



FLEXIGLASS BUILD MANUAL - SECTION 1-2D

HOLDEN COMMODORE VE PREMIER CANOPY ISSA2

NOTE: Familiarise yourself with the instructions before you start to ensure you are clear on all aspects of the build

SAFETY EQUIPMENT

- Hearing protection as required
- Eye protection as required

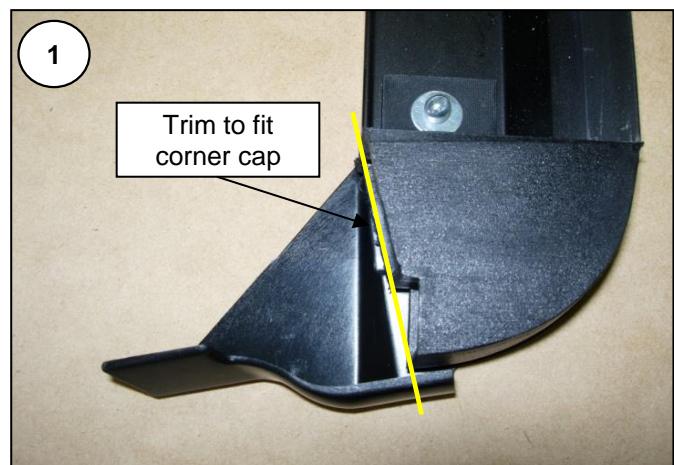
TOOLS REQUIRED

- Pneumatic 10mm capacity hand drill
- 3mm drill bit
- Countersinking bit
- 5mm drill bit
- Pneumatic pop rivet gun 3mm & 5mm tips.
- Pneumatic Power screwdriver
- 1/4" hex socket bit for above.
- Sharp knife (ie box cutter)

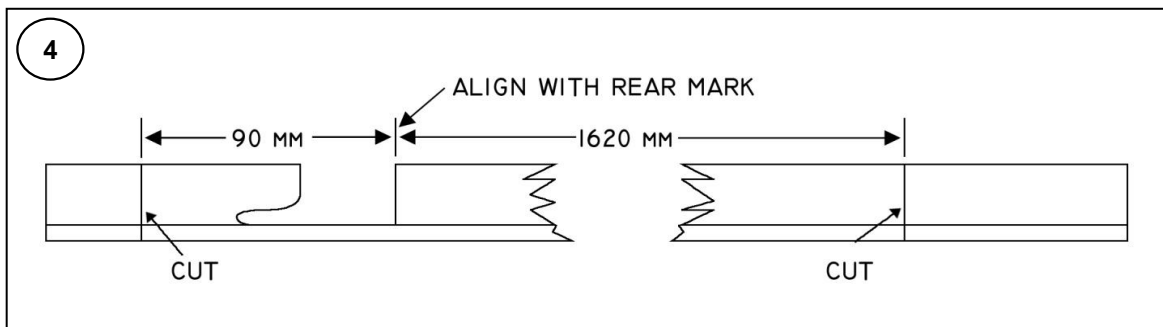
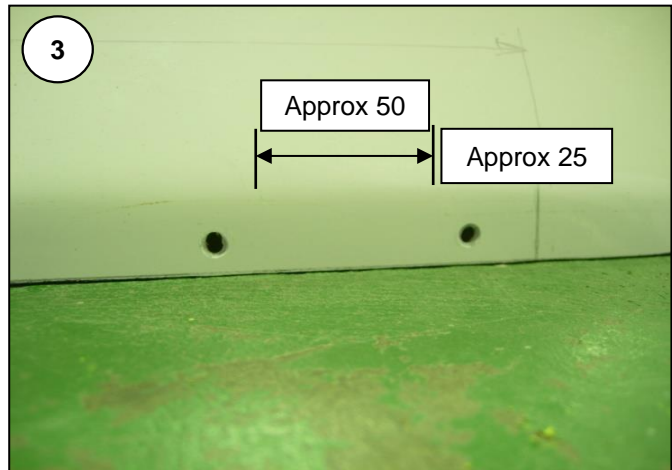
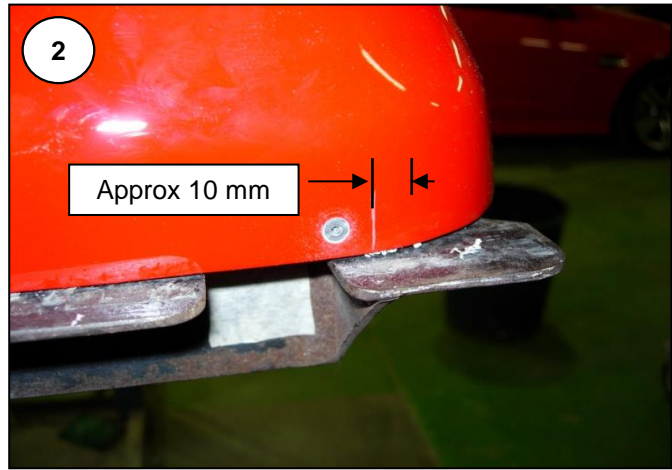
MATERIALS & PARTS REQUIRED (BUILD KIT)

