

# **H-Body Sealants Guide**

**"Attention: The information contained in this sealant guide was created by Winnebago Industries, Inc. for manufacturing purposes. Sealing processes and the type of sealant used can change depending upon a variety of circumstances. Duplication of a sealing process used by manufacturing may be difficult on a completed motor home. This information should be used as a reference tool. Please contact Winnebago Industries Technical Service for assistance."**



## H - BODY ROOF CAP SEALING

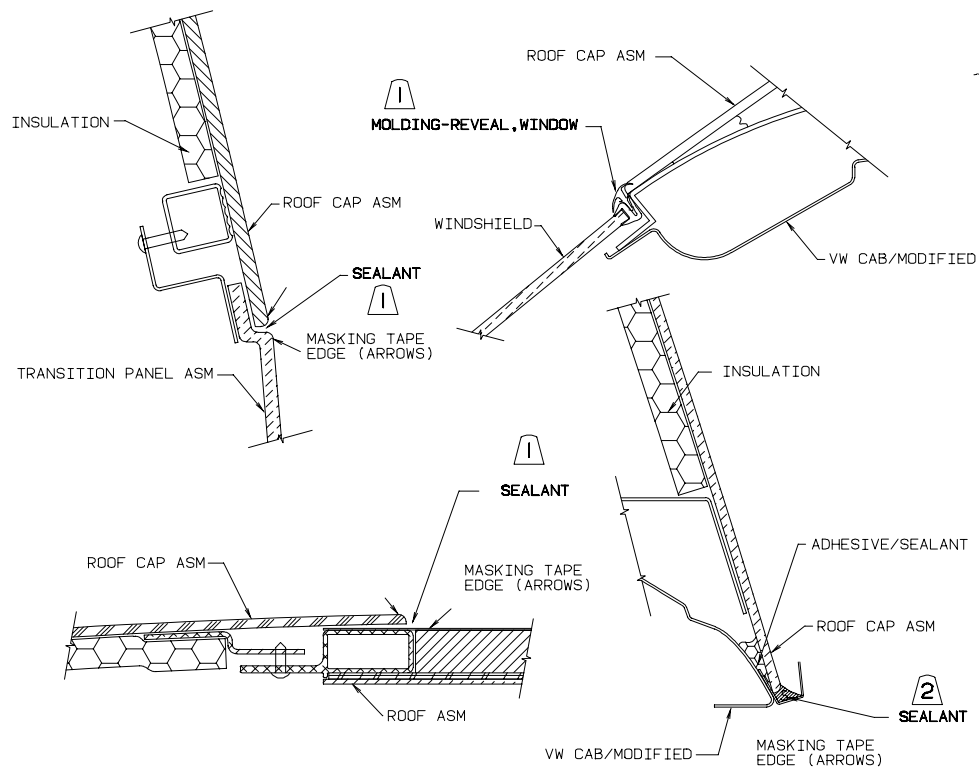
Revision Date: 9/3/98

ref-2

1. From the windshield trim, mask both edges of the sealing surface as required for aesthetic requirements, to the top edge of the roof corner. Apply cap seal (72889) to the edge all around and trowel per aesthetic requirements.
2. Apply sealant (72889) inside the drip rail sealing the edge of the roof cap to the inside edge of the drip rail

**NOTE: All painted aluminum skin surfaces that have sealant 72889 applied to them must be wiped with lacquer thinner (45704-02). Areas that have sealant 131264-03 applied must be wiped with Isopropyl Alcohol. Follow applicable procedures outlined below:**

- a. Wipe areas for sealant (72889) application with lacquer thinner (45704-02). Application should wet the surface for at least 5 seconds.
- b. After the surface is wet wipe excess from the surface with a dry towel
- c. Allow remaining thinner to flash off, then apply the silicone within 5 minutes of thinner application.
- d. Wipe areas for sealant (131264-03) with Isopropyl Alcohol (900058-01). Application is to insure a clean surface.



