction is to describe the replacement of a sensitive edge.

2. References:

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

3. Definitions:

- 3.1. None

4. Applicable for:

- 4.1. All doors with a sensible edge.

5. Tools:

- 5.1. Cloth
- 5.2. Knife
- 5.3. Lubricant (sort of soap)
- 5.4. Brush
- 5.5. Sandpaper
- 5.6. Draw wire

6. Needed parts:

- 6.1. Sensitive edge
- 6.2. Loctite 7063 super cleaner or equivalent
- 6.3. Loctite 406
- 6.4. Loctite 770 primer

Revision no.	Date:	Description of the change:	Name & function:		
3	13-10-2011	Added §6.4 Loctite 770 primer, and added a remark about the application of the primer to §7.1.2 and §7.2.2.	<table border="0" style="width: 100%;"> <tr> <td style="width: 50%;">Hidde Leeuwendal</td> <td style="width: 50%; text-align: right;">Project Engineer</td> </tr> </table>	Hidde Leeuwendal	Project Engineer
Hidde Leeuwendal	Project Engineer				
2	04-07-2011	Made a distinction between rubbers with glued corners and rubbers with vulcanized corners.	<table border="0" style="width: 100%;"> <tr> <td style="width: 50%;">Hidde Leeuwendal</td> <td style="width: 50%; text-align: right;">Project Engineer</td> </tr> </table>	Hidde Leeuwendal	Project Engineer
Hidde Leeuwendal	Project Engineer				
1	19-12-2007				

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7. Execution:

7.1. Rubber with glued corners

7.1.1. Disassemble the sensitive edge

- Loosen the bolts of the door arms to remove the door wings and disconnect the connector (see figure 1 and 2).
- The sensitive edge is installed in the mid. seal of the door wing (see figure 3).
- Make the incision between the upper door seal and the mid. door seal (see figure 3).
- Loose the wires of the sensitive edge out of the connector.
- Remove the sensitive edge (see figure 4).

7.1.2. Mounting the sensitive edge rubber

- Put the sensitive in the mid. seal of the door wing (see figure 4).
- Mount the wires of the sensitive edge according scheme enclosed in appendix "Electricity" of the installation manual.
- Make the surfaces (door seals which should be glued together) rough with sandpaper.
- Clean the surfaces with Loctite 7063 super cleaner (or equivalent) with help of a cloth.
- Apply primer (Loctite 770) on the area's that will be glued.
- Apply glue (Loctite406) to the face of the mid. door seal and press the parts together (see figure 3).
- Link the connector and mount the door wing.



Figure 1

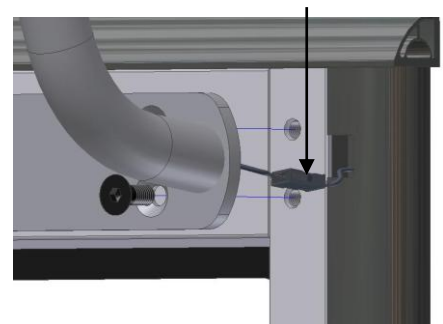


Figure 2

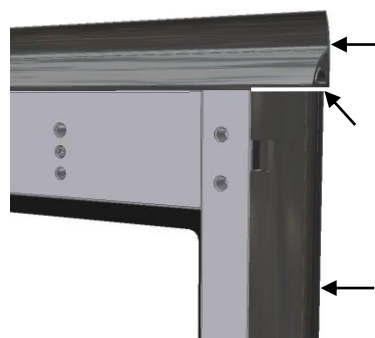


Figure 3

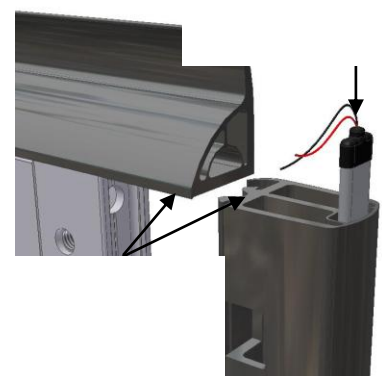


Figure 4

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7.2. Rubber with vulcanized corners

7.2.1. Disassemble the sensitive edge

- Loosen the bolts of the door arms to remove the door wings and disconnect the connector (see figure 5 and 6).
- Make the incision only on the backside (inside of the vehicle) between the upper door seal and the mid. door seal (see figure 7).
- The sensitive edge is installed in the mid. seal of the door wing. The cable of the sensitive edge is glued on the top of the mid. door seal (see figure 7).
- Pull the sensitive edge cable loose from the mid. door seal. If it's possible don't remove the connector of the sensitive edge.
- Remove the sensitive edge (see figure 9).