Part No.	Description	Qty.
SHLCOMVESM	Sports canopy fibreglass shell,	1 of.
LINCAN	Lining Canopy 45 Metre Rolls	2.2m
RAIL1615R&L	Rail Inner 1615 VE Commodore	1 pair
BLK120R&L	VU rear corner blocks,	1 pair
WSH260	Washer 3/16"ZP flat	2 of
RIVET240	3mm countersunk 4-6 rivets,	20 of
RAILO2081R&L	Out/Rail 2080 Adhesive L&RH D/P	1 pair
TAPE220	Double sided baserail tape	3.6m
RIVET200	5mm steel 6-6 rivets,	22 of
CAP240	Cap rear corner VE	1 pair
TAPE160	Window tape	8.72m
LIGHT160	Brake light.	1 of.
RIVET120	Rivet 4-6 alum	2 of
WIRE100	Wire 3MM twin 100 mtr	3m
DRSVE10	Moulded plate glass rear door	1 of.
RIVET220	Rivet 5MM Steel 6-12	12 of
SCRHBTX1520	18mm door tek screws,	14 of
LIGHT200	Internal light.	1 of.
CON110	Connector Joiner Red 2.5-3mm	2of
WINSVE10R&L	55x12 side slider	1 pair.
SCRHBTX1512	12mm window tek screws,	60 of
SEAL130	Seal front 004 pinchbulb x 50m	2.75m
CLIP1010	Clamp ring wire clip large.	5 of
CAP110	Black rivet caps	2 of
SEAL430	Sikaflex-221 White sealant/adhesive	0.5
BADGE120	Badges Flexiglass Challenge.	2 of
STIC120	Q A sticker	1 of.
STIC160	Serial number label.	1 of.
BADGE170	Badge Flexiglass Lid	1 of.

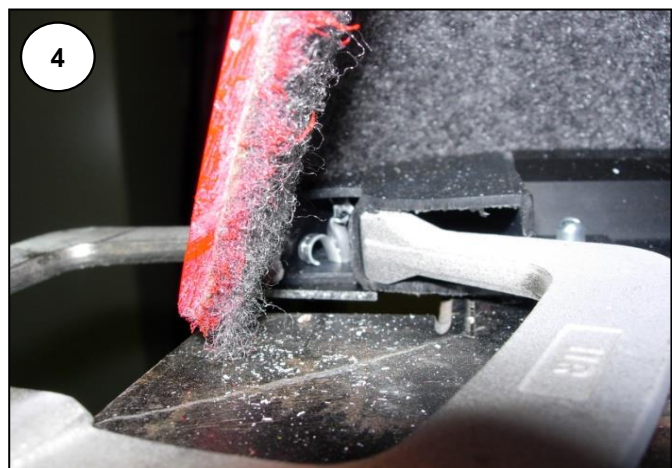
- 1 Trim canopy to template. **T58 (15/10/08)**.
- 2 Line canopy with **LINCAN** gray felt and trim back from bottom and front edges for base rails and pinch weld.
- 3 After painting, wipe bottom edges of shell with IPA wipes.
- 4 Fit **BLK120** corner blocks to the **RAIL1615** base rails using a **RIVET200** and **WSH160** each.
- 5 Trim the inside of the corner blocks. See **ILL 1**.
- 6 Wipe the outside face of each rail and block with IPA wipes.



