

TECH.NICAL. BULLETIN - #A201
SUBJECT: **PROLO (92XX SERIES) HATCH**
INSTALLATION INSTRUCTIONS
Effective Date: 4/16/04 Revised Date: 8/10/05

OEM Installation Instructions for Specialty Manufacturing ProLo 92XX Series Roof Hatches

HATCH HOLE CUTTING:

1. The hatch hole that the gasket will be applied to must be cut 23.5" x 23.5" x 4" R. corners. Slight variation of these dimensions may be allowable (such as 23.688" x 23.688" x 4.438" R. corners) provided that the perimeter of the hole is the same (87.13"). An accurate hole cut is required for the pre-spliced endless loop gasket to fit properly.
2. Cut headliner hole 24" x 24" x 4.5" radii. Hole should be positioned directly underneath top hole (+/- 0.25").

MOUNTING ADHESIVE GASKET:

3. The top surface of the hole (minimum 7/8" outward from the edge of the hole) should be clean, dry, free of fasteners or sheet metal overlaps, and 60°F or warmer.
4. If sheet metal overlaps exist on the top surface, a 5/8" long bead of exterior adhesive may be applied from the edge of the hole outward along the gap between the sheets. (Using a bead length slightly less than the width of the gasket keeps the adhesive underneath the gasket and provides a clean appearance.) This should be done just prior to gasket installation. If this is not desirable, sealer may be applied to this gap after the hatch has been completely installed.
5. Beginning at the rear center of the hatch hole, start with the splice and remove six to twelve inches of the release liner from the weather-strip adhesive. Using the down facing flap as a guide, touch this flap to the cut edge of the hole first and then press down to engage the adhesive to the top surface of the bus. The bulb of the gasket should be positioned on the top surface of the bus. Continue to remove release liner about 12 inches at a time, positioning the gasket using the downward flap against the sheet metal edge, and using finger pressure to attach the adhesive.
6. Once the gasket loop is fully positioned, visually check that the gasket has been positioned correctly. At this point, you may pick up and reposition if needed. Once in place, use a small hand roller to wet-out the adhesive by using firm even pressure one time around the gasket. This step is important to maintaining ultimate leak protection and must not be skipped. If for some reason, the gasket must be repositioned after rolling, it should be discarded and a new gasket should be used.
7. 3M recommends keeping the surface and gasket temperature above 60F for at least two hours after installation. Full cured strength typically occurs in 72 hours.

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MOUNTING PROLO HATCH

8. Bring the roof hatch inside the bus, push the lid to pop the hatch to the “fully ventilated” position. Open the handle to open the lid. Orient the lid to a 45° angle relative to the hatch hole and push the lid up through the hole (the trim ring assembly will still hang down inside the bus). Orient the lid such that the handle is at the rear of the hole and rest the lid on the gasket. (This is an awkward maneuver the first time it is done and may take a little practice).
9. With the lid resting on the gasket, swing the trim ring up into position such that the black plate nests in the plastic slot properly, and close the handle. At this point, the trim ring should be suspended from the headliner about 3 inches.
10. Attach wiring harness for handle alarm and tuck excess wire away.
11. Align the hatch by adjusting side-to-side and front-to-back spacing using your fingertips between the edge of the gasket and the hatch. There should be an even gap side-to-side and front-to-back.
12. Hold inside red handle down with one hand and push rear side of trim ring up with other hand to snap into position. Hold front handle down with one hand and push front side of trim ring up with other hand to snap into position. Minor adjustments can be made to trim ring for better alignment if necessary.
13. Attach trim ring with fasteners to headliner as usual.

Installation is now complete. Hatch may be operated to check installation.

Notes: The installation instructions for the adhesive mounted gasket are based on 3M’s official installation instructions which are available by calling the number below. These instructions may be conservative in that slightly lower installation temperatures may be acceptable, but should be verified by the customer in their process before use on production units.

Questions concerning ProLo hatch installation? Call 1-800-951-7867