

CAB (CONT'D)

Glass Installation

Top And Rear Glass

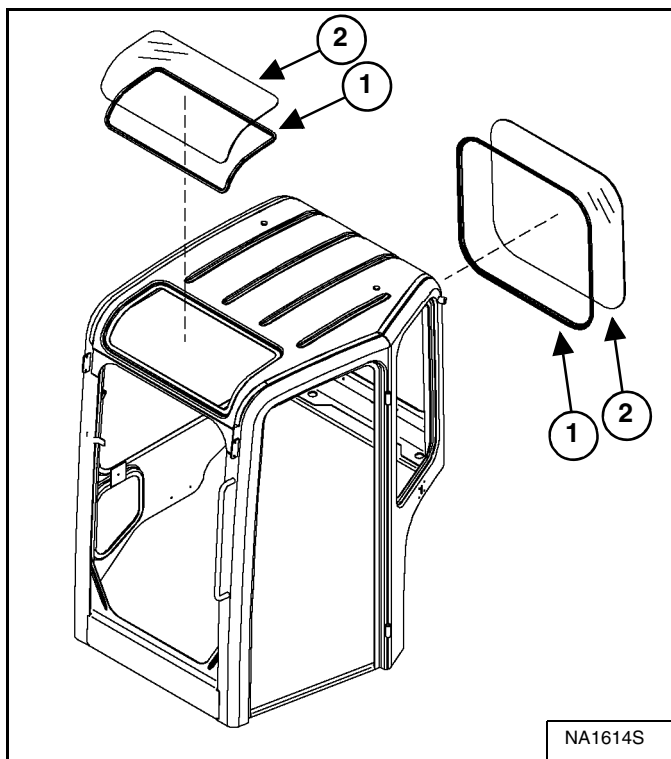
Remove the majority of the old urethane adhesive from the perimeter of the cab.

NOTE: Leave a thin film (0.03 in. (0,79 mm) thick) of the old urethane on the cab frame, fresh urethane will bond to the remaining film.

Prime and paint any bare metal or scratches.

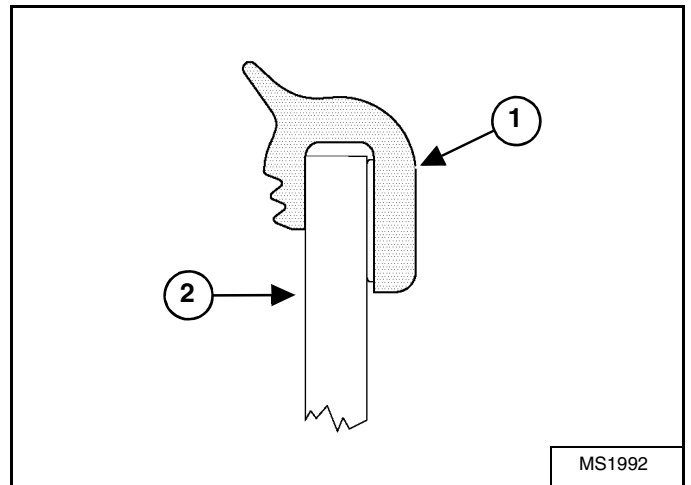
Clean the metal surfaces with general purposes adhesive cleaner. Clean the glass surface with glass cleaner

Figure 40-30-23



Install the seal (Item 1) on the glass (Item 2) [Figure 40-30-23] & [Figure 40-30-24].

Figure 40-30-24



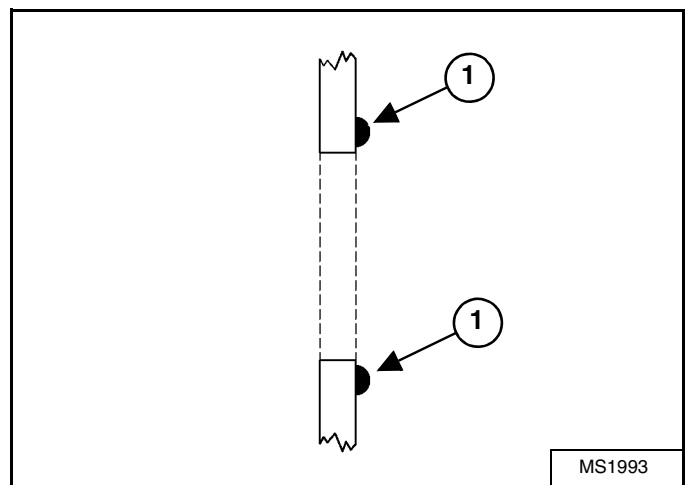
Shake the combo primer for one minute.

