








# Crown Canopy Assembly - Side Window Installation

## WORK INSTRUCTION



Department	Canopy Assembly	DATE	14 September 2015	Instruction No.	WI 04012
Process	Side Window STD	ISSUE	1	PAGE	1 of 4
Activity No	12	AUTHOR	Kevin Fox		

No	Operation	Tools, Materials, Parts & Process	
12.01	Prepare Tools, Materials & Parts:	<p>Pneumatic gun + 1/4" socket</p>  <p>Special levering tool</p>  <p>Alcohol &amp; Cloth</p>  <p>C5-54-TAPE-WB Window Sealing Bead</p>  <p>C5-21-39626R R/H Side Sliding Window</p> <p>C5-21-39626L R/H Side Sliding Window (Not</p> 	<p>C5-54-3144 Window Trim Garnish Clip</p>  <p>C5-54-2027148 Window Screw X 20</p> 

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**12.02** Select pre-checked Side Sliding window (C5-21-39626R - Shown) 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.



**12.03** Wipe down sealing surface with a Alcoho and prepare for Window sealing bead



**12.04** 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



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12.05	Working from inside of canopy fit Side Window (C5-21-39626R - Shown) into pre cut aperture	
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12.06	Firmly pull Side Window into aperture.	
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12.07	Centralise window top to bottom and from side to side.	
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<p><b>12.08</b></p>	<p>Locate &amp; centralise keeper plate on window and secure in 2 places (see photo) using window screws (C5-54-2027148 ).</p> <p>Check alignment - adjust as required</p>	
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<p><b>12.09</b></p>	<p>Working from Top Centre of keeper plate outwards (see photo) screw in remaining screws with pre torque pneumatic gun &amp; 1/4" socket driver</p>	
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<p><b>12.10</b></p>	<p>Once window is fully fitted check the outside for Window Sealing Bead ooze.</p> <p>Spray area (where sealing bead is oozing) with soapy water and trim excess sealing bead as required taking care not to damage canopy</p>	
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<p><b>12.11</b></p>	<p>Repeat operations 2.02 to 2.09 for opposite side.</p>	
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