

# Crown Canopy Assembly - End Cap Installation

## WORK INSTRUCTION



	Department	Canopy Assembly	DATE	22 August 2017	Instruction No.	WI 04016
	Process	End Cap Installation	ISSUE	6	PAGE	1 of 5
	Activity No	16	AUTHOR	Gowtham Ramesh		

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

16.01 Work Instruction WI04016 End Cap Fitting is suitable for All models:

**Prepare Tools, Materials & Parts:**

C5-56-0621



YC-11-WXM510



C5-56-0652710



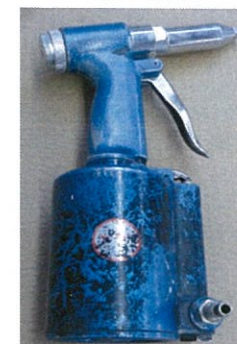
Sealant Gun with Sealant



Pneumatic gun +



Pneumatic Cutter



Pneumatic Rivet gun



End caps X 2



Pneumatic Grinder

# Crown Canopy Assembly - End Cap Installation

## WORK INSTRUCTION



<b>Department</b>	Canopy Assembly	<b>DATE</b>	22 August 2017	<b>Instruction No.</b>	WI 04016
<b>Process</b>	End Cap Installation	<b>ISSUE</b>	6	<b>PAGE</b>	2 of 5
<b>Activity No</b>	16	<b>AUTHOR</b>	Gowtham Ramesh		

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

16.02

Trim edge trim below the outer door frame by 10 mm

Use the rubber moulded End Caps

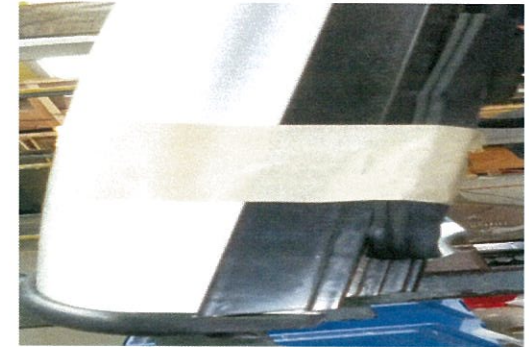
A) Place the end cap to the rain channel of the rear door and mark the length to be trimmed off door frame

B) Mask the pope seal prior to trimming the rear door frame

A



B



Frame to be trimmed to

16.03

A) Use a Pneumatic or hand - saw cutter to cut the marked frame

B) Remove the cut frame with the help of a cutting pliers

C) Grind the cut area to remove the excess material left after cutting and remove burrs & imperfections

A



B



C





# Crown Canopy Assembly - End Cap Installation

## WORK INSTRUCTION



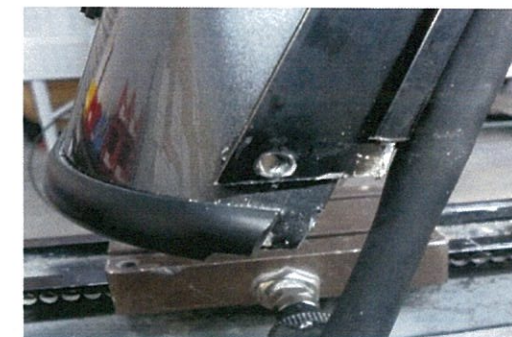
<b>Department</b>	Canopy Assembly	<b>DATE</b>	22 August 2017	<b>Instruction No.</b>	WI 04016
<b>Process</b>	End Cap Installation	<b>ISSUE</b>	6	<b>PAGE</b>	3 of 5
<b>Activity No</b>	16	<b>AUTHOR</b>	Gowtham Ramesh		

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

**16.04**

A) Before fitting the end caps, place the end cap over the edge trim and mark the area of edge trim to be removed for perfect fitment of the end caps