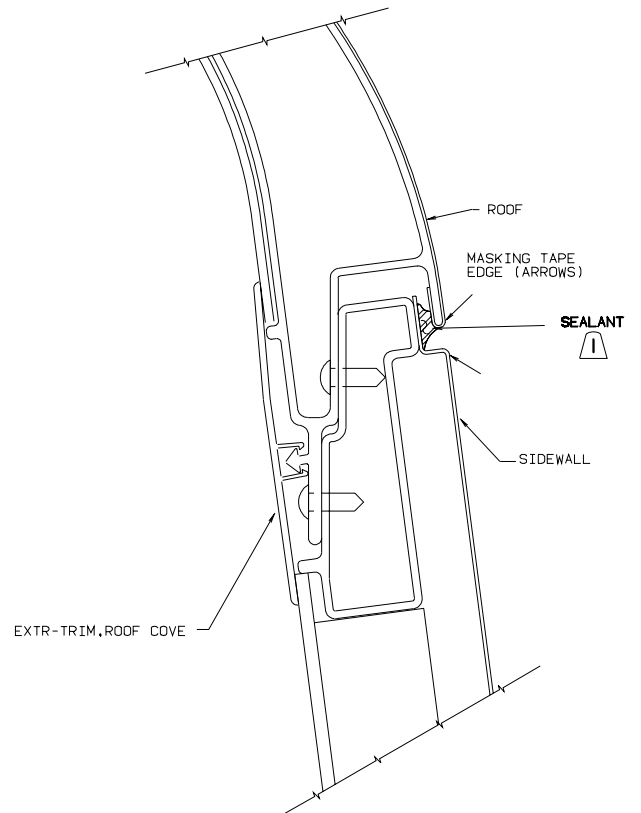
## H - ROOF TO SIDE WALL SEAL

Revision Date: 9/3/98

ref-3

1. Per aesthetic requirements, mask as necessary both edges of roof to side wall seam to be filled. Fill seam with sealant (72889). Trowel per aesthetic requirements.

**NOTE: All painted aluminum skin surfaces that have sealant applied too must follow the procedure outlined on page 2.**

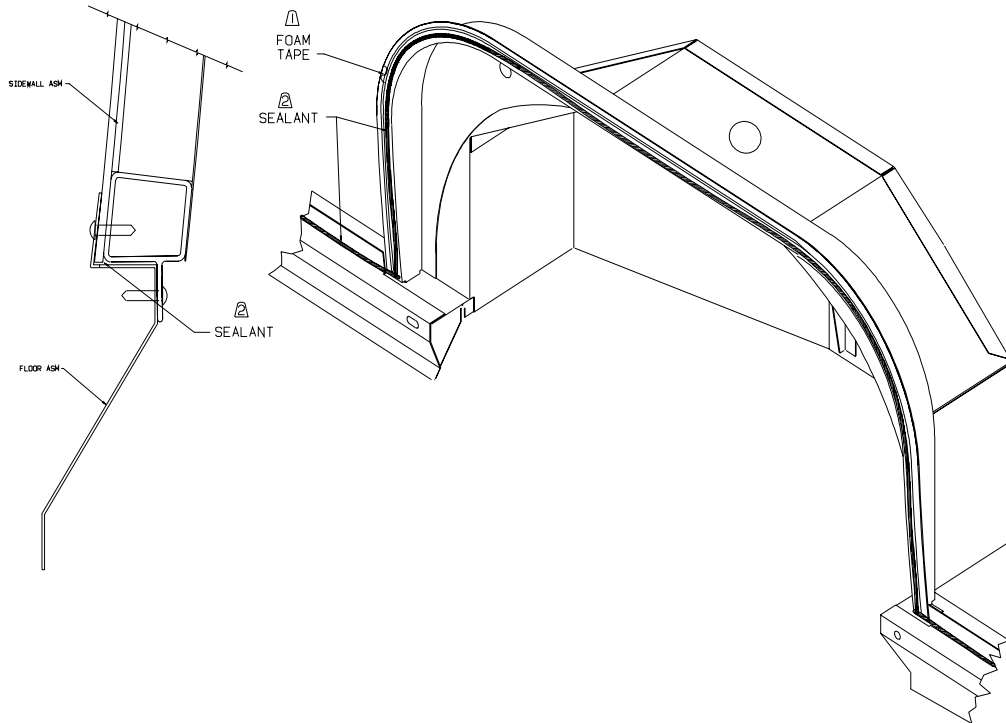


## H - SIDE WALL TO FLOOR SEAL

Revision Date: 2/2/94

ref-4

1. Apply foam tape (100128-02) around the perimeter of the wheel well.
2. Apply sealant (100932) to the floor flange that supports the sidewall.



