

**DOORS**

## Purpose

This document describes the proper procedure to replace a single-pane window on an RV door.

## Safety

This document provides general instructions. Many variables can change the circumstances of any procedure, i.e. the degree of difficulty involved in the service operation and the ability level of the individual performing the operation. This document cannot begin to plot out procedures for every possibility, but will provide the general instructions for effectively installing, removing or servicing the system. In the event the skill level required is too advanced or the procedure too difficult, a certified technician should be consulted before performing the necessary operation. Failure to correctly install, remove or service the system may result in voiding the warranty, inflicting injury or even death.

**⚠ WARNING**

The "WARNING" symbol above is a sign that a procedure has a safety risk involved and may cause death, serious personal injury, severe product and/or property damage if not performed safely and within the parameters set forth in this document.

**⚠ CAUTION**

The "CAUTION" symbol above is a sign that a procedure has a safety risk involved and may cause personal injury, product and/or property damage if not performed safely and within the parameters set forth in this document.

Single-Pane Window Kit PN 2023060415
Single-Pane Replacement Window
MS Super Fast Polymer
Steel putty knife

## Resources Required

- Single-Pane Window Kit PN 2023060415
- Non-abrasive shop towels
- Distilled water
- Hammer
- Masking tape with a strip width of at least 2" (50mm)
- Compressed air tool
- Clamps with soft, non-abrasive pads

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## Instructions

1. Remove the door from the unit, and place it on a flat, level working surface.
2. Clamp the door in place to the working surface at each end using clamps with soft, non-abrasive pads.
3. Use masking tape with a strip width of at least 2" (50mm) to outline the entire perimeter of the window (Fig. 1 and Fig. 2).
  - A. Butt the edges of the tape as close as possible to the edges of the window.
  - B. Use long, continuous pieces of tape for each side of the window.
4. Use a short strip of tape to tape diagonally at each corner of the window (Fig. 3A).
5. Repeat steps 3 and 4 to add a second layer of tape on top of the first.

Fig. 1

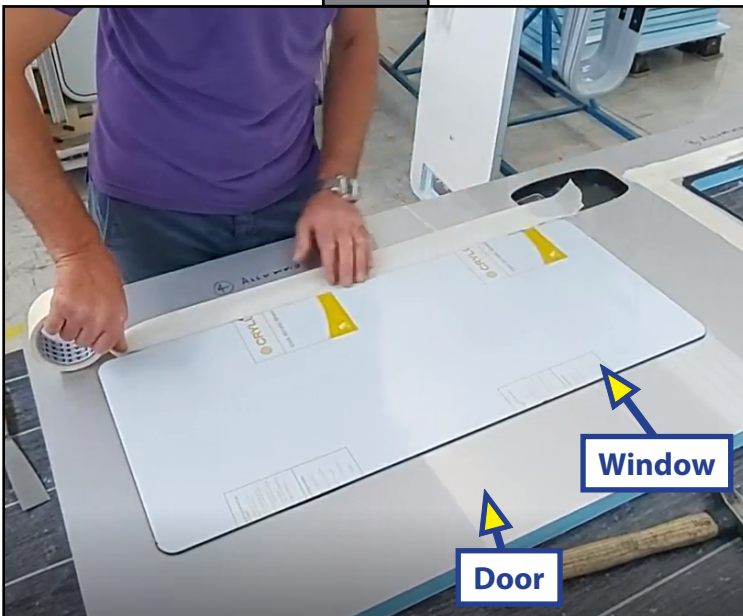
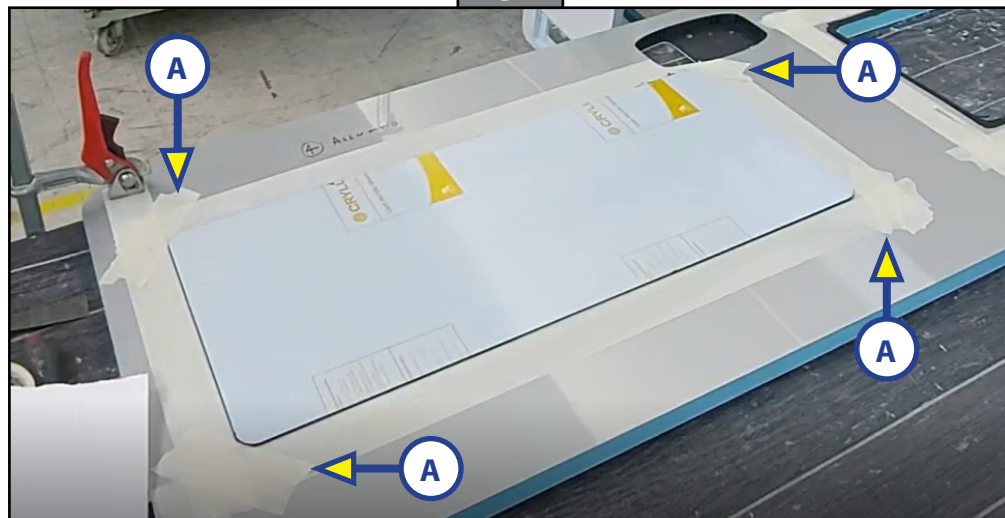