- 7 With the canopy build bench rails set up for AU base rails, place the canopy shell on them.
- 8 Working one side at a time, apply a 3 - 4mm bead of **SIKA221 (SEAL430)**, 6 - 10mm up from the bottom edge, on the inside of the shell.
- 9 Push the prepared base rail into place along the bottom of the canopy sides.
- 10 Ensure the corner blocks are firmly pushed into the rear corners, then clamp the rails against the canopy in the usual manner.
- 11 With a removable marker (whiteboard or a pencil) mark, on the outside of the shell, the joint of the corner block and rail at the rear and the end of the inner rail at the front. See **ILL 2**.
- 12 Drill 10 of 3mm holes approximately 6mm up from the bottom of the canopy. At rear the hole should be approximately 10mm forward of the mark. See **ILL 2**. At the front drill one 25mm back and one 75mm back from the rail end mark. See **ILL 3**. Space the remaining seven evenly by eye.
- 13 Counter sink the holes and rivet them with **RIVET240**.
- 14 Measure the **RAIL02081 R&L**. See **diagram 4**.



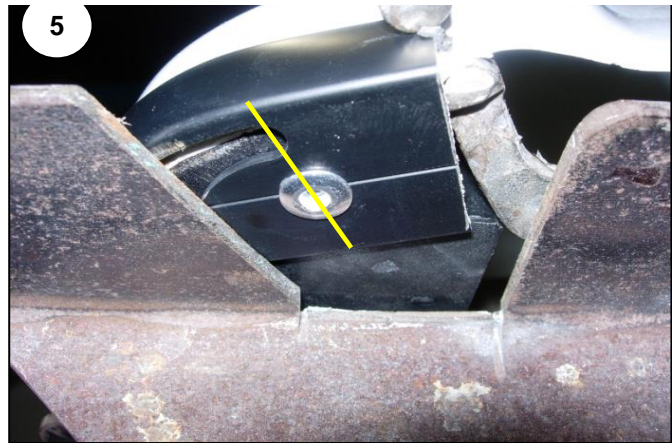
- 15 IPA wipe the trimmed outer rails and affix the **TAPE220** to the inside of the vertical flange and the bead of **SIKA 221** to the corner.
- 16 Align the notch with the rear mark as indicated in the diagram and attach the outer rail to the canopy with the adhesive tape.
- 17 Clamp the assembly to the build bench rails.
- 18 Pull the rear end of the outer rail around the corner of the canopy and clamp it firmly. See **ILL 4**.



- 19 Drill a 5mm hole up through up through the

outer rail and the corner block. See **ILL 5**.

