

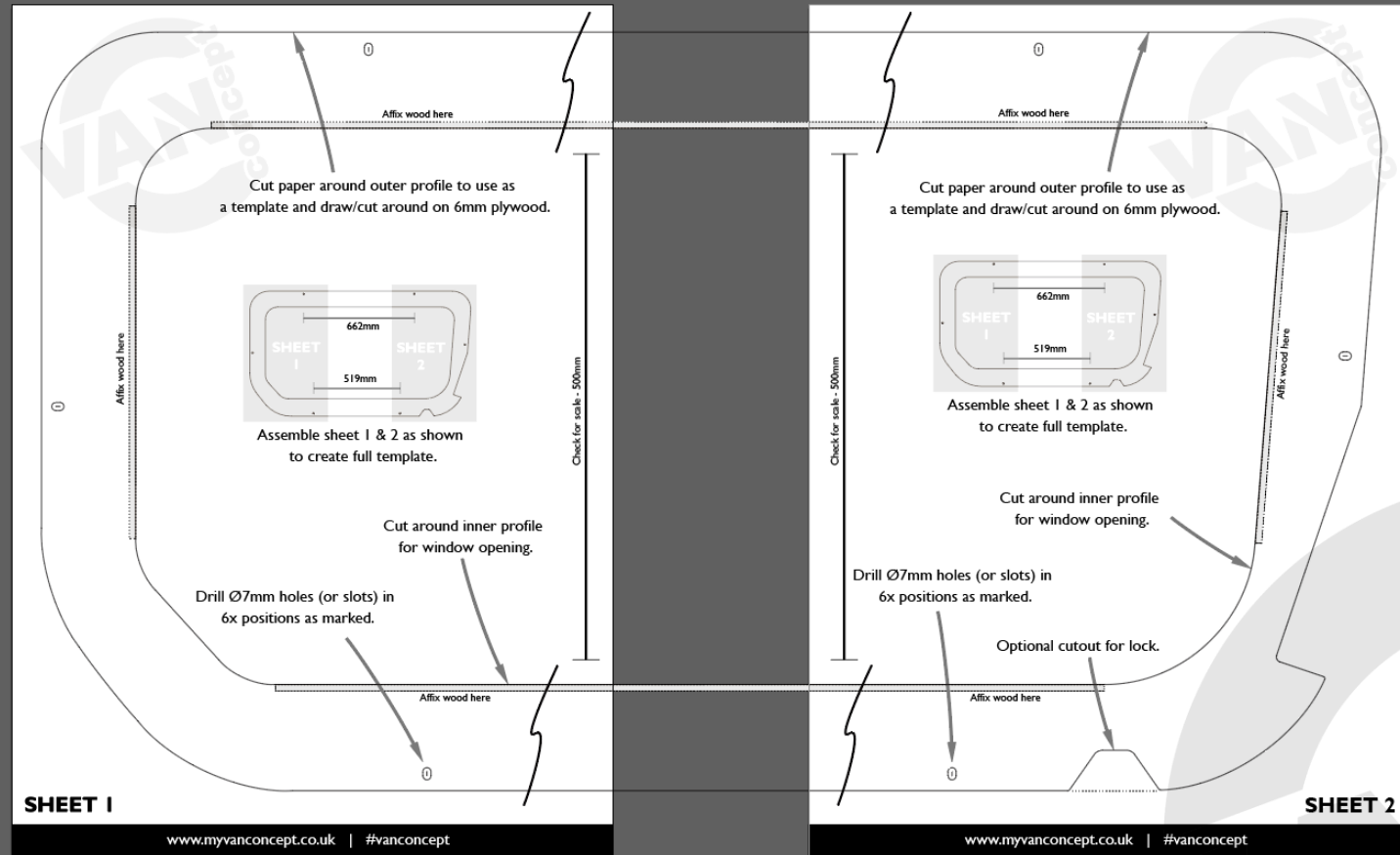
What's in the box?

