



XJ range

DATE 12/05

XJ417-02

SERVICE

TECHNICAL BULLETIN

Bezel Detached From Tail Lamp Assembly – Adhesive Repair Procedure

MODEL 2004-05 MY
XJ range

VIN G00001-G45289

Issue:

On some 2004-05 MY XJ range vehicles, within the above VIN range, customers may have concerns of the tail lamp bezel coming away from the tail lamp. This condition can be caused by poor adhesion between the bezel and lamp assembly.

Action:

In case of a customer complaint of the above condition on a 2004-05 XJ range vehicle, clean and reinstall the bezel following the procedure outlined below.

TAIL LAMP BEZEL REPAIR

On vehicles **up to** VIN G25515, when removing one tail lamp assembly, the other tail lamp assembly must also be removed and a new seal installed.

From VIN G25516 remove the affected tail lamp assembly only.

⚠ Caution: While working on the tail lamp assembly, protect lens and bezel surface from damage by using a clean working area, and protective bench surface.

1. Remove the tail lamp assembly (see Global Technical Reference GTR Workshop Manual, section: 417-01).

NOTE: THE INFORMATION IN TECHNICAL BULLETINS IS INTENDED FOR USE BY TRAINED, PROFESSIONAL TECHNICIANS WITH THE KNOWLEDGE, TOOLS, AND EQUIPMENT TO DO THE JOB PROPERLY AND SAFELY. IT INFORMS THESE TECHNICIANS OF CONDITIONS THAT MAY OCCUR ON SOME VEHICLES, OR PROVIDES INFORMATION THAT COULD ASSIST IN PROPER VEHICLE SERVICE. THE PROCEDURES SHOULD NOT BE PERFORMED BY "DO-IT-YOURSELFERS." DO NOT ASSUME THAT A CONDITION DESCRIBED AFFECTS YOUR CAR. CONTACT A JAGUAR DEALER TO DETERMINE WHETHER THE BULLETIN APPLIES TO YOUR VEHICLE.

Note: Use care to clean off adhesive tape from tail lamp bezel surface with wipe cleaner supplied in kit (C2C 33542).

2. Remove the seal from the tail lamp bezel/housing (Illustration 1).

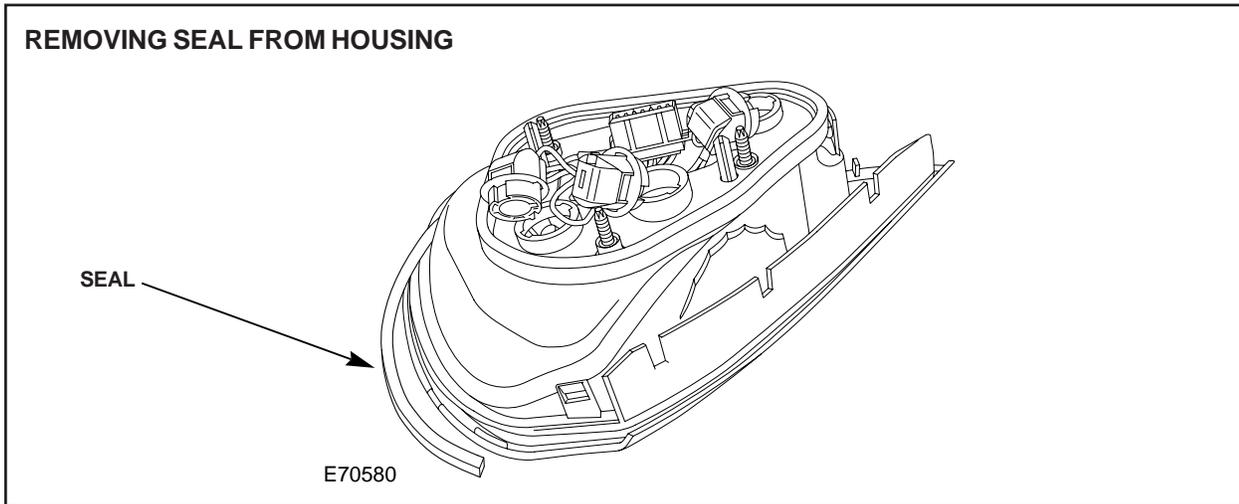


ILLUSTRATION 1

3. Remove loose dust and dirt from the tail lamp housing and bezel.
4. Hold the loose part of the tail lamp bezel away from the tail lamp housing (Illustration 2).

