

## OVERVIEW

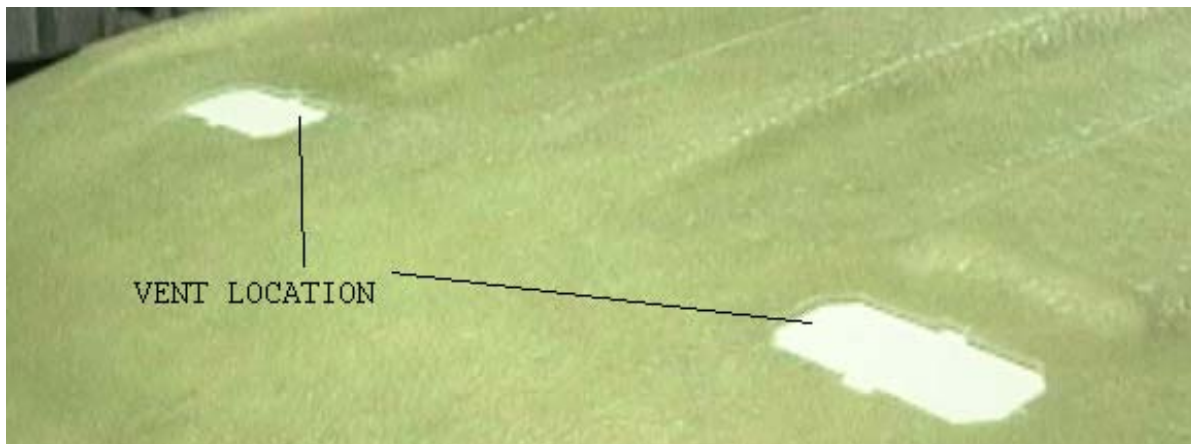
The au Falcon Canopy is a purpose built unit made exclusively to fit that vehicle. It is also one of the first of this company's products to incorporate the new adhesive bonding base rail system, which gives a far superior. "Look" to the canopy.

Due to the curved styling of the canopy and the requirements for adequate bonding, the cutting of the shell and front panel must be performed both carefully and accurately.

To assist the builder with both speed and accuracy the inner base rails and "P" tube have been pre cut and manufactured to suit. This will provide a positive check to the accuracy of the shell cut.

### Special note: To sales staff

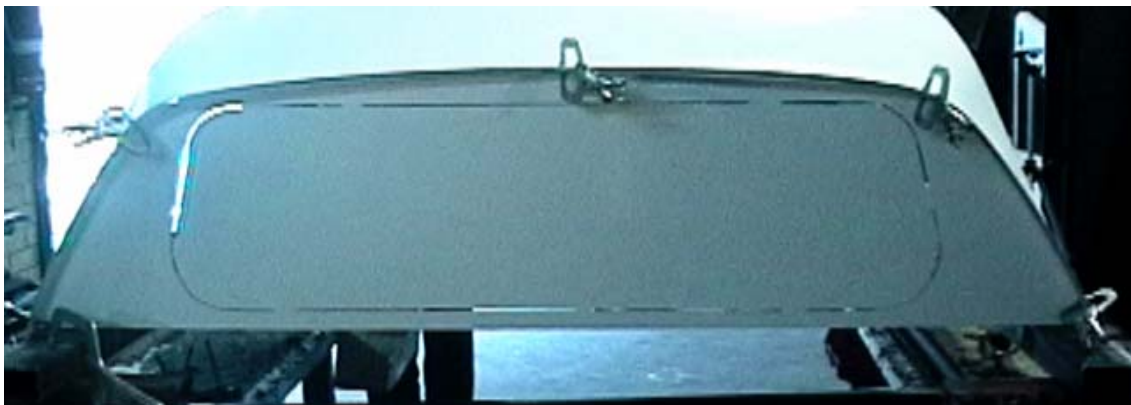
Please note that the FCI plastic vents are fitted in pairs due to the shape of the ribs in the roof.