- 4x 15mm Lightweight Plywood Window Surrounds
- 2x 15mm Lightweight Plywood Door Handle Surrounds
- 4x Aluminium Corner Profiles (*Flat*)
- 6x Aluminium Mounting Brackets
- 1x Aluminium Installation Tool
- 2x Templates
- 17x Countersunk Screws (*Larger*)
- 16x Countersunk Screws (*Smaller*)
- 6x M5x20mm Flanged Head Bolts
- 6x M5 Chimney Nuts
- 12x Rivets



INSTRUCTIONS SLIDING DOOR WINDOW SURROUND

1



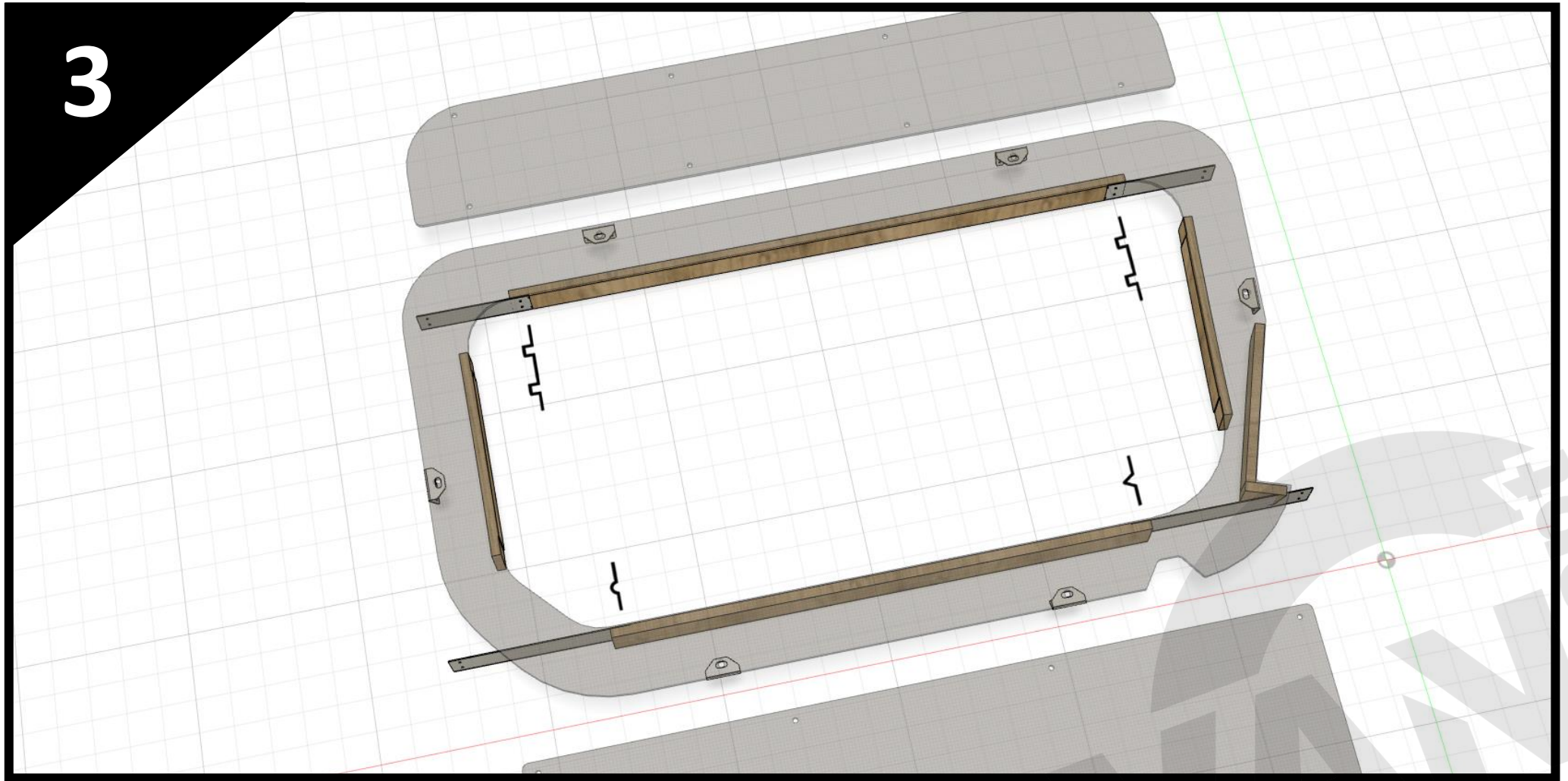
- With a sheet of 6mm plywood, use the template provided to cut the window surround outer profile and window aperture inner profile along with drilling the 6 mounting holes, by following the notes on the template.
 - Please ensure you cut on the waste side of each line!
- Mark on the plywood the end points of the “affix wood here” sections.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- Position the widest long piece of wood along the bottom edge of the window aperture, using the pencil marks for correct positioning.
- Drill and countersink three $\text{Ø}3\text{mm}$ pilot holes, one roughly in the centre and one at each end where the wood attaches, approximately 7-8mm in from the edge of the plywood.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- The diagram shows the positioning for the remaining parts to make the surround.
- To identify the correct side pieces, the wider ends are at the bottom and the machined sections face inwards. The curve of the part should be positioned so the two ends touch the 6mm plywood.
- The sheet metal corners are supplied flat and have markings on one edge for easy identification. These edges fit to the top and bottom 15mm plywood, not the vertical sides.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- The sheet metal corner profiles need to be shaped to match the curve of the window cutout profile. This can be easily done by using mild thumb pressure or gently pressed over a round object, such as a wide reel of tape.
- *Please ensure the countersunk holes on the sheet metal are on the inside of the curve and we suggest to rough the surface up a little with some sandpaper to help the trim adhesive adhere.*

