

## WINDOWS

**Purpose**

This document outlines the procedures for securing an acrylic trim piece on the cockpit windows of motorized RVs if the trim works loose from the window (Fig. 1).

Fig. 1

**Safety**

Read and understand all instructions before installing or operating this product. Adhere to all safety labels. This manual provides general instructions. Many variables can change the circumstances of the instructions, i.e., the degree of difficulty, operation and ability of the individual performing the instructions. This manual cannot begin to plot out instructions for every possibility, but provides the general instructions, as necessary, for effectively interfacing with the device, product or system. Failure to correctly follow the provided instructions may result in death, serious personal injury, severe product and/or property damage, including voiding of the Lippert limited warranty.

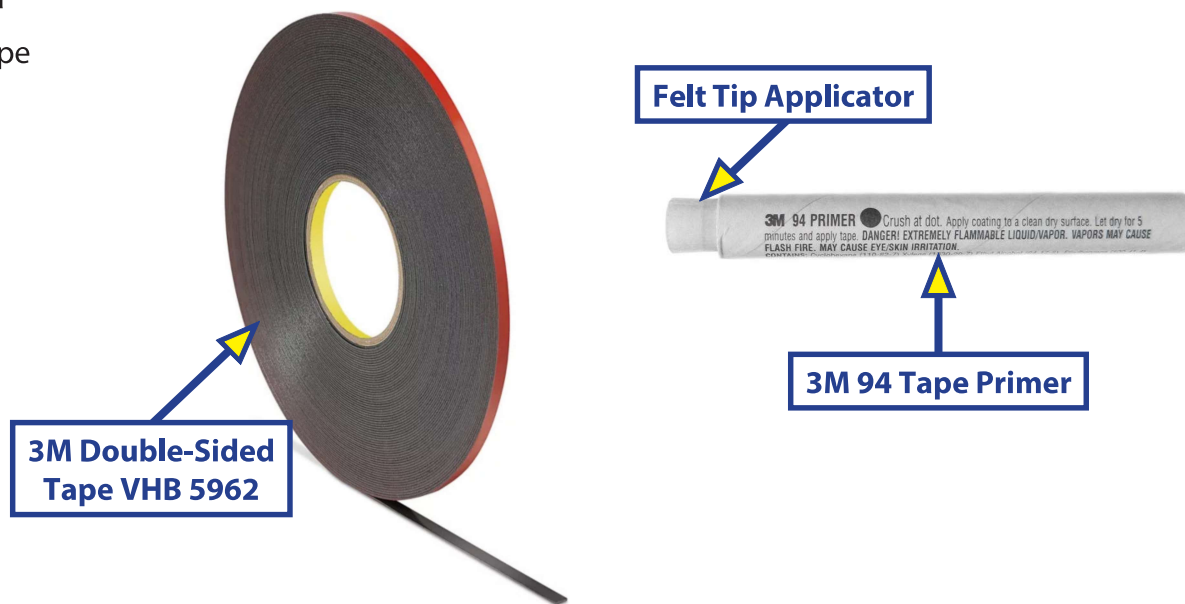
**⚠ CAUTION**

**Moving parts can pinch, crush or cut. Keep clear and use caution.**

## WINDOWS

### Resources Required

- 3M Double-Sided Tape VHB 5962, 1/4" x 36'
- 3M 94 Tape Primer
- Scissors
- Adhesive cleaner
- Rags
- Rubber gloves



### Procedures

#### If Tape Is Still Usable

If the double-sided tape on the window is still tacky and can be reused, follow these procedures.

1. With adhesive cleaner, clean residue on surface of the material which is not secure.
  - A. If the acrylic section is loose, clean the acrylic piece.
  - B. If the tape pulled away from the window frame, clean the frame.
2. Apply 3M Tape Primer 94 to the cleaned surface.

