

Title: Replacing the cushioning rubbers on the P/N E410 (F875).

1. Purpose:

The purpose of this service instruction is to describe how to replace the C858 cushioning rubbers on a bearing house axle of the E410 (F875).

2. References:

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

3. Definitions:

3.1. None

4. Scope:

4.1. Applicable for all PS door mechanisms based on the E410 basic door mechanism.

5. Tools:

5.1. Scissors

6. Needed parts:

- 6.1. C858 Cushioning rubber (2 pieces)
- 6.2. Loctite 406 (glue)
- 6.3. Loctite 770 (primer)
- 6.4. Loctite 7063 (cleaner)

7. Time needed:

7.1. 10 minutes

Revision no.	Date:	Description of the change:	Name & function:
2	15-04-2014	Added use of primer Loctite 770	Sieberen Feenstra Project Engineer
1	19-11-2013	Initial release	Johan van der Kooij Engineering

Title: Replacing the cushioning rubbers on the P/N E410 (F875).

8. Execution:

- 8.1. Removing the old cushioning rubbers
The old cushioning rubbers are located as shown in the figure below (red arrows):

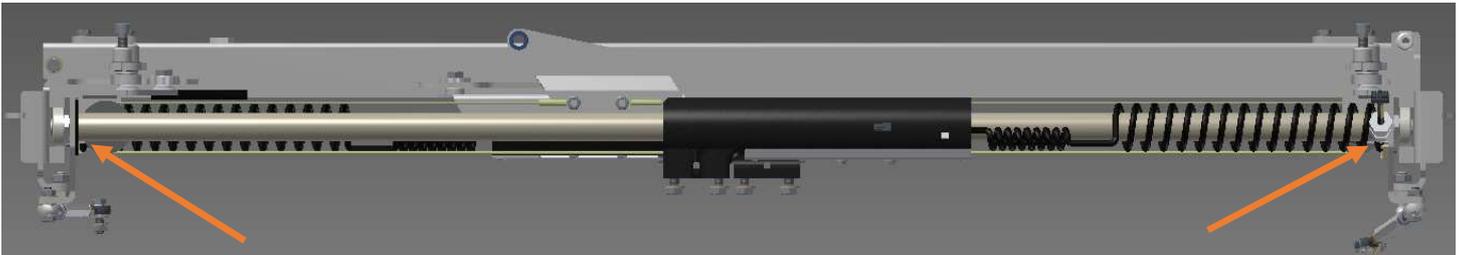


Figure 1: Location of the cushioning rubbers

The old cushioning rubbers are removed by cutting them off the axle using a pair of scissors (figure 2). Do not damage the axle while cutting the rubber.



Figure 2: Scissors

- 8.2. Installing the new cushioning rubbers
The new cushioning rubbers have to be cut across one section to ease the assembly. The new cushioning rubbers are cut across the red line, as shown in figure 3.

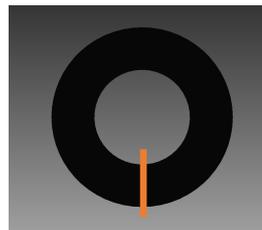


Figure 3: Cutting the new cushioning rubber

- 8.3. Once the cutting is done, the assembly of the new rubbers can start. The position of the first rubber is shown in figure 4 (blue ring).



Figure 4: First cushioning rubber

Title: Replacing the cushioning rubbers on the P/N E410 (F875).

- 8.4. Before the rubber is pushed back into the right position, the cleaner has to be used across the cut through section. After cleaning the surface, apply the primer on the surface to be glued. After applying the primer, wait 30 seconds for it to dry. Now the glue can be flowed on the cut through section. The correct glue, as well as the correct primer and cleaner, is shown in figure 5.



Figure 5: Loctite 406 (glue), Loctite 770 (primer) and Loctite 7063 (cleaner)

- 8.5. Once the glue is put on the cushioning rubber, it can be placed back on the axle in between the frame and the bearing house. These steps are repeated for the second cushioning rubber, located as shown in figure 6 (blue ring).

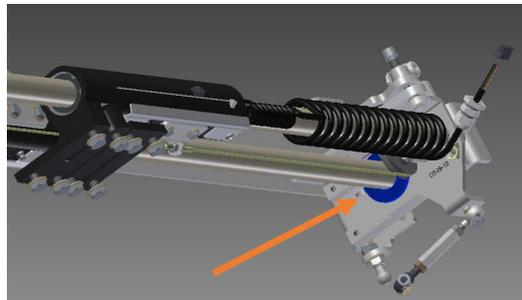


Figure 6: Location of the second cushioning rubber

- 8.6. Once the glue is dry, the assembly of the new cushioning rubbers is complete.