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



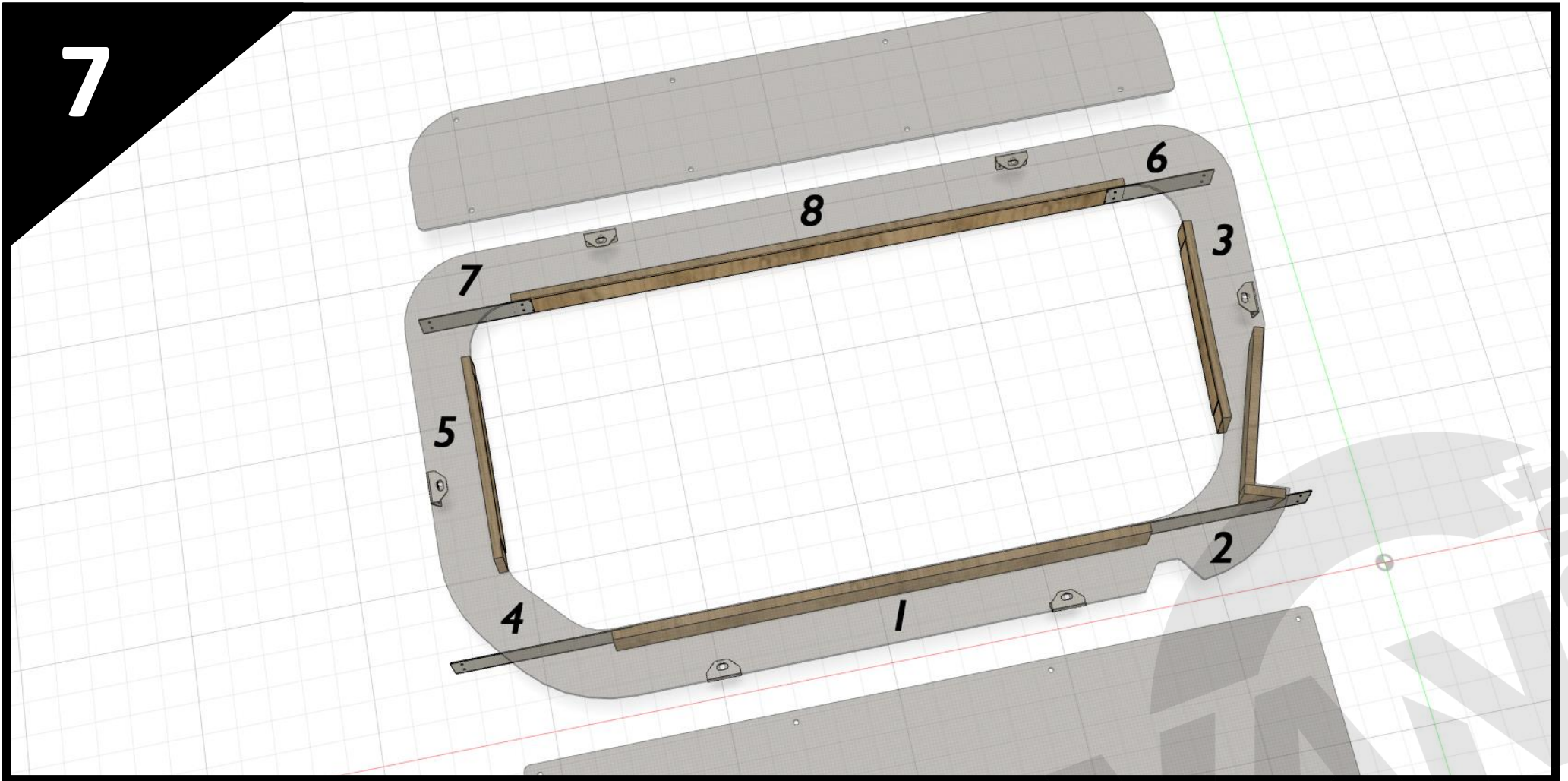
- With the corner profile matching the plywood edge, take one of the smaller diameter screws and attach the metal to the plywood in the position shown.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- Fit the second piece of wood to the side of the window cutout, using the pencil mark for alignment. (*This should match up nicely with the end of the first metal corner.*)
 - Drill and countersink three Ø3mm pilot holes as before to attach the wood.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



