

THE CRUISER COMPANY.

Lift-up window instructions ***200 Series Land Cruiser*** ***V1.0***



Lift-up window instructions
200 Series Land Cruiser

The following instructions have been created showing the install of a driver's side lift-up window, however the procedure is identical but reversed for a passenger side window, the supplied and required items are shown below, please read through these instructions in entirety before beginning the install.

<u>Required tools/ items</u>	<u>Supplied Hardware</u>	<u>Supplied window components</u>
8mm open end spanner	Gas strut stubs x 2	Fixed window panel x 1
10mm open end spanner	Flange nuts x 2	Opening window panel x 1
10mm socket and socket wrench	M8 nuts x 8	Stainless steel offset bracket x 1
14mm socket and socket wrench	M6 washer x 8	Window mounting panel x 1
trim removal tools	M5x16mm Button head screw x 9	Upper gas strut mount x 1
pointy nose pliers	M5 Washer x 16	Lower gas strut mount x 1
3mm Allen key	Pop rivets, black x 3	
Pop rivet gun	Gas strut 450x150NM x 1	
Sikaflex 252, High strength structural adhesive cartridge, black	1.6m length bulb seal x 1	
caulking gun	Black hinges x 2	
Solvent to remove excess Sikaflex	Window locks with keys x 2	
suitable rags for adhesive cleanup		
Quick Grip clamps or similar		
Diagonal pliers / cutters for cutting bulb seal		
Hammer and steel punch		
Fasteners of choice to attach window to car body		
Philips head screwdriver		
Power drill and various drill bits		

Lift-up window instructions
200 Series Land Cruiser

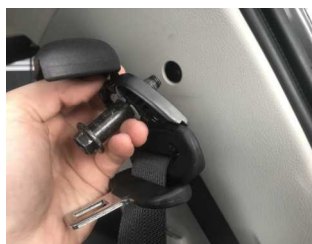
1. The internal trim in your vehicle on the side the window is to be installed on needs to be removed, this requires removal of the 3 row seat which is not included in these instructions. However these can be easily removed by un-clipping the plastic covers and removing the mounting bolts.
2. To remove the trim the first piece to remove is the tailgate plastic cover removed, the best way to do this is to pull it up from behind, there are several clips that hold this cover along the its length.



3. Next there is a small clip under the corner of the cover that needs to be removed, the center plug needs to be flicked up before the clip can be lifted out, use the trim removal tool to flick this clip up.



4. Now the seat belt fixings need to be removed, the third row seat belt top and bottom and the bottom fixing of the second row seat all need to be removed. This is done by un-clipping the plastic cover and undoing the bolts with the 14mm socket and wrench.

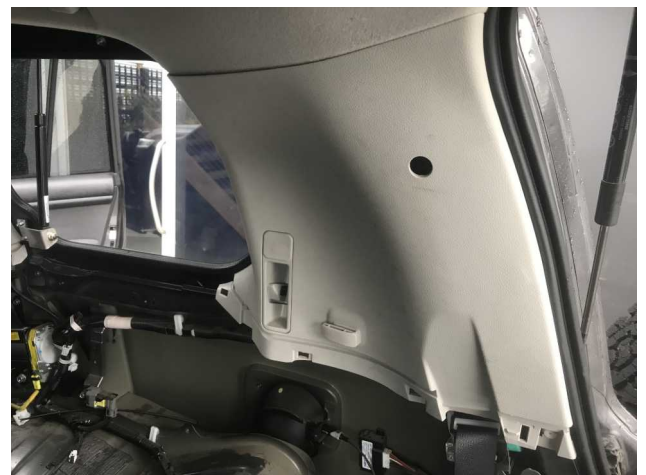


Lift-up window instructions
200 Series Land Cruiser

5. Next at the base of the 2nd row of seats by the door there is a plastic cover plate that needs to be removed, it is fixed with a small screw that can be accessed by first removing the cover with a trim removal tool as shown below. The screw is undone with a 10mm socket, once removed lift off the cover plate as shown on the right.



6. Now pop off the main side trim panel and then the rear upper white panel as shown below. On the passenger side the main panel has a wiring loom attached to it that must be unclipped. When fitting the drivers side window the antenna connection will need to be unclipped from the window.



Lift-up window instructions
200 Series Land Cruiser

7. Remove the white B-pillar trim cover next by unscrewing the small screw with the 10mm socket then pop the cover off, the cover will hang from the two hooks, lift off and feed the seat belt through the cover to remove it.



