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FLEXIGLASS FITTING MANUAL - SECTION 3.12A

FLEXIGLASS OEM TRAY SSANYONG ACTYON DC FIT - ISSA2

Note: Familiarise yourself with the instructions before you start to ensure you are clear on all aspects of the fit

SAFETY EQUIPMENT

- Hearing protection as required
- Eye protection as required

TOOLS REQUIRED

- Pneumatic / electric drill
- Pneumatic / electric hacksaw
- Drill bits: 21/64", 1/4" & 3/16"
- Sockets: 10, 13 & 18
- Toledo cable strippers
- Pneumatic driver
- Rivet gun with 5mm tip
- Loctite 243
- 2 of Adjustable wrenches.
- Wurth Cable strippers

TRYSSANG03 OEM Tray Ssanyong DC FIT PARTS LIST

Type	No.	Description	Quantity per	Unit of Measure Code
Item	BLTHHZP1250	Bolt & Nut Hex ZP 12x50mm	4	EACH
Item	NUT12C	Nut Channel M12	4	EACH
Item	NUT6N	Nut Nyloc M6	28	EACH
Item	PLT390C	Fish Plate forTrayBearers Coat	4	EACH
Item	RIVET200	Rivet 6-6 Steel	1	EACH
Item	SCRHHSS825	Screw Set Hex Head S/S 8x25mm	8	EACH
Item	SPACER40	Mounting Cross Bar Spacer	8	EACH
Item	SPACER50	Mounting Block Spacer 10MM	4	EACH
Item	TIE100	Tie Cable BLK 4.8x300mm	6	EACH
Item	WSH220	Washer 5/16 X 3/4 Flat	8	EACH
Item	WSH240	Washer 1/2X 1 1/8 ZP Flat	4	EACH
Item	WSH300	Washer Spring Z/P 12x2.5x2.5mm	4	EACH
Item	BAR320	Bar Tray Mount Sliding Draw	2	EACH
Item	BKT420	Bracket Fuel Filler	1	EACH
Item	KIT920	Kit Tail Light Set	1	EACH
Item	CAP220	Cap Tie Rope	2	EACH
Item	NUT8N	Nut Nylon Insert Lock 8MM ZP	8	EACH
Item	SCRHHSS620	Screw Set Hex Head S/S 6x20mm	27	EACH
Item	SCRHHSS625	Screw Set Hex Head S/S 6x25mm	1	EACH
Item	WSH180	Washer Brt Z/P 1/4x5/8x18G	10	EACH
Item	FUELSTAY10	Hilux Fuel Neck Stay	1	EACH
Item	MFLP320	Mudflap SSangyong 280x355 BT	2	EACH
Item	TRSTDFITKIT	Tray STD Fitting Kit	1	EACH

When removing the well body from the vehicle cut the wiring to the rear lights between the multi connector and the lights.

When the replacement lights are connected to these short lengths the lights will then be easily connected/disconnected using the multi connectors on the vehicle wiring harness.

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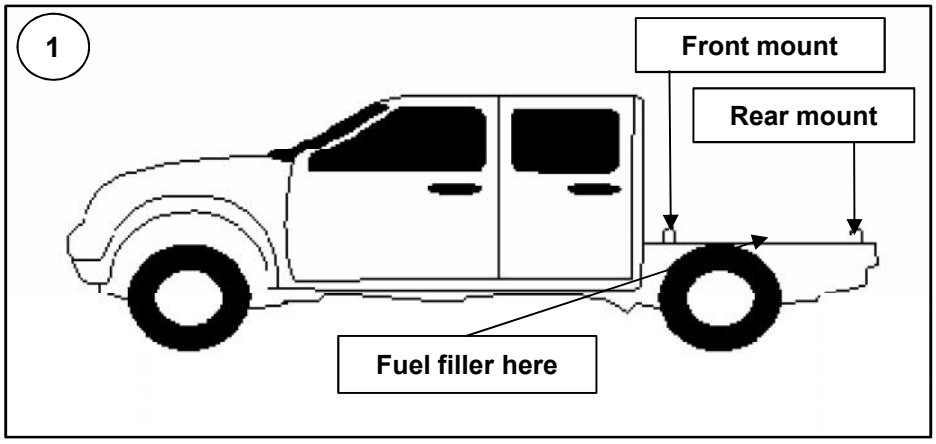
FIT INSTRUCTIONS

1 Refer to **ILL 1** showing dual cab Actyon mounting positions. Locate these positions on the vehicle.
Note: All mount points on the vehicle must be used when fitting a Flexiglass Tray.

