



## *Instructions for installing ACRYLIGHT framed windows*

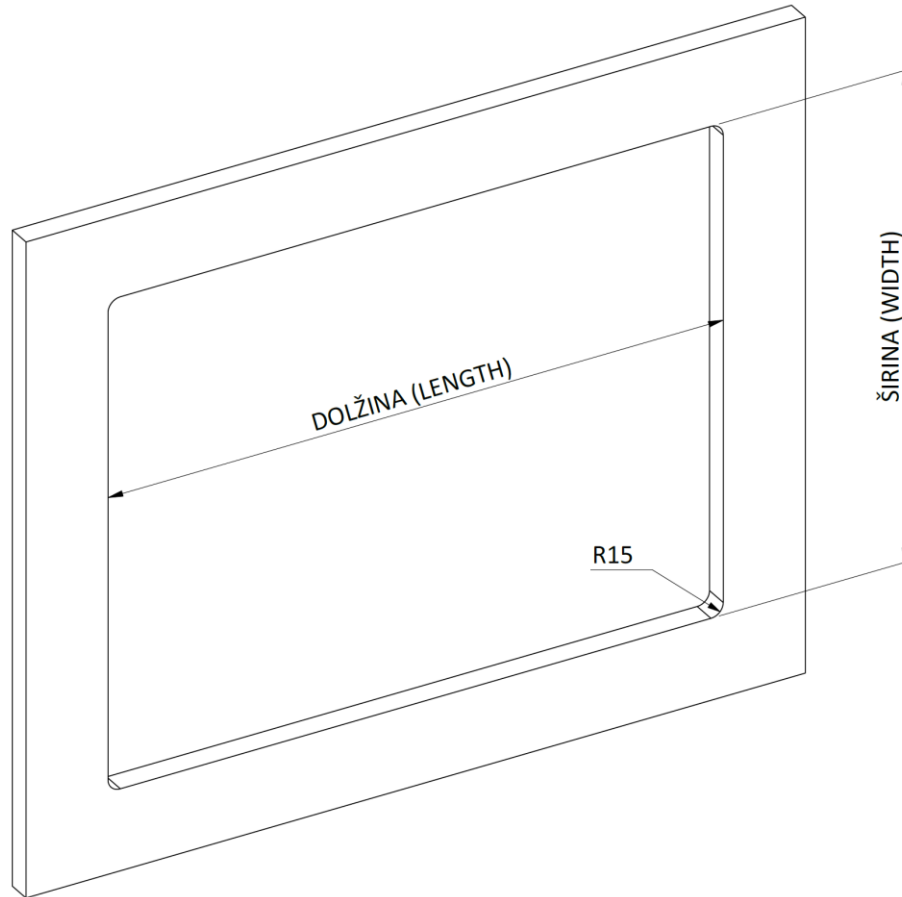
## Instructions for installing framed ACRYLIGHT windows

### Wall opening:

The window opening should have R15 mm radiuses.

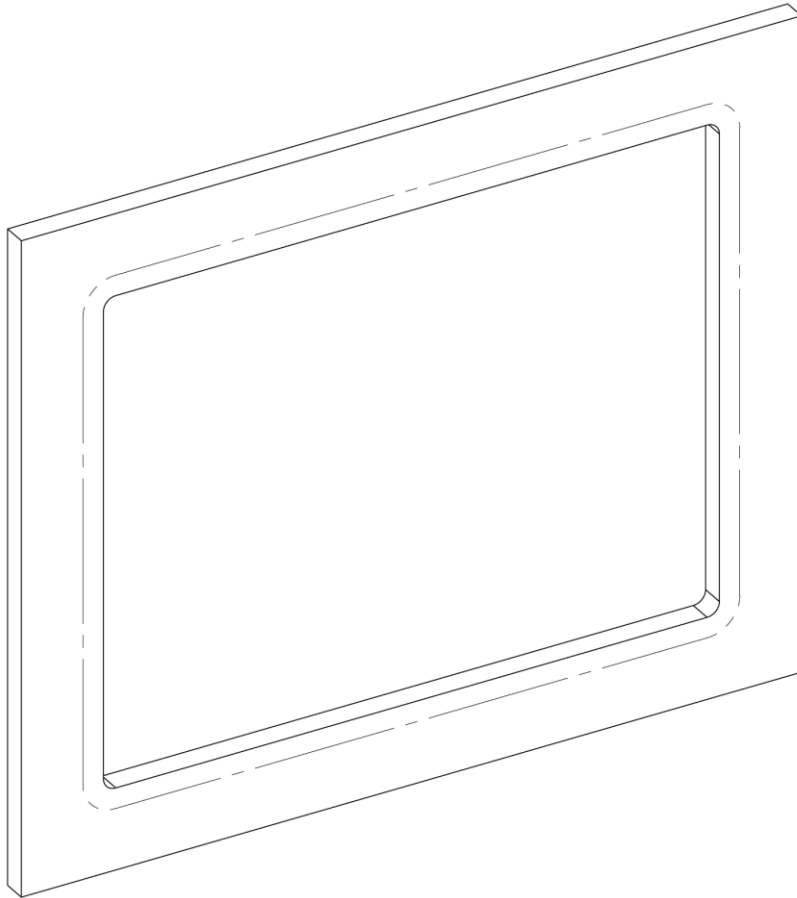
Wall opening tolerance +1,5/-0,5 mm.