Fig. 2



Fig. 3

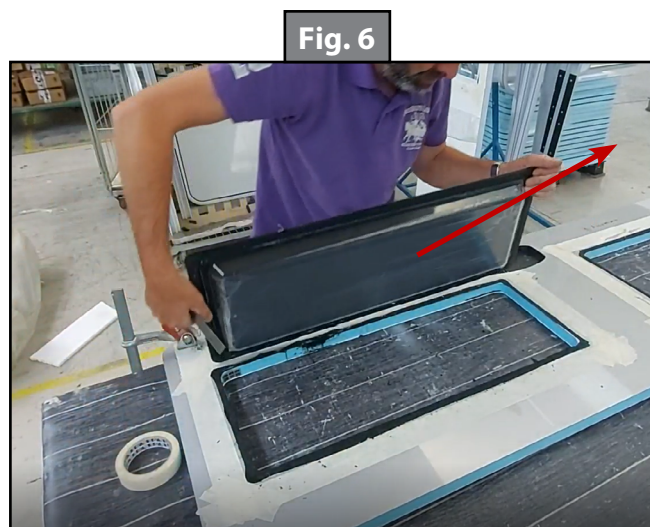
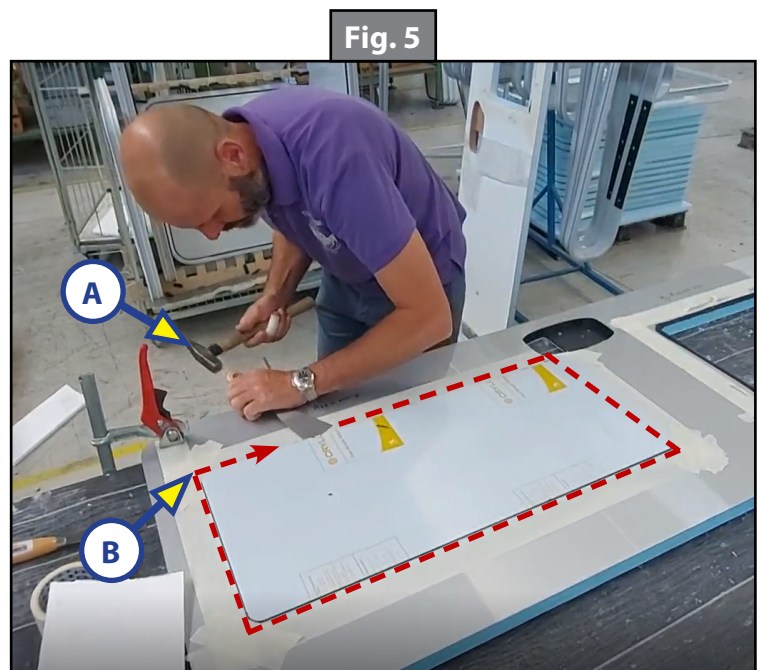
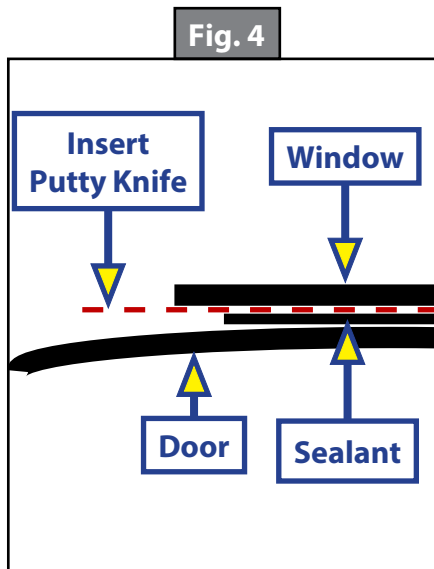