2 Refer to mount diagrams on **Page 3** which illustrates standard part useage for mounts on SSANYONG ACTYON and Flexiglass Tray.

3 Fit the mounts in place on the chassis, using the parts and applying lock tight to thread as shown in the two diagrams on **Page 3.**
Note: The fuel filler neck must lay rearward under the front cross bar.



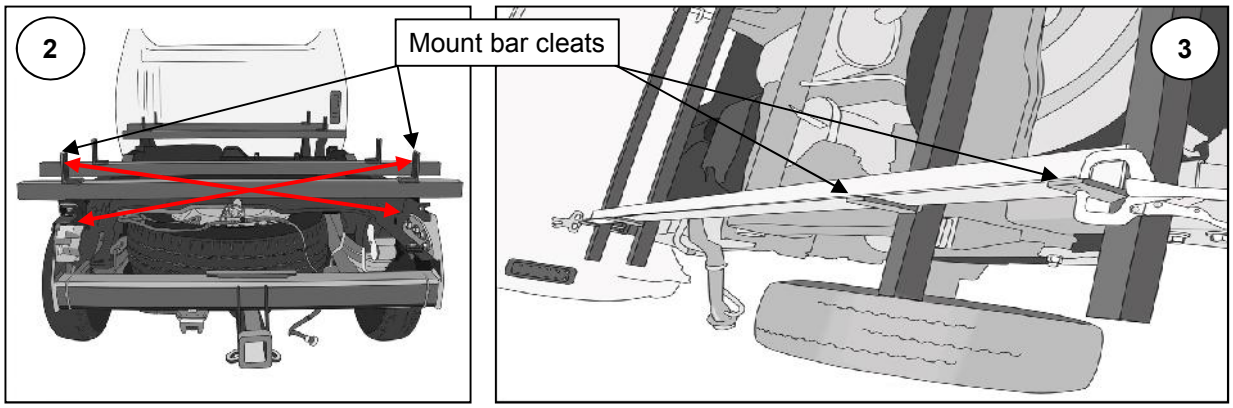
4 With all parts in place and the bolts still loose check the front and rear mounts are central over the chassis by measuring from the inside of one mount cleat to the inside of the opposite chassis rail. Repeat this for the other mount cleat and rail sliding the mounting cross bar "to and fro" until the measurements are equal. See **ILL 2**.

5 Tighten the four bolts securing the mount bars to the chassis mounts front and rear.

6 Before moving the tray to the vehicle, drill two 1/4" holes through the front plank web, 145mm from the edge of the headboard angles. See **ILL 13 on page 8.**

7 Place the Flexiglass Tray in place on the mounts.

Note: There must not be more than 700mm overhang of the tray bearers from the rear **mounting position**.



8 Slide the tray into position with the front end of the main bearers about 30 to 40mm clear of the cab rear.

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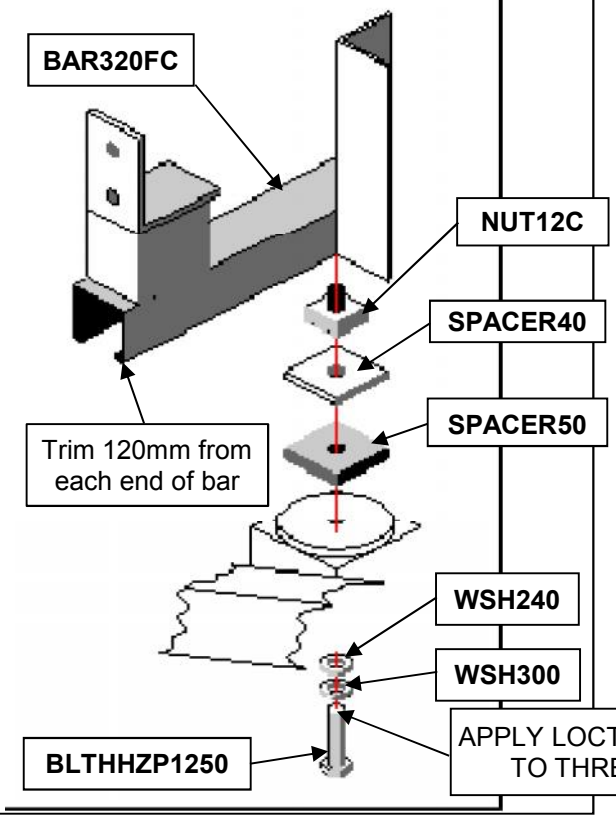
4 FRONT MOUNT STACK



