

## 2001 Volvo V70 XC AWD L5-2.4L Turbo VIN 58 B5244T3

### **Interior - Door Panel Insert Loose**

S60/C70/S70/V70 (-00)/V70 (01-)/V70 XC (01-)/XC70 1998-  
Section8

Group85

No.  
0027

Year03

Month05

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

Description	Quantity	Part No.
Hot adhesive	1	116 1656

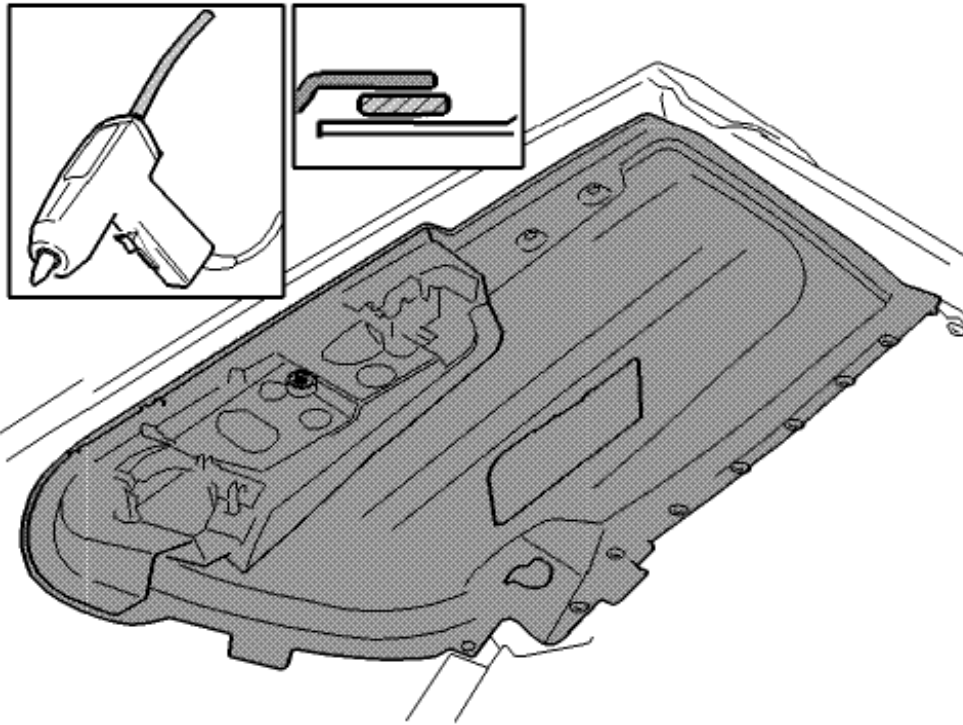
#### Special tools

Description	Part No.
Hot glue gun 110V	951 2847

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.

