



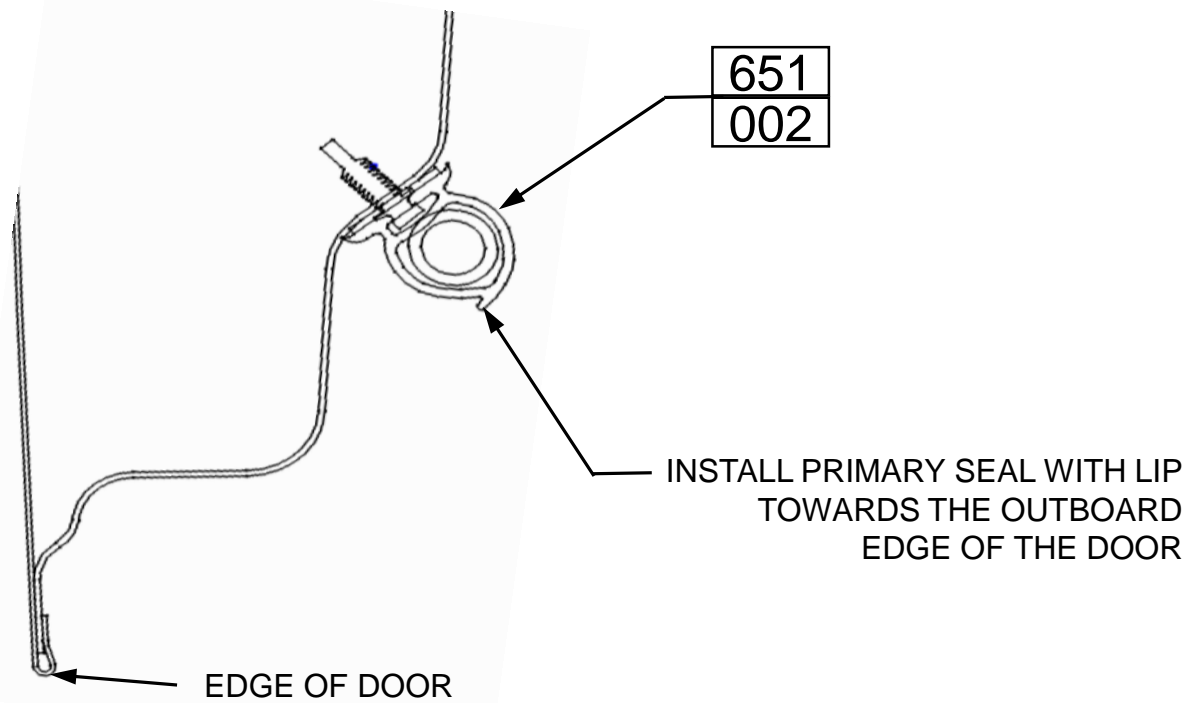
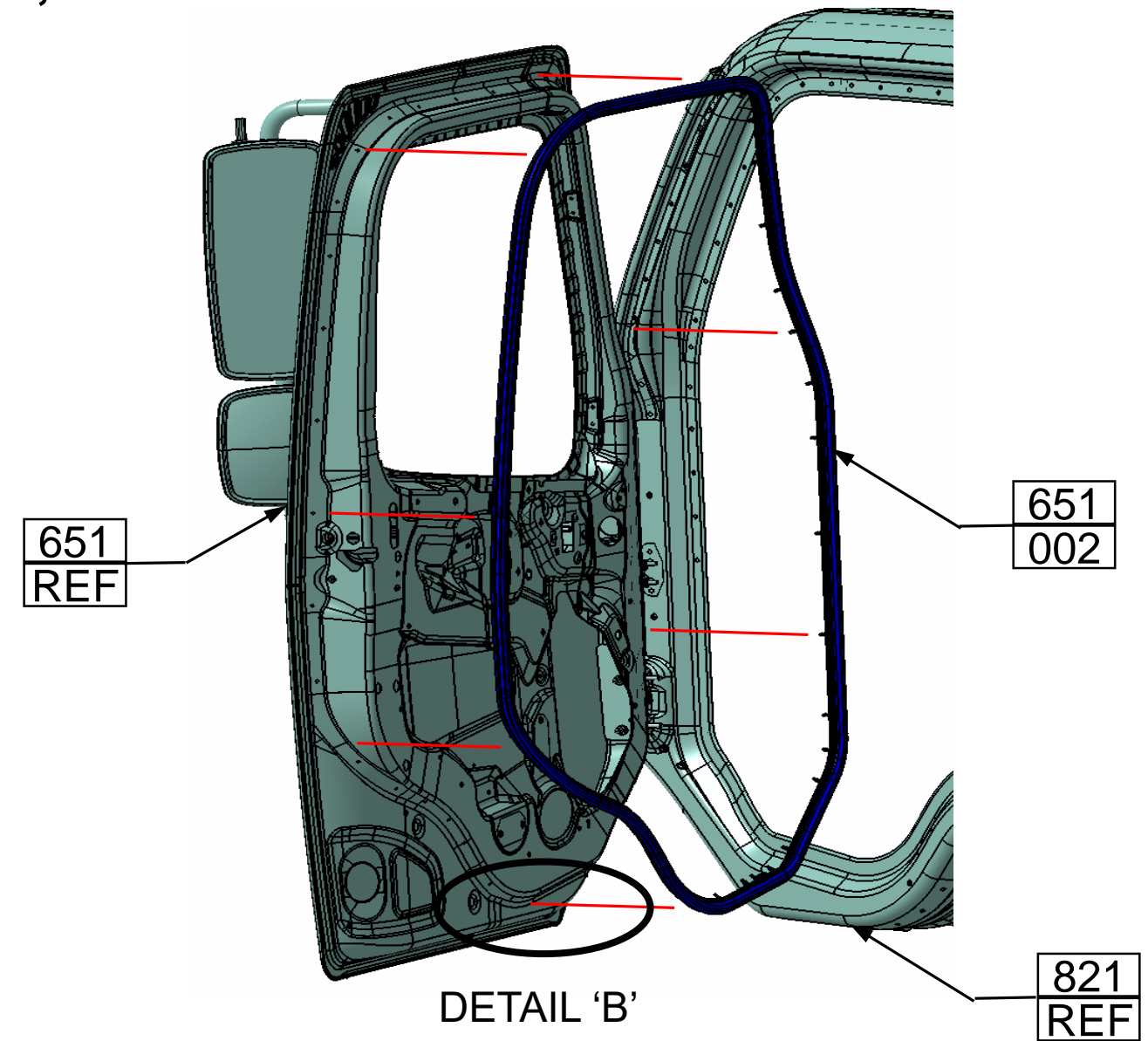
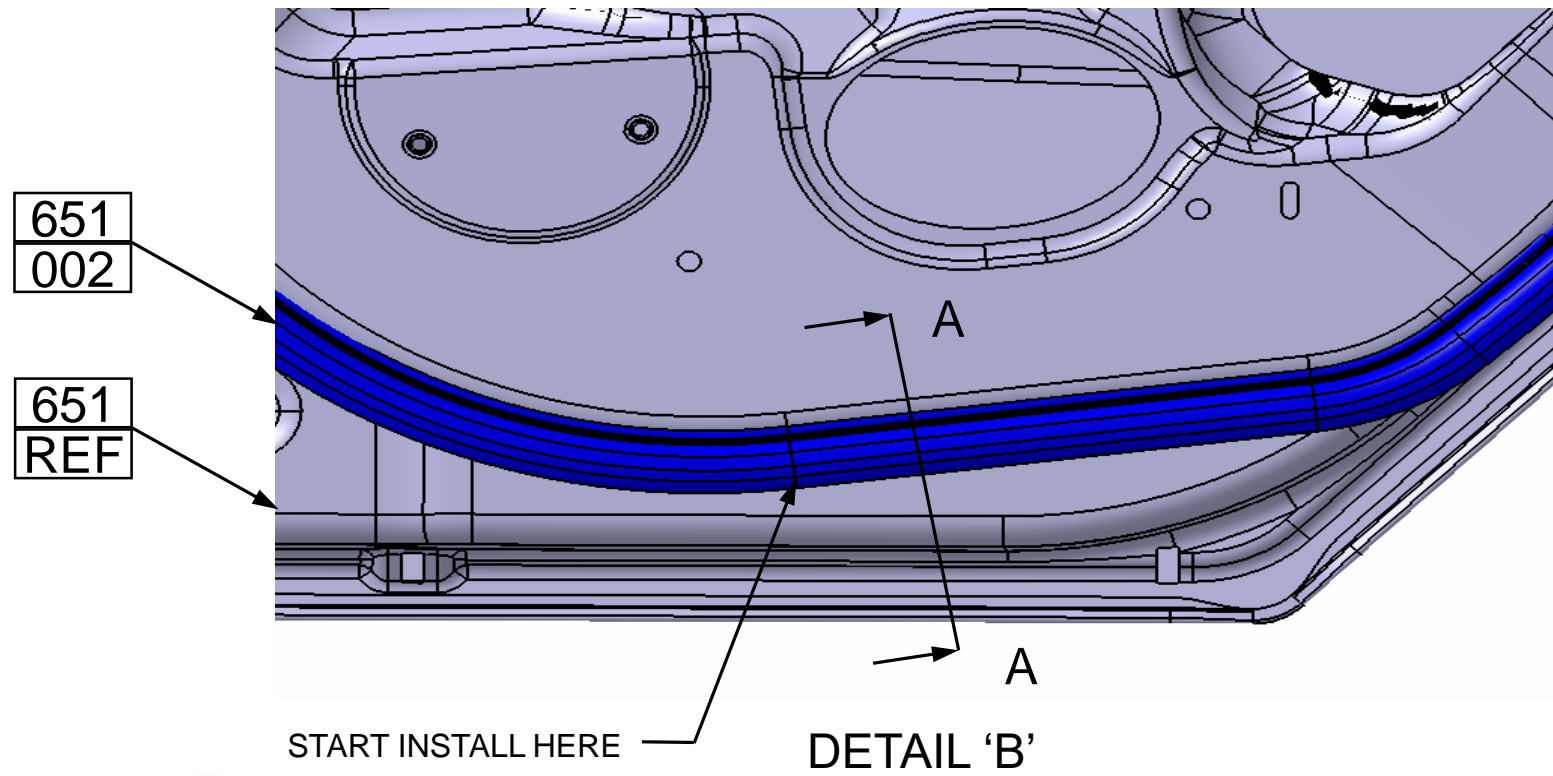
RELEASE NUMBER	REV LTR	REVISION DESCRIPTION	BY	DATE	APPD
P38785-37	-	INITIAL RELEASE	Z1B	05/08/13	ATO
P38785-53	A	REVISED NOTES AND VIEWS ON SHEET 2	Z1B	09/30/13	ATO
P11CAB-L3	B1	REMOVE PAGE 2.	NAH	06/15/16	ATO
	B2	ADD TOLERANCE TO SEAL START POSITION			
P15CAB-76	C1 & C2	ADDING ANOTHER ADHISION PROMOTER	Y1K	07/29/19	DRG