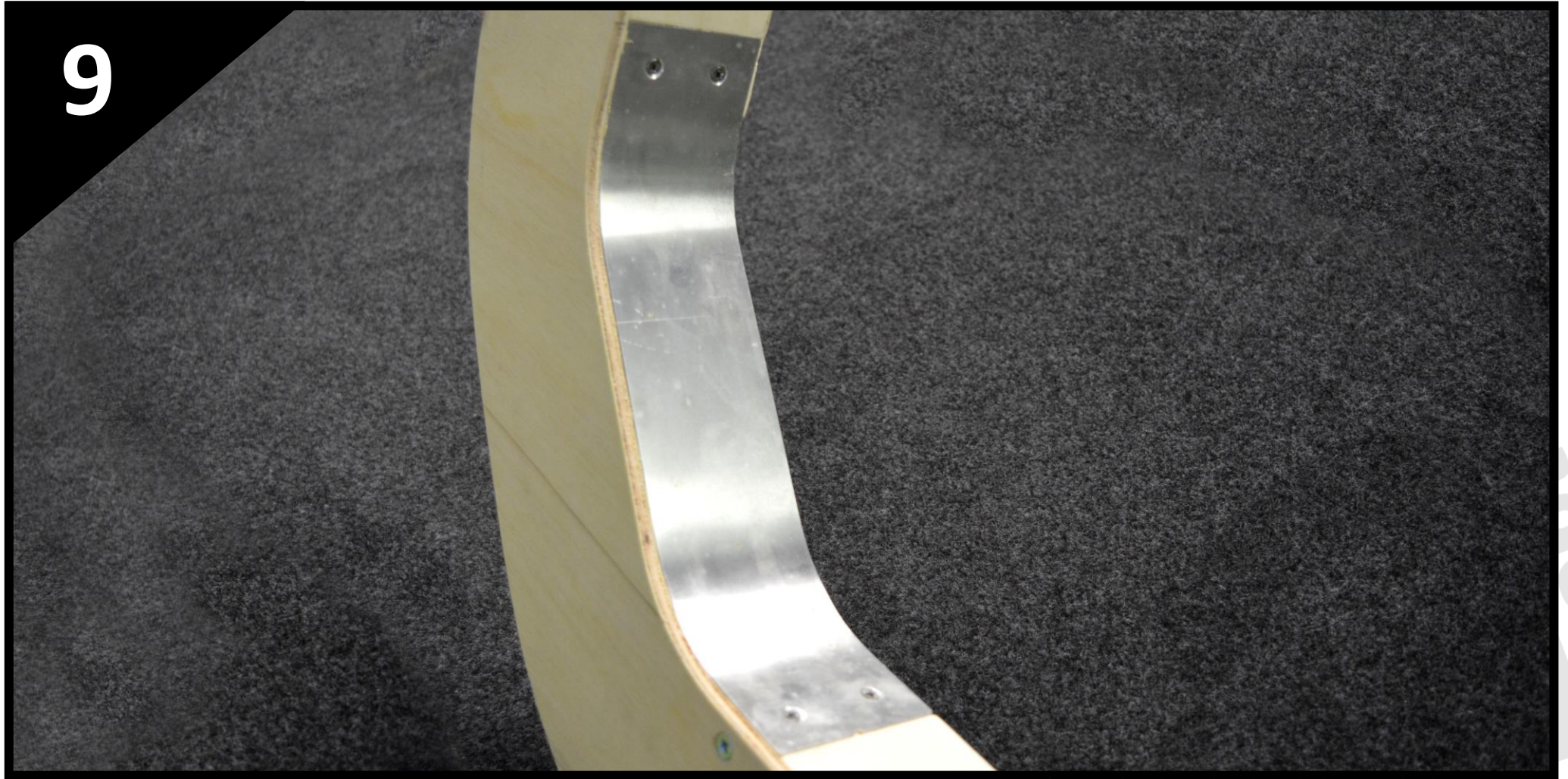
- Repeat the process of curving and fitting the corners and 15mm plywood as previously done to work around the window opening and complete the surround.
 - The above diagram shows the suggested order, working from the bottom around to the top.
- When fitting wood piece 3 & 5, screw in order from the bottom to the top so the 6mm plywood fits against the curve.
- *If the final corner/plywood join has a small gap, this is not an issue as it will not be noticeable when the surround is lined in carpet.*