Wall thickness tolerance  $\pm 1$  mm.



NOMINAL SIZE	LENGTH (mm)	WIDTH (mm)	RADIUS (mm)
900x600	904	603	15
750x600	750	600	15
800x450	800	450	15
700x500	700	500	15
700x300	700	300	15
350x500	350	500	15

## *Instructions for installing framed ACRYLIGHT windows*

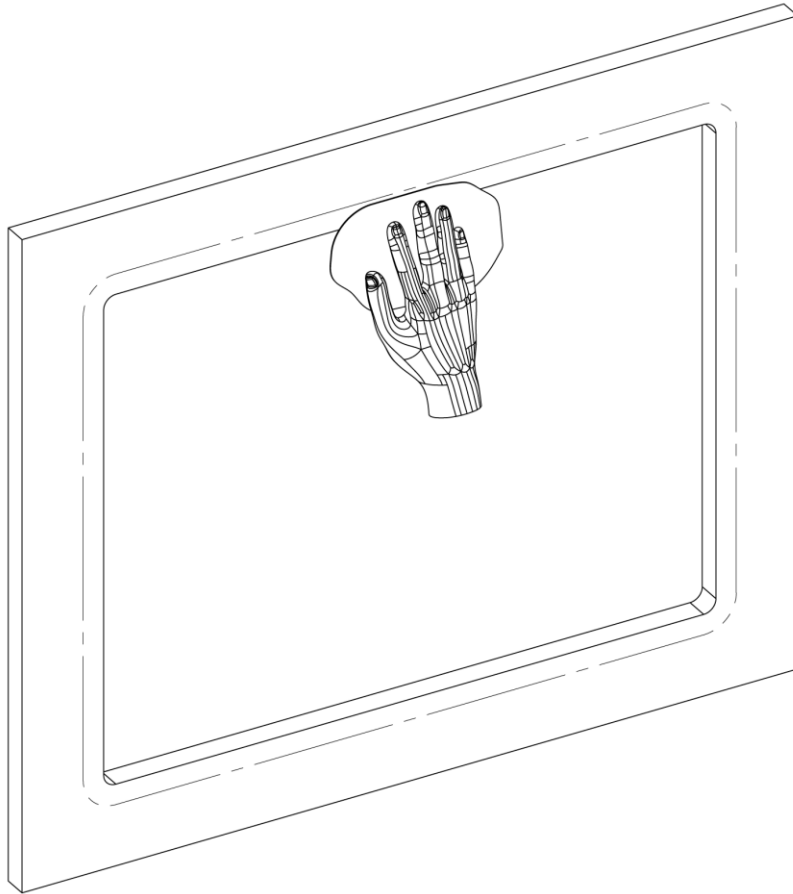


### Reinforcements around the wall opening:

A good seal is ensured by adhesive sealant and screwing the window frames together, which causes pressure on the wall in the window area.

It is therefore recommended that all sides of the opening are reinforced with wooden inserts or similar elements enabling the firm and permanent installation of window components.