Apply one coat of the combo primer to the perimeter of the cab and glass (Item 2) [Figure 40-30-24].

Allow the combo primer to dry for at least 15 minutes. Excess primer can be removed from the glass using a razor blade.

Cut the tip of the adhesive tube to the desired shape and size to provide a bead height sufficient to give good contact with the glass around the entire perimeter.

Figure 40-30-25



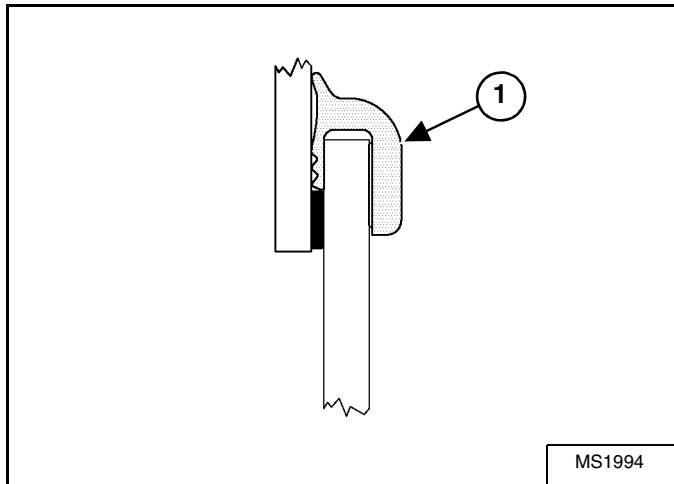
Apply a 0.25 X 0.375 in. (6.4 X 9.5 mm) bead of urethane adhesive (Item 1) [Figure 40-30-25] to the perimeter of the cab.

CAB (CONT'D)

Glass Installation (Cont'd)

Top And Rear Glass (Cont'd)

Figure 40-30-26



Install the glass and seal assembly (Item 1) [Figure 40-30-26]. Press the glass into the cab to make complete contact with the adhesive. Tape the glass in place.

Allow the adhesive to cure for a minimum of eight hours at 75° F and 20% relative humidity.

Remove the tape after the adhesive is cured.

Right And Left Side Glass

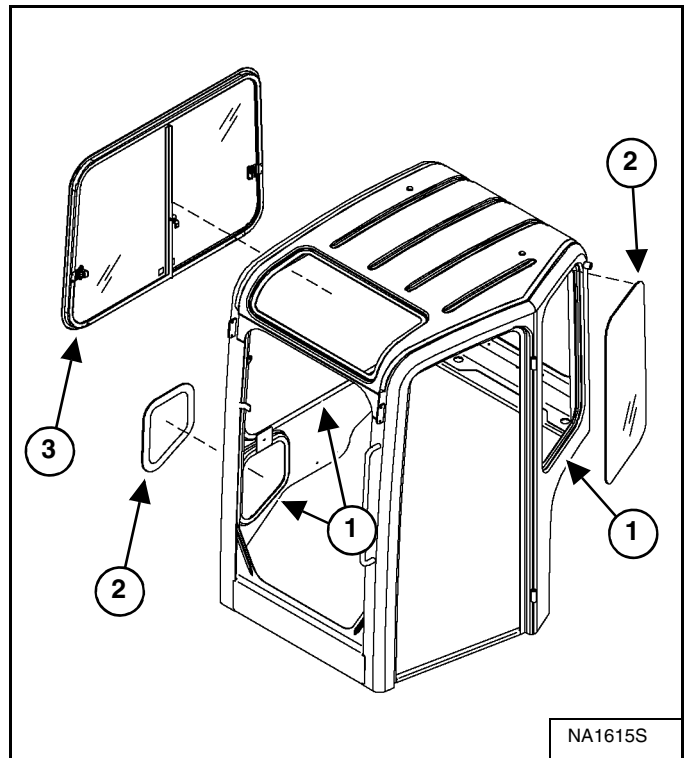
Remove the majority of the old urethane adhesive from the perimeter of the cab.

Prime and paint any bare metal or scratches.

Clean the metal surfaces with general purposes adhesive cleaner. Clean the glass surface with glass cleaner.

Shake the combo primer for one minute.

Figure 40-30-27



Apply the combo primer to the perimeter of the cab opening (Item 1), glass (Item 2) and window frame [Figure 40-30-27].