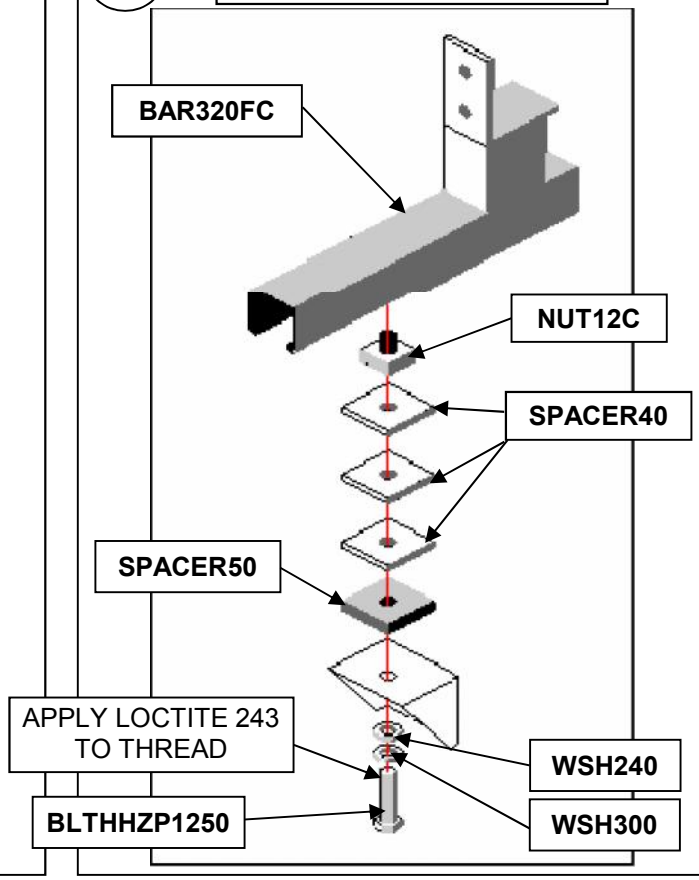
5 MIDDLE MOUNT STACK

NO MOUNT ON THIS MODEL

6 MID REAR MOUNT STACK

NO MOUNT ON THIS MODEL

7 REAR MOUNT STACK



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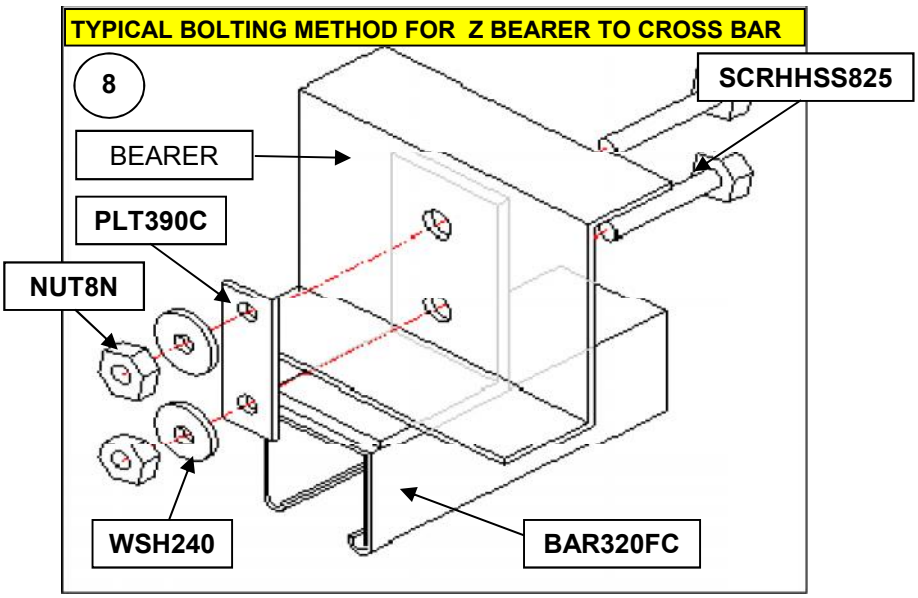


