



V8 XJ Series/XK8

DATE 8/98

501-22

SERVICE

TECHNICAL BULLETIN

Detached Rear View Mirror Mounting –
Repair Procedure

MODEL

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

VIN

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

This bulletin provides a procedure for reinstalling the mounting boss for the rear view mirror.

Action:

Perform the following operations with the vehicle having been stabilized at normal workshop temperature. The temperature of the glass during the repair and curing of the adhesive should be maintained at a minimum of 16° C (60° F). Working at a somewhat higher temperature will speed the rate of curing.

MIRROR MOUNTING REPAIR PROCEDURE

1. Spread plastic sheeting or nonabsorbent cloths over the fascia and console to protect against any spillage of adhesive materials.
2. Remove the mirror stem cover that surrounds the mounting boss. (The stem cover is liable to break during removal and may need to be replaced). Separate the mirror assembly from the mounting boss.
3. Remove the residue of old adhesive tape from the mounting boss and glass. If scraping is required to remove adhesive tape from the glass, soak the tape with denatured alcohol. A plastic scraper or a piece of kitchen laminate (e.g., Formica™) cut to a suitable size should be used as a scraper. Do not use a metal scraper.
4. Clean the boss, and the glass in the location for the mounting boss, with denatured alcohol, and allow to dry.
5. Hold the mounting boss in the correct location on the glass. Mark out the location for the mirror boss on the glass, using strips of masking tape. If necessary, take measurements from a similar vehicle. Position the tape strips so as to surround closely the space occupied by the boss. Any excess adhesive which may be squeezed out from under the boss in subsequent operations will then become spread on the tape, to be more easily removed.
6. 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.
7. 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 up to the top or bottom edges. Do NOT attempt to spread the adhesive.
8. Ensuring that the mirror mounting boss is correctly positioned and aligned, immediately press it to the glass, spreading the bead of adhesive. Hold it steady for 1 minute, while initial bonding takes place.

9. The adhesive will partially cure in 5 - 15 minutes, depending on the ambient temperature. Any excess adhesive may then be cleaned away using first the scraper made from kitchen laminate, and then peeling away the surrounding tape strips.
10. **Wait a minimum of 6 hours, but preferably 24 hours, to allow full curing of the adhesive before reinstalling the rear view mirror to the boss.**

⚠ 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>
Mirror stem cover	HXF 3131AB	1
Permabond adhesive F246*	obtain locally	

Supplier:

Permabond Engineering Adhesives
 Customer Service 1 (800) 653-6523
 Technical Service Helpline 1 (800) 370-9647
 MSDS information 1 (800) 370-9647

Warranty Information:

<u>FAULT</u>	<u>R.O.</u>	<u>DESCRIPTION</u>	<u>TIME</u>
<u>CODE</u>	<u>NUMBER</u>		<u>ALLOWANCE</u>
UM DD BB	76.10.62	Reinstall mirror mount	0.40 hrs.

* An amount equal to 10% of Permabond F246 Adhesive kit may be claimed as a sublet amount.