## AU FALCON CANOPY WITH CURVED BASE RAIL SYSTEM

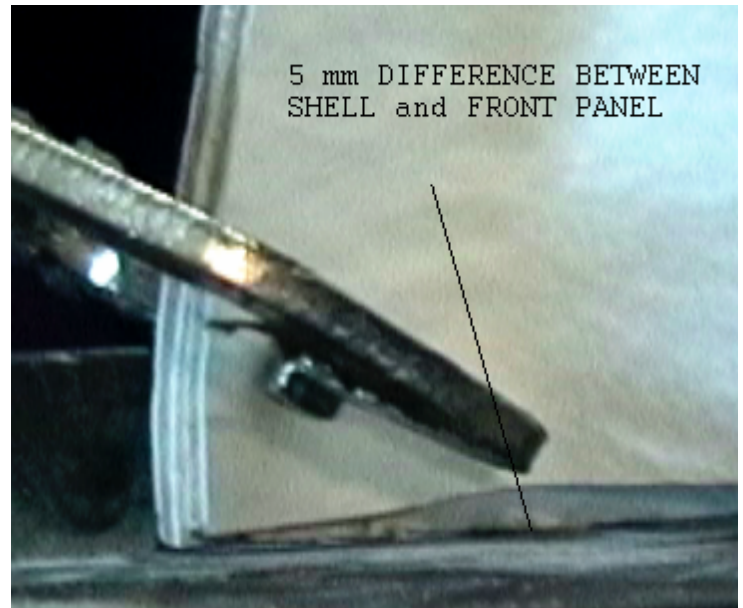
### PROCEDURE

1. Mark and cut shell **SHLFALCAU**. It is recommended that all cutting is done at this stage unless the canopy is to be painted in which case the window cut outs should be left attached by the four (4) small tags to minimise the masking required on the inside.



2. Mark the front panel **PAN120** and cut the bottom edge only. Leave the lip untouched and the window opening attached by the four (4) tags. (This maintains the strength of the front panel until it is fitted).
3. Clamp the front panel in place. Ensure it is 5 mm shorter than the canopy sides. Now rivet in place using counter sunk 3 mm rivets **RIVET100** and trim the front panel back to the canopy front edge.

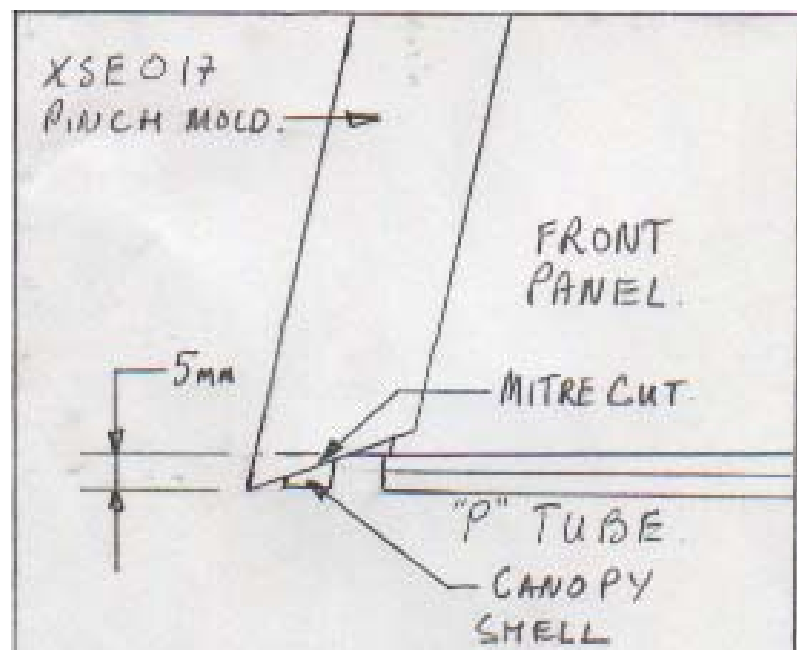
Note: These two operations may be altered



to suit the builder / branch's production method.

Cleaning the outer base rail with Isopropyl Alcohol or Isopropanol (IPA).

4. Apply a thin bead of Sika Flex to the front edge of the front panel / canopy joint and fix a length of **SEAL175** pincheld around it. Mitre cut the ends as shown.
5. The bottom edge of the shell and inside of the outer rail should now be thoroughly wiped clean with I.P.A. use a white lint free rag and fold and change regularly.



