

THE SERIES-E

Tri-Vent Slider

C.R. Laurence™
AUTOMOTIVE PRODUCTS

MODEL: ECT1585S
2013+HiLux
NAGS FY95055PK5

CRL Tri-Vent



2013+ TOYOTA HILUX (ALL CABS)

Installation Instructions for the Professional Installer

Preparation and Precaution

This rear sliding window is designed to be glazed to the cab opening with urethane auto glass adhesive. **Do not attempt to install with a rubber gasket or silicone.** Please read this entire instruction sheet carefully before beginning installation, and note all cautions. Use caution during removal / installation of the interior trim (i.e. window trim, door threshold plate, etc.). Take necessary precautions to prevent scratches or breakage of the plastic components or the window assembly. Make sure that all components are installed securely and will not rattle or interfere with any moving parts. Sharp edges should not be left exposed. We recommend that safety glasses be worn while using power tools or working on tempered glass.

Tools and Equipment Required

- Medium Slotted Screwdriver **Cat. No. BD144**
- Utility Knife **Cat. No. 99**
- 10 mm Socket
- 1/2" Masking Tape **Cat. No. 40312**
- High Ratio Cartridge Caulking Gun **Cat. No. AB26**
- Urethane Primer Dauber **Cat. No. PT1U409**
- Urethane Auto Glass Adhesive **Cat. No. 1217349**
- Urethane Pinchweld Primer **Cat. No. 1214006**
- General Purpose Solvent and Adhesive Cleaner **Cat. No. CRL2032**
- Wildcat Urethane Cut-out Knife **Cat. No. AK10**
- Wildcat Blade **Cat. No. AKB300**
- Chisel Blade **Cat. No. FKB146**
- Safety Glasses **Cat. No. SH610**
- Hook Tool **Cat. No. CP253**
- Putty Knife **Cat. No. 4243**

NOTE: Window must be installed using an approved automotive urethane bonding system, following the procedures recommended by the urethane manufacturer. C.R. Laurence recommends our 1217349 Urethane, 1214006 Urethane Pinchweld Primer, and CRL2032 General Purpose Solvent and Adhesive Cleaner.



STEP 1: VEHICLE PREPARATIONS

1. Using a 10 mm socket remove the upper seat belt brackets.
2. Remove the upper side plastic panels by pulling out at the bottom first, then downward to release the top of the trim panel from the roof locator opening.
3. Remove the lower plastic trim panels by pulling outward.
4. Starting at the bottom of the back wall plastic trim panel, pull outward to release the fasteners.
5. Using the appropriate tool, remove the two fasteners from the headliner over the rear window.

STEP 2: REMOVE THE GLASS

1. Cut the back glass from the body using a standard cold knife with a 3/4" (19 mm) blade.
2. Start at a bottom corner, cut up the side to the middle of the top, then stop and back out blade to starting position. (Four plastic spacers, two on top and two on the bottom, are used at the factory to align the glass in the opening and are easily bypassed by the cut-out blade).
3. Insert blade at opposite corner and cut up the side to the top to complete this cut.
4. Apply tape in two locations on the top of the glass to hold the glass from falling when cutting out the bottom.
5. Cut across bottom of window to complete the removal.

NOTE: If using a power tool from the interior, extra care must be given to not damage the paint. Marking your removal blade with a permanent marker for the depth of blade being used is a good measure to prevent paint damage.

STEP 3: PREPARE THE CAB

Trim excess urethane from the pinchweld, leaving a thin skin of adhesive remaining to bond with the new adhesive. The Fein Chisel Blade is ideal for this purpose as the side of the blade guides it along the pinchweld to provide better control and avoid damage to the exterior perimeter of the window opening to protect the paint surface. The operator must also use extra care to control the tool.

NOTE: Primer should be applied to any exposed body metal that will not be covered by the urethane adhesive.

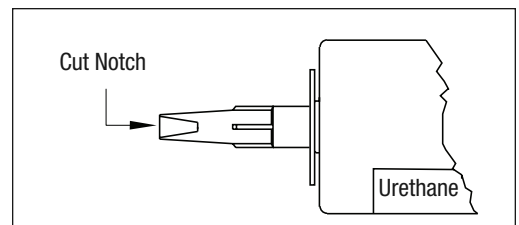
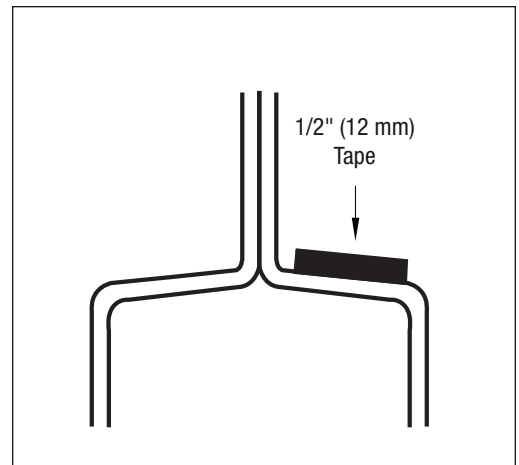
Apply 1/2" (12 mm) masking tape around the entire window opening, between the cab exterior and the original adhesive on the pinchweld, to prevent the new urethane adhesive from bonding to the cab metal. The slider frame will conceal the tape. If an accident or vandalism requires the window to be replaced, the tape will act as a release agent for the adhesive and the window may be removed by cutting it out.