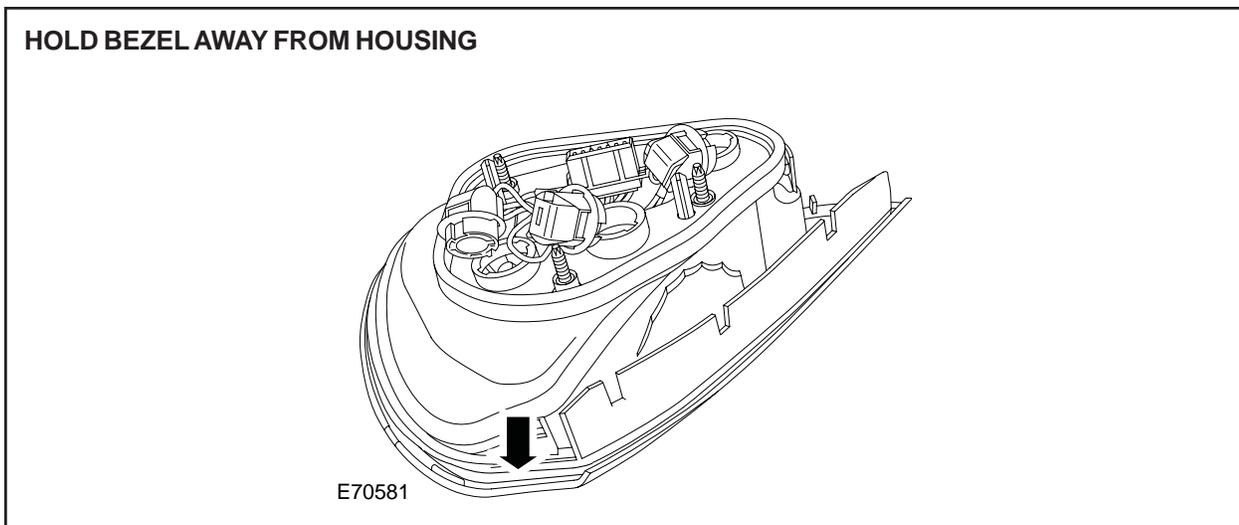


ILLUSTRATION 2

Note: Effectiveness of this repair is dependant on this cleaning operation.

5. Using wipe cleaner supplied in kit (C2C 33542) fully clean the surfaces between the tail lamp bezel and the tail lamp housing.

- Using masking tape, mask around the outer edge of the tail lamp bezel to prevent adhesive transfer to the visible surfaces of the bezel (Illustration 3).