## *Instructions for installing framed ACRYLIGHT windows*



### Preparing the wall – cleaning:

Before mounting the window, make sure that the outer surface of the wall is properly prepared and cleaned.

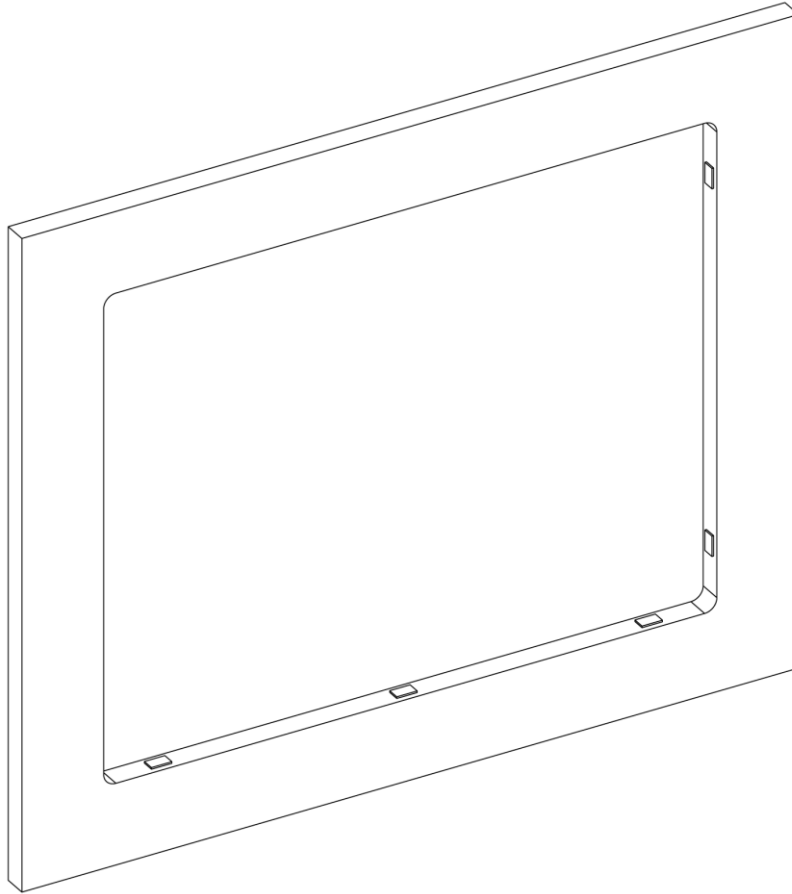
Wipe the surface with a clean cloth and a cleaner.

Verify with the supplier of the cleaner that the selected product is suitable for use on all installed materials.

Change the cleaning cloth frequently if the wall is very dirty and/or contains fat residues.

When the surface is free of dirt and fat, wait till the cleaner evaporates or remove it in accordance with the instructions of the cleaner supplier.

## *Instructions for installing framed ACRYLIGHT windows*



### Preparing the wall – spacers:

The framed window must be placed in the center of the opening on the wall, which is ensured with spacers.

We recommend using **2mm** thick spacers.

Place spacers on the bottom and one side of the opening.

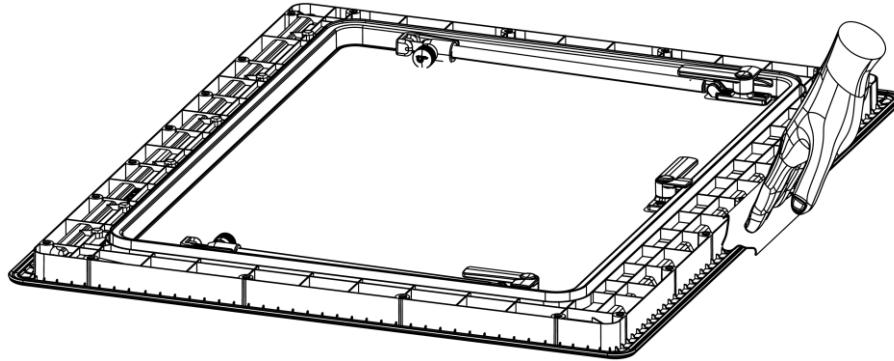
Self-adhesive EPDM foam is recommended for spacers.