9 Once tray is lined up drill 21/64" Holes into the bearers using the mounting cross bar as a guide. See **ILL 8**.

10 Secure tray to the bearers as shown in the diagrams above.

11 Take the bent bar with three holes from the **FUELSTAY10** kit and increase the bend angle until it measures about 90°.

12 Take the **BKT420** filler bracket and bend it as shown in **ILL 9**.

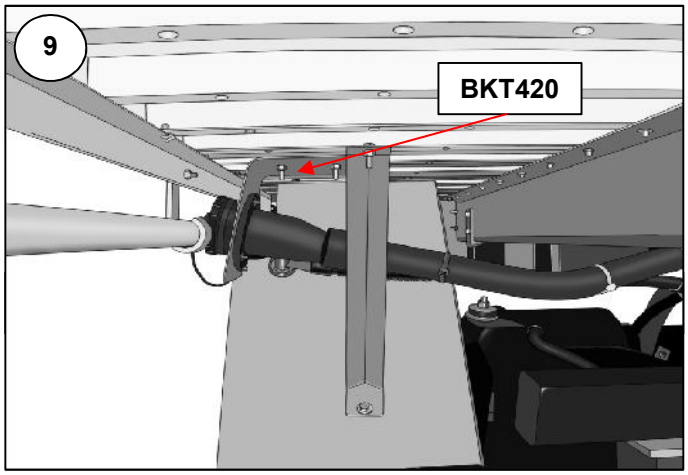
13 Measure and mark the passenger side rope rail about 150 & 350mm back from the front dropside hinge. See **ILL 10**.

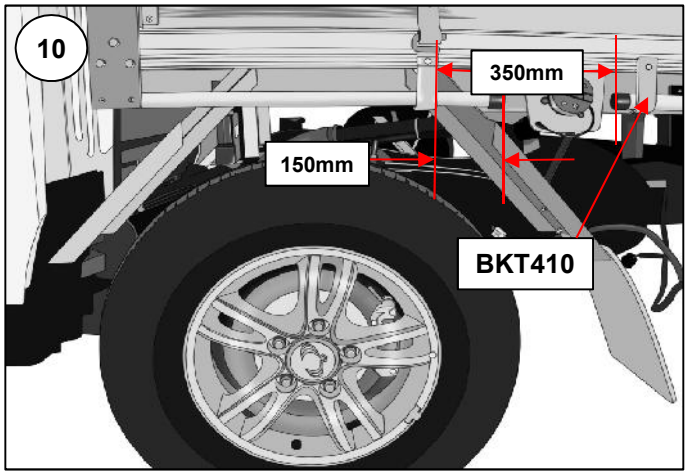
14 Cut the rope rail on the marks and remove the 200mm section between them.

15 Slide the **BKT410** over the rear section of the rope rail. Drill, screw and rivet in position as shown then fit **CAP220** to the rail ends.

