FLEXIGLASS BUILD MANUAL - SECTION 1.2B

HOLDEN COMMODORE VU CANOPY BUILD ISSA7

Familiarise yourself with the following info before you start to ensure you are clear on all aspects of this procedure

SAFETY EQUIPMENT
● Hearing protection as required
● Eye protection as required

MATERIALS & PARTS REQUIRED (BUILD KIT)		
Part No.	**Description**	**Qty.**

TOOLS REQUIRED
● Drill - Electric / Compressed Air
● Rivet Gun - Air / Hand
● Angle Grinder
● Hacksaw - Air / Hand
● OS&H

The VU canopy shell incorporates integral cutting outline.
This is done to save time on the shop floor while maintaining accuracy and consistency of product.

1 Check shell for any imperfections, if imperfections are found notify Production Manager.

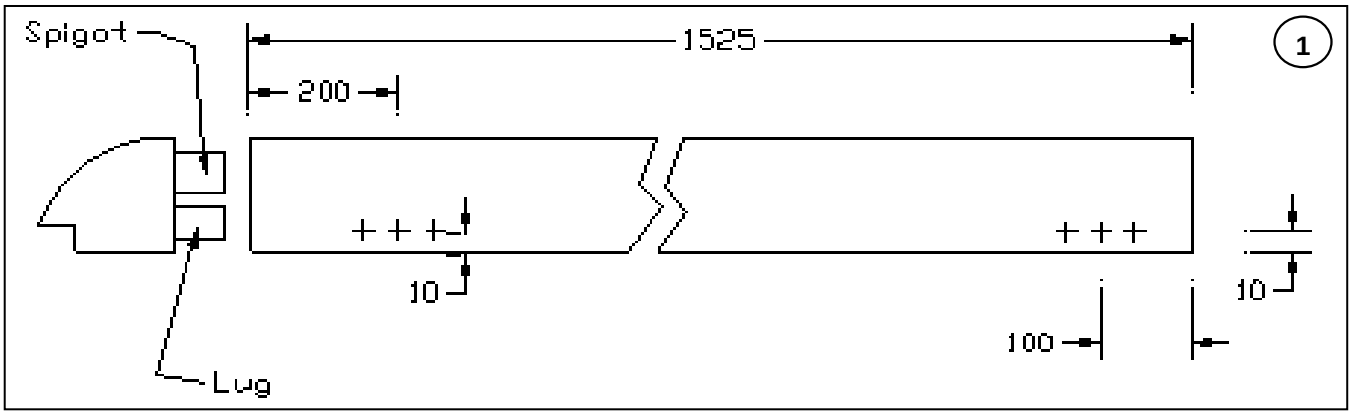
2 Move to cutting booth. Mark out window 90mm up from base line and 30mm forward of the rear corner flute.
Note: Production Manager / Quality Controller inspect at this point.

3 Cut canopy to trim line include windows and door. Cut door opening on the grained side of the line to ease door fitting. Remove waste to the scrap bin.
Note: Painting, if required, should be carried out at this stage.

4 Place canopy shell on build bench.
Note: Build bench beams will need to be altered to suit VU rails.

5 Cut **RAIL1750V** inner rails 1525mm long. Ensure the cut is neat and square. Remove any burrs and insert the rear corner blocks **BLK120L** and **BLK120R** (left and right).

