

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	CA-CMP-001-C-A-	Windscreen Frame	1
2	CA-CMP-002-C-A-	Canopy Composite Frame	1

Note:
See next page for the Windscreen/Window Bonding Procedure.

Note
Refrigerate the Sika products for use later in the construction

Step 1

Start the canopy construction by painting the inside of Part number (1) and (2) to the desired colour or finish preferred.

Note: Do not paint outer parts of canopy frames

Step 2

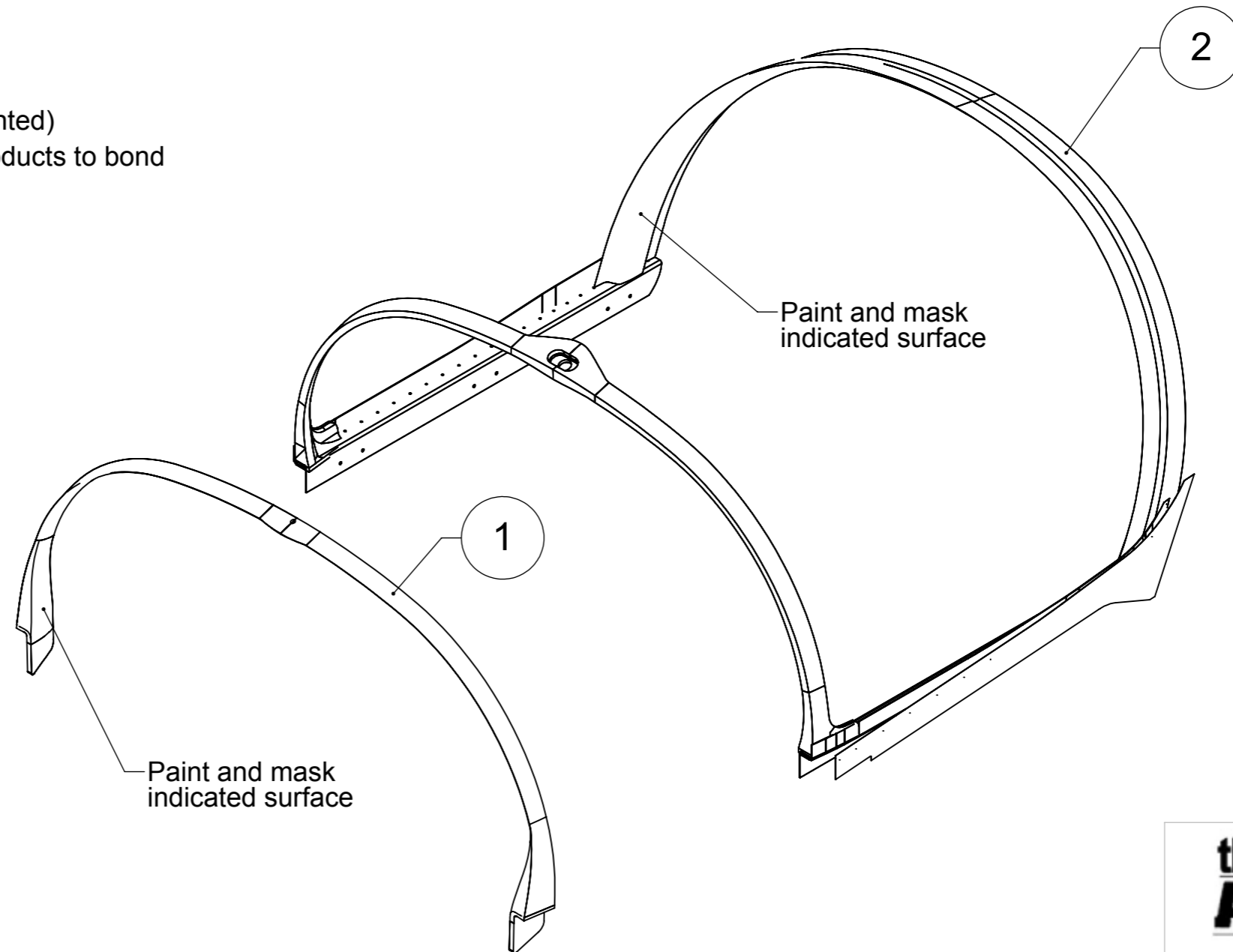
Use masking tape on the painted surface of parts (1) and (2) so that Sika products in following steps will not damage painted surface.