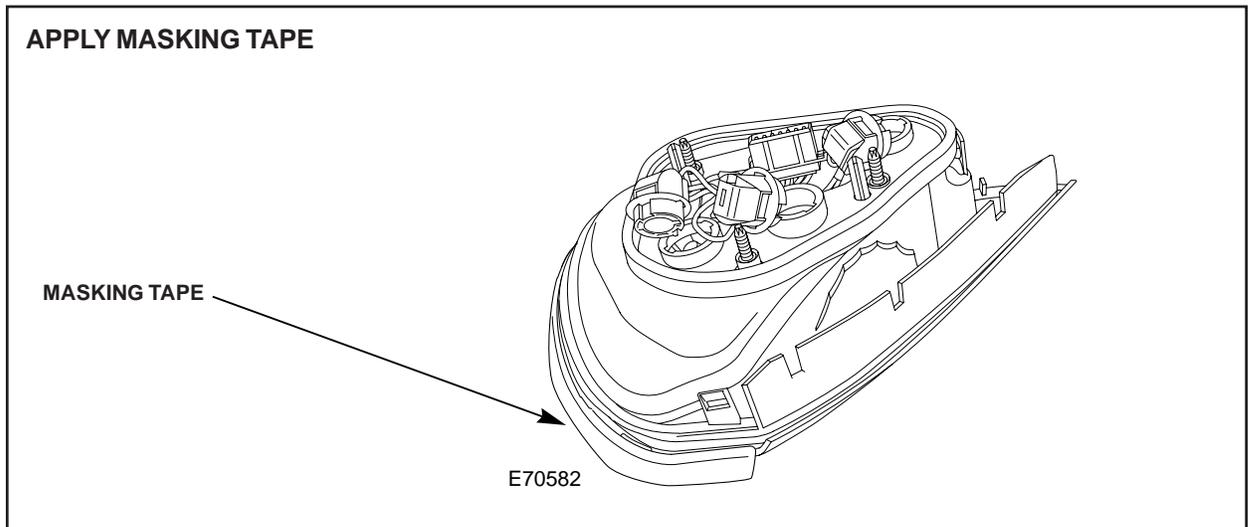


ILLUSTRATION 3

- Position strips of masking tape to the tail lamp lens in preparation for holding the bezel down once adhesive is applied (illustration 4).