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6. To avoid damaging the surface of the door, carefully slide a putty knife horizontally between the window and the layer of sealant securing it to the door (Fig. 4).
7. Use a hammer to tap on the handle of the putty knife until it cuts through the sealant securing the window and door (Fig. 5A).
8. Pull out the putty knife, move to a new area of the window and horizontally insert the putty knife between the sealant and window.
9. Repeat steps 7 and 8 around the entire perimeter of the window (Fig. 5B).

**NOTE:** It may be necessary to use the putty knife to cut remnants of sealant and/or pry the window away from the face of the door to fully release it.

10. Remove the window and discard it (Fig. 6).





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11. Clean off any loose pieces of sealant using compressed air (Fig. 7).

**NOTE: DO NOT** remove any sealant that remains adhered to the face of the door.

**NOTE: DO NOT** apply any substance or cleaner to the residual sealant adhered to the face of the door.

**NOTE:** No more than 15 minutes may pass between the time the old window is removed, and the new one is installed.

12. Apply distilled water to a non-abrasive shop towel. Using the edge of the towel with distilled water applied, clean the bonding area of the replacement window. Clean around the entire bonding area (Fig. 8).

Fig. 7

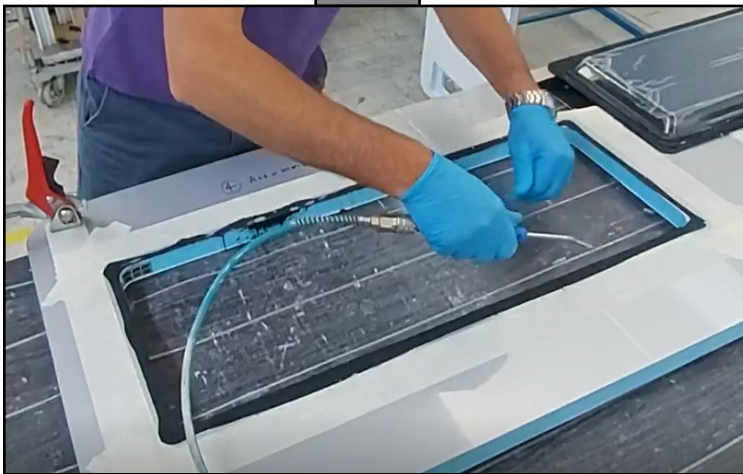
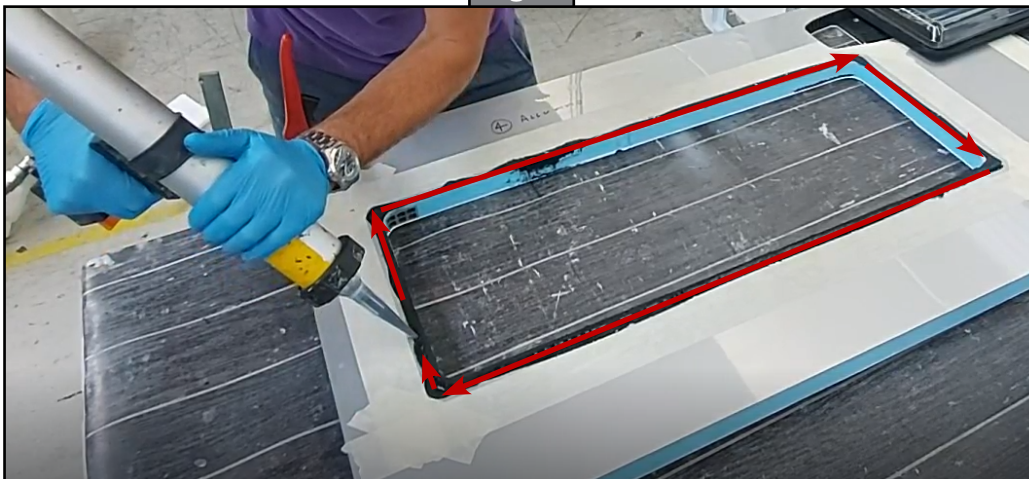