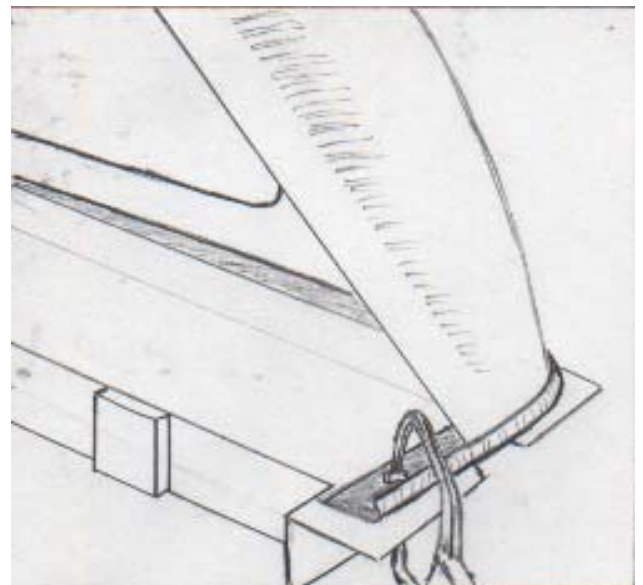


**Cleaning the base rail area**



**Applying the base rail tape.**

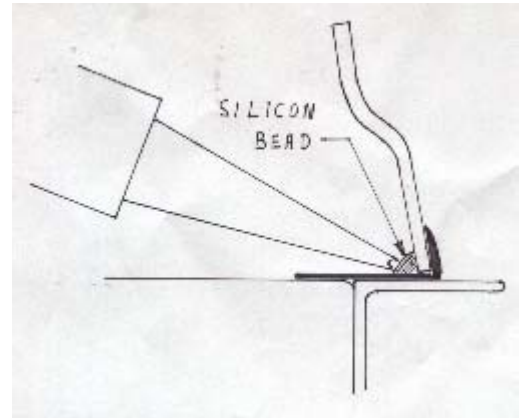
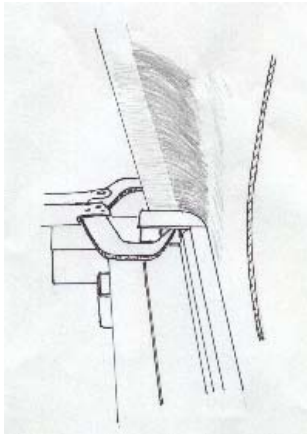
6. Apply adhesive tape **TAPE220** to the inner surface of the outer rail. Be careful not to go too close to the top edge.
7. Move shell onto building bench and slide outer rails under edges. Put "p" tube **TUBP160** in place but do not fix.
8. Push the outer rail carefully into position with backing tape still in place. Mark the position of the rear edge of the pinchweld onto the outer rail with a pencil and cut the adhesive tape at this point, removing the short piece forward of the mark.
9. Start to fit outer rail **RAILO2081 L&R** (Adhesive B rail) one side at a time. Peel back the backing tape and bend rail around canopy rear corner, push Clamping the outer rail firmly into position in corner and against the bottom edge. Clamp to bench rail as shown leaving adequate room to fit inner rail.



**Note:** Rear corner bend may be formed off the canopy if desired.

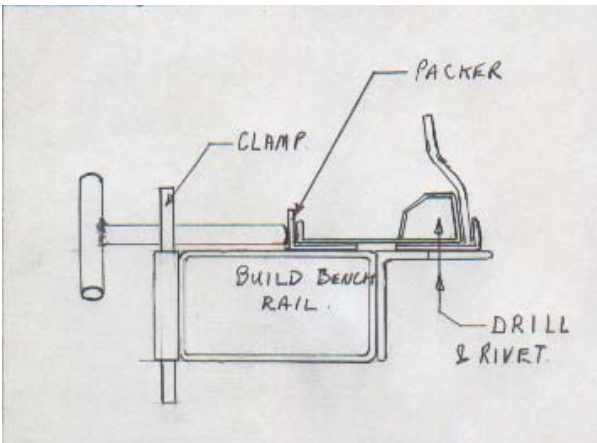


10. Apply a bead of Sika Flex compound to the joint area of the outer rail and the canopy edge. Ensure it goes all the way to the front of the canopy otherwise water leakage will occur.
11. Push inner rail firmly into the rear corner of the canopy and clamp at the door frame position.
- 12 Slide screw clamps into their slots. Slip packers under the inner rail at each clamp and working