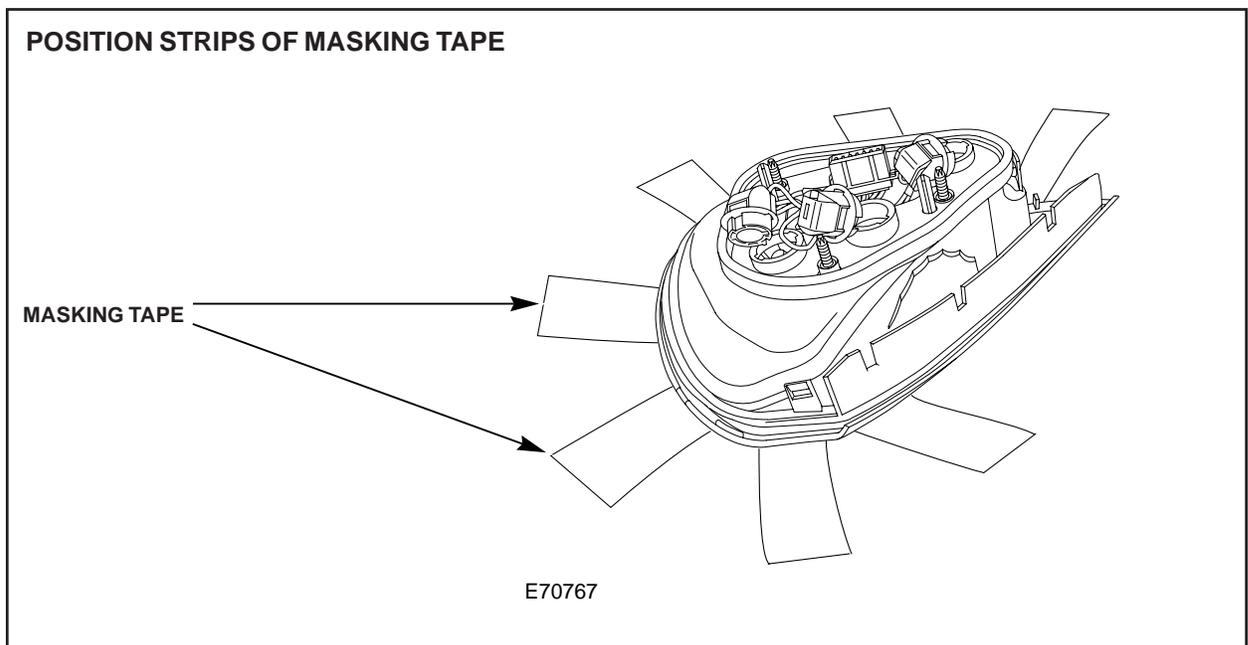


ILLUSTRATION 4

8. Only apply adhesive in the area identified in Illustration 5.

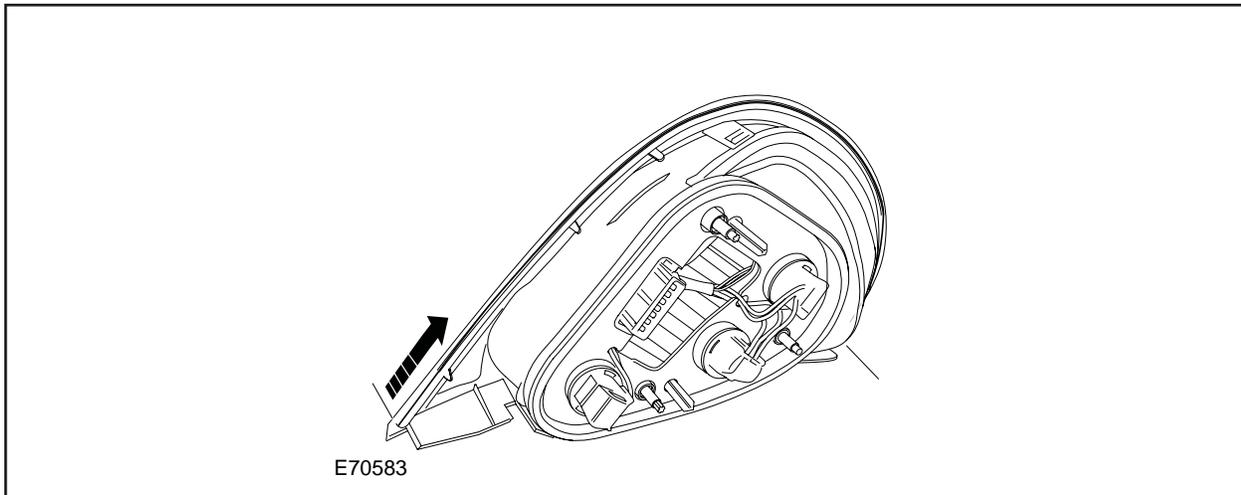


ILLUSTRATION 5

Note: The nozzle delivers a 3 mm (0.11 inch) bead of adhesive without the need to trim the nozzle. Working time for the adhesive product is four minutes maximum at 30°C (86°F). Allow the adhesive to cure for a minimum six hours before installing the lamp.

Note: Using special tools DS272990500, DS272990484, adhesive cartridge (C2C 33549) and nozzle supplied in kit (C2C 33542).

9. Hold the loose part of the bezel away from the tail lamp housing (approximately 1-2 mm (0.04-0.07 inch)); apply a 3 mm (0.11 inch) bead of adhesive in 40 mm (1.57 inch) strips every 40 mm (1.57 inch (see illustration 6)) between the tail lamp bezel and the lamp housing (see inset in illustration 6). Ensure the adhesive does not penetrate through to visible surface of the tail lamp lens. Spatula adhesive into gap and smooth out adhesive bead.

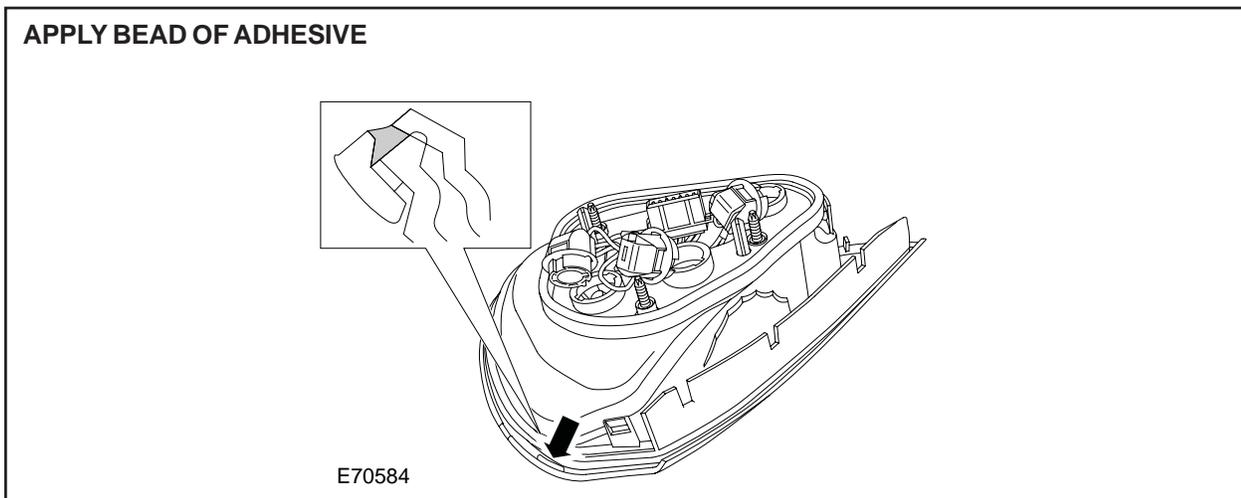


ILLUSTRATION 6

10. Attach the bezel to the rear tail lamp housing, and retain in place using strips of masking tape, previously applied in step 7 (Illustration 7).