If solid spacers are used, they must be removed after mounting the outer frame.

## *Instructions for installing framed ACRYLIGHT windows*

### Preparing the outer frame – cleaning:

Place the outer frame on a flat surface.



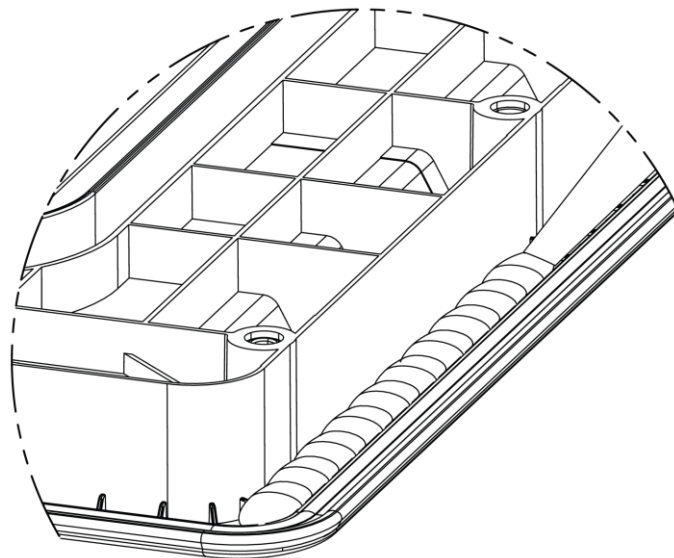
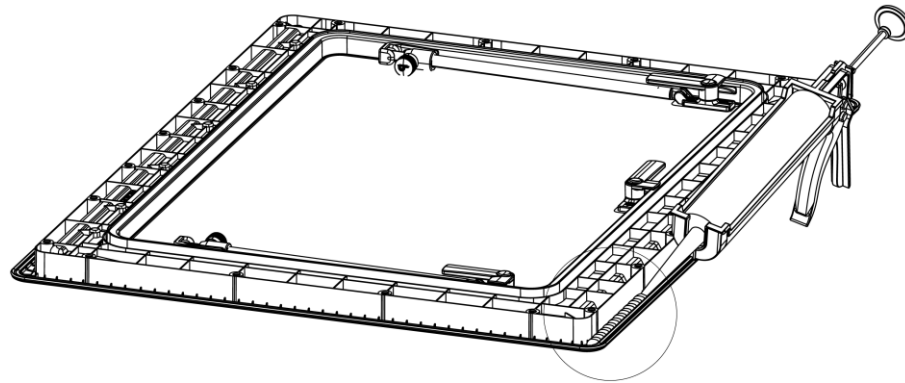
Make sure that the rubber seal around the edge of the frame is undamaged and correctly installed and that the surface in the area where the adhesive sealant is applied is clean. Eliminate irregularities and impurities before applying the adhesive sealant.

Prepare the surface of the outer frame according to the instructions of the adhesive sealant supplier. If necessary, apply a primer to the surface of the frame before applying the adhesive sealant.

Verify with the supplier if the selected products are suitable for use on all built-in materials.

Contact Acryform sales for the outer frame material information.

## *Instructions for installing framed ACRYLIGHT windows*



Preparing the outer frame – applying the adhesive sealant:

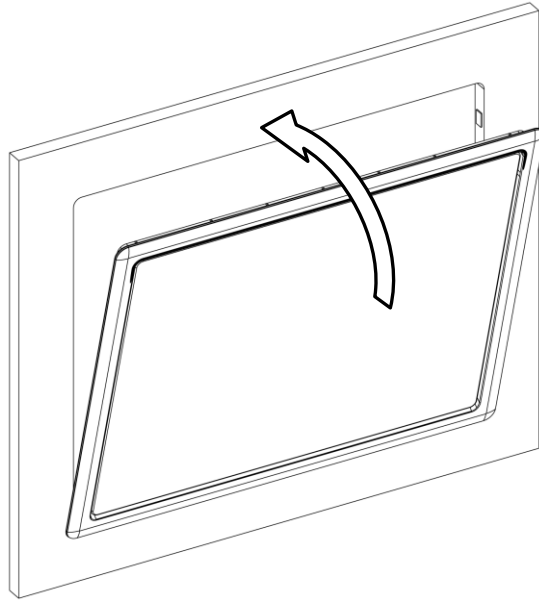
Apply the adhesive sealant in the dedicated groove around the perimeter of the outer frame.