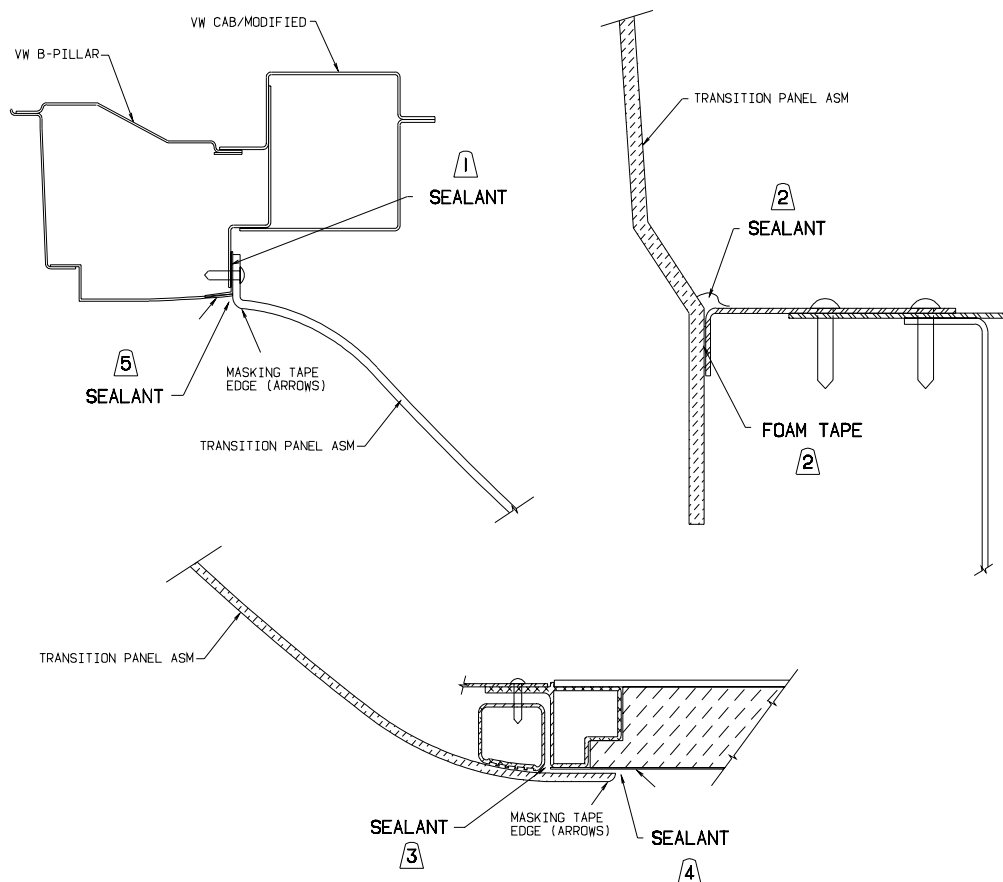
## H - TRANSITION PANEL SEAL

Revision Date: 9/3/98

ref-5

1. Apply sealant (72889) to the B pillar transition joint area. If squeeze out to the outside is an issue the area will need to be masked and squeeze out removed.
2. Apply foam tape (100128-02) to the flange of the transition sealing plate. Install the plate. Apply sealant (34552) to the top edge of the plate to transition panel joint. Insure that the foam has sealed the gaps at the ends of the transition plates.
3. Apply a 1/2 inch diameter bead of sealant (72889) to the transition panel at the point where the side wall meets the attachment tube on the transition panel.
4. Mask both surfaces of the exterior seams as required to meet aesthetic requirements. Apply sealant (72889) and trowel per aesthetic requirements.
5. Mask both surfaces of the exterior seams as required to meet aesthetic requirements. Apply sealant (900076-01) and trowel per aesthetic requirements.

**NOTE: All painted aluminum skin surfaces that have sealant applied too must follow the procedure outlined on page 2.**



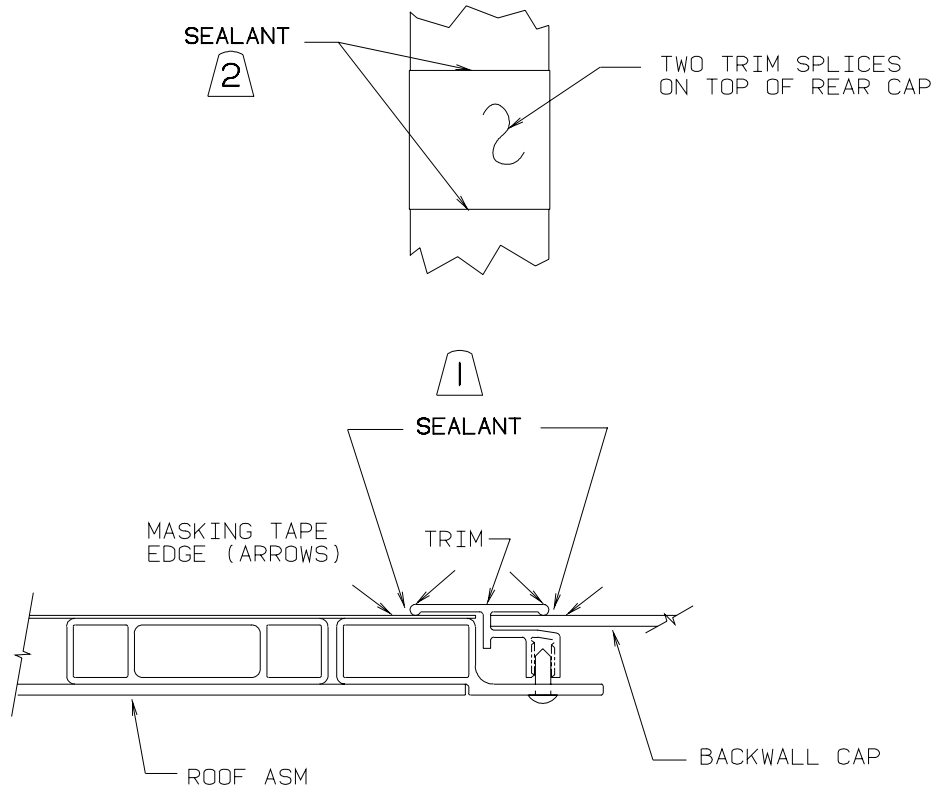
## H - ROOF/SIDE WALL TO REAR CAP SEAL

Revision Date: 9/3/98

ref-6

- 1 To cap seal, as required mask both edges of the seam on the front and back of the trim. Masking should be from the bottom edge up to the top edge of the roof radius. Cap seal (34552-14) the trim on both sides around the top radius of the rear cap. On the roof to back cap joint seal with self-leveling silicone (131264-03) Trowel 34552-14 per aesthetic requirements.