B) Edge trim removed for fitment of End caps



**16.05**

Hold end cap in place and mark out the hole location x 2 using a marker

Drill 5mm Dia hole for rivet

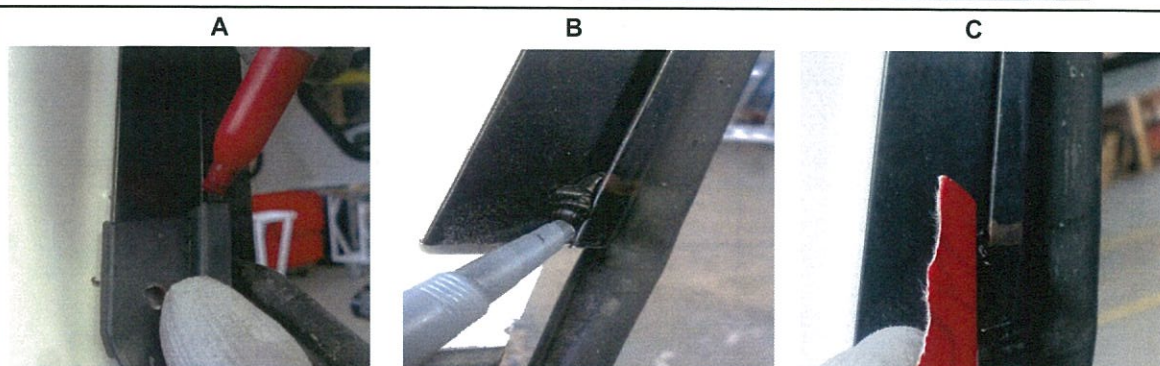


**16.06**

A) Place the End cap and mark a small line on the water drain channel frame as shown in picture A

B) Fill the sealant with the help of the sealant gun from the line marked ref 16.07 A to the bottom of the channel frame

C) With the help of a small cardboard piece push the sealant into the rain channel










# Crown Canopy Assembly - End Cap Installation

## WORK INSTRUCTION



<b>Department</b>	Canopy Assembly	<b>DATE</b>	22 August 2017	<b>Instruction No.</b>	WI 04016
<b>Process</b>	End Cap Installation	<b>ISSUE</b>	6	<b>PAGE</b>	4 of 5
<b>Activity No</b>	16	<b>AUTHOR</b>	Gowtham Ramesh		

No	Operation	Tools, Materials, Parts & Process	
16.07	<p>A) Before installing the end cap apply sealant as shown in the picture A 2 mm below the marked line (16.07 A)</p> <p>B) Locate the end cap and the rivet</p>	<p>A</p> 	<p>B</p> 
16.08	<p>Locate rivet through end cap door frame and canopy and place a washer (YC-11-WXM510) over the back of the rivet prior to riveting.</p> <p>Rivet end cap in the drilled hole.</p> <p>Locate rivet cover cap (C5-56-0652710) on 2 rivets</p>		
16.09	<p>Using the sealant gun, fill the gap between the rubber moulding and the frame</p>		

# Crown Canopy Assembly - End Cap Installation

## WORK INSTRUCTION



<b>Department</b>	Canopy Assembly	<b>DATE</b>	22 August 2017	<b>Instruction No.</b>	WI 04016
<b>Process</b>	End Cap Installation	<b>ISSUE</b>	6	<b>PAGE</b>	5 of 5
<b>Activity No</b>	16	<b>AUTHOR</b>	Gowtham Ramesh		

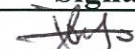


No	Operation	Tools, Materials, Parts & Process
----	-----------	-----------------------------------

16.10

- Cut the excess pope seal using side cutters
- Fill sealant in the end cap slot where pope seal is to be inserted
- Insert the cut pope seal into the end cap slot provided
- Glue the pope seal into the moulded rubber part of the end cap



# Crown Canopy Assembly - End Cap Installation

<b>PROCESS SIGN-OFF</b>							
<b>Department</b>	<b>Signatory</b>		<b>Signature</b>		<b>Issue</b>	<b>Date</b>	
Team Leader	Jayson Beato				6	1-9-17	
Production Manager	Kevin Fox				6	1-9-17	
Design Manager	Mike West				6	1-9-17	