



S-TYPE	Date 03/2000	S417-03
TECHNICAL BULLETIN		

Subject HIGH-MOUNTED STOP LAMP - FIXING ADRIFT	Model S-TYPE Year 1995.25 ON VIN L00600 ON
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ISSUE: S417-03 - HIGHMOUNTED STOP LAMP - FIXING ADRIFT

In the event of a mounting boss for the high-mounted stop lamp becoming detached from the heated backlight glass, the following repair procedure should be followed.

ACTION:

The following operations should be undertaken with the vehicle having been stabilized at normal workshop temperature. The temperature of the glass during the repair and during the curing of the adhesive should be at a minimum of 16°C (60°F). Working at a somewhat higher temperature is preferable and will speed the rate of curing.

1. Spread plastic sheeting or non-absorbent cloths over the rear parcel shelf and rear seats to protect against any spillage of adhesive materials.
2. Recover the detached mounting boss. Examine the other mounting boss to determine whether it remains securely attached.
3. Remove the residue of old adhesive tape from the mounting boss and glass. If scraping is required to remove tape from the glass, moisten the tape with methylated spirit or denatured alcohol. A piece of kitchen laminate (eg, Formica™) cut to a suitable size is recommended for use as a scraper - unlike a metallic scraper it should not scratch the glass.
4. Clean the boss, and the glass in the location for the mounting boss, with methylated spirit or denatured alcohol and allow to dry.
5. Offer up the mounting boss to the correct location on the glass. Mark out the location for the boss on the glass, using strips of masking tape. If necessary, take measurements from a similar vehicle.
6. Position the tape strips so as to surround closely the space occupied by the boss. Any surplus adhesive which may become squeezed out from under the boss in subsequent operations will then become spread on the tape, to be more easily removed.
7. Apply 'PERMABOND' F Grade 5 Initiator SPARINGLY to the glass in the area of the mounting location, using the brush supplied in the kit. The Initiator will remain moist.
8. Apply a vertical bead of 'PERMABOND' F.246 Adhesive to the center of the boss, for approximately 2/3 of the height of the boss. Do not apply adhesive right to the top or bottom edges.
Do NOT attempt to spread the adhesive.
9. Immediately offer up the mounting boss, ensuring that it is correctly positioned and aligned, and press it to the glass, thus spreading the bead of adhesive. Hold it steady for 1 minute, while initial bonding takes place.
10. The adhesive will partially cure in 5 - 15 minutes, depending on the ambient temperature. Any excess adhesive may then be cleaned away using first the scraper made from kitchen laminate, and then peeling away the surrounding tape strips
11. **Wait a minimum of 24 hours, to allow full curing of the adhesive before refitting the stop lamp to the bosses. The vehicle should remain in as warm an atmosphere as possible for the whole of this period.**

When the stop lamp is fitted to the bosses the lamp exerts tension on them. Unless the full 24 hour curing time is allowed before refitting the lamp assembly, detachment of the refixed boss is likely.

HANDLING PRECAUTIONS:

The Initiator and Adhesive are flammable. Observe suitable procedures for storage and handling. Work in a well ventilated area.

WARRANTY INFORMATION:

Warranty Fault Code: QN DB 33
SRO: 76 93 76
Labor Time Allowance: 0.35 hours

Sundry code ZZZ001 may be used to claim a maximum of 10% of the cost of a Permabond Adhesive Kit.

PARTS INFORMATION:

Permabond is NOT available via Jaguar Parts Operations but should be procured via one of the Material Stockists listed in Appendix 1

APPENDIX 1**MATERIAL STOCKISTS:**

PERMABOND F 246 Adhesive Kit (containing a 50ml tube of Adhesive and a 5ml bottle of Initiator) may be obtained as follows:

UK Stockist include branches of: Arco - (Arco Stock Code: 44782.50 for 50ml kit)

Inquiries to: ARCO Ltd, Tel: 01482 611539
 PO Box 21 Fax: 01482 218536
 Waverley Street
 Hull, HU1 2SJ

or contact your local branch of ARCO Ltd.

Overseas Markets

Austria	Ing. E. Comp. GmbH Peter Jordanstrasse 159/2 A - 1180 Wien	Tel: (43) 1479 0488 Fax: (43) 1479 0489
Belgium	CCMP NV SA Katwilgweg 15 2050 Antwerpen 5	Tel: (32) 3 254 0700 Fax: (32) 3 254 0325
Denmark	DIATOM VAERKTOJ a/s Postboks 1911 Avedorholmen 84 2650 Hvidovre	Tel: (45) 36 773 600 Fax: (45) 36 773 633
France	PERMABOND FRANCE ZI Nord BP 438 Rue Grange Morin 69655 Villefranche sur Saône	Tel: (33) 474 023 942 Fax: (33) 474 023 943
Germany	PERMABOND GERMANY Im Altenschemel 55 Postfach 8004 48 D-7000 Stuttgart 80	Tel: (49) 6327 382 231 Fax: (49) 6327 382 126
Greece	KARMACO LTD 51 Gounari Street 165-61 Glyfada, Athens	Tel: (30) 1 960 1346 Fax: (30) 1 961 5361
Holland	LAAGLAND B.V. Stolwijkstraat 20 PO Box 9443 3007 AK Rotterdam	Tel: (31) 10 292 22 22 Fax: (31) 10 292 22 29
Italy	ANGST & PFISTER SpA Viale Teodorico 25 20124 Milano	Tel: (39) 231 06.1 Fax: (39) 233 103 148

Israel	L.S.M. INDUSTRIES 1 Haofan Street Industrial Estate Holon	Tel: (97) 2 3 559 0910 Fax: (97) 2 3 559 0958
Portugal	Cautus Equipamentos Para IND Apartado 1725 2685 Santa Iria Azoia	Tel: (35) 119 567 003 Fax: (35) 119 595 067
Spain	Pentol Espanola Alta de Pedrell 32 08032 Barcelona	Tel: (34) 3357 6500 Fax: (34) 3407 1244
Sweden	G A LINDBERG AB Box 6044 164 06 Kista	Tel: (46) 8703 02 00 Fax: (46) 8703 02 48
Switzerland	SHELL ASEOL AG Steigenhubelstrasse 8 CH-3000 Bern 5	Tel: (41) 313 807 718 Fax: (41) 313 807 878
Australia	Rowe Trading Company PTY LTD 4 Holder Avenue Richmond S A 5033	Tel: (61) 88 234 000 Fax: (61) 88 234 2092
South Africa	ACHIEVO CHEM (PTY) LTD 13 1167 Northmead Benoni 1511 Transvaal	Tel: (27) 11 425 254 Fax: (27) 11 425 254
USA	PERMABOND INTERNATIONAL 480 South Dean Street Engelwood New Jersey 07631 - 6849	Tel: (1) 201 657 9494 Fax: (1) 201 567 3747

Importers/Dealers in Central and South America, Asia and the Far East should make inquiries from Permabond International in USA.