

## WINDSCREEN PANEL ASSEMBLY PROCEDURES

1. Before beginning the windscreen panel assembly make sure that:
  - a) the work station is set-up properly around the “windscreen panel assembly table”;
  - b) all material and hardware required is located and within easy reach of the work table;
  - c) all required tools are on work table, tools required are:
    - battery operated drill with a flat screwdriver bit
    - battery operated drill with a 7/16” socket on a universal drive
    - air drill with a 9/64” drill bit
    - 2 - 7/16” combination wrenches
    - 2 - 5/16” combination wrenches
    - 2 - flat blade screwdrivers
    - hack saw
    - rubber mallet
  - d) you have drawings and bill of materials for each different panel assembly you will be doing.
2. Slide the aluminum tube into the windscreen panels as per sizes on B.O.M. making sure that the panels all face the same way. You may need to use a rubber mallet to tap the tubes into place, making sure not to bend the tubes or crimp the ends.
3. On three (3) panel assemblies make sure that the shorter panel is positioned on the correct end of the assembly, this is what makes them “left” or “right”. See drawing for correct orientation.
4. Make sure that the aluminum tube does not stick out the ends of the panels when the tube is in place. If tube protrudes from end of panel, use a hack saw to cut it flush with end of panel.
5. Screw the panels together as per drawing and B.O.M. facing all screws in the same direction. Note correct screw positions on drawings. “Rear” panels require screws on both sides of the panels whereas the front panels only require screws on the inside. Place required length screws into each position.

**Note:** On a three panel front assembly remember **Do Not** place a screw in the top position holding the shorter panel in place.

6. Snugly tighten all nuts and locknuts on panels. Do not over tighten as you may “cave in” or break the panels.

7. Check the overall length of the assembly and compare it to the overall length as specified on the assembly's blueprint drawing. If it is out of specs, then contact your supervisor.
8. Place panels on the pegs which are welded to the front of the assembly table, so that the top edge of the panel is flush or slightly higher than the top of the table.

**Note:** The one peg is adjustable for the different lengths of panels. Adjust so that the pegs are on either ends of the panel assembly.

9. Position the drill jig to the correct setting on the table according to the marking on the table and the size of panel being done. Make sure that the drill guide is seated on the top edge of the panel, and using a 9/64" bit drill a hole through the panel and aluminum tube. Move the drill jig to each required setting for that particular size of panel assembly to drill one hole into each panel of that assembly.
10. Insert the required screws from the top of the panel into each hole which was drilled. Start and snugly tighten each locknut on the end of each bolt. Do not over tighten as you may "cave in" or break the panel.
11. Place into shipping crates as required.