Pay attention to the correct amount and constant, continuous application of the adhesive sealant.

Check with the supplier if the sealing adhesive is suitable for use on all installed materials.

Contact Acryform sales for the outer frame material information.

## *Instructions for installing framed ACRYLIGHT windows*



### Installing the outer frame on the wall:

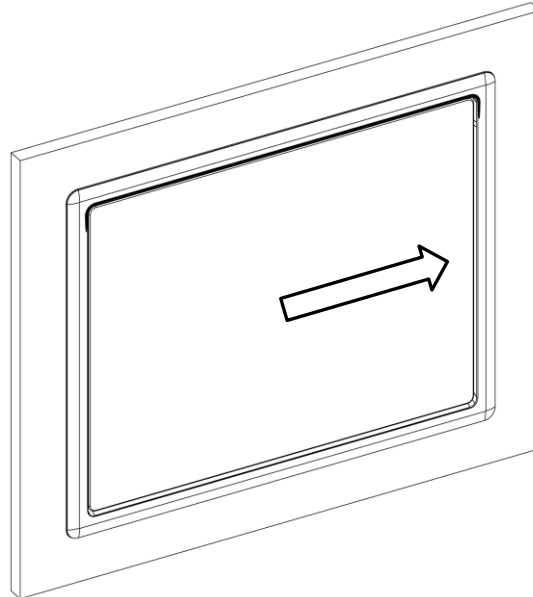
Carefully transfer the outer frame to the opening on the outside of the vehicle wall.

Make sure the framed window is oriented correctly!

Place the bottom edge of the frame on the opening first and make sure it is centered with the wall opening.

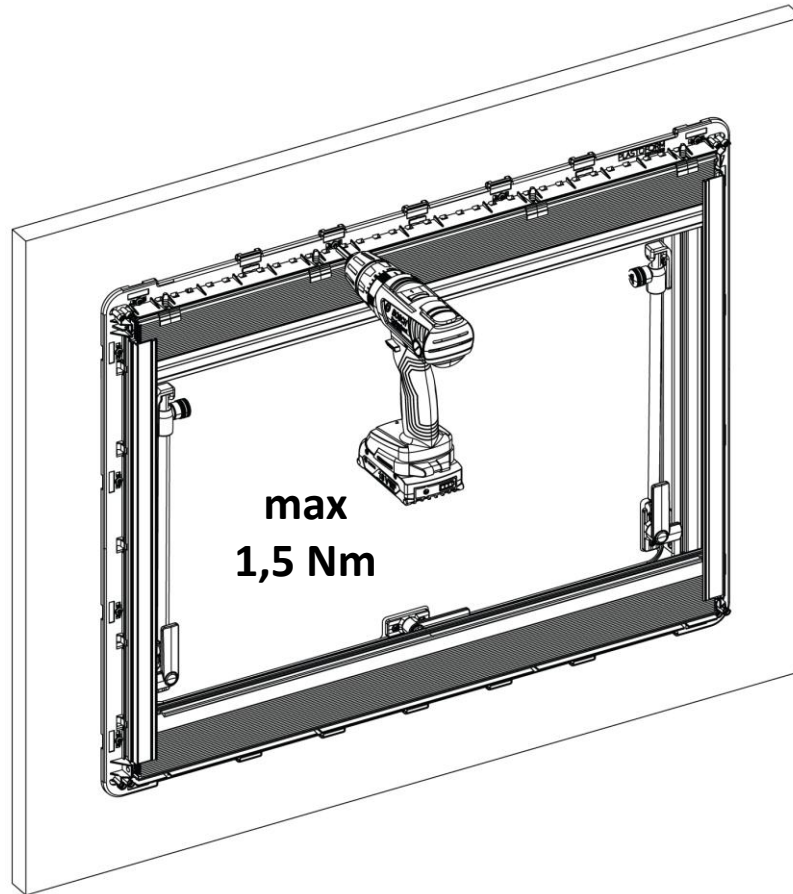
Push the frame into the wall opening, setting it on the spacers on the underside of the opening.