16 Remove the fuel cap from the filler neck and enter it into the **BKT420**. Position the bracket and filler, under the tray. See **ILL 9 & 10.**

17 Drill and attach the **BKT420** to the underside of the deck with two **SCRHHSS620, WSH180 & NUT6N.**





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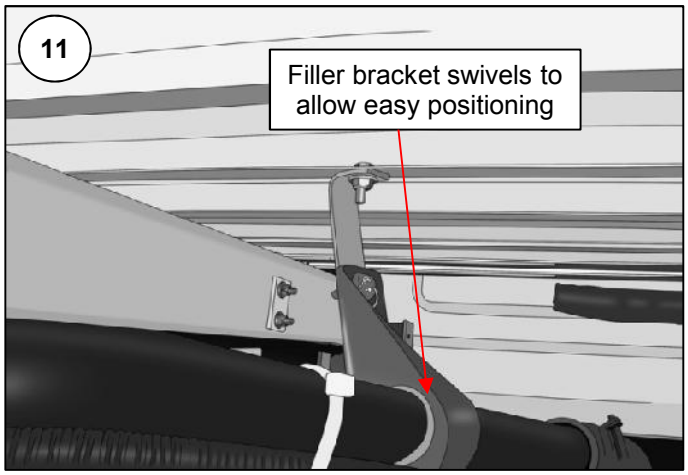
18 Working from underneath the vehicle, attach the modified **FUELSTAY10** bracket to the fuel filler bracket with two **SCRHHSS620**, **WSH180** & **NUT6N**. See **ILL 11**.

19 Lift the assembly up and drill and screw it to a convenient plank flange with **SCRHHSS620**, **WSH180** & **NUT6N**. See **ILL 11**.

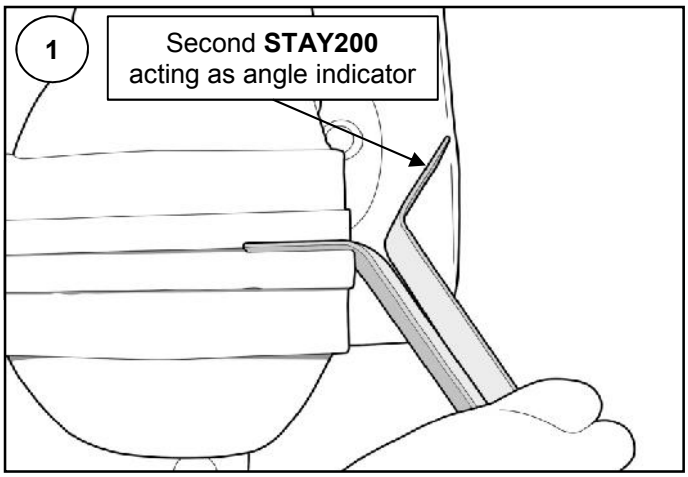
20 Attach the filler pipe to the **BKT420** and tighten all screws fully.



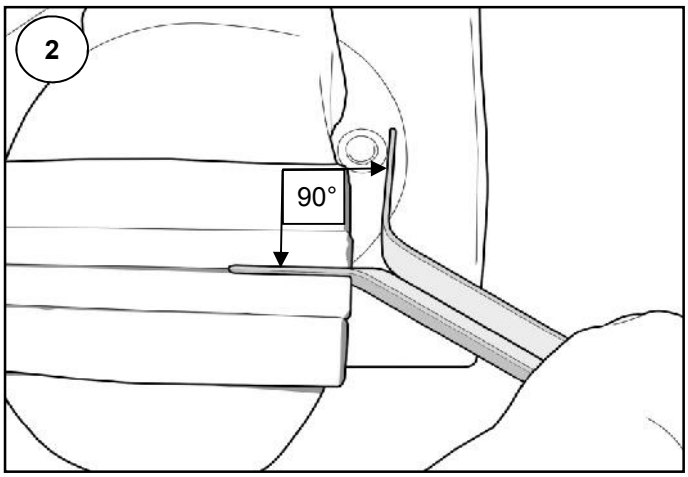
STAY MODIFICATION

About 1/3 of tray fits will require a shorter mudguard stay than the **STAY200,** supplied, to accommodate fuel fillers etc. In those cases two of the **STAY200**'s will require modifying in the following manner.

1 Clamp the bottom end (large diameter hole) of the **STAY200** in a vice. See **ILL 1**.



2 Use a second stay as a guide to staighten the bottom end, use the guide stay to achieve about 90° between the two ends. See **ILL 2**.