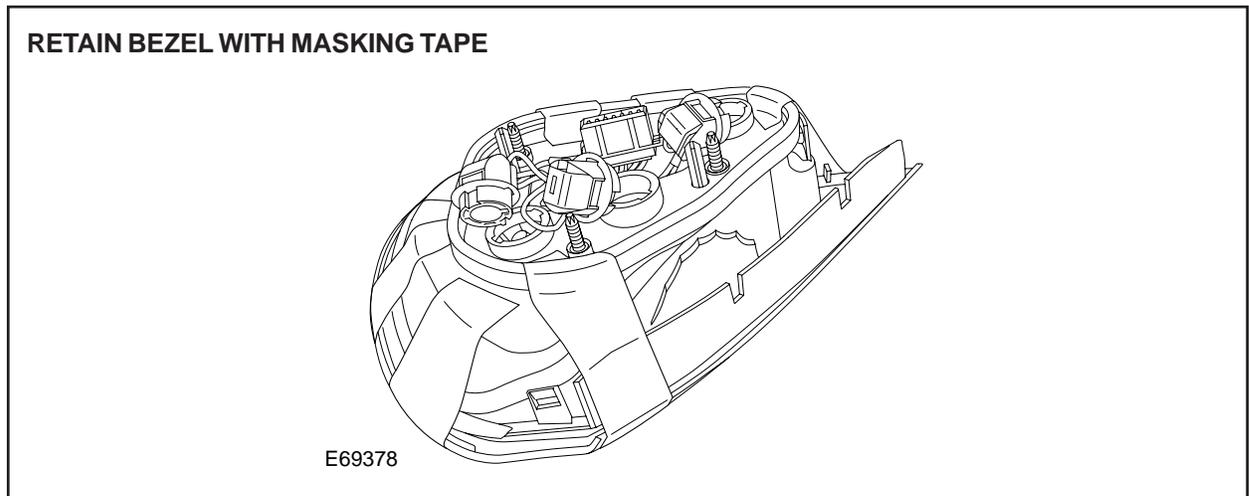


ILLUSTRATION 7

11. Clean off any excess adhesive from the tail lamp assembly using the wipes supplied in the kit (C2C 33542).
12. Starting adjacent to the reference line on the tail lamp bezel (see illustration 8), install tail lamp seal supplied in kit (C2C 33542) to the tail lamp housing.