**NOTE:** Wear rubber gloves during the application, if needed, and apply in ventilated area.

3. Wait 5 minutes for the primer to dry.
4. Re-establish seal by firmly pressing the parts together.

**NOTE:** Firm application pressure develops better adhesive contact and helps improve bond strength. Typically, good surface contact can be attained by applying enough pressure to ensure the tape experiences approximately 15 psi (100 kPa) pressure.

**NOTE:** At room temperature, approximately 50 percent of ultimate bond strength will be achieved after 20 minutes, 90 percent after 24 hours and 100 percent after 72 hours. This is faster at higher temperatures and slower at lower temperatures. The use of tape primer as indicated in the instruction can also have the effect of increasing bond strength and achieving ultimate bond strength more quickly.

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If Tape Needs to Be Replaced

If the double-sided tape cannot be reused, follow these procedures.

1. Remove old tape.
2. With adhesive cleaner, clean residue on surfaces of both the acrylic material and window frame.
3. Apply 3M Tape Primer 94 to both of the cleaned surfaces.

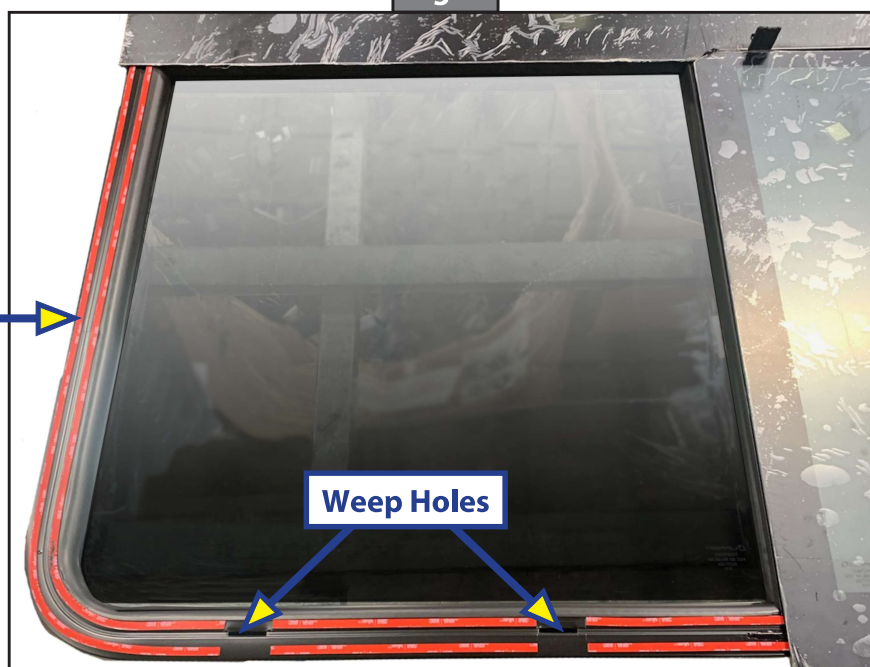
**NOTE:** Wear rubber gloves during the application, if needed, and apply in ventilated area.

4. Wait 5 minutes for the primer to dry.
5. Install two parallel lines of 3M VHB Tape 5962 around the perimeter of the window frame where the acrylic piece will be located (Fig. 2).
  - A. The two-sided tape should be applied as a mostly continuous piece, with spaces left for the weep holes. Pinch to extend the tape around the corner.
  - B. Cut both pieces of tape so they do not cover the weep holes. Blocking the weep holes will not allow moisture to drain from the window.
6. Remove paper backing from double-sided tape and firmly press parts together.

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Fig. 2



As a supplier of components to the RV industry, safety, education and customer satisfaction are our primary concerns. Should you have any questions, please do not hesitate to contact us at 432-LIPPERT (432-547-7378) or by email at [customerservice@lci1.com](mailto:customerservice@lci1.com). Self-help tips, technical documents, product videos and a training class schedule are available at [lippert.com](http://lippert.com) or by downloading the LippertNOW app.