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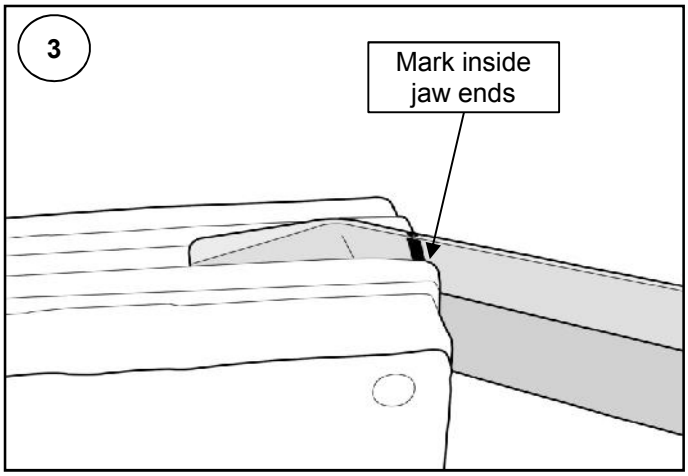
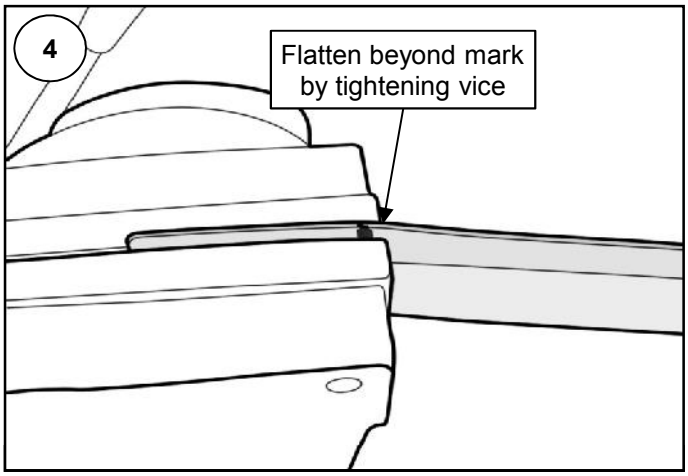
3 Measure from the inside of the bottom bend. About 255 - 260mm towards the top and make a mark.

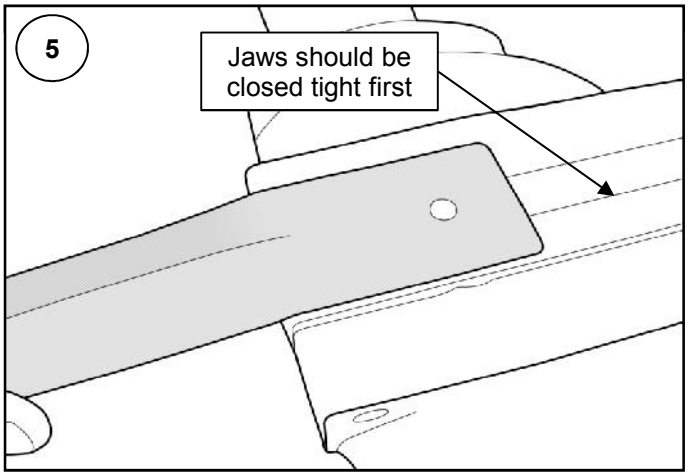
4 Clamp the top end into the vice with the mark inside the end of the jaw.
See **ILL 3**.



5 Press end flat by tightening vice jaws.
See **ILL 4**.

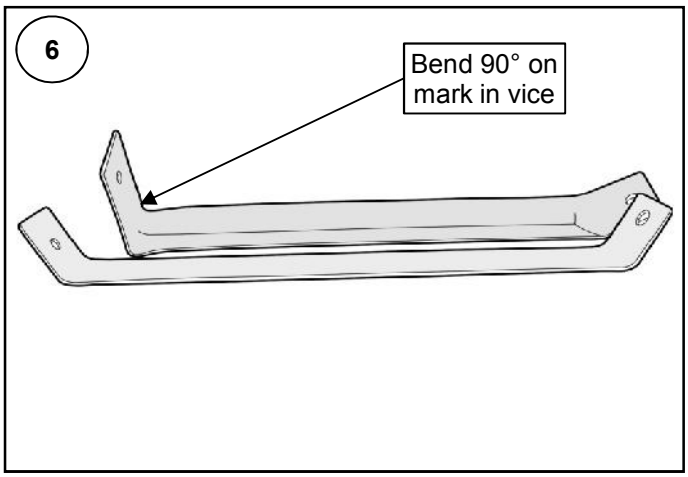


6 Lightly hammer the last bit of distortion out on the tightened jaws of the vice.
See **ILL 5**.



Omit stage 7 for this vehicle and proceed to stage 8.