Allow the combo primer to dry for at least 15 minutes. Excess primer can be removed from the glass using a razor blade.

IMPORTANT

If the glass has direct contact with the metal frame, the glass may break due to machine vibration.

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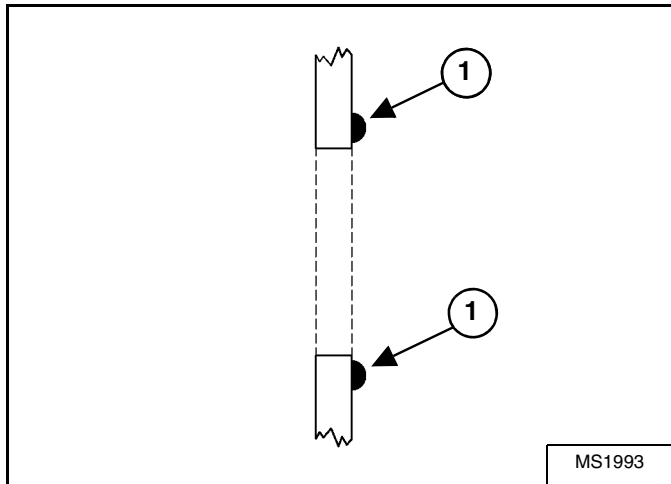
Cut the tip of the adhesive tube to the desired shape and size to provide a bead height sufficient to give good contact with the glass around the entire perimeter.

CAB (CONT'D)

Glass Installation (Cont'd)

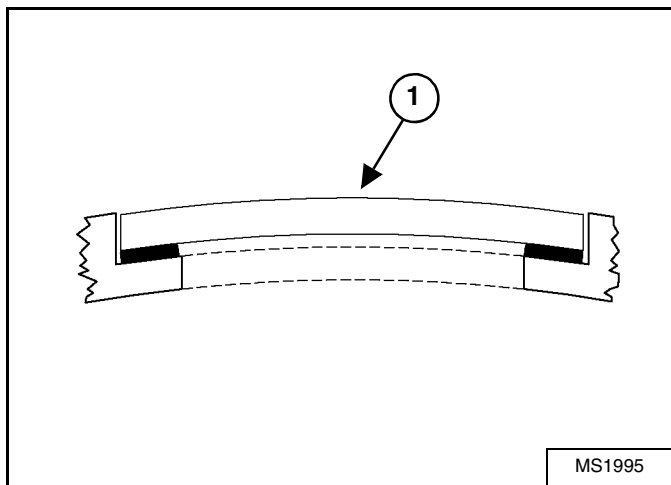
Right And Left Side Glass (Cont'd)

Figure 40-30-28



Apply a 0.25 X 0.375 in. (6,4 X 9,5 mm) bead of urethane adhesive (Item 1) [Figure 40-30-28] to the perimeter of the cab.

Figure 40-30-29



Install the glass (Item 1) [Figure 40-30-29]. Press the glass into the cab to make complete contact with the adhesive. Tape the glass in place.

Allow the adhesive to cure for a minimum of eight hours at 75° F and 25% relative humidity.

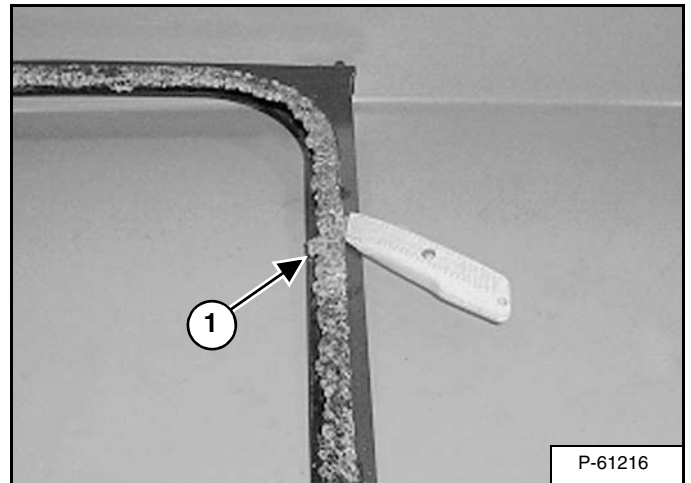
Remove the tape after the adhesive is cured.

Door And Front Window Glass

NOTE: The door and front windows are supplied as kits that include the glass, urethane adhesive, combo primer, glass cleaner and bumpers for correctly installing the new glass.