Step 3

Using sanding paper sand down the outer surface (Unpainted) of part (2) to a rough texture as this will help the Sika products to bond in step 17, 18 and 19 on page CA7 and CA8.

Step 4

Use a cloth and Sika Cleaner -205 to clean / Prime the roughened surface of part (2)



DESCRIPTION pg CA1

CANOPY FRAME PREPERATION

Sling 2 Windscreen/Window Bonding Procedure.

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The following steps needed to be followed only after the Windscreen/Window has been properly cut and correctly fitted as described in the Construction Manual.

Please note that the Shelf Life of the Cleaner, Primer and Bonding paste listed below must be within the allowed specification clearly marked on the container.

- 1) **Sika Cleaner – 205.** For all cleaning before the Primer is added.
- 2) **Sika Primer – 206 G+P.** To be used on Composite (Canopy) parts only.
- 3) **Sika Primer – 209 N.** To be used on Perspex (Windscreen/Windows) only.
- 4) **Sikaflex – 295 UV.** To be used for bonding of the Windscreen/Windows.

Step 1.

- a) Windscreen/Window must be held firmly in place.
- b) Use a Whiteboard marker and mark Windscreen/Window on inside, using the canopy edge as reference.
- c) Use a thin Pinstripe tape to mark the Windscreen on the outside using the dashboard stitch as a reference. (Tape should be ± 2 mm below the stitch mark.)

Step 2.

Abrade the marked bonding surfaces on the Windscreen/Window with P80 sandpaper. The defined bonding area should be from the Whiteboard marker and/or Pinstripe towards the edge of the Windscreen/Window.

Step 3.

- a) Mark the outside of the canopy with a Pinstripe on the edge of the Windscreen/Window recess on the canopy.
- b) Use masking tape to cover up a wide strip of the canopy from the Pinstripe towards the back. Only the bonding area must be visible. Also cover the inside of the canopy with a masking tape strip.
- c) Cover exposed areas on Skin 015 also with a masking tape strip.

Step 4.

Abrade the exposed bonding area on the canopy with P80 sandpaper. Care must be taken that the covered areas on the canopy does not get damaged.

Step 5.

After sanding both bonding areas they must be properly cleaned with Sika Cleaner-205 and a paper towel.

Step 6.

The following primers to be applied onto the bonding areas using a new and clean sponge.

- a) Sika Primer - 206 G+P to be used on the composite (canopy) only
- b) Sika Primer – 209 N to be used on Perspex (Windscreen/Window)

Allow approximately 10 to 15 seconds for Primer to dry. (Do not touch these areas.)

Step 7.

Apply a thick layer of Sikaflex – 295 UV to the canopy and dashboard bonding areas only, using a proper Sikaflex Gun. Sikaflex must not be applied to the Windscreen/Window.

Step 8.

After the Sikaflex is applied, the Windscreen/Window can be fitted by evenly pressed it down onto the frame until it fits perfectly and flush with all edges.

Step 9.

Remove all excess Sikaflex and clean surfaces properly with Benzene.

Step 10.

All other markings and masking tape can be removed after Sikaflex are properly dried and again clean all areas thoroughly with Benzene.

Please note that in some cases it has been found that the cracks are straight or curved.

Straight crack

Straight crack

Curved crack

Curved crack

Cracks from front of Canopy

Cracks from rear of Canopy