Push the frame toward the spacers on the side, thus ensuring that the outer frame is positioned in the center of the opening.





## *Instructions for installing framed ACRYLIGHT windows*



### Mounting and screwing the middle frame:

Place the middle frame in the opening from the inside. The correctly facing middle frame has a mosquito net on top and blackout on the bottom.

The middle frame is screwed to the outer frame with dedicated M5 screws supplied by Acryform.

The tightening torque of the screws should not exceed 1.5 Nm!

The number and length of screws depends on the size of the window and the thickness of the wall. Obtain this information from Acryform sales department.

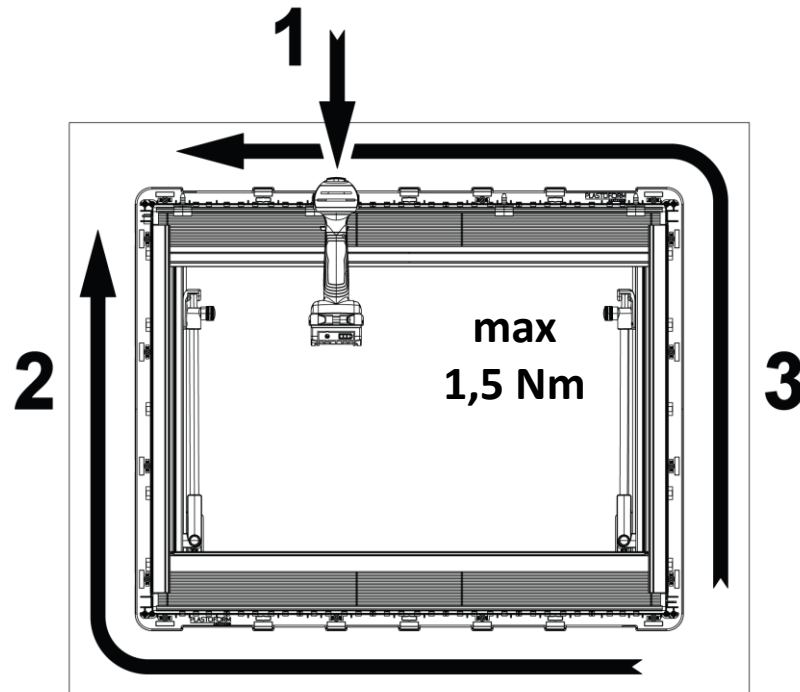
### Attention:

Dedicated M5 screws are used to hold the outer frame during the drying time of the adhesive sealant and later to hold the middle frame in place. Sealing between the wall and the frame is ensured by the adhesive sealant!

## *Instructions for installing framed ACRYLIGHT windows*

Additionally for installing windows on parabolic walls:

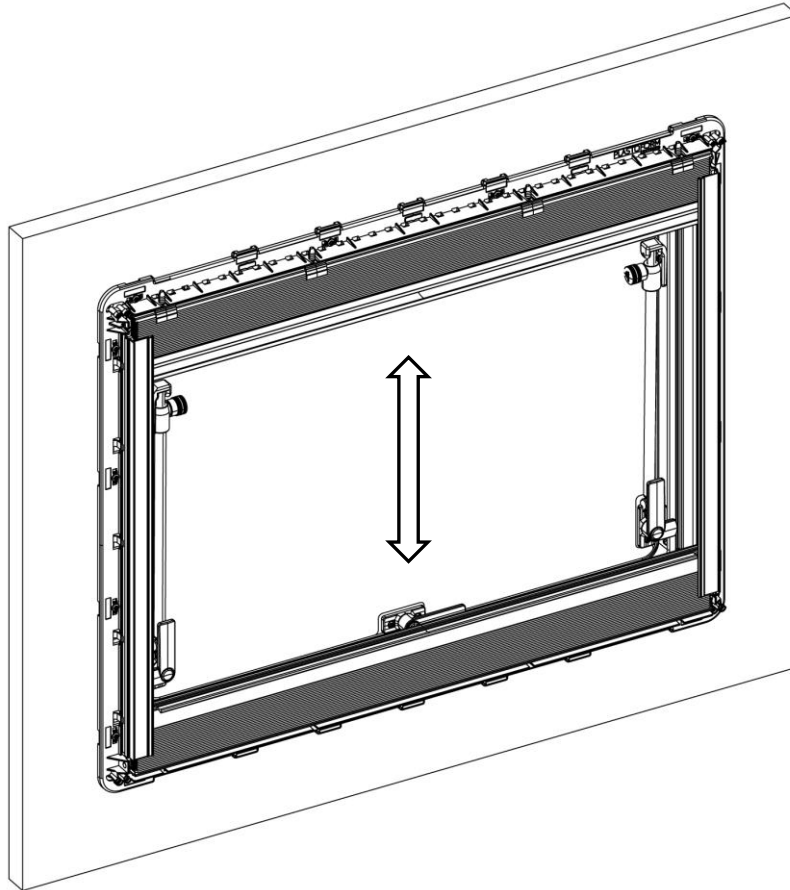
Before installation, open the window on the outer frame to the ventilation position. This enables the frame to better adapt to the wall.