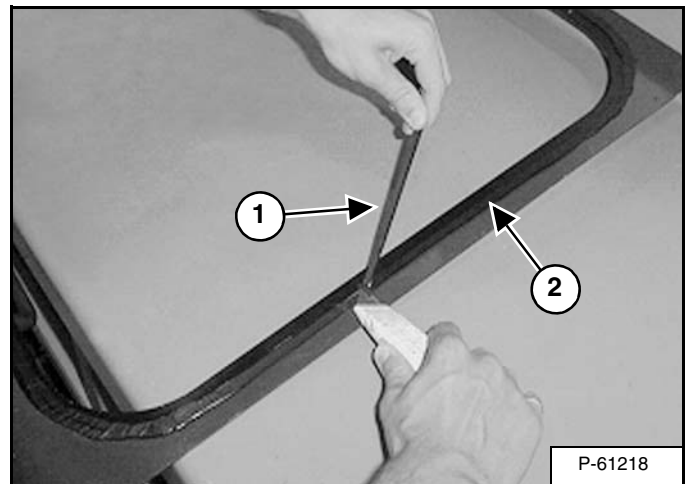
Remove the front window or door that is to be repaired from the excavator.

Figure 40-30-30



Remove the broken glass (Item 1) [Figure 40-30-30].

Figure 40-30-31



Cut and remove the old urethane adhesive (Item 1) and leaving less than a 0.03 in. (0,79 mm) thick layer (Item 2) [Figure 40-30-31] for the new adhesive to bond to.

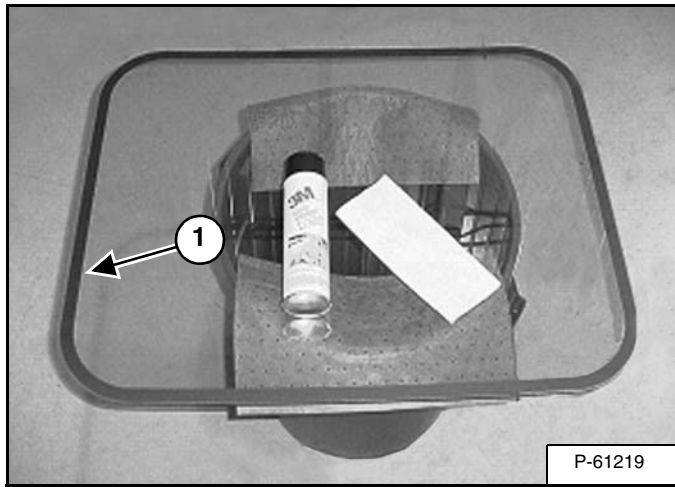
NOTE: Use care not to scratch the paint on the frame.

CAB (CONT'D)

Glass Installation (Cont'd)

Door And Front Window Glass (Cont'd)

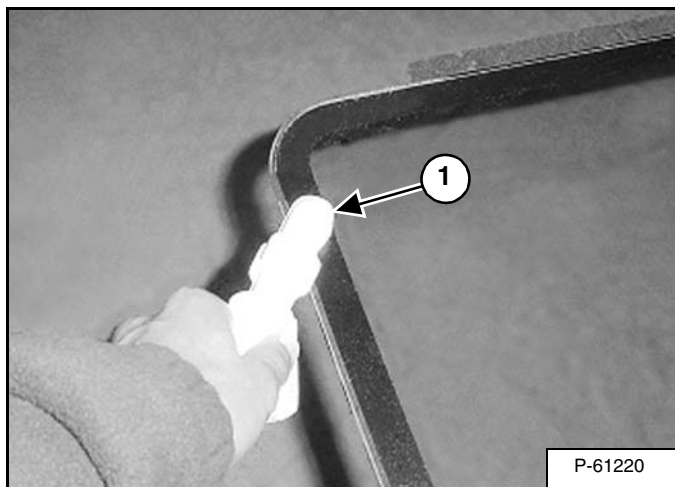
Figure 40-30-32



Place the glass on a flat surface with the painted side of the glass (Item 1) [Figure 40-30-32] facing up.

Thoroughly clean the entire glass with glass cleaner.