Fig. 8



13. Generously apply a bead of MS Super Fast Polymer to the face of the door directly on top of the remaining adhesive left from the previous window (Fig. 9). Apply enough polymer so that when the new window is placed excess polymer should leak out along the entire edge of the window. **This leakage is intended.**

Fig. 9



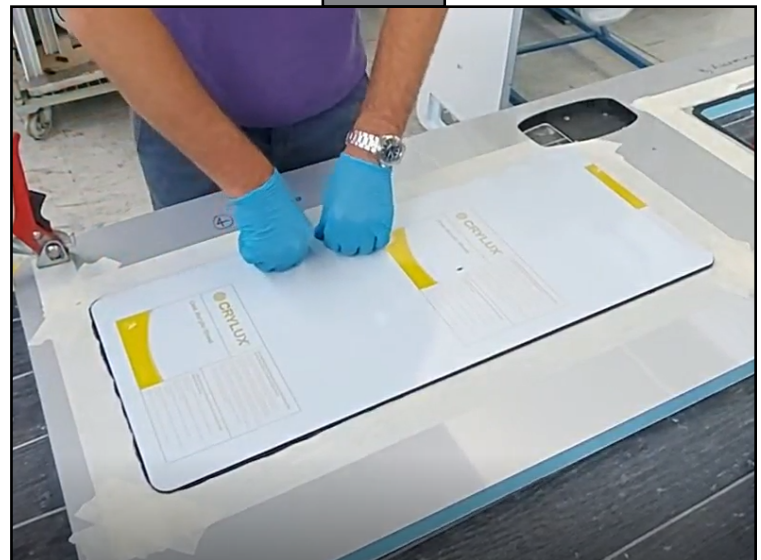
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14. Carefully flip the replacement window so its bonding area (with the cleaned edge) faces the front face of the door (Fig. 10). Align the top edge of the window with the bottom edge of the tape placed around the top of the perimeter of the old window as an anchor, then align the rest of the window's outer edge perimeter with the inner edges of the tape perimeter.
15. Once the window is aligned, carefully lower it onto the polymer bead and gently press down to seal the window to the face of the door (Fig. 11). Excess polymer should seep out from the entire perimeter of the window onto the tape.
16. Wait at least 5 hours before handling the door. This includes putting the door into an upright position or attempting reinstallation. The complete curing period for the adhesive for the best seal is 24 hours.

Fig. 10



Fig. 11



17. Once 5 hours have passed, remove the excess polymer that has leaked from the perimeter of the window using a putty knife.
18. Remove the protective adhesive paper tape.
19. Clean the face of the door with soap, water, and a non-abrasive shop towel.

**⚠ WARNING****COMPLETE CURING OF THE SEALANT TAKES 24 HOURS.**

Do not stress the door or window before this 24 hour period has passed. Do not drive the vehicle during this 24 hour bonding period.