STEP 4: APPLY THE ADHESIVE

It is important to check the fit of the slider before applying adhesive. Place the window into the cab opening and check for a flush fit. Old adhesive or uneven pinchweld may interfere with the window frame and hold the frame flange away from the cab. Interference should be corrected before application of the adhesive.

Trim a "V" notch into the nozzle making the top of the "V" equal to the height of the body when nozzle is placed on the pinchweld. Apply the bead of urethane over the old adhesive on the pinchweld; pull the caulking gun, rather than pushing the adhesive ahead of the nozzle. This will lay the bead down in a raised standing shape and ensure complete contact with the window frame with no voids. Go back and fill any low spots along the top or side of the pinchweld.

NOTE: It is important that the raised urethane bead come within 1/4" (6 mm) of pinchweld depth for contact with the window frame.



STEP 5: POSITIONING AND SECURING THE SLIDER

1. Being careful to avoid touching the bonding surface, carefully pick up the Tri-Vent and bring it to the cab opening. Position the bottom of the slider in the opening first. See Diagram 1.
2. Have a helper to support the Tri-Vent from outside.
3. After making sure that the slider is level and well into the opening, bend over the installation/alignment tabs to keep it properly located. See Diagram 2.
4. While your helper puts pressure on the slider from the truck bed, fold the bend over tabs around the pinchweld with the aid of a rigid bent Putty Knife. See Diagram 3. These tabs secure the slider while the urethane cures and allows the truck to be driven immediately after installation.

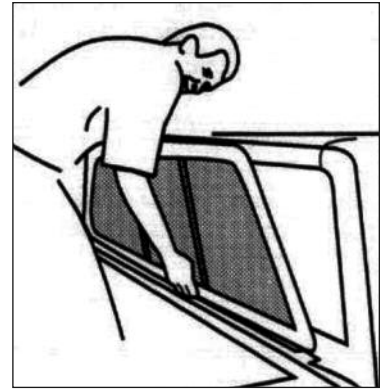


Diagram 1

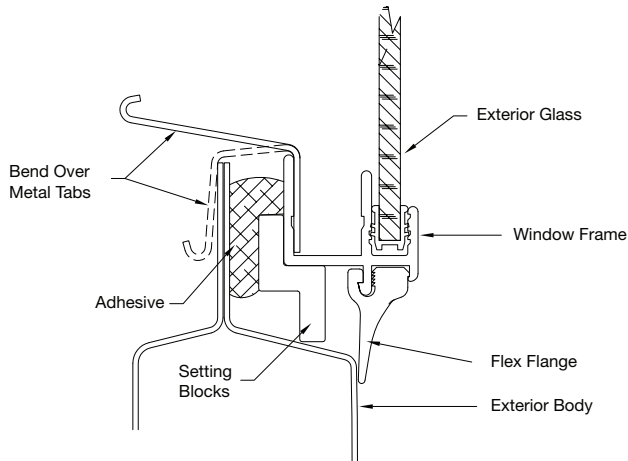
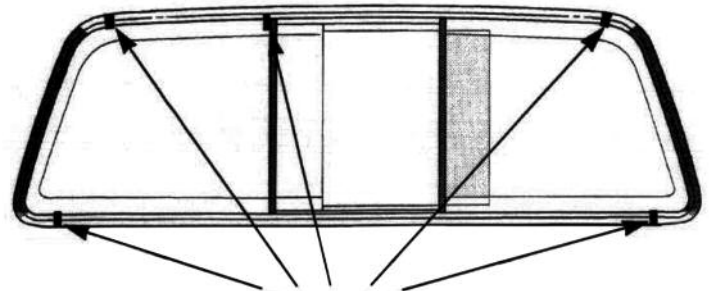


Diagram 2



BEND OVER TABS

Diagram 3

STEP 6: CLEAN UP

Remove any smears of urethane from the cab interior. Your Series-E slider installation is now complete. Although the adhesive will not be fully cured for several days, with the bend over tabs in place the window is secure, and the vehicle may be driven away. However for a period of four hours do not abruptly close the vehicle doors with all windows closed. The air pressure could blow out the fresh urethane and cause a leak.

STEP 7: LEAK TEST

To test the installation, gently spray water over the top of the cab and inspect the vehicle interior for evidence of leaks. If a leak develops, determine the exact location and reseal from the interior by applying additional urethane adhesive as needed. If the weepholes are restricted, inspect and clear weepholes.