



Installation and handling

The following instructions must be followed for the warranty to remain valid.

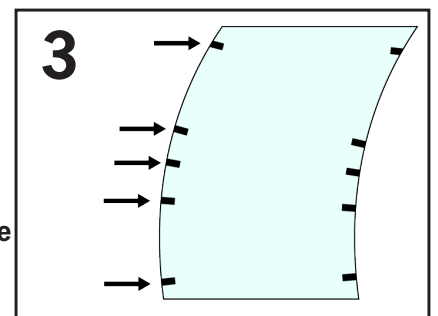
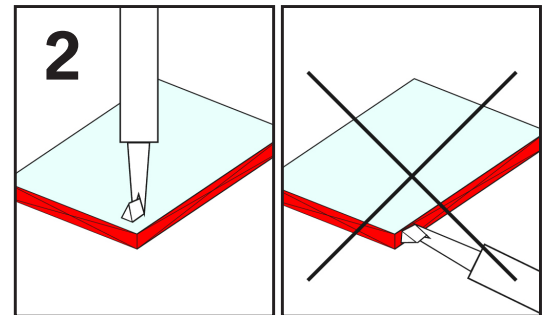
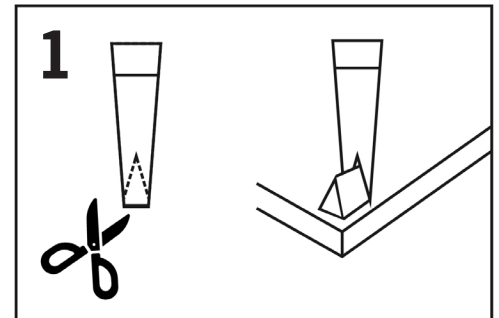
Read the instructions carefully before starting the installation.

Before installation:

- The surrounding temperature and the temperature of the materials must not be below +15°C.
- Thoroughly clean the surfaces where the adhesive will be applied.

During installation:

- KM Wins replacement windows must only be installed using our recommended adhesive, **Sikaflex 221**. This adhesive is chemically compatible with the anti-scratch coating and the polycarbonate.
- Apply the adhesive as a triangular bead by cutting a "V" in the nozzle (see **Figure 1**). The bead must be at least 4.5 mm thick.
- The adhesive should only be applied to the back of the window to allow some flexibility. **Never apply adhesive to the outer edges of the window during installation**, as this will make the window stiff and may cause stress and cracking (see **Figure 2**).
- **Handle the window as if it were made of glass:** The window must never rest directly on metal parts, such as the frame or bolts. Use 4 mm rubber spacers when installing flat windows that need to be bent during installation (see **Figure 3**). Apply the adhesive in a continuous bead, including the placed rubber spacers, to prevent leakage.
- Tighten bolts to a maximum of 15 Nm. Over-tightening can cause cracking around the bolt holes. **Note: Gradually tighten all bolts in several stages to evenly distribute stress, up to the maximum of 15 Nm.**
- Ensure there is sufficient gap between the bolt and the bolt hole in the window. If it is too tight, the hole may need to be slightly widened.
- **The adhesive must set before the machine can be used.** Follow the instructions on the tube.



Examples of cracking that may void the warranty:

- Cracking from the outer edge of the window, caused by too tight a fit between the window and the frame, or adhesive applied to the outer edges of the window.
- Cracking around the bolt holes, caused by over-tightened bolts or bolts positioned too close within the bolt hole.