



V8 XJ Series/XK8

DATE 04/00

417-03

SERVICE

TECHNICAL BULLETIN

Loose Mounting – Center High Mounted Stop Lamp – Repair Procedure

MODEL

1997 MY-ON XK8 Coupe
1998 MY-ON V8 XJ Series

VIN

001001-ON
812256-ON**Issue:**

Some XK8 and V8 XJ Series vehicles may experience a detached mounting boss for the high-mounted stop lamp assembly. This bulletin provides a repair procedure for reattaching the mounting boss using the specified adhesive.

Action:

Perform the following procedure after the vehicle has been stabilized at normal workshop temperature. The temperature of the glass during the repair and during the curing of the adhesive should be at least 16°C (60°F). Working at a somewhat higher temperature is preferable and will speed the rate of curing.

1. Spread plastic sheeting or non-absorbent cloths over the rear shelf and rear seats to protect against any spillage of adhesive materials.
2. Recover the detached mounting boss. Examine the other mounting boss to determine whether it remains securely attached.
3. Remove the residue of old adhesive tape from the mounting boss and glass. If scraping is required to remove tape from the glass, moisten the tape with denatured alcohol. Use a plastic scraper - unlike a metallic scraper it should not scratch the glass.
4. Clean the boss, and the glass in the location for the mounting boss, with denatured alcohol and allow both to dry.
5. Position the mounting boss correctly on the glass. Mark out the location for the boss on the glass, using strips of masking tape. If necessary, take measurements from a similar vehicle.
6. Position the tape strips so that they closely surround the space occupied by the boss. Any excess adhesive which may become squeezed out from under the boss in subsequent steps will then become spread on the tape, to be more easily removed.
7. Apply 'PERMABOND' F Grade 5 Initiator SPARINGLY to the glass in the area of the mounting location, using the brush supplied in the kit. The Initiator will remain moist.
8. Apply a vertical bead of 'PERMABOND' F.246 Adhesive to the center of the boss, for approximately 2/3 of the height of the boss. Do not apply adhesive right to the top or bottom edges.
Do NOT attempt to spread the adhesive.
9. Immediately position the mounting boss, ensuring that it is correctly positioned and aligned, and press it to the glass, thus spreading the bead of adhesive. Hold it steady for 1 minute, while initial bonding takes place.
10. The adhesive will partially cure in 5 - 15 minutes, depending on the ambient temperature.

Any excess adhesive may then be cleaned away by first using the plastic scraper, and then peeling away the surrounding tape strips.

11. **Wait a minimum of 24 hours, to allow full curing of the adhesive before reinstalling the stop lamp onto the bosses. The vehicle should remain in as warm an atmosphere as possible for the whole of this period.**

When the stop lamp is installed, it exerts tension on the bosses. Unless the full 24 hour curing time is allowed before reinstalling the lamp assembly, the reattached boss is likely to detach again.

⚠ Warning: The Initiator and Adhesive are flammable. Observe suitable procedures for storage and handling. Work in a well-ventilated area.

Parts Information:

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
Adhesive kit for high mounted stop lamp	JLM 1696	1

Warranty Information:

<u>FAULT CODE</u>	<u>R.O. NUMBER</u>	<u>DESCRIPTION</u>	<u>TIME ALLOWANCE</u>
QN DB 33	76.93.76	Reattach mounting boss for high-mounted stop lamp	0.35 hrs.