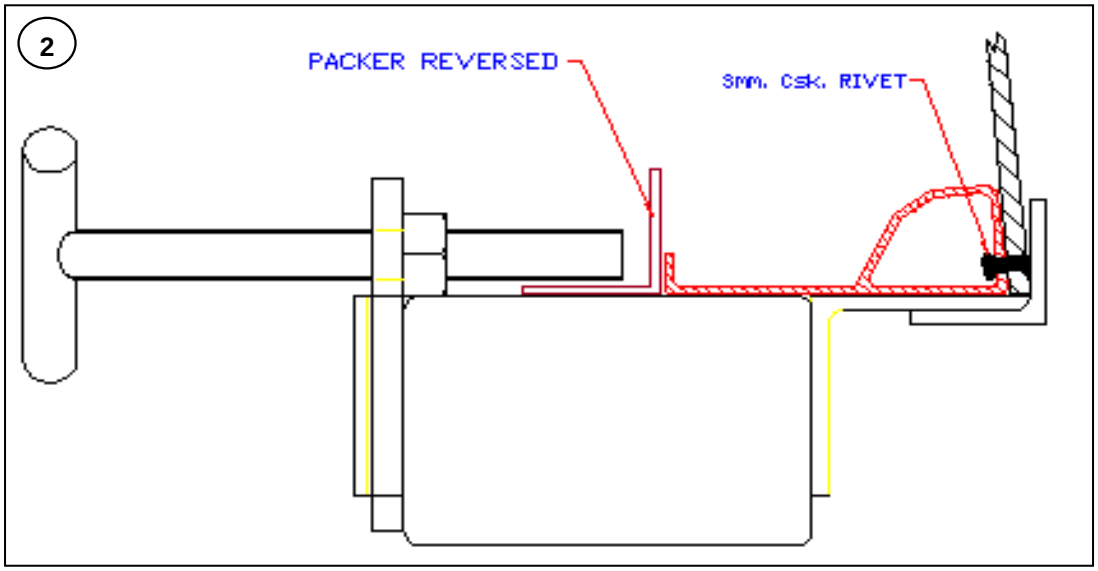
6 The inner rail should be drilled before installation. The rear corner blocks can also be fitted at this time. Secure them together through the lug of the block with a **RIVET200** steel rivet and a ø5mm washer. See **Diagram 1**.



7 The bottom edge of the canopy sides and the contact surfaces of the inner and outer rails, should now be wiped clean with IPA.

8 Apply a bead of adhesive sealant along the inside of the bottom canopy edge, about 5 - 10mm up from the cut.

9 Push the inner rail into position against the canopy and clamp the rear corner at the door opening.
Note: As the inner rail is being fitted before the outer rail, the clamping packer must be placed with the horizontal flange under the screw thread NOT UNDER THE BASE RAIL. See **Diagram 2**.



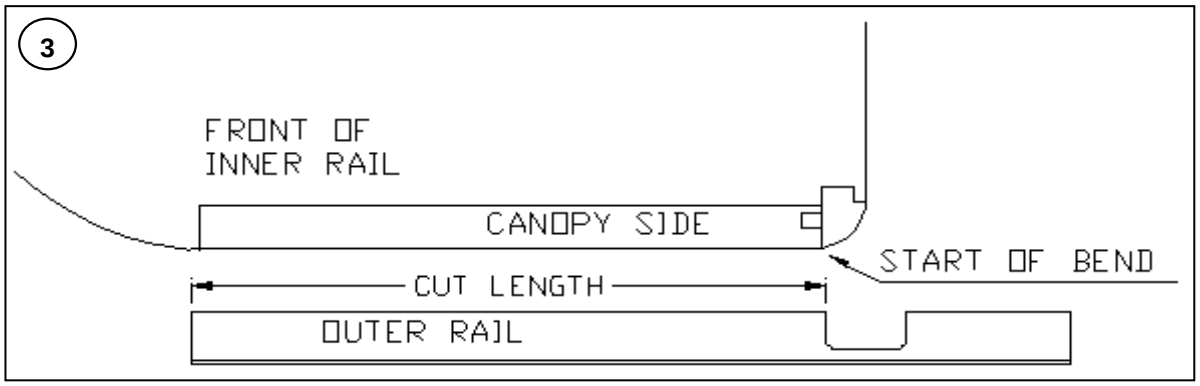
10 Clamp inner rail against the canopy (see note above) and onto the build rail in the normal way.

11 Using 5 or 6 **RIVET100** counter sunk 3mm rivets fix the canopy to the inner rail. Be sure not to drill any more than 6mm up from the top face of the build rail or the head of the rivet will be visible above the outer rail when fitted.

Note: As this is an over cab model without a front panel, the inner base rail must be riveted to the shell. The two end rivets should be placed no more than 30 mm from each end. The rest of the rivets are to be evenly spaced along the rail.