The screwing process is shown in the picture on the left:

1. First, we connect the frames with one of the upper screws in the middle. We do not tighten the screw yet.
2. We start screwing in one of the lower corners. We screw on the bottom and up the side.
3. We continue up the opposite side and on the top. When we come across the first screw, we tighten it.

## *Instructions for installing framed ACRYLIGHT windows*



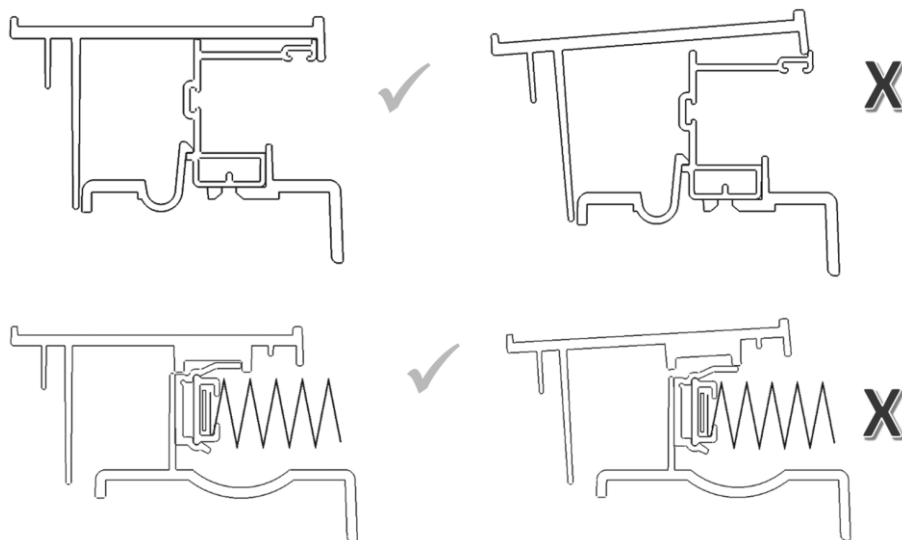
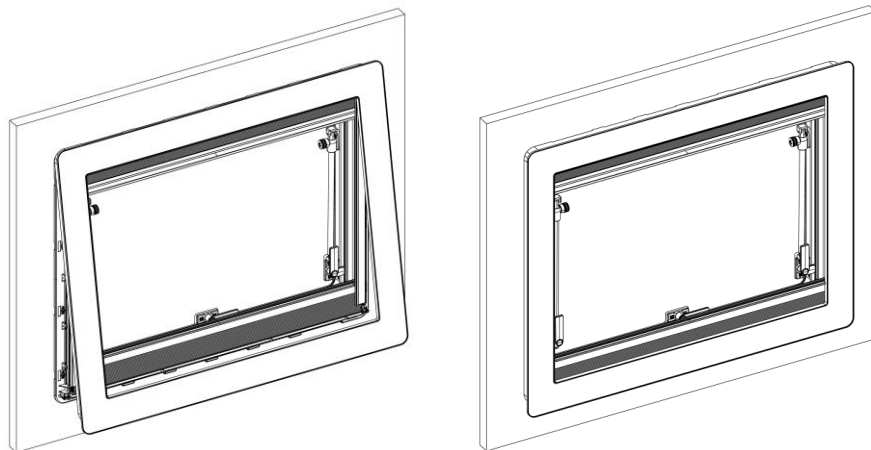
### Checking the middle frame installation:

Check the operation of the mosquito net and the blackout.