2. Seal with silicone (131264-03) across the rear cap trim at both splice joints on top of the cap.
- NOTE: All painted aluminum skin surfaces that have sealant applied too must follow the procedure outlined on page 2.**



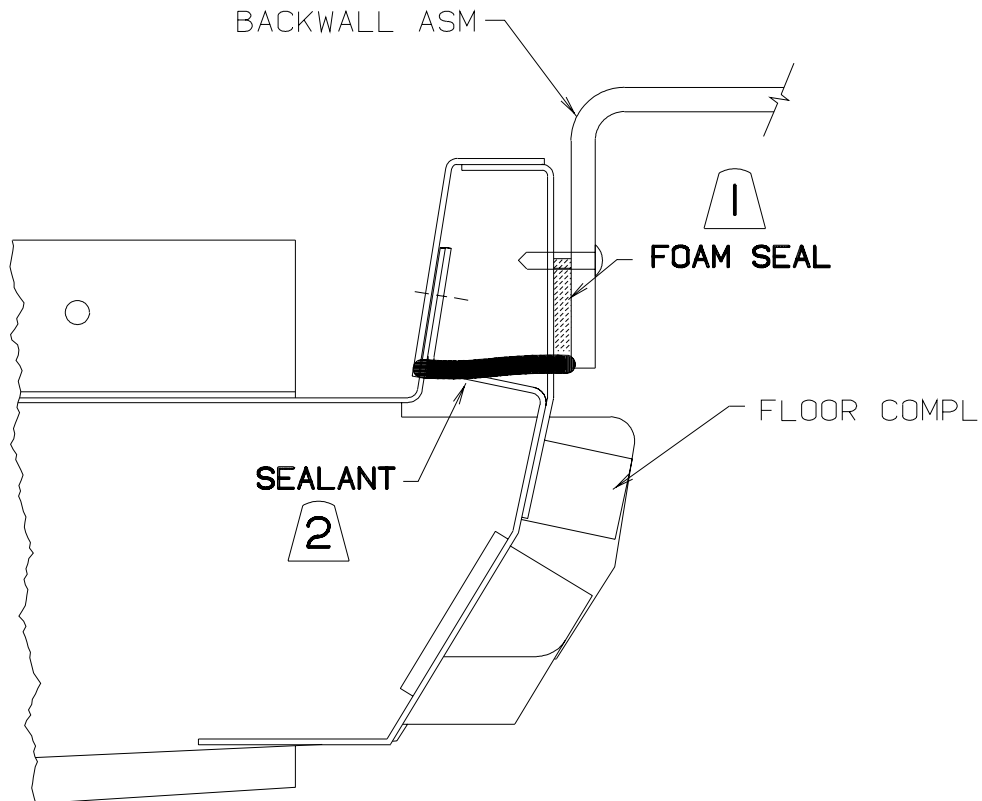
## H - FLOOR TO REAR CAP SEAL

Revision Date: 3/26/97

ref-7

1. Apply foam tape (104692-01) to the joint formed by the steel floor and rear cap flange.
2. Apply sealant (72889) to the bottom corners of the cap to floor joint.

**Note:** This new procedure started with the 97 Rialta

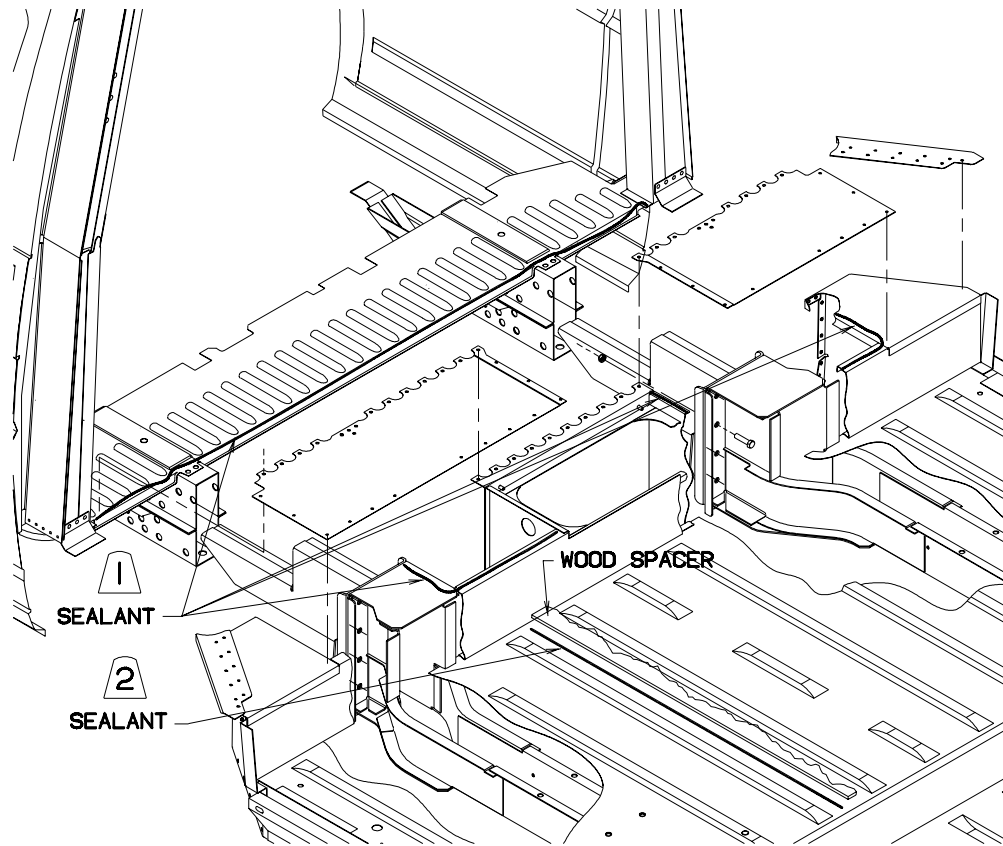


## H - CAB TO BODY FLOOR PANEL SEALING

Revision Date: 5/23/97

ref-8

1. Apply sealant (102352) to the floor to seal plate joints. Plates are at the cab to body joint at the floor.
2. Apply sealant (72889) under the wood spacers placed on the steel floor. The main purpose of the sealant is adhesion of the wood spacer to the floor.





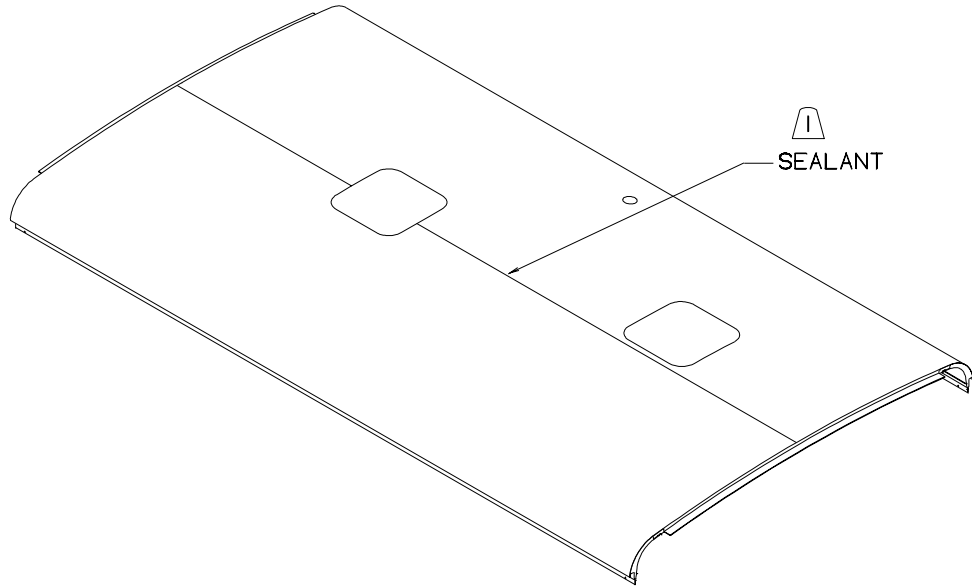
## H - ROOF

Revision Date: 9/3/98

ref-9

1. Apply sealant (131264-03) to the metal seam down the center of the roof.

**NOTE: All painted aluminum skin surfaces that have sealant applied too must follow the procedure outlined on page 2.**

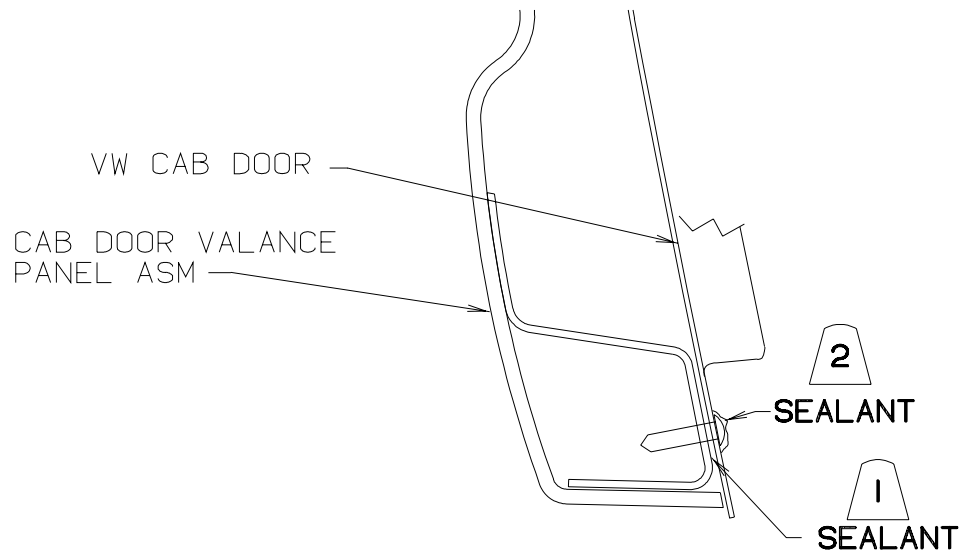


## H - PAS/DR DOOR VALANCE PANEL

Revision Date: 3/3/94

ref-10

1. Apply tape (69640-14) to the inside bottom-metal surface of the valance panel. Insure the tape covers the area were the attachment screws will fasten.
2. After installing the panel apply sealant (72889-08) over the head of the screw insuring that any raw metal edges are covered.

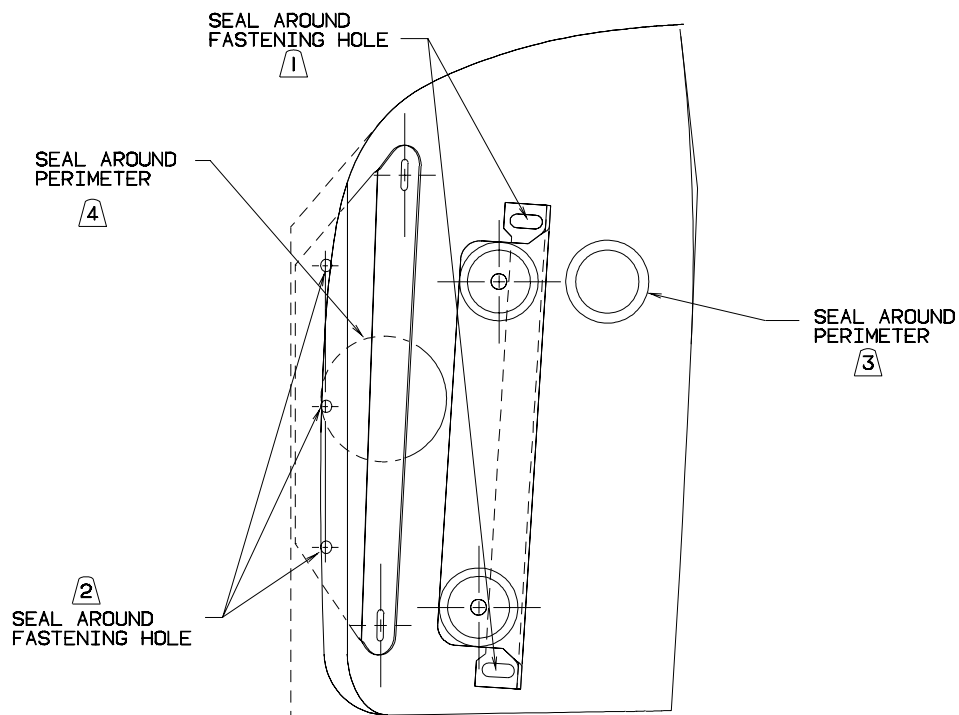


## H - REAR TAIL LIGHTS

Revision Date: 6/21/94

ref-11

1. Apply sealant (107828) to the bracket around the fastening holes. As the bracket is fastened the sealant should seat around the screw.
2. Apply sealant (107828) to the bracket around the fastening holes. As the bracket is fastened the sealant should seat around the rivets.
3. After the plugs are installed seal (107828) around the perimeter of the plugs.
4. After the grommet is installed seal (107828) around the perimeter of the grommet and seal all the wires going through the grommet.
5. Be sure the light is adjusted up against the top of the pocket to prevent as much water as possible from getting behind the light.