1. COMPONENTS FEATURED IN THIS DOCUMENT ARE LH SHOWN, RH OPPOSITE EXCEPT WHERE OTHERWISE NOTED

DELIVERY MUST CONFORM EXACTLY WITH DRAWING SPECIFICATIONS AND, WHERE REQUIRED BY Q.A., WITH APPROVED Q.A. SAMPLES. ABSOLUTELY NO CHANGES ARE PERMITTED WITHOUT PRIOR APPROVAL BY DTNA. THIS INCLUDES CHANGES TO: SOFTWARE, MATERIALS, INTERNAL COMPONENTS, MANUFACTURING PROCESSES.

ITEM NUMBER D18-67625-001		DESCRIPTION INSTL-SEALS,DOOR,RH		ITEM NUMBER D18-67625-000		DESCRIPTION INSTL-SEALS,DOOR,LH				Daimler Trucks North America	
<small>THE INFORMATION CONTAINED HEREIN IS PROPRIETARY DATA, AND IS NOT FOR DISSEMINATION OR DISCLOSURE, IN WHOLE OR IN PART, FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS SUBMITTED, EXCEPT AS AUTHORIZED IN WRITING BY DAIMLER TRUCKS NORTH AMERICA LLC (DTNA)</small>											
MATERIAL APPROVAL		DATE		UNLESS OTHERWISE NOTED, DIMENSIONS AND TOLERANCES ARE DEFINED ACCORDING TO ASME Y14.5M-1994, WITH EXCEPTION PER DTNA 09ENG-WI037							
A.OLSON		05/08/13									
DRAWN BY		DATE									
Z.BARRA		05/08/13									
CHECKED BY		DATE									
P.BAKONYI		05/08/13									
RESPONSIBLE ENGINEER		DATE		THIRD ANGLE PROJECTION				UNITS OF MEASURE MM			
Z.BARRA		05/08/13									
APPROVED BY		DATE									
A.OLSON		05/08/13									
DESCRIPTION		INSTL-SEALS,DOOR									
SUPPLEMENTAL DESCRIPTION		M2									
ITEM/DRAWING NUMBER		REVISION LETTER		PAGE							
D18-67625		C		1 of 4							