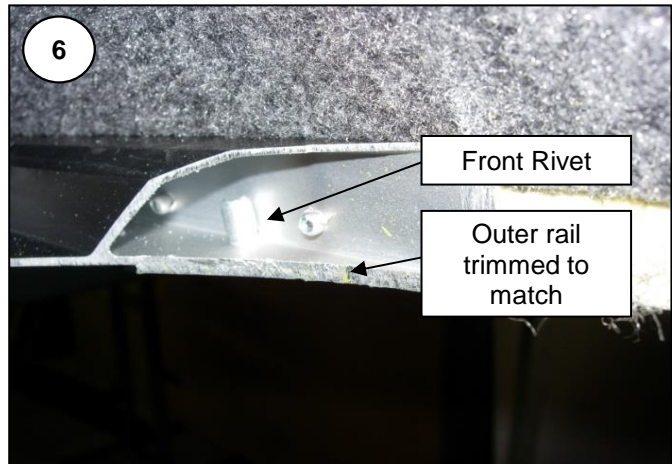
20 Fix with a **RIVET220** star rivet.



21 Using a 5mm drill bit and **RIVET200** steel rivets fix the base rails together as usual.

Note: At the front of the rail fix one rivet as in **ILL 6**.

22 Trim the rear ends of the outer rails in line with the edge of the corner block. (**Refer to item 5**).



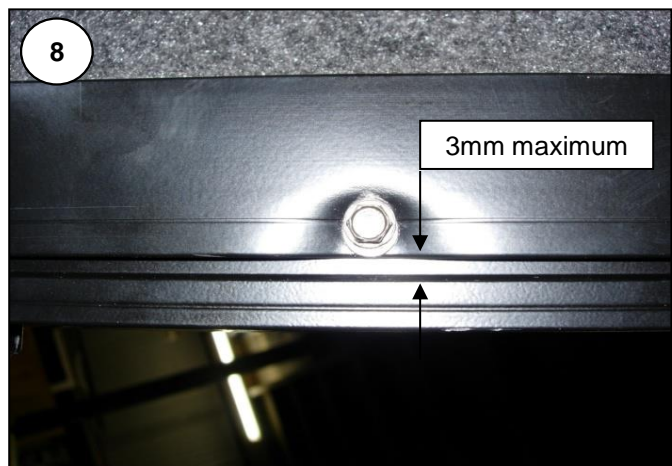
23 Attach **TAPE160** window tape to rear door and side glazing outer frames.

24 Place an 8 to 10mm packer under the ends of the door recess at each rear corner. See **ILL 7**.



25 Fit rear door into opening. Ensure frame is hard up against fibre glass edge at each end and that the clamp ring is within 3mm of the ridge indicated in **ILL 8** along the top of the door opening.

Note: Close door and check "glass to recess" gaps for evenness and catch operation before fully tightening.

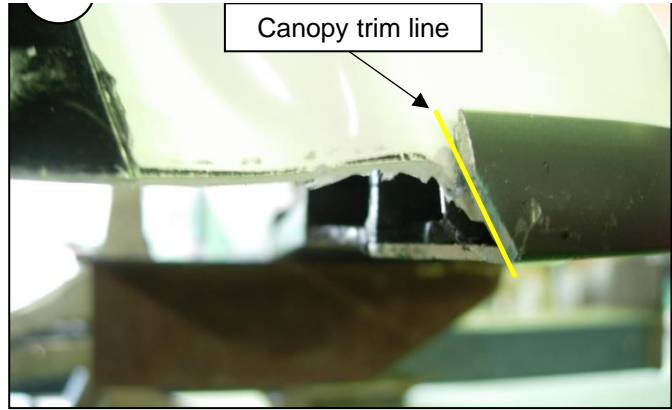


26 Position **CAP240** over their respective corners. Drill and rivet Hole 1 - **See photo 10**. Check

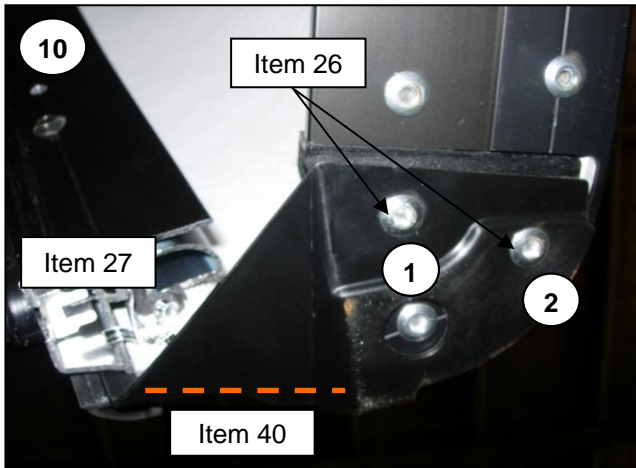


fit of cap then drill and river Hole 2 to achieve neatest finish. Use **RIVET 180** star rivets.