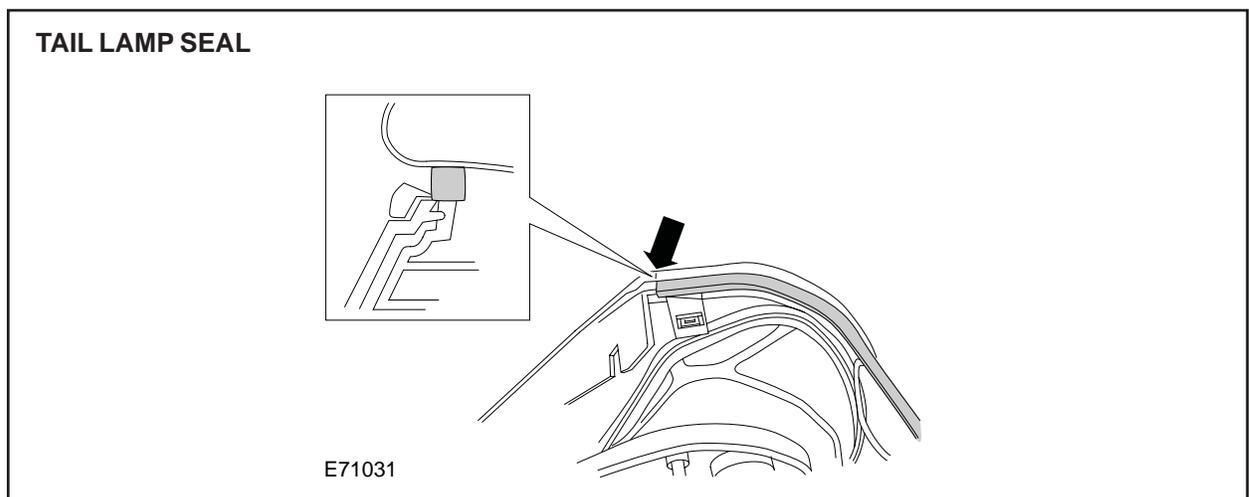


ILLUSTRATION 8

On vehicles prior VIN G25515, with only one side tail lamp bezel loose

13. Carry out steps 1 to 3 for the opposite tail lamp.

14. Starting adjacent to the reference line on the tail lamp bezel (see Illustration 9), install tail lamp seal supplied in kit (C2C 33542) to the tail lamp housing.

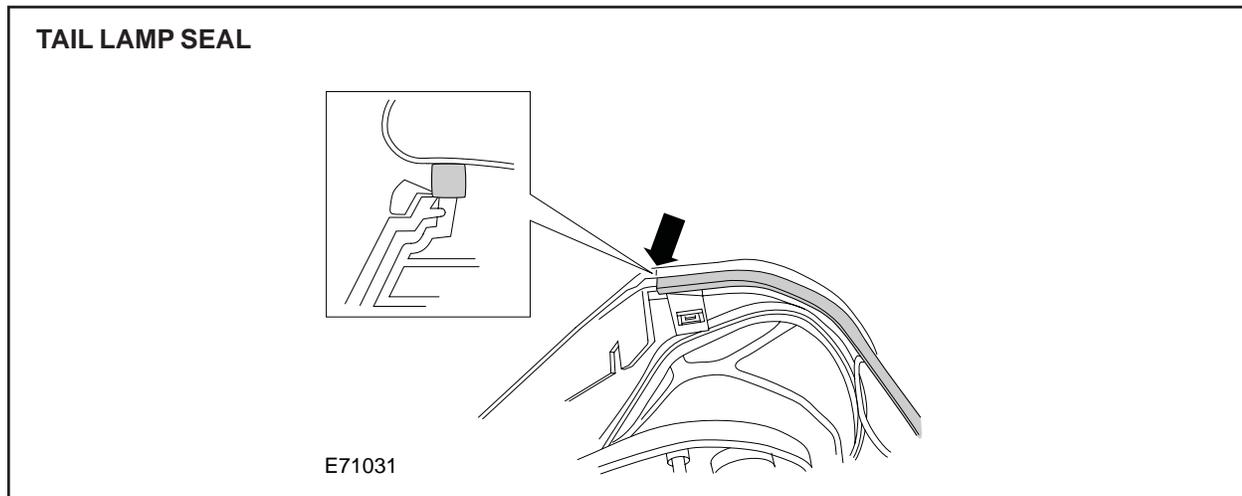


ILLUSTRATION 9

On all vehicles, if the opposite tail lamp bezel is loose

15. Carry out steps 1 to 12.
16. Install rear lamp assembly(ies) (see Global Technical Reference GTR Workshop Manual, section: 417-01).

Global Technical Reference (GTR) Workshop Manual Information:

Dealer access: <https://hub.franchise.jaguar.com>

Internet access: <http://www.jaguartechno.com>

Parts Information:

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
Adhesive cartridge (3M Scotch-Weld EPX Polyurethane Adhesive DP609) Kit (contains: Wipe cleaner x 6, Nozzle adhesive mix x 2 and Tail lamp seal x 2	C2C 33549	1
	C2C 33542	1

Warranty Information:

Warranty claims should be submitted quoting the information found in the table below. This will result in payment of the stated time and, where applicable parts/miscellaneous expense codes as listed.

Description	SRO	Time	Causal Part Number
Tail lamp bezel repair - From VIN G25515	86.93.56	0.5 hrs.	C2C 19432
Tail lamp bezel repair - Prior VIN G25516	86.93.61	0.9 hrs.	C2C 19432
Tail lamp bezel repair both sides - VIN G00442 to G45289	86.93.60	1.0 hr.	C2C 19432

Note: Repair procedures are under constant review, and therefore repair times are subject to change. The times quoted here must be taken as guidance only. Always refer to DDW to obtain the latest repair time.