7 Clamp in the vice and bend the flattened end 90° at the mark to make the shape shown in **ILL 6**.



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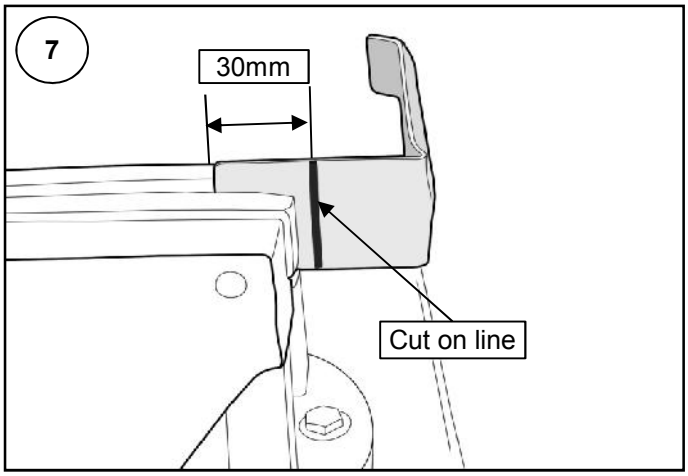
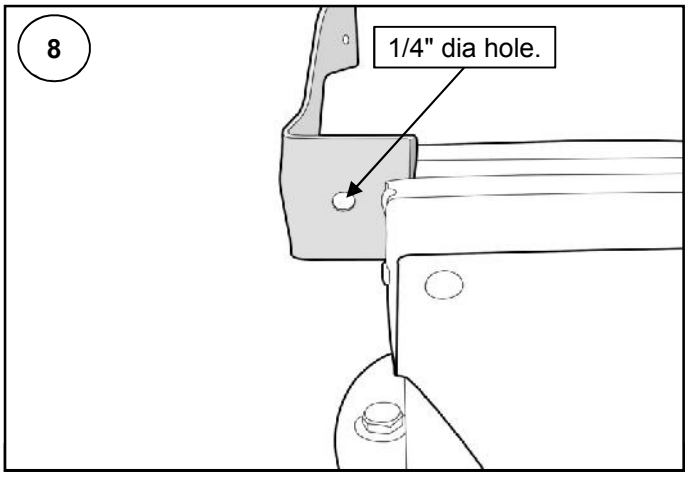
8 Shorten the newly bent end by about 30mm. See **ILL 7**.



9 Drill a 1/4" hole in the middle of the new end. See **ILL 8**.

10 Remove sharp edges and corners with a file.



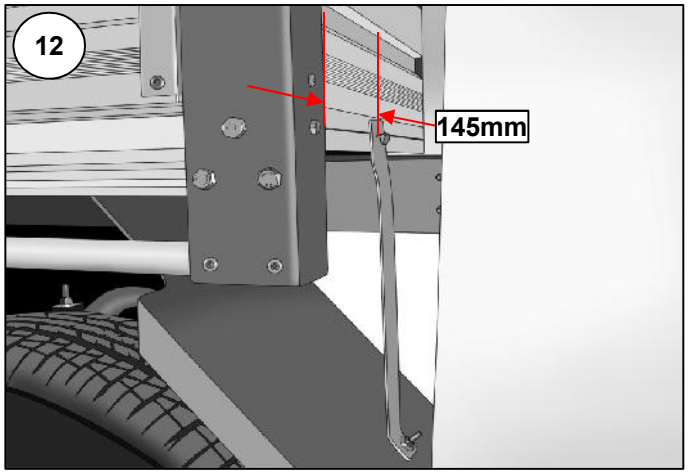
FIT INSTRUCTIONS (cont…)

21 The stays are mounted to the mudguards using the pre-drilled holes and one each **SCRHHSS620, WSH180 & NUT6N.**

22 Attach the modified **STAY200** to both mudguard panels then fit them to the tray as in **ILL 12**.

23 Mount the mudguards to the underside of the tray deck by lining up the pre-punched holes in the mudguard with one of the ribs running along the underside of the tray. Drill 1/4" holes and attach with 2 of **SCRHHSS620** & **NUT6N**.

