Interior - Door Panel Insert Loose

S60/C70/S70/V70 (-00)/V70 (01-)/V70 XC (01-)/XC70 1998-
Section 8

Group 85

No. 0027

Year 03

Month 05

Door panel, bonding adjustment

Background
This service bulletin describes how adhesive bonding can be applied when the door panel insert has become loose.
The method applies to all panels with bonded inserts. Only one type of panel and one example of bonding are illustrated.

Material

<table>
<thead>
<tr>
<th>Description</th>
<th>Quantity</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hot adhesive</td>
<td>1</td>
<td>116 1656</td>
</tr>
</tbody>
</table>

Special tools

<table>
<thead>
<tr>
<th>Description</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hot glue gun 110V</td>
<td>951 2847</td>
</tr>
</tbody>
</table>

Upholstery for the door, wall/side, parcel shelf
Door panel, bonding adjustment

Remove the door panel 1

Remove the door panel according to the method in VADIS, function group 83.
Application of the adhesive

Apply adhesive to the mating surface of the door panel and the panel insert in the places where the insert has come loose.
Bonding the panel insert into place

Position protection over the door panel upholstery where the bonding is to be applied. Press the door panel and the panel insert together using a G clamp or similar while the adhesive cures.

Note! The hardening time for the door panel glue is 6 minutes at room temperature.

Adhesive reinforcement

Apply more adhesive to the loose section so that the adhesive grips around the panel insert.

Installing the door panel

Remove the clamp used during curing.
Check that the panel insert is secure.
Check that there is no damage to the door panel upholstery.
Install the door panel according to the method in VADIS, function group 83.
WARRANTY STATEMENT:
Claims may be submitted under the New Car Warranty when there is a documented customer complaint, using claim type 01.

<table>
<thead>
<tr>
<th>Operation No.</th>
<th>Labor description</th>
<th>Time allowance</th>
</tr>
</thead>
<tbody>
<tr>
<td>85962-2</td>
<td>Door trim panel 1 pcs gluing</td>
<td></td>
</tr>
<tr>
<td>85962-2</td>
<td>S70, V70 (~00)</td>
<td>0.4 hr</td>
</tr>
<tr>
<td>85962-2</td>
<td>S70, V70 (01--)</td>
<td>0.5 hr</td>
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