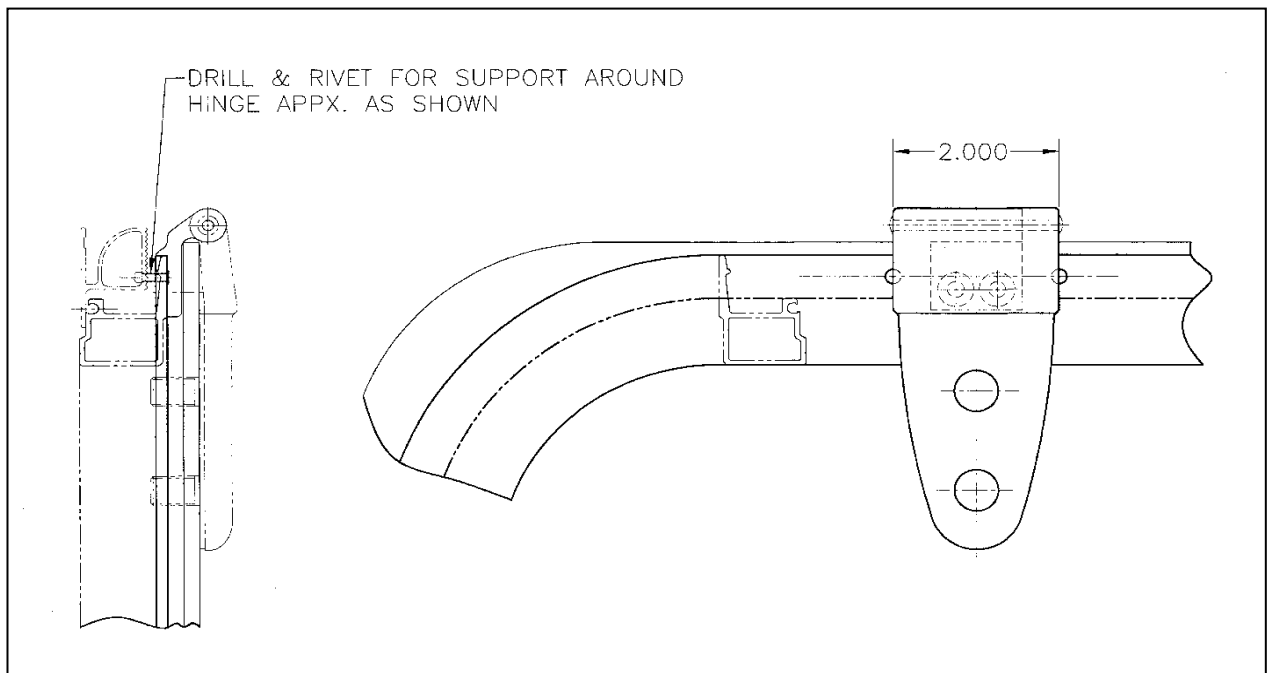
Note: If difficulty is experienced getting the caps to sit "comfortably" in position it may be necessary to take the end corner of the outer rail off as shown in **ILL 9**.



- 27 Drill through the cap end, door frame and canopy shell with a 5mm drill and lock entire assembly with **RIVET220**. See **ILL 10 & 11**.