Figure 40-30-33



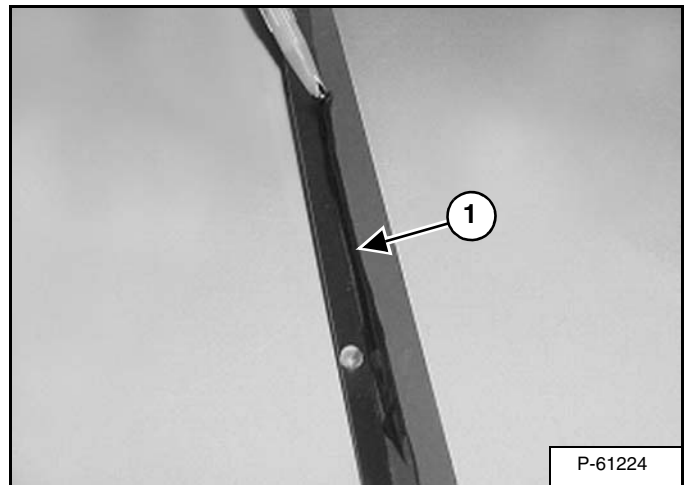
Apply one coat of combo primer (Item 1) [Figure 40-30-33] on the painted edge of the glass.

Apply the combo primer to any scratches on the door/front window frame in the area where the glass is installed.

Allow the primer to dry for a minimum of 15 minutes.

Excess primer may be removed from the glass using a razor blade.

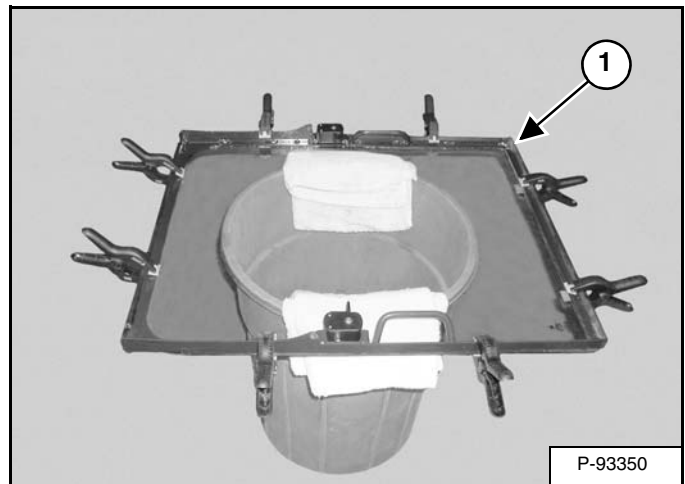
Figure 40-30-34



Apply a 0.25 X 0.375 in. (6,4 X 9,5 mm) bead of urethane adhesive (Item 1) [Figure 40-30-34] around the front window/door frame.

Apply the adhesive directly on top of the old adhesive.

Figure 40-30-35



Place the frame (Item 1) [Figure 40-30-35] & [Figure 40-30-36 on Page 40-30-13] on the glass. The frame must be centered on the glass, and the glass must not have direct contact with the front window/door frame.

IMPORTANT

If the glass has direct contact with the metal frame, the glass may break due to machine vibration.

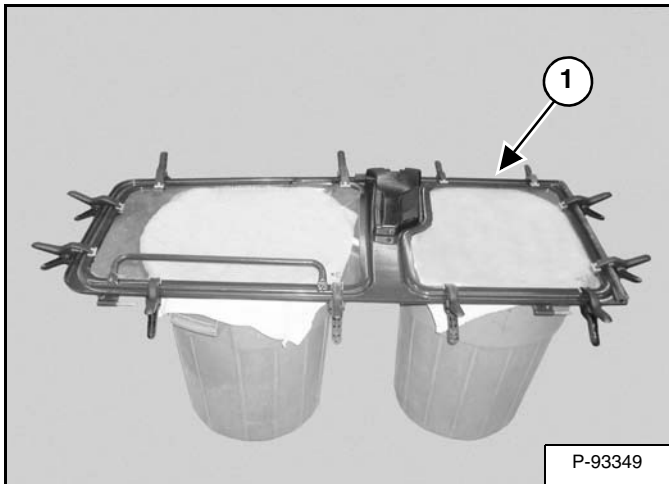
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CAB (CONT'D)

Glass Installation (Cont'd)

Door And Front Window Glass (Cont'd)

Figure 40-30-36



Place the frame and glass together (Item 1) **[Figure 40-30-35 on Page 40-30-12] & [Figure 40-30-36]**.

Place the clamps over the frame.

Allow the adhesive to cure for a minimum of eight hours at 75° F and 25% relative humidity before removing the clamps.

Install the front window. (See Front Window Removal And Installation on Page 40-30-5.)

Install the door. (See Door Removal And Installation on Page 40-30-4.)