8. Finally the top window trim needs to be removed, this is the most difficult to remove because of the style of clips used. The trim clips can be removed from the car body with a 90° trim removal tool or by pulling with a pair of pointy nose pliers. It is also possible to use the pliers to gently twist the clip 90° to release them from the trim panel without removing them from the car body, they then can be more easily accessed to be removed from the body. They must be removed and refitted to the trim panel in order to be able to reinstall the panel.



Lift-up window instructions
200 Series Land Cruiser

9. We recommend contacting a local glazier to professionally remove the rear quarter window. Plan your build and book a glazier in advance to come out after you have removed the trim. Explain to the glazier that the window surround will be visible and ask them to avoid scratching the body. It is possible to remove the window yourself using a thin long knife (a Stanley knife is too short and will not suffice) however this method can result in scratching the surround of the window which is visible. Once the window is removed your vehicle will look as shown below

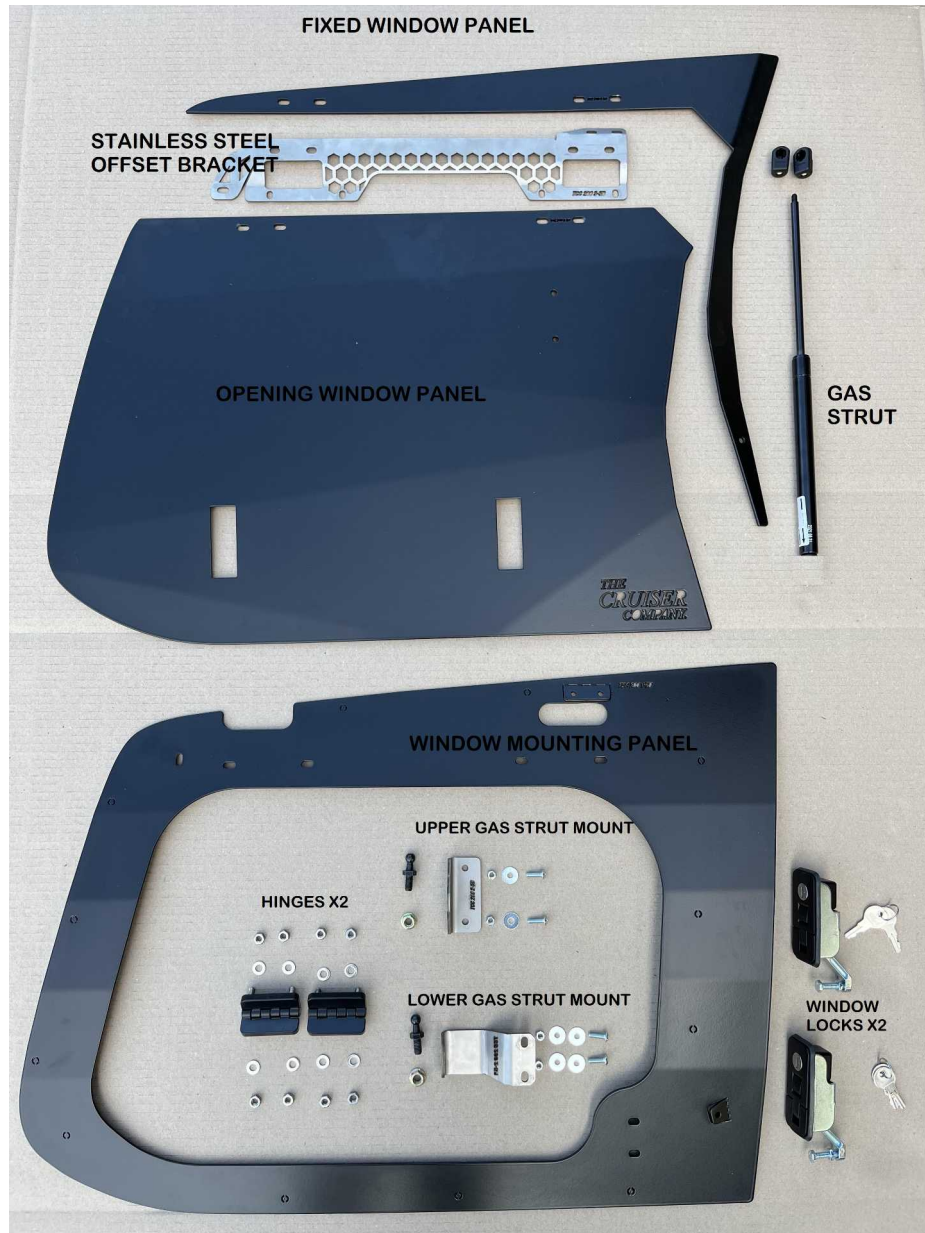


10. Once the window is removed there will be adhesive on the body, as seen in the right hand photo above, this can be left on the car and new Sikaflex can be applied over the top, however depending on the final alignment of the window some of the original adhesive may be slightly visible. To remove the remaining adhesive a suitable solvent, a plastic scraping tool (a trim removal tool can be used), together with some elbow grease is required. A cleaned passenger window is shown below.