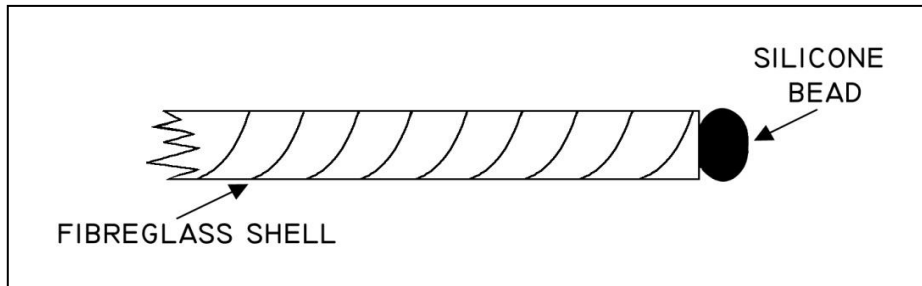
- 28 Drill and fit 4 of **RIVET200** adjacent to the hinges as indicated in the illustration below.
- 29 Attach the **LIGHT160** to the bonded door bracket with 2 of **RIVET220**.
- 30 Attach interior lamp **LIGHT200** to the door clamp ring and wire as per usual with **WIRE100**, **CON110** and **CLIP1010**.



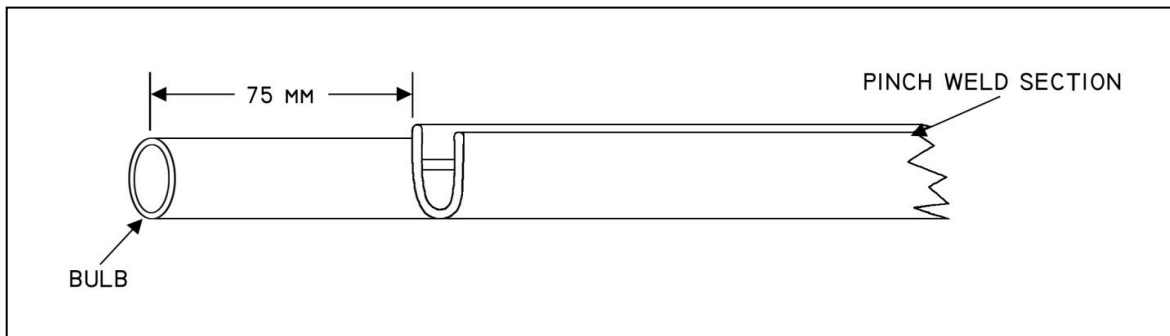
- 31 Fit side glazing as specified on work order. **Note:** Ensure opening is 325mm high at least.
- 32 Move canopy forward on bench and clamp with front of base rails over hanging, trim outer rail to match

the inner rail. **See ILL 6** (item 21).

- 33 Apply a 2 - 3mm bead of clear silicone along the cut edge of the canopy front, as illustrated below.



- 34 Trim end of **SEAL130** as shown below. Push bulb end into the inner rail cavity then press pinch weld section over the front edge of the shell.



- 35 With the channel firmly and fully fitted to within 200 - 300mm of the opposite base rail, mark and trim the end to match the other side.
Note: Cut the channel longer rather than shorter to minimise the chance of a gap between the channel and the outer rail.

- 36 Use a small quantity of black silicon to finish off the joint between the pinch weld and the outer rail neatly. **See ILL 12.**

- 37 Apply a small quantity of black silicon to each bottom rivet head on the rear door and fit 2 **CAP110**. Fill the gap between the **CAP240** and shell. **See ILL 11.**

- 38 Clean the exposed adhesive on the door seal extension with IPA. At the same time wipe the underside of the corner cap.

- 39 Attach a 40-50mm strip of **TAPE180** adhesive tape to the underside of the end cap (see dotted line in **ILL 10**)

- 40 Pull the door seal extension around the corner and stick it to the strip of adhesive tape, neatly trim the end. **See Photo 13.**