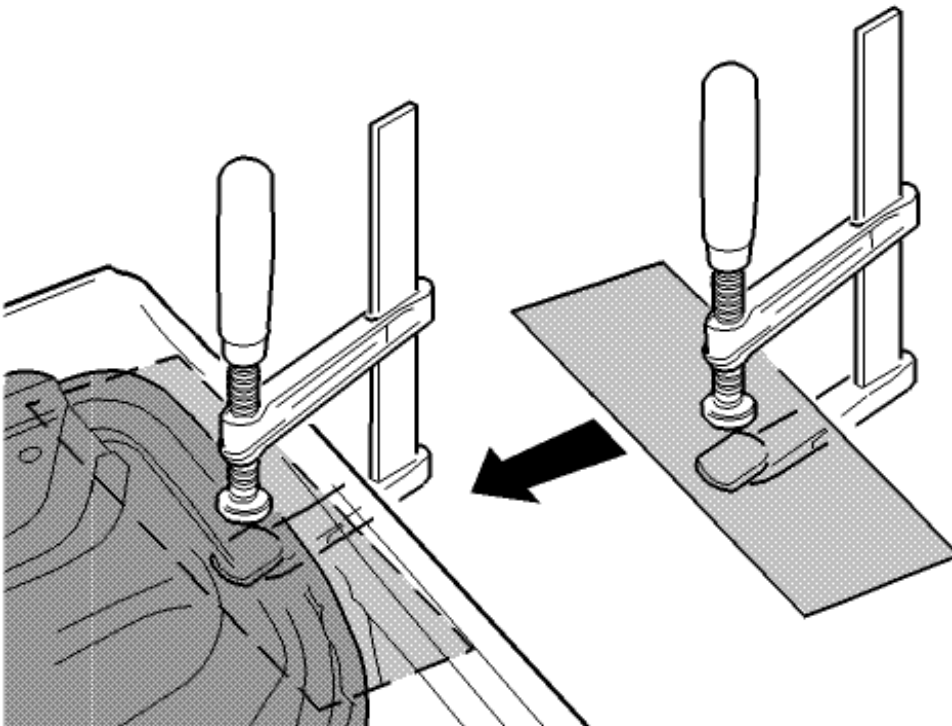


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## Application of the adhesive

2

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



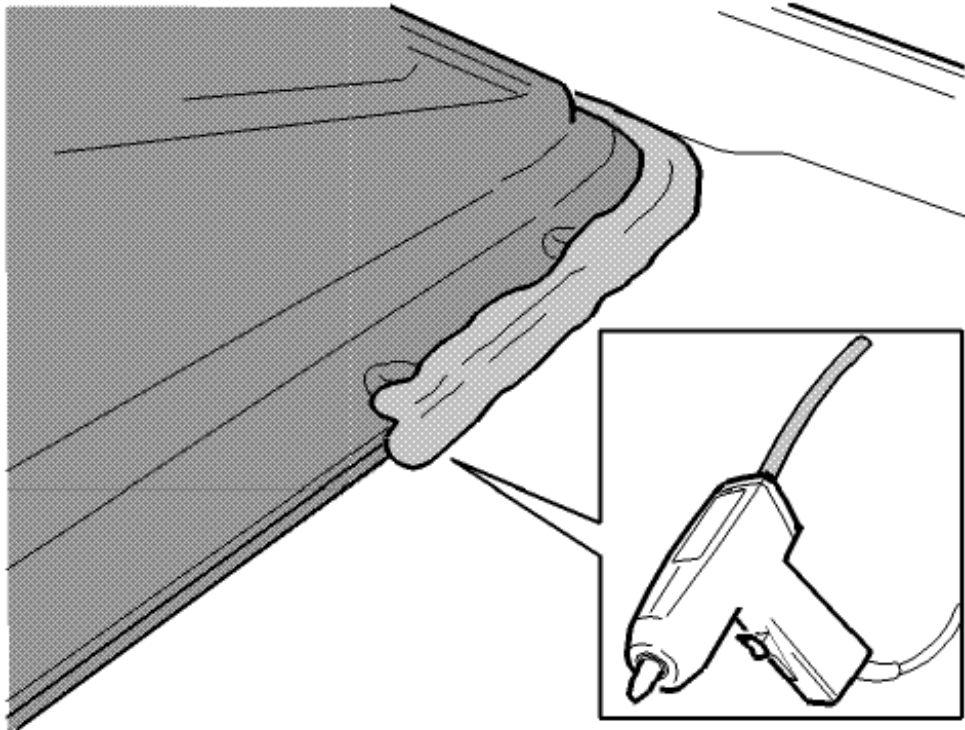
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### Bonding the panel insert into place

3

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.



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### Adhesive reinforcement

4

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

### Installing the door panel

5

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.

<b>Operation No.</b>	<b>Labor description</b>	<b>Time allowance</b>
85962-2	Door trim panel 1 pcs gluing	
85962-2	S70, V70 (-00)	0.4 hr
85962-2	S70, V70 (01-)	0.5 hr

**WARRANTY STATEMENT:**

Claims may be submitted under the New Car Warranty when there is a documented customer complaint, using claim type 01.