

Crown Canopy Assembly - Front Window Installation

WORK INSTRUCTION



Department	Canopy Assembly	DATE	1 October 2015	Instruction No.	WI 04011
Process	Front Window STD	ISSUE	1	PAGE	1 of 4
Activity No	11	AUTHOR	Kevin Fox		

No	Operation	Tools, Materials, Parts & Process
----	-----------	-----------------------------------

11.01	<p>Prepare Tools, Materials & Parts:</p>	<div data-bbox="965 405 1346 464"> <p>Pneumatic gun + 1/4" socket</p> </div>  <div data-bbox="965 711 1227 770"> <p>Alcohol & Cloth</p> </div>  <div data-bbox="972 975 1285 1066"> <p>C5-54-TAPE-WB Window Sealing Bead</p> </div>  <div data-bbox="976 1235 1193 1390"> <p>C5-10-39594 Front Sliding Window</p> </div>  <div data-bbox="1783 432 2130 523"> <p>C5-54-3144 Window Trim Garnish Clip</p> </div>  <div data-bbox="1827 762 2101 853"> <p>C5-54-2027148 Window Screw X 20</p> </div> 
-------	--	--

Crown Canopy Assembly - Front Window Installation

WORK INSTRUCTION



Department	Canopy Assembly	DATE	1 October 2015	Instruction No.	WI 04011
Process	Front Window STD	ISSUE	1	PAGE	2 of 4
Activity No	11	AUTHOR	Kevin Fox		

No	Operation	Tools, Materials, Parts & Process
----	-----------	-----------------------------------

11.02 Select pre-checked Front Sliding window (C5-10-39594) and remove the keeper plate from window

Attach the Garnish clip (C5-54-3144) to the keeper plate and hang keeper plate on hooks for future use.



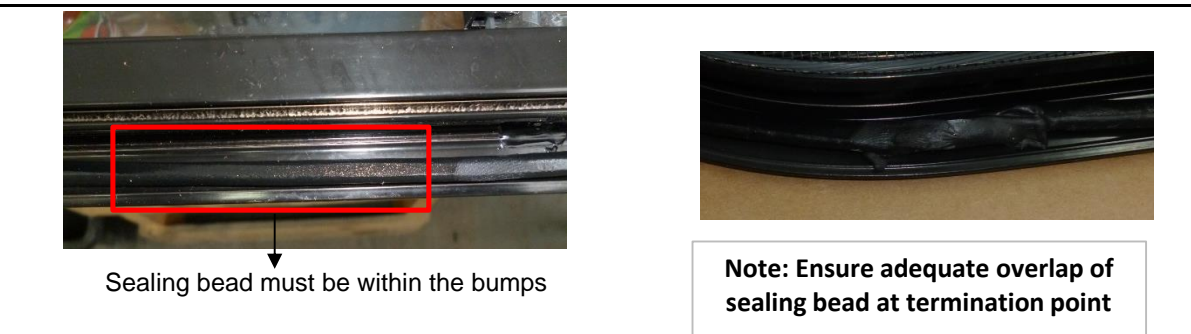
11.03 Wipe down sealing surface with a Alcohol and prepare for Window sealing bead



11.04 Note: Before applying sealing bead:-

- a) Check window splice joint for excess caulking
- b) If excess caulking is present - Remove excess to ensure a good seal between window frame and canopy without breaking sealed joint

Apply window sealing bead (C5-54-TAPE-WB) around periphery of window frame



Crown Canopy Assembly - Front Window Installation



WORK INSTRUCTION



		Department	Canopy Assembly	DATE	1 October 2015	Instruction No.	WI 04011
		Process	Front Window STD	ISSUE	1	PAGE	3 of 4
		Activity No	11	AUTHOR	Kevin Fox		

No	Operation	Tools, Materials, Parts & Process
----	-----------	-----------------------------------

11.05	Working from inside of canopy fit Front Sliding Window (C5-10-39594) into pre cut aperture	
-------	--	--

11.06	<p>Firmly pull Front Window into aperture.</p> <p>Ensure window is centralised horizontally.</p>	
-------	--	--

11.07	<p>Locate & centralise keeper plate on window and secure in places (see photo) using window screws (C5-54-2027148).</p> <p>Check alignment - adjust as required</p>	
-------	--	--

Crown Canopy Assembly - Front Window Installation



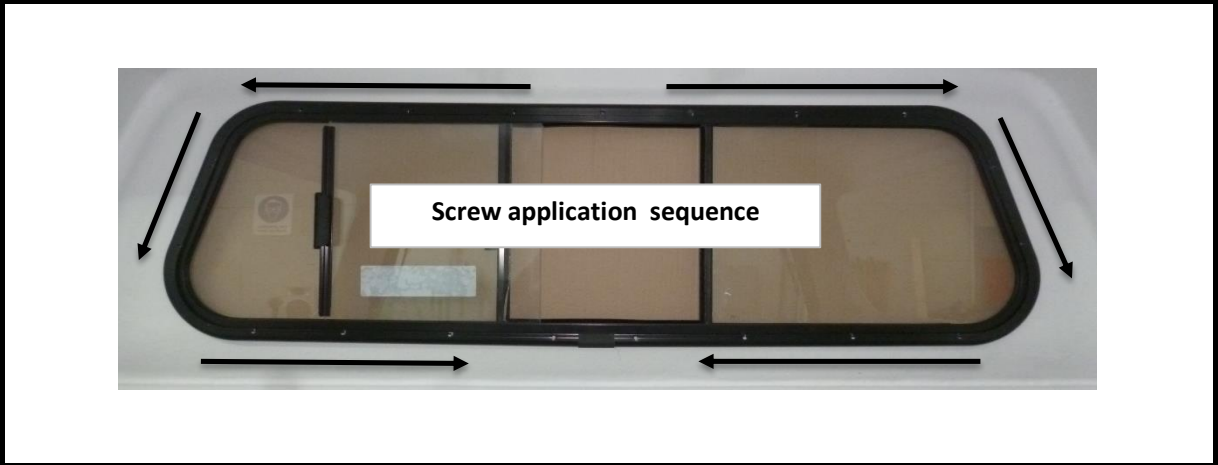
WORK INSTRUCTION



		Department	Canopy Assembly	DATE	1 October 2015	Instruction No.	WI 04011
		Process	Front Window STD	ISSUE	1	PAGE	4 of 4
		Activity No	11	AUTHOR	Kevin Fox		

No	Operation	Tools, Materials, Parts & Process
----	-----------	-----------------------------------

11.08 Working from Top Centre of keeper plate outwards (see photo) screw in remaining screws with pre torque pneumatic gun & 1/4" socket driver



11.09 Once window is fully fitted check the outside for Window Sealing Bead ooze.

Spray area (where sealing bead is oozing) with soapy water and trim excess sealing bead as required taking care not to damage canopy