INSTALL-SEAL, PRIMARY, DOOR



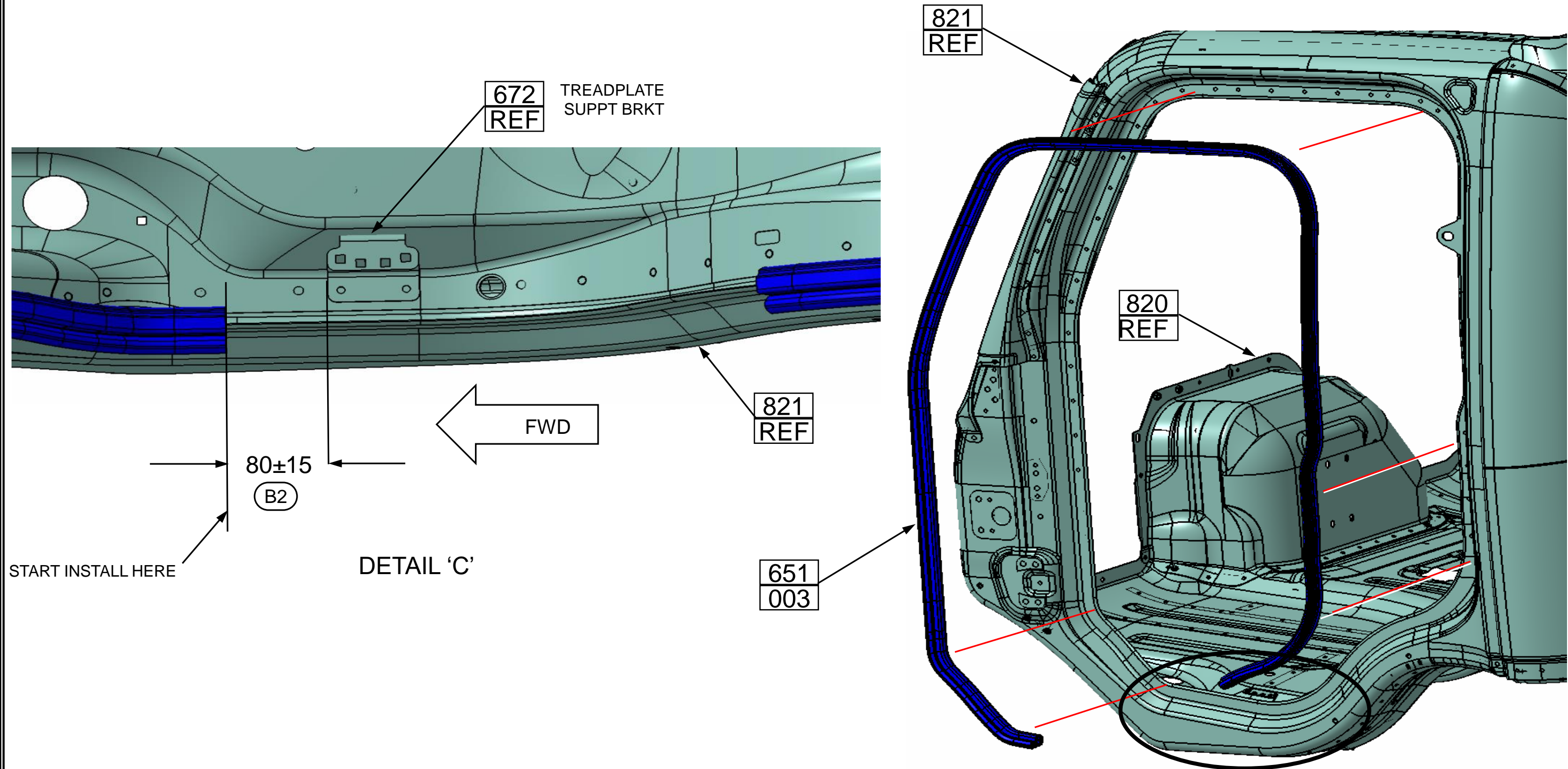
SECTION A-A

1. PRIMARY SEAL INSTALL:

- (C1) • WIPE MOUNTING SURFACE WITH ISOPAR G OR 3M PRIMER 94, ALLOW TO DRY
- POSITION SEAL WITH LIP POINTING OUTBOARD
- ALIGN FIRST FASTENERS WITH MATING HOLES ON DOOR
- PUSH IN FASTENERS WHILE PEELING PSA LINER AS YOU GO
- COMPLETE INSTALL BY USING A ROLLER AROUND THE FULL PERIMETER OF THE DOOR, ENSURE CAULKING SEALS GAP