12 Repeat steps 9 – 11 for the opposite side.

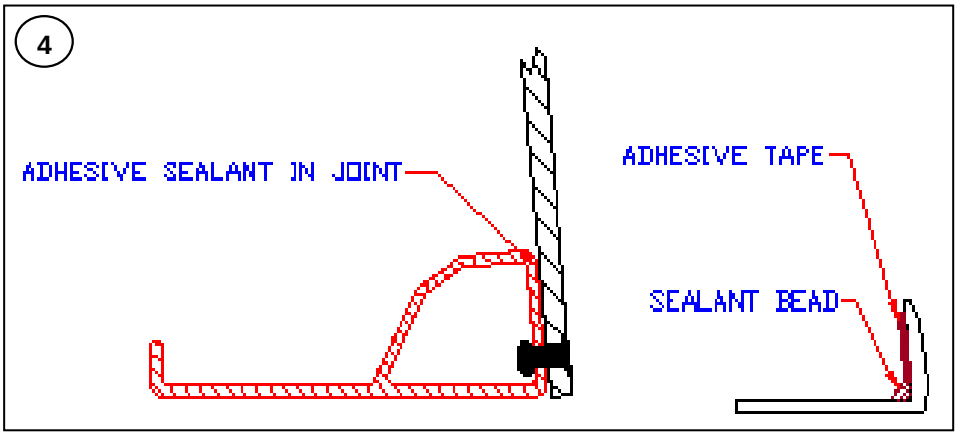
13 Take a pair of **RAIL0208IL** & **RAIL0208IR** Commodore outer rails and fit them in place around the canopy base. See **Diagram 3**.



14 Mark the front extent of the inner rail onto the outers and the outside of the canopy, and trim the outer rails to length.

15 Apply adhesive tape to the inside of the outer rail. Keep it between 1 and 2mm down from the top edge.

16 Apply a 3 or 4mm bead of adhesive sealant into the angle of the outer rail below the tape to ensure thorough sealing along each side. See **Diagram 4**.



17 Take one outer rail and fit it under the canopy side. Align the front with the pencil mark drawn earlier.

18 Clamp the rails using the screw clamps and 11R self grip pliers with the necessary packers.

19 Drill upwards through the inner and outer rails and secure using **RIVET200** rivets. Ensure the rear most rivet, before the corner, secures the spigot of the plastic corner block.

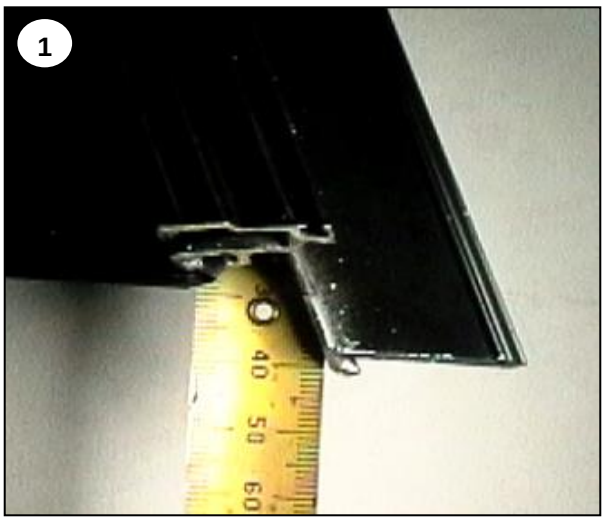
20 Carefully bend the outer rail around the rear corner, trim, clamp and rivet in place.