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND

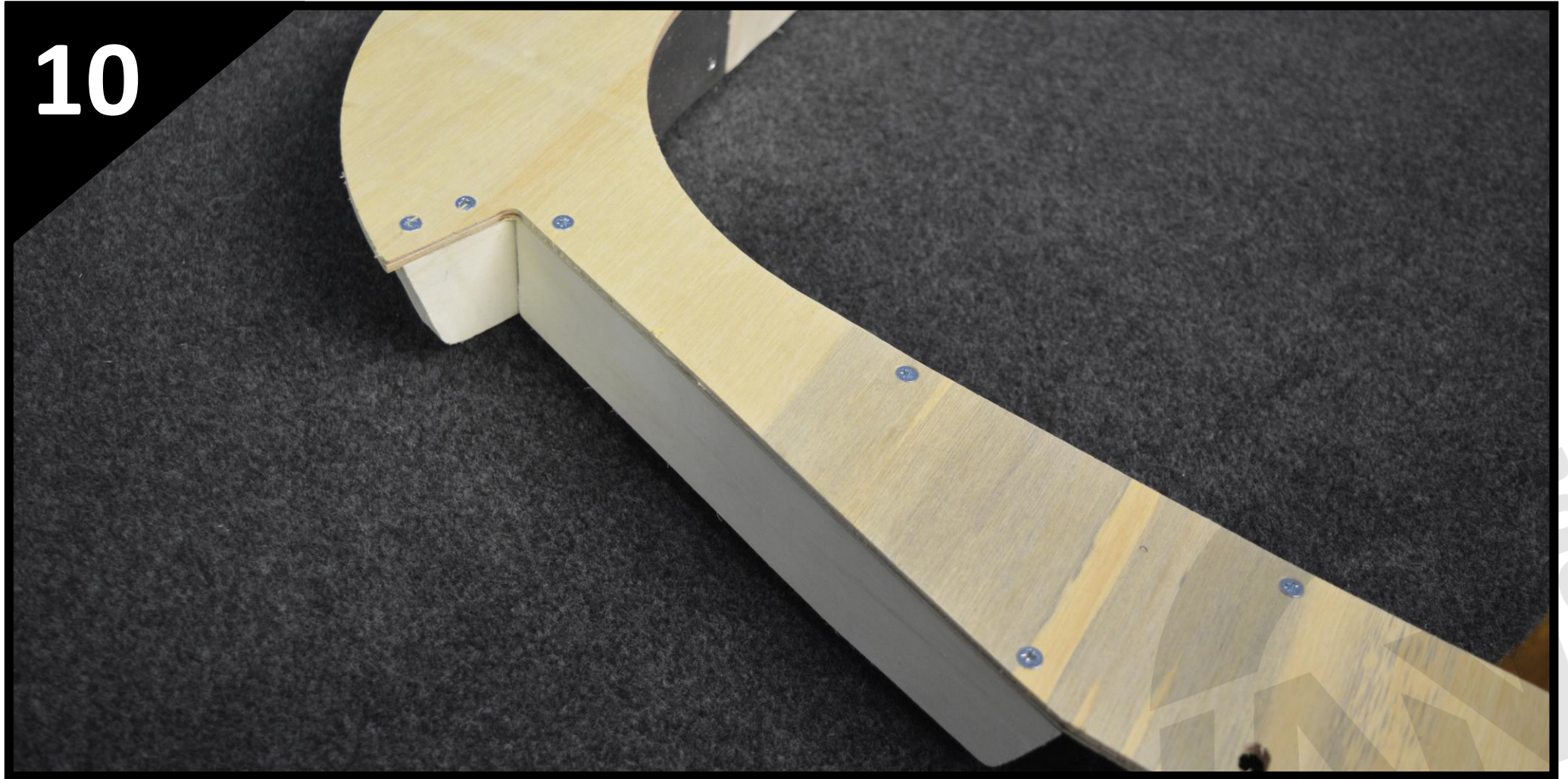


- With the surround fitted to the plywood the remaining screws can be fitted to the countersunk holes in the metalwork.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- With the surround fitted to the plywood the remaining screws can be fitted to the countersunk holes in the metalwork.



- The two remaining 15mm plywood sections that make the door handle surround can be fitted as shown, using five screws.
- There is a butt joint where they meet. Screw the two together from the small piece into the end of the long piece from behind.