24 Attach the rear mudguards and stays in the usual manner.



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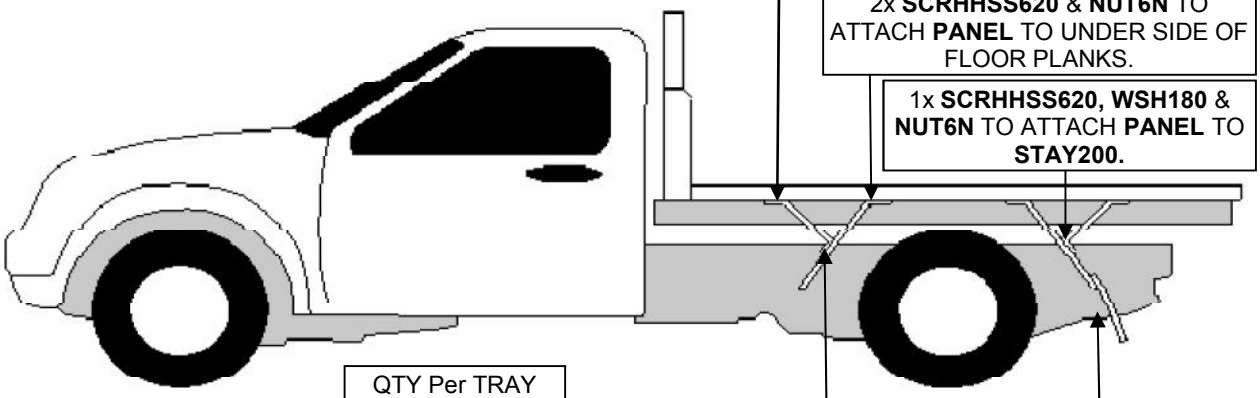
MOUNTING OF TWO PART MUDGUARDS

13

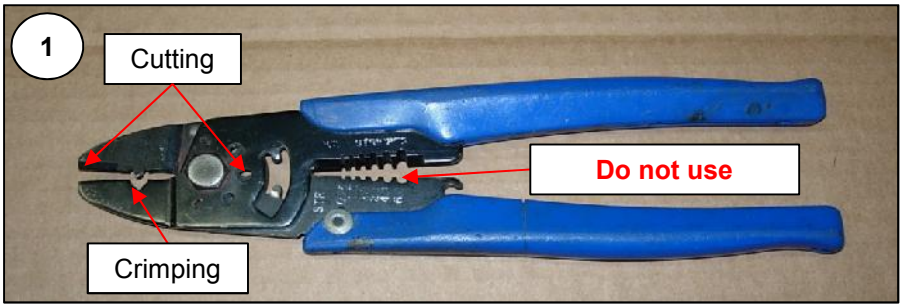


	QTY Per TRAY	
SCRHHSS620	- M6 x 20mm SS HEX BOLT	20
NUT6N	- M6 NYLOC NUT	20
WSH180	- 6mm PLAIN WASHER	4
PAN440	- L/H 275mm MUDGUARD PANEL	2
PAN450	- R/H 275mm MUDGUARD PANEL	2
STAY200	- REAR MUDGUARD STAY	4
MFLP320	- MUDFLAP SSANYONG	2
STRAP200	- MUDFLAP STRAP	2

Note: Make sure the spacing between the mudguard and wheel is sufficient for both aesthetic and functional purposes. See **ILL 13**.

ELECTRICAL WIRE STRIPPING SAFETY PROCEDURE

It is Flexiglass policy that the use of combination electrical cutting/crimping and stripping pliers be restricted to cutting and crimping use only.



It is a documented fact that the use of these pliers can cause personal injury due to the fact that they are reliant upon holding the cable in one hand while pulling with the pliