

FLA COE  
FLB COE  
FLD Conventional  
Business Class  
FLC 112 Conventional

Century Class Conventional  
Argosy COE  
Cargo  
Columbia

122SD and Coronado  
Business Class M2  
> Cascadia  
108SD/114SD

Freightliner  
Service Bulletin

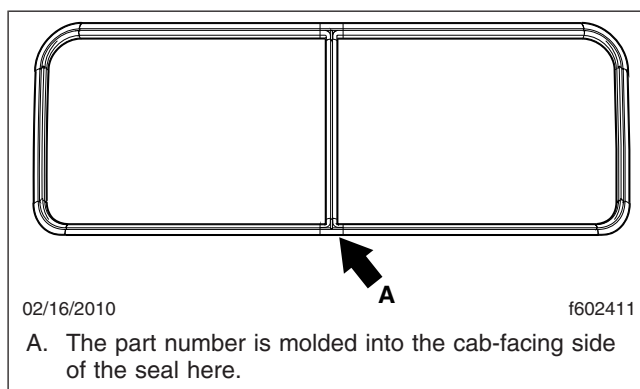
**Description of Revisions:** *This bulletin replaces the version dated April 2013. The information on Dow products is revised.*

## General Information

From November 23, 2009, Cascadia models were built with a specially treated windshield seal/gasket that improves bond strength with the urethane adhesives used in production. The replacement seals A18-66173-000 and A18-64181-000 are also specially treated. This change eliminates the need to use Lord Chemlok® 7701 in the installation of the new seal.

## Recommended Adhesives and Pre-Treatment Materials

The treated seal has the part number "A18-66173-000" or "A18-64181-000" molded into the seal at the bottom center "T" section, on the cab-facing side; see [Fig. 1](#).



**Fig. 1, Location of Part Number on New Seal**

**IMPORTANT:** If the part number "A18-66173-000" or "A18-64181-000" is molded on the seal, it is a treated seal, and it must be installed using the materials listed below. Do not use Lord Chemlok 7701 when installing a treated seal.

If the part number molded on the seal is anything other than "A18-66173-000" or "A18-64181-000," or if the part number is missing, it is the old-style untreated seal, and Lord Chemlok 7701 must be applied to the seal as specified in step 12 of the *Cascadia Workshop Manual*, **Section 60.02, Subject 110**.

When installing a treated seal (A18-66173-000 or A18-64181-000), DTNA recommends using the Sika products as listed in the *Cascadia Workshop Manual*, **Section 60.02, Subject 110**, with the exception of Lord Chemlok 7701. The following recommended products may be used:

- Sika®-Primer 206 G+P—priming of any bare metal that may be exposed during the removal of the old seal
- Sika® Aktivator—cleaning and preparing of the cab and new seal surfaces
- SikaTack®-Ultrafast or SikaTack®-ASAP— adhesive

Two alternative adhesives from the Dow Automotive product line also provide sufficient strength needed for use with the new treated seal. These adhesives and the pre-treatment materials are listed below. Use with application guidelines supplied by Dow.

# 60-144 New Cascadia Windshield Seal, Adhesive, and Preparation

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## Freightliner Service Bulletin

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- Dow Betaprime™ 5504G or 5404A—priming the bonding surface of the replacement gasket and any bare metal or painted surfaces that may be exposed during the removal of the old seal
- Dow Betaclean™ GC-800 Glass Cleaner—cleaning of adhesive contact surfaces
- Dow Betaseal™ U-418HV or Betaseal™ Express—adhesive

For Dow product descriptions and application guidelines, see <http://automotive.dow.com>.

## Warranty

This is an informational bulletin only. Warranty does not apply.