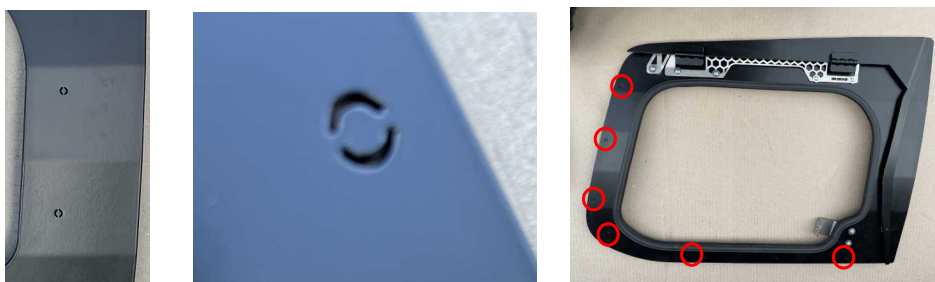
Lift-up window instructions
200 Series Land Cruiser

11. Next for the assembly of the lift up window, layout all of the received parts as shown below, there will be additional fasteners for fixing the stainless steel offset bracket to the window mounting panel and the enclosed rectangular black vinyl sticker is not shown below.



Lift-up window instructions
200 Series Land Cruiser

12. Several half cut holes have been laser cut in your window mounting panel (shown below), for fastening your window to the car body. These half-holes can be punched out, with a steel punch and a hammer, and then later used to mechanically fix the lift- up window to the car. Position the window mounting panel in the window surround on your vehicle and confirm which holes you would like to use ensuring they are suitable for the type of fastener you are using. Please note several of these holes will not be accessible when the window is installed as per these instructions, the holes that can be accessed have been circled in the image below. Punch out the holes you would like to use.



13. Take the window mounting panel and bend the tab at the top (shown in the image below) outwards slightly by hand.



14. Then take the stainless-steel offset bracket and fix it to the panel as shown in the right image below using the 5 screws and two washers for each screw. Take care when assembling the parts as the laser cut edge on the stainless steel can easily scratch the powder coated mounting panel.



Lift-up window instructions
200 Series Land Cruiser

15. Using a pop rivet gun, and two of the supplied rivets, pop-rivet the stainless steel offset bracket to the window mounting panel as shown below. If the rivet cannot fit in the hole in the window mounting panel ream out the hole slightly with a drill bit.



16. Next the lower gas strut mount is installed on the window mounting panel, take the components shown below and fix the bracket in the orientation shown.



17. Now bend out the other tab on the window mounting panel by hand approximately 10°, this will be used to fix the tail of the fixed window panel.



Lift-up window instructions
200 Series Land Cruiser

18. Now take the fixed window panel as well as the two hinges and assemble them on the window mounting panel as shown below.



19. Flip the window and rest it on the hinges on a smooth surface that will not scratch the hinges or the window mounting panel and then assemble the hinges on the stainless-steel standoff with the supplied nuts and washers, leave the nuts loose so the window panel can slide.



20. Next fix the tail of the fixed window panel to the window mounting panel using the third supplied rivet. Take care and consider using masking tape to protect the face of the painted rivet as scratches from the rivet gun will be visible.



Lift-up window instructions
200 Series Land Cruiser

21. After riveting the fixed window panel your lift-up window should look like the image below, as the hinges are not fully fastened the fixed window panel will be able to pivot and bend slightly when moving it left to right, next the opening window panel will be mounted and the fixed window panel adjusted so that the gap is even around the opening window panel



22. First assemble the opening window by attaching the upper gas strut mount and the two locks to the opening window panel as shown below.



The locks are fitted to the window by removing small Philips head screw on the back and the folded metal bracket then reassembling on the window panel sandwiching the panel with the bracket. We have not supplied washers for the upper strut mount for the external side of the window, rather there are no washers under the head of the screws on this side as shown in the image below.



Lift-up window instructions
200 Series Land Cruiser

23. Next install the bulb seal onto the inner edge of the window as shown in in the images below, this is done by starting at one point and working the seal onto the edge of the window mounting panel, ensure that the seal is firmly pressed into place hard up against the edge of the panel. The exact straight length of bulb seal required is 1515mm however it is recommended that you fit the seal onto your window and then cut the excess material and push the ends together. The join of the bulb seal could be glued together if desired.