2. DOOR CLOSING EFFORT DUE TO SEAL SYSTEM TO BE 65±15 LBS

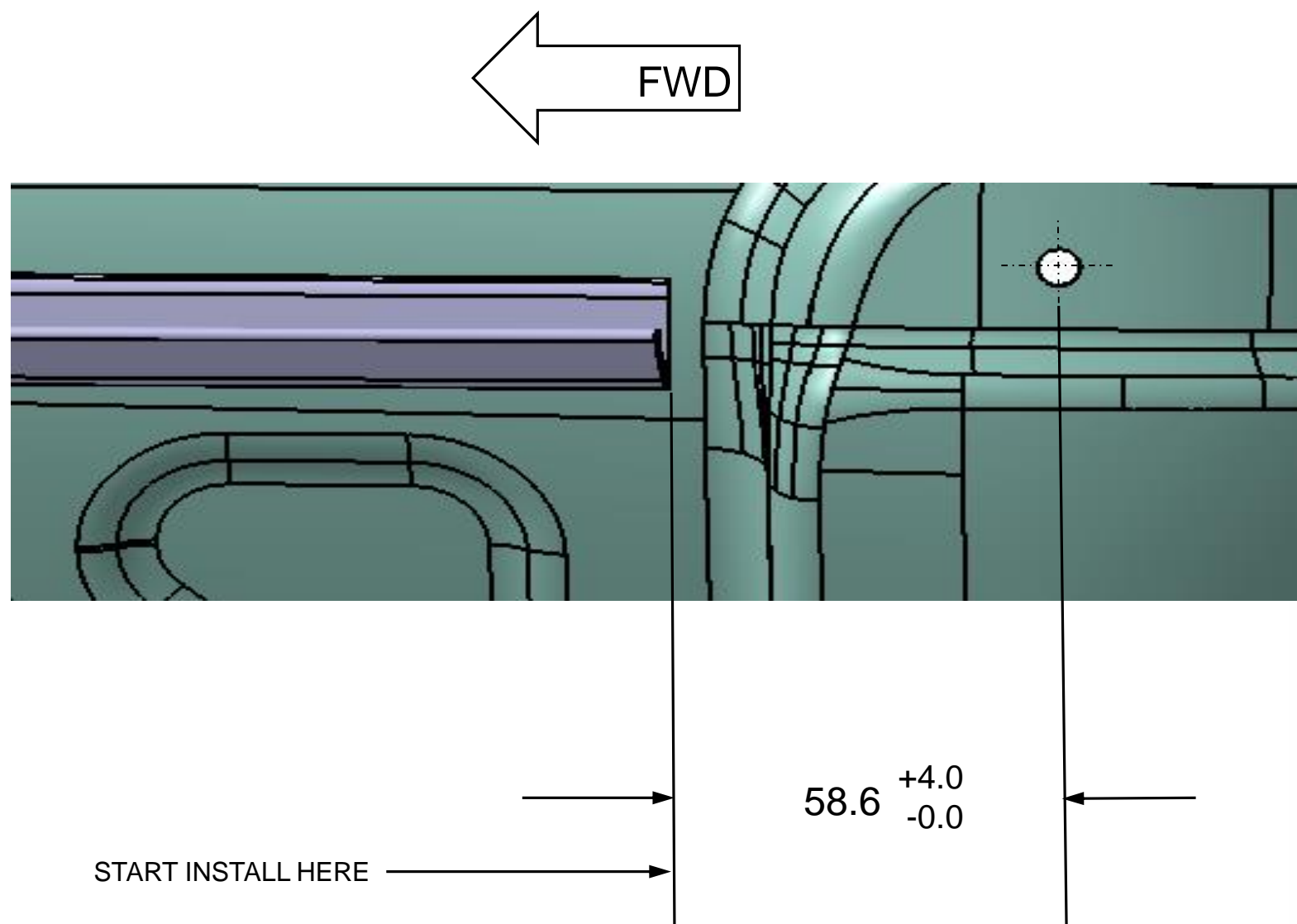
INSTALL-SEAL, SECONDARY, DOOR



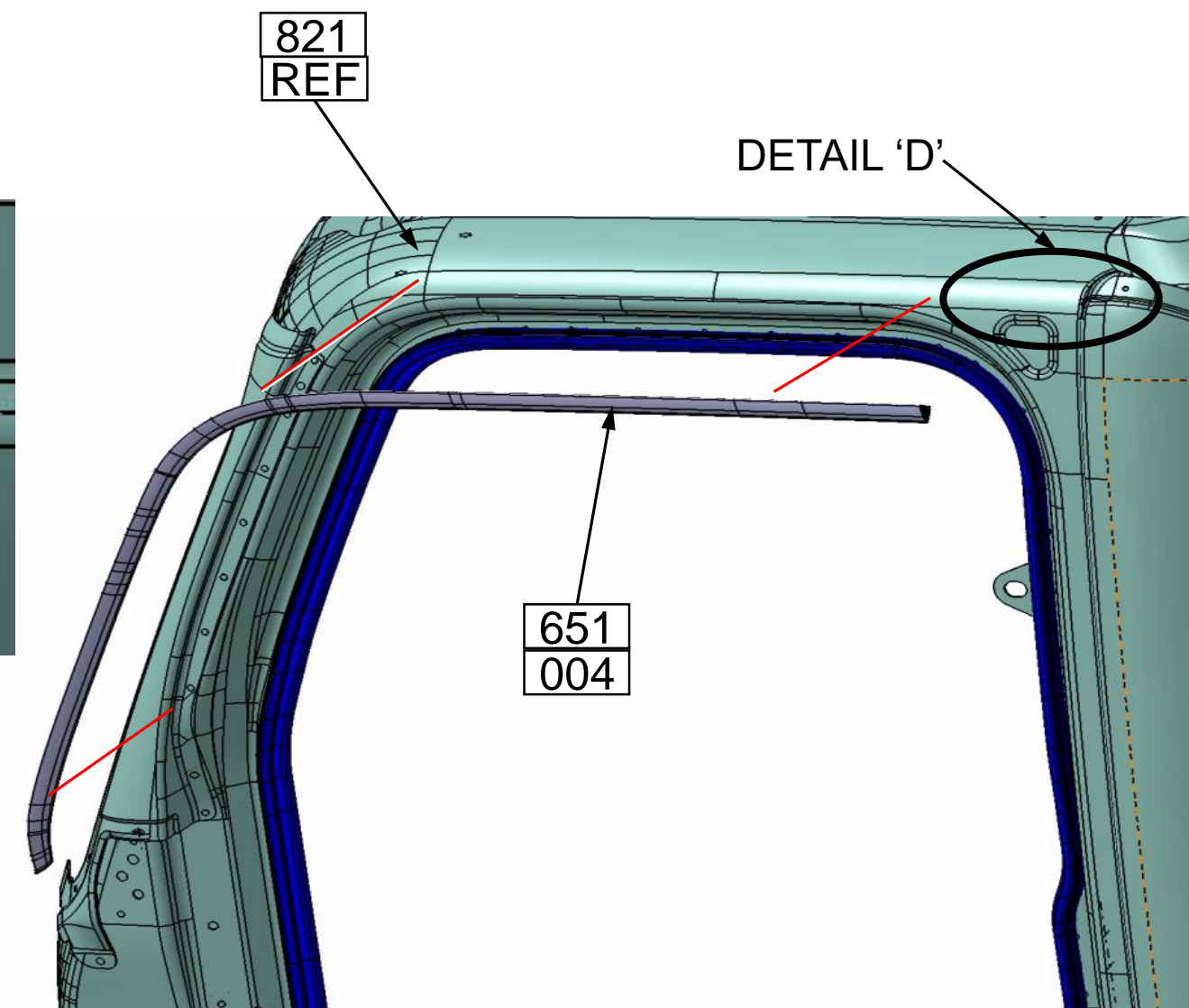
1. PRESS SEAL FIRMLY ONTO CAB STRUCTURE TO ENSURE FULL ENGAGEMENT OF SEAL. USE A MALLET IN CORNERS AS REQUIRED.

NOTE: DOOR OMITTED FOR CLARITY

INSTALL-RAIN GUTTER, DOOR



DETAIL 'D'



1. RAIN GUTTER INSTALL:

- (C1) • WIPE MOUNTING SURFACE WITH ISOPAR G OR 3M PRIMER 94, ALLOW TO DRY
- PEEL BACK THE LINER ON THE REAR EDGE OF THE SEAL
- ALIGN THE REAR EDGE RELATIVE TO THE CAB STRUCTURE
- PRESS SEAL FIRMLY TO CAB FOLLOWING CAB PROFILE
- COMPLETE INSTALL BY USING A ROLLER AROUND THE FULL PERIMETER OF THE DOOR, ENSURE BUTYL SEALS GAP