

VAN TEK



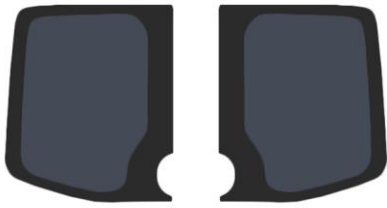
VAN WINDOW FITTING



Van Windows can be fitted at home with no real specialist tools. There are many ways to fit van windows depending on what tools you have available.

These instructions are based around the tools most DIY van converters would have. With that in mind please use this guide as a reference.

YOU WILL NEED



VAN TEK GLASS WINDOWS



VAN TEK BONDING KIT



VAN TEK U TRIM
(IF USING)

TOOLS REQUIRED



ELECTRIC JIGSAW / NIBBLER /
ELECTRIC SHEARS / GRINDER



DRILL



HOLE SAW



RULER



SHARPIE



PROTECTIVE
SHEETING



MASKING TAPE



SILICONE GUN

1, The Cut Out!

No matter what van you have the process for cutting the panel out is the same. On the inside of the van is an internal stamping this is referred to as the inner lip. This acts as your template or cut out guide. See **picture 1** showing the inner lip.

The outer panel (the area you will be cutting out) needs to be cut the same height as the inner lip.

To get the cut mark so you know where to cut drill small pilot holes round the edge of inner lip pictured below with the yellow dots in **picture 2**. The pilot holes need to be as close to the inner lip. But try not to damage the inner lip with the drill.

In **picture 2** showing the inner lip guide and the drill markings you will also see a yellow line, this is the internal support this will need cutting. To get the cut mark use a ruler and sharpie to draw a line same height as the inner lip left and right of the support. Shown as a yellow line in **picture 2**.

On the outside of the vehicle, use your sharpie to draw your cut line. The outer panel needs to be cut same height as the inner lip. You can just about see the inner lip through the drilled pilot holes to help you (indicated in **picture 3**).

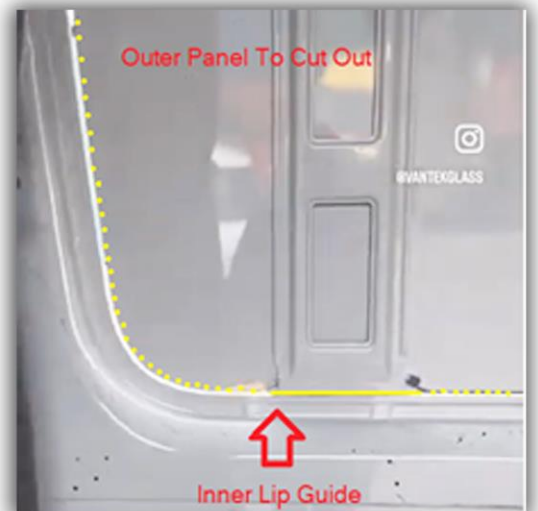
Your now ready to cut the window out, the next steps will depend on what tool you will be cutting your window out with. The easiest way to do this is with a jigsaw or nibbler. Electric shears are our favourite tool. But appreciate not everyone would have these.

You will need access to get the tool through the outer panel. A large hole saw in the corners will give you enough room and can also be used to cut the corners for you. If you're using a nibbler then the tool would go round these corners so cutting holes with a hole saw isn't needed on each corner. Just make one hole to get the tool in. Depending on the size of the hole saw (the radius) you can use the hole saw to do the corners for you. If you're going this way then position the hole saw so it's not going to catch the inner lip guide. Any damage here would be seen on the inside of the van once your install is complete. Drill from the inside out so you can see where the inner lip is. (shown in **picture 4** overleaf)

PICTURE 1



PICTURE 2



PICTURE 3



PICTURE 4

Once your hole is cut out the next step is to clean the area and prep the cut edge to prevent rust and prime the area ready to bond the window in

Use a clean unused cloth to remove any dust or debris from the metal work

In our kit we supply 2 of the orange pads. This acts as a cleaner and primer activator needed to achieve a structural bond

Use one on the metal work and one on the glass in the area where the bonding adhesive would be. Pinch the white area used to hold the pad for the fluid to flow onto the orange area.

Next step is to apply the primer using the primer stick once the cleaner fluid has dried. Remove the cap from the primer stick and make a small hole in the top. Put the cap back on and gently squeeze the tube to start the flow of primer onto the sponge pad.

The primer is applied to the metal work of the van and the Glass.

Apply primer in one layer approx. 30-40mm wide.

It's important that the primer is in any area that would be bonded.



U Trim Fitting:

U Trim is used to cover the cut edge. If you have purchased this then now is the time to fit it before the window is bonded in. See **Picture 5**

Our U Trim fits over BOTH the inner lip and cut edge. It's a specially designed size for this purpose to give a professional finish.

Bonding The Window In:

Apply the adhesive to the metal work of the vehicle in one continuous run starting at the bottom.

No gaps and approx. 8-10mm tall

Fit the glass using suction pads (or a second person to help) and press down slightly.

Adjust for correct position.

Use strong tape if any areas need to clamp closer to the body work. Open a window before shutting doors, to avoid pressure build up inside the vehicle.

Clean off any surplus adhesive with white spirit, do not use cleaner containing alcohol.

Leave the adhesive to set till the window is set firm. Minimum 2-3 hours. Ideally leave overnight.

PICTURE 5





Please Note:

- Van Tek Glass and Tek Distribution LLC are not responsible for your fitting or inability to fit.
- If you are in any doubt, please use a trained professional
- Make sure you have all the tools and correct equipment before starting the fitting process.
- Correct structural bond is only achieved by using the Cleaner/Activator pad & PRIMER included.
- Please use the proper safety equipment including eye protection and gloves.
- 1 K adhesives react to humidity. Final joint strength is obtained only after complete hardening, which relies on temperature and air humidity
- Note the safe drive away time on the relevant data sheet available from sika.com Approx 1-3 hours weather dependent **DO NOT DRIVE THE VEHICLE TILL THE ADHESIVE IS SET AND WINDOW IS SET FIRM**
- It is important to position the glass just after the adhesive has been applied
- **DO NOT LET THE ADHESIVE GET WET WITH RAIN ETC**
- **FOR FUTHER SAFTEY INFO PLEASE SEE THE RELEVANT SAFETY INFO AND SPECIFIC PRODUCT DATA SHEETS AND ON SIKA.COM**

We have videos available for cutting windows out and how to use the fitting kit correctly here:

Instructional video also available



Watch a full window installation



@vantekglass