Open and close the mosquito net several times and observe its movement for possible abnormalities. Repeat the same with the blackout.

If the movement of the mosquito net or the blackout is obstructed, check the screwing force and whether the wall on the vehicle is of the appropriate thickness for the frame assembly.

## Instructions for installing framed ACRYLIGHT windows



### Mounting the inner frame:

Hang the inner frame on top of the middle frame.

Press firmly on the inner frame all the way around until it engages with the middle frame.

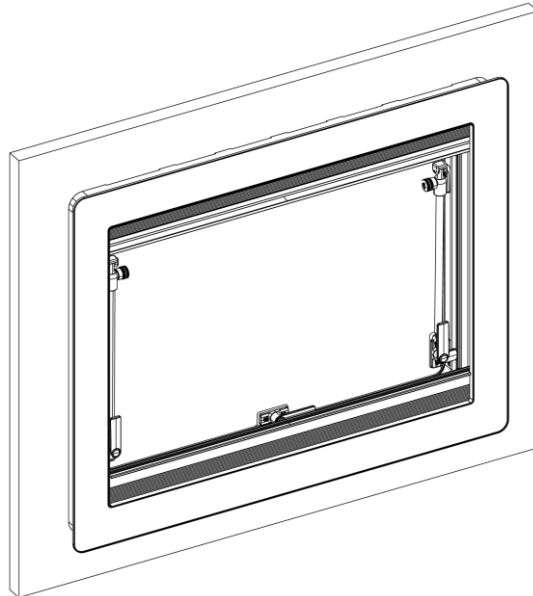
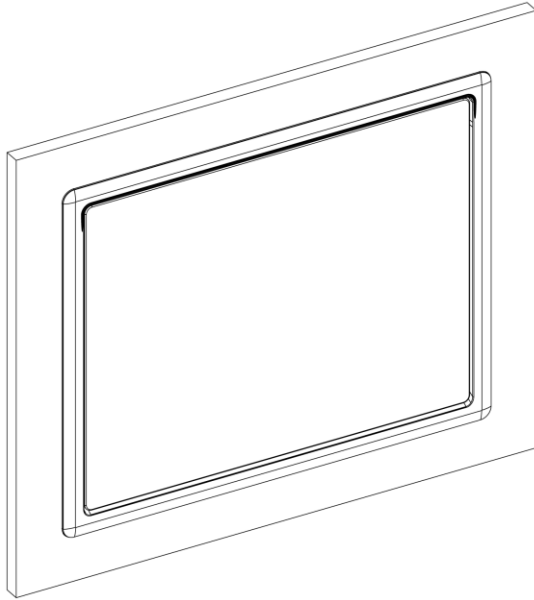
Check the fit with the middle frame around the perimeter visually and by touch and eliminate any irregularities.

The left pictures show examples of correct fit on the guide rails and on the mosquito net and blackout holders.

The right images show common errors in the installation of the inner frame that need to be corrected.

A good indicator of correct installation is the flat surface of the inner frame and the smooth movement of the mosquito net and the blackout.

## *Instructions for installing framed ACRYLIGHT windows*



### Checking the framed window installation :

Inspect the framed window visually and functionally for possible irregularities and eliminate them.

Check:

- opening and closing of the window,
- operation of stays and handles and
- operation of the mosquito net and the blackout.

Once the framed window is appropriately installed, protective foil should be removed from the window.

Also remove any excess adhesive. Be careful not to damage the surface of the frame.

## *Instructions for installing framed ACRYLIGHT windows*

Following these steps the installation of the framed window will be done correctly.

To ensure proper functioning and longevity of your windows, please also read the safety and longevity guidelines in the instruction for use.

Find them on the product page at [www.acryform.com](http://www.acryform.com).