11

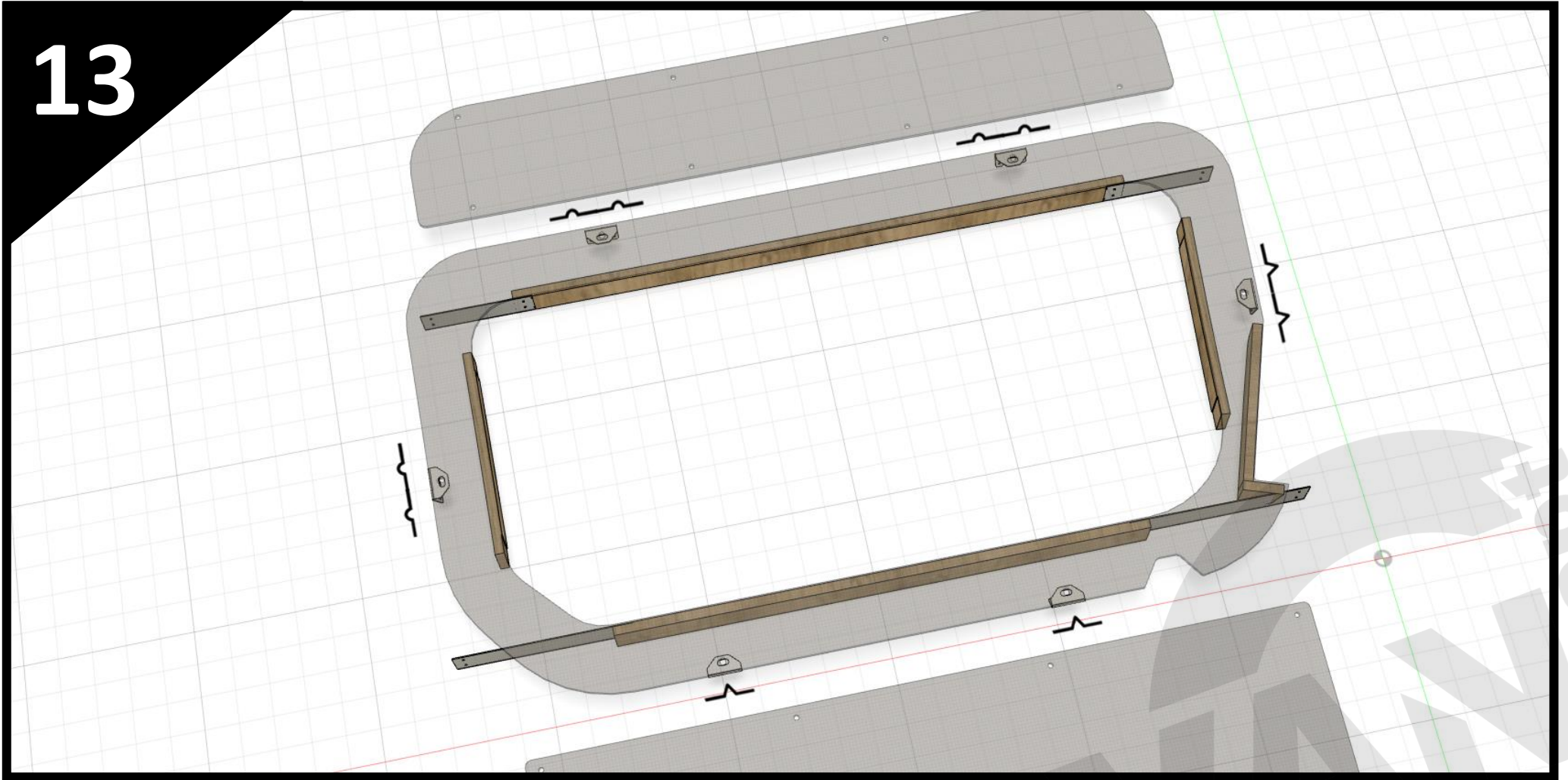


- The surround is now ready to be lined, though we'd suggest doing this after fitting the mounting bracketry to the van.
- In order to line the surround successfully in one piece of carpet, we strongly suggest using a good quality 4-way stretch automotive carpet (such as Easyliner automotive carpet) due to the tight corners and depth of return. *(Alternatively, it could be done in two-parts with a hidden join along the corner of 6mm & 15mm ply. On the back, cut away the carpet in the areas where the brackets fit, so they sit flat against the plywood.)*



- To fit the mounting brackets, measure out 156mm from the OEM top panel central holes and make a mark on some masking tape as shown.
 - This will be the centreline for the top two brackets.

13



- There are three variants of the mounting bracket provided, each with a different angle bend and identification marks.
- The brackets fit in the positions shown in the diagram.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- Use the alignment tool to locate the bracket position correctly and mark the two rivet holes in the bracket for drilling into the van bodywork.
- The tool will give you the correct offset for the bracket for the plywood surround to sit flush.

15



- Drill 2x Ø3.2mm holes in the van bodywork, de-burr the hole and rivet the bracket in place. (We advise applying some anti-corrosion paint to the bare metal in the hole before fitting the rivets).
 - Repeat this for both top brackets.

16



- Fit one M5 chimney nut to each of the fitted brackets, with the flat side of the nut facing outward from the window.
 - *The brackets have plenty of adjustment both vertically and horizontally.*

17



- Offer the window surround into place and fit two of the M5 flanged bolts to the two top mounts.
- Adjust the position of the surround to perfect the alignment with an equal gap all around.

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- Apply masking tape by the four remaining mounting holes/slots and mark the centreline with a pencil.
- Remove the surround and use the alignment tool to fit the remaining four aluminium brackets using the same method previously used. *Check stage 13 for bracket identification.*

INSTRUCTIONS SLIDING DOOR WINDOW SURROUND



- With all the brackets fitted, fit the finished surround using the M5 flanged head bolts.
- *The panel should protrude no further than the upper and lower panels and the surround should fit nicely against the window, with the thickness of the carpet taking up the gap to the glass.*