from the front and rear clamps progressively work the complete assembly against the outer stops. Clamp down onto the packers using 11R vice grips as and where necessary.

**Note:** The joint between the top of the inner base rail and the underside of the “p” tube MUST be sealed with Sika Flex or water leakage will occur.



USING THE CLAMPS ON THE BASE RAIL JIG TO CLAMP THE INNER RAIL

14. Repeat 4 (four) to 13 (Thirteen) for other side.

15. Canopy rails can now be released and the canopy slid forward on the bench rails to facilitate fixing the front corners.

FASTEN THE OUTER BASE RAIL TO THE INNER BASE RAIL WITH RIVETS

**Don't fix bottom edge of front panel at this stage.**

13. Drill and rivet **RIVET200** upwards through the slots in the jig starting at the rear and working forward, clamp front panel, shell and outer rail together using vise grips and rivet “p” tube to inner and outer rails from the under side. Be sure to centralise the “p” tube.

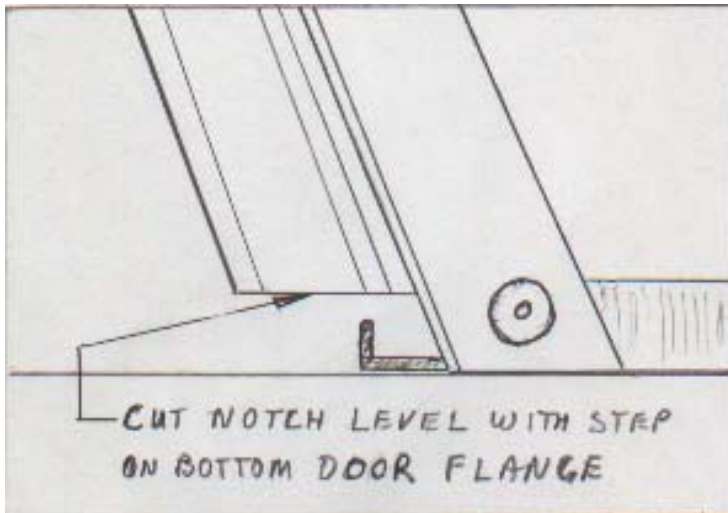


**Note:** Painting should be carried out at this stage if required. A single 3 mm pop rivet on the centre line will prevent the panel masking the flange of the “p” tube. Remove before attempting to fit the window.

**16** The front window can now be positioned and fixed. Notice that the bottom edge of the locking ring fits below the top line of the “p” tube up stand.

**17.** With the window fixed, the bottom of the front panel can be riveted to the “P tube with 5 mm rivets **RIVET200**. Remove the lower half of the lock ring joint sleeve by cutting with tin snips.

**18.** Trim rear ends of outer rail and end blocks flush with door opening.



**19.** Notch rear door outer frame to the dimensions shown.

**Note:** this operation will be unnecessary when stocks of modified frames become available from the manufacturer.

**20.** Fit rear door as normal, ensure that the frame is pushed outward and upwards firmly. The bottom ends of the frame should finish flush with the bottom face of the outer rail or slightly above it.

**21.** Remove all burrs and sharp corners from the frame ends and rivet through the frame, outer rail, canopy and end block with a **RIVET160** rivet as shown in the illustration

above.

**22.** Put a small blob of black silicone on the top of the rivet heads and push the black rivet caps **CAP110** into the rivet head.

**23.** Side windows are fitted as normal though special attention should be paid to the front corners due to the curvature of the canopy. It may be necessary to drill and fit extra screws **SCRHBTX1512** in these areas to ensure an even joint.