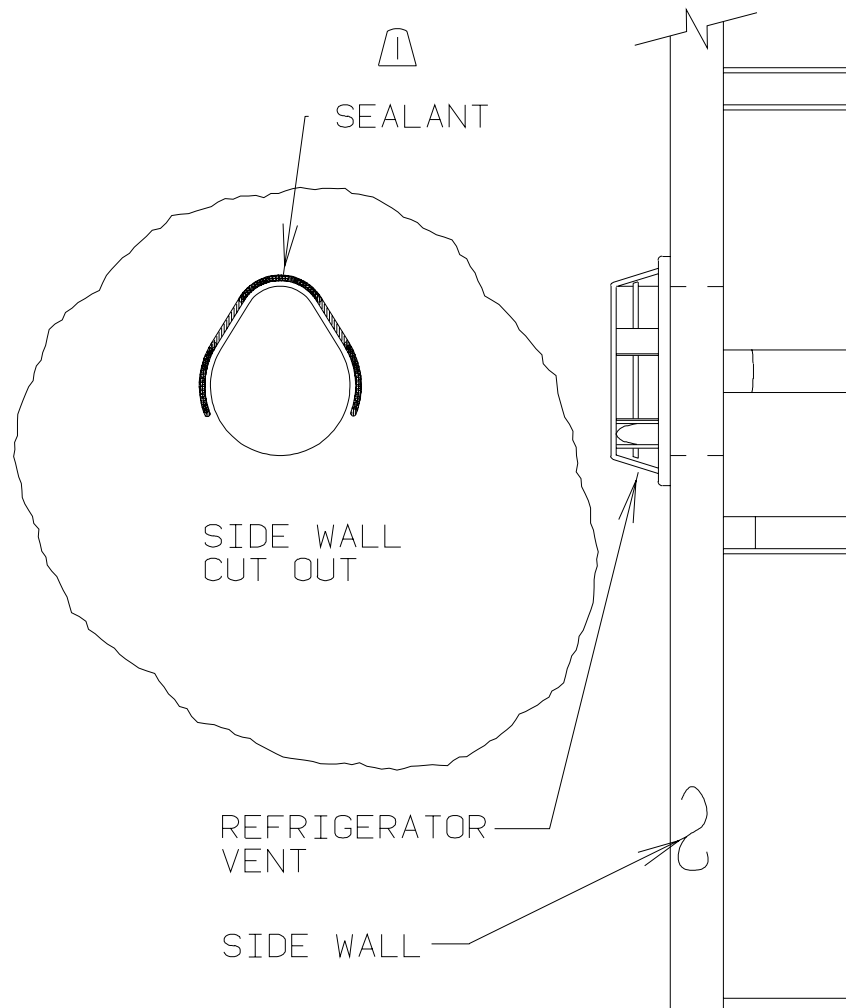


## H & B REFRIGERATOR VENT

Revision Date: 6/24/94

ref-12

1. Apply a 1/4 inch diameter bead of sealant (34552 or 94401 or 107828) to the sidewall around the upper 2/3 of the refrigerator vent cut out. After installing the vent, wipe off all excess squeeze out per aesthetic requirements.