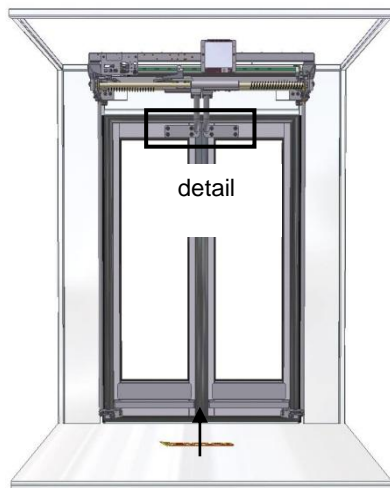


Figure 5

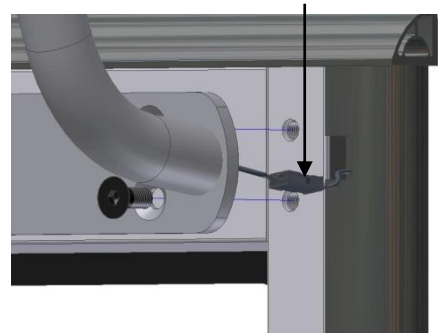


Figure 6 (detail)

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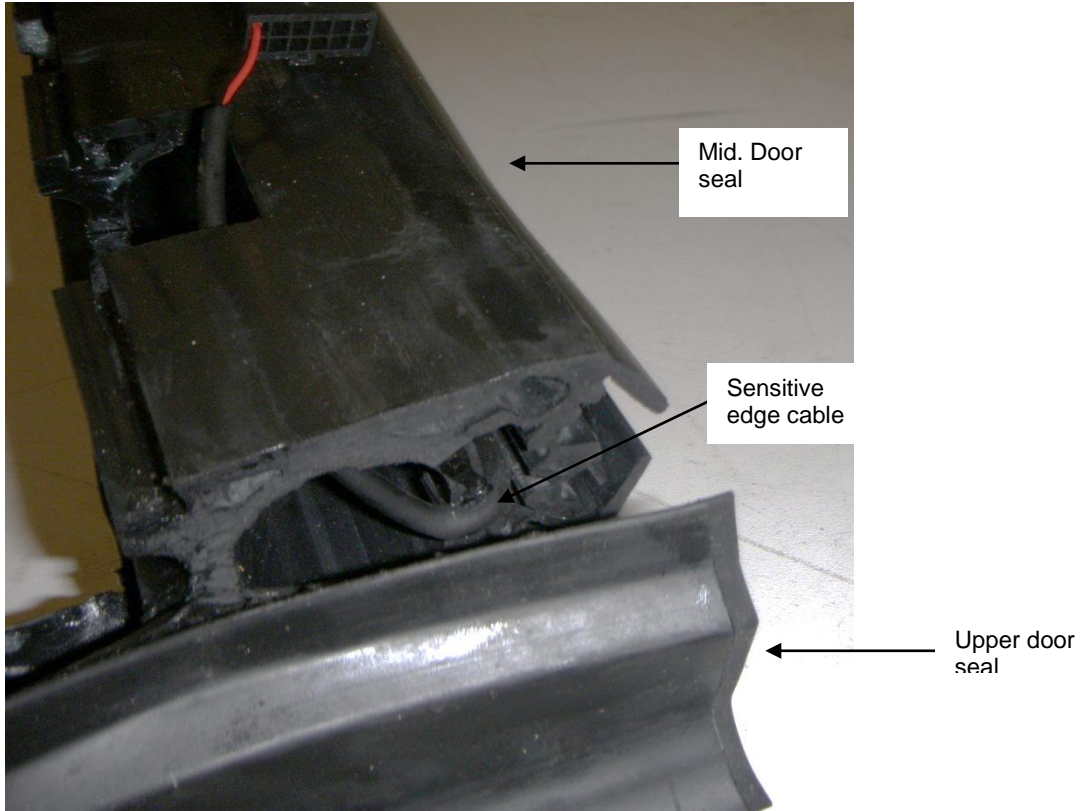


Figure 7



Figure 8

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Figure 9

7.2.2. Mounting the sensitive edge rubber

- Put the sensitive in the mid. seal of the door wing (see figure 9).
- To put the sensitive edge in de mid. Seal use soap or use air gun to blow pressure in the chamber for the sensitive edge.
- If this doesn't work you can use a draw wire to pull the sensitive edge in the rubber.
- Mount the wires of the sensitive edge according scheme enclosed in appendix "Electricity" of the installation manual.
- Make the surfaces (door seals which should be glued together) rough with sandpaper.
- Clean the surfaces with Loctite 7063 super cleaner (or equivalent) with help of a cloth.
- Apply primer (Loctite 770) on the area's that will be glued.
- Apply glue (Loctite406) to the face of the mid. door seal and press the parts together (see figure 7).
- Link the connector and mount the door wing.