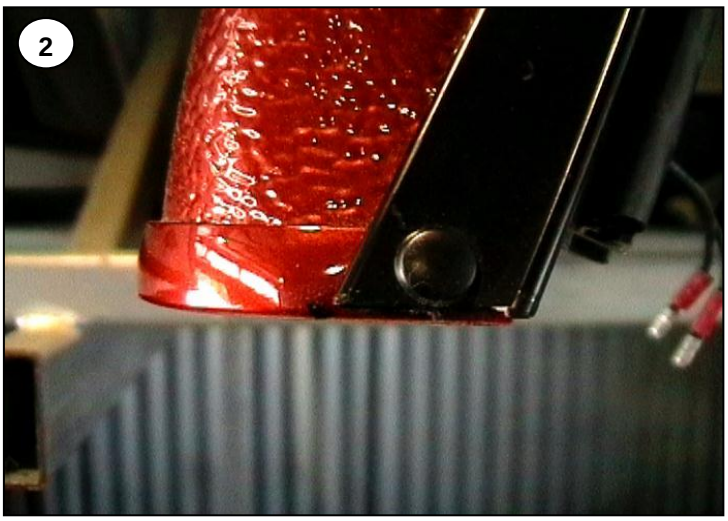
Note: Due to the increase in the height of the outer rail up stand, there will be an enlarged gap around the corner. This can be reduced by driving it inwards using a wooden block struck with a hammer or a nylon (plastic) faced mallet.

21 Repeat steps15 – 20 for other side.

22 Check the length of outer door frame extending past the bottom edge of the door. It should be no more than 8mm. Usually one side will need to be trimmed, as this is due to bending allowances in manufacture. See **Photo 1**.

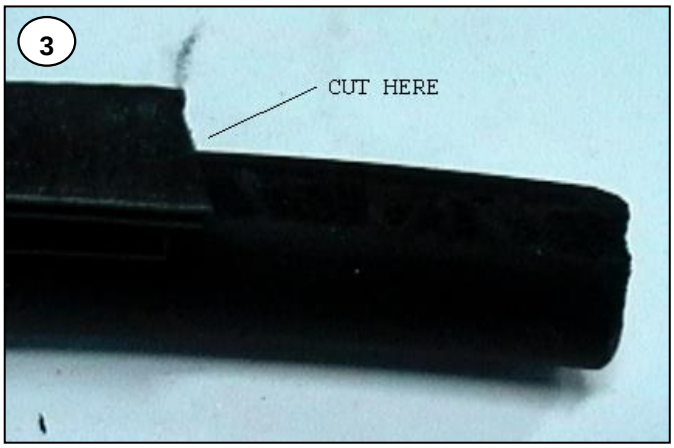
23 Fit the rear door, ensuring that the frame is firmly pushed outwards against the canopy door opening edges. Clamp the frame being careful not to mark it and tek screw the lock ring in place, lightly tap the end of the outer frame onto this corner. See **Photo 2**.

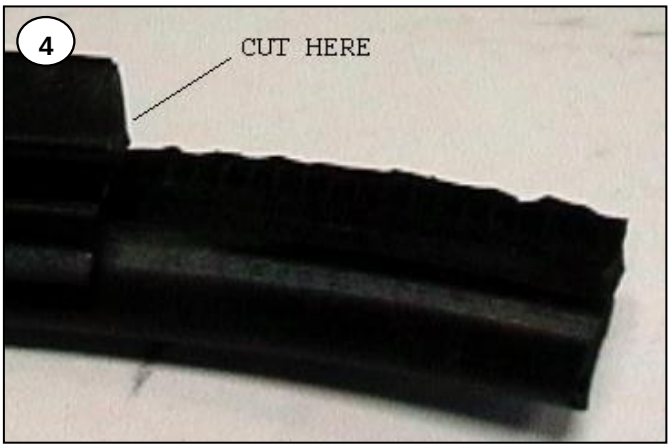




24 Rivet end of door frame in place over the top of the outer rail. Use a **RIVET220** to prevent splitting of the plastic corner block. Cap the rivets with plastic screw caps held in place with a small blob of adhesive sealant.

25 Place bulb seal **SEAL130** over the raw cut edge at the front of the canopy. Cut the ends of **SEAL130** 40mm longer both sides, a cut out needs to be done to achieve a neat fit. See photo **Photo 4** - **SEAL130**.





26 Cut the clip section of the bulb seal through to the rubber bulb, cut out the clip section leaving the rubber bulb intact.

27 Insert bulb section of the cut out into the hollow area of the inner rail and push firmly into place, keep the clip section and outer rail neatly butting together. See **Photo 5** (inside) and **Photo 6** (outside). Repeat procedure for opposite side.

28 Make the canopy ready for inspection.