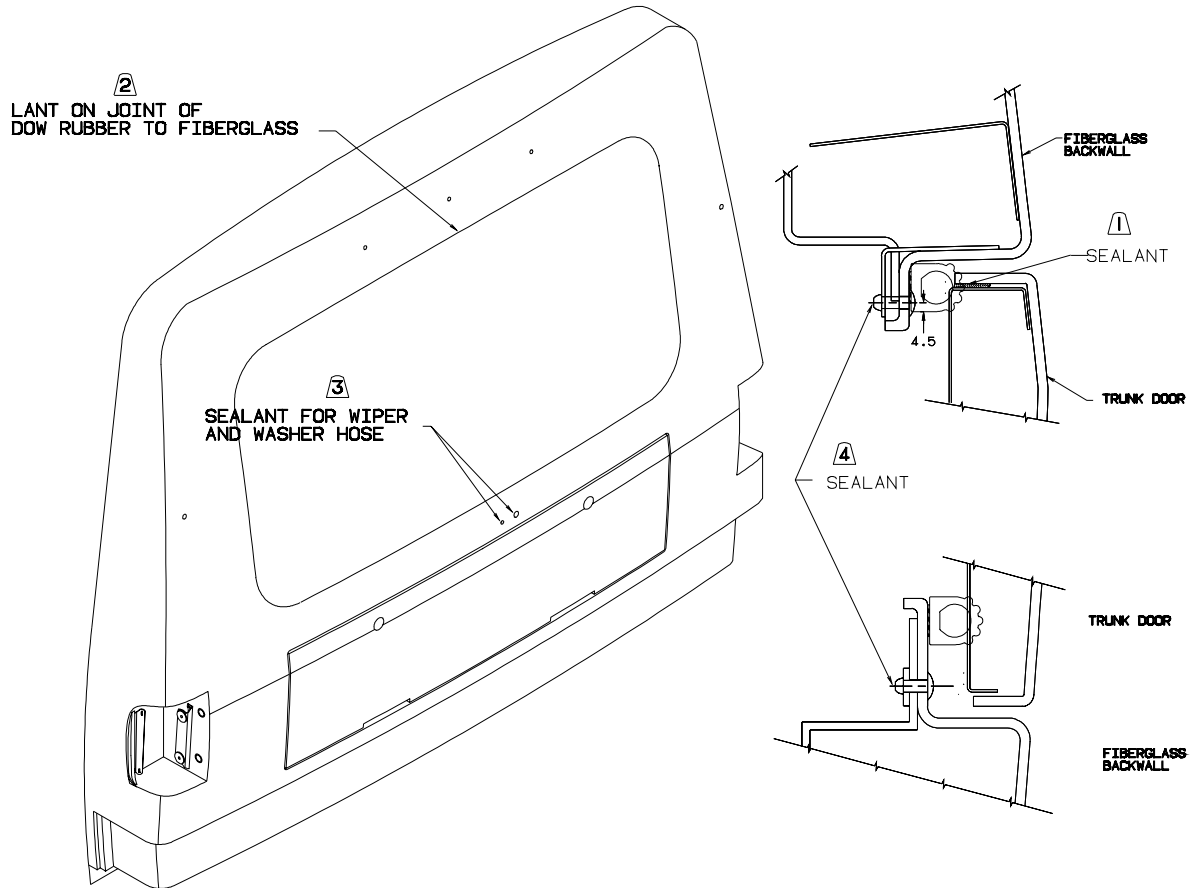


## H - BACK WALL

Revision Date: 10/19/99

ref-13

1. To the trunk door apply sealant (34552) filling the groove between the inside of the fiberglass and the steel support panel. **Fill the groove on the top and the sides of the door only.**
2. Apply sealant (053752-09) to the joint formed by the window rubber molding and the fiberglass cap.
3. Apply sealant (34552) to the joint formed by the wiper shaft and the fiberglass. Apply sealant (34552) to the washer hose and retainer ring.
4. Apply sealant (102352-02) to the ends of the rivet. The material only needs to seal the middle of the rivet that the mandrel is in.
5. All openings through the back wall must be sealed (107828). *i.e.* light attachment screws, wire holes, *etc.*,

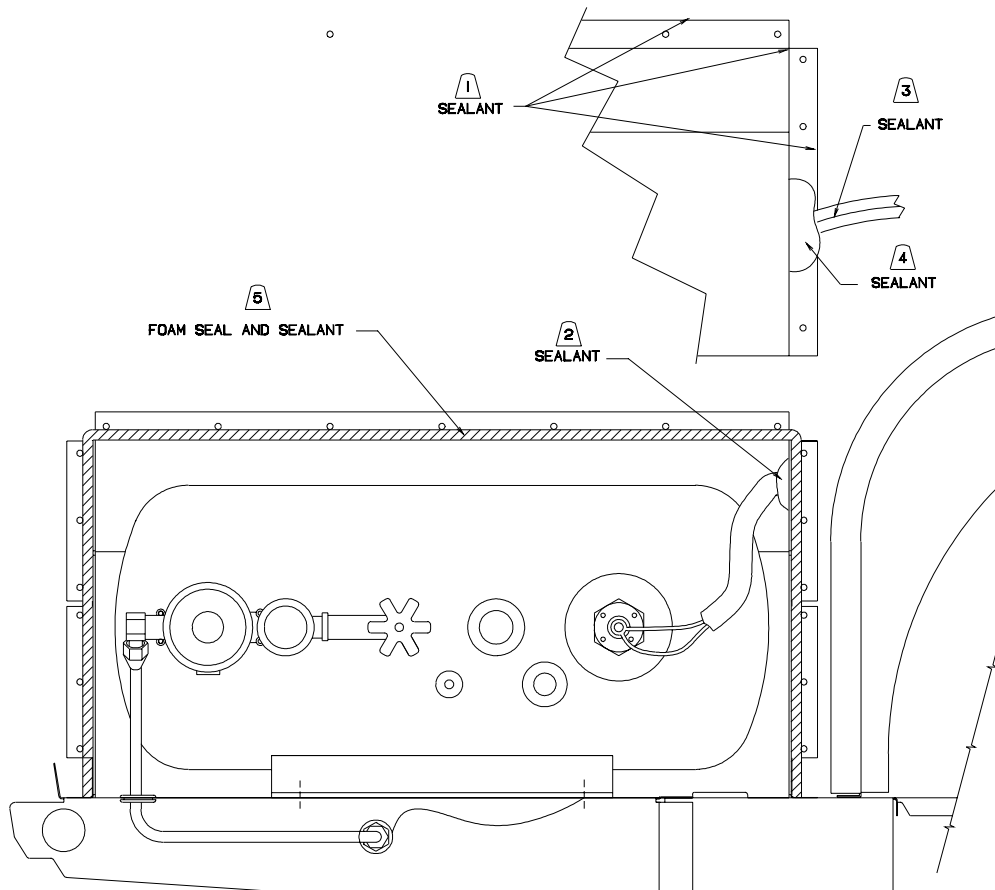


## H - LP COMPARTMENT

Revision Date: 7/22/94

ref-14

1. Apply sealant (102352) to the bottom flange of the compartment. Install the compartment and insure sealant squeeze out around the entire perimeter of the compartment. Check the corners for voids and add sealant to any questionable areas.
2. Apply butyl tape (69640-12) around the convolute and to the inside wall of the LP compartment.
3. Insert foam (110744-01) into the convolute from the outside of the compartment, insuring that the foam goes through the convolute to the inside of the compartment. This will seal the inside of the coach from gases entering through the convolute.
4. Apply foam (110744-01) on the outside of the box around the convolute to box joint to insure sealing.
5. Apply foam (100128-02) to the sidewall to compartment box joint. After installing the side wall, apply sealant (100932 or 106206 or 39518) to the perimeter of the box to side wall joint.



## H - EXTERIOR 110 PLUG COVER

Revision Date: 4/14/99

ref-15

1. Cap seal (72889) the top and sides of the plug cover. Finish per aesthetic requirements.