24. Next using the supplied nuts and washers attach the opening window panel to the hinges as shown below, again keep the nuts loose so the opening window panel can move slightly for adjustment



Lift-up window instructions
200 Series Land Cruiser

25. The gas strut can now be fitted, to the lower gas strut mount and the upper gas strut mount as shown below using the two gas strut stubs and flange nuts supplied. Particularly with the lower gas strut mount again be careful to avoid scratching the powder coat on the window mounting as the fasteners should still be loose.



26. Next the window panel alignment is to be set. The fixed window panel is riveted in the corner but needs to be made square to the opening window panel, the best way to do this is by closing the window and locking it shut and standing the window up as shown in the image below and pressing down on the fixed window panel. The desired result is to have the two edges circled in blue in the right image below parallel to one another and an even gap along the edges circled in red. Once the fixed window panel is in the correct position fasten the nuts on the upper side of the hinge (that support the fixed window panel).



Lift-up window instructions
200 Series Land Cruiser

27. Now that the opening window and fixed window panels are square the opening window panel is to be adjusted to make the gap along the window top edge and leading edge even. The two edges that should be made even are circled below, this is done by moving the opening window panel in the provided slots and then fastening it in place.



28. Next flip the window onto its back and move and then fasten the gas strut mounts so that the gas strut is acting perpendicular to the hinges. The best way to do this is to open the window to release the pressure and first fix the upper gas strut mount in place and then adjust the lower gas strut mount to suit.

29. Your window is now almost complete and ready to install on your vehicle, take the vinyl sticker shown on the left image below and apply it over the hinge hole and bent-out tab on the left hand side when viewed from the back as shown in the left image below.



30. 'Dry fit' the window on the vehicle and check appearance, use the adjustment in the hinges if required. Then use an assistant to hold the window to the vehicle in the correct position and mark the pre punched holes on the vehicle body then drill out the holes in the vehicle body to suit the fastener you are using (these fasteners have not been supplied).

Lift-up window instructions
200 Series Land Cruiser

31. Finally using Sikaflex seal all of the remaining holes in the window fixing panel that could allow water through the window.
32. Next apply generous amounts of Sikaflex to the window surround on the car body. We recommend applying more than required initially then cleaning up the excess after the window is clamped to avoid any leaking.



33. On the rear of the window apply Sickness to the edges marked below, in the install of the window the seal from this edge must be checked to avoid leaks as it is close to the edge of the vehicle body lip.

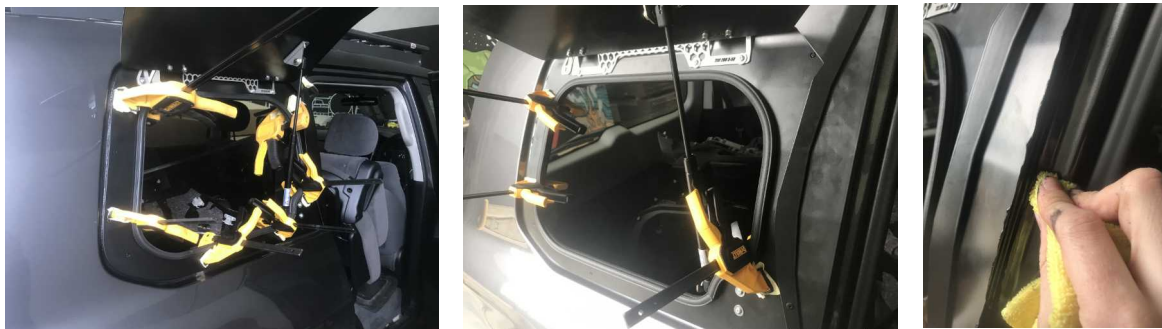


Lift-up window instructions
200 Series Land Cruiser

34. Next install the window onto the vehicle, align evenly on the vehicle body, fasten the lift up window to the vehicle body using pre drilled holes and the fasteners of your choice.



35. Apply clamps and clean up excess adhesive, adjust clamps and apply more adhesive if required, verify that all possible points of water leakage are sufficiently sealed. Pipe additional adhesive under the leading edge of lift up window and clean up with a rag and solvent as shown on the right image below.



36. Leave adhesive to set for 24 hours before moving the vehicle, and confirm sufficient adhesive was used to seal the window, pipe in more adhesive if required.
37. Reinstall the vehicle trim as per steps 2-9
38. Sit back and enjoy a well installed Cruiser Company Lift up window! Please let us know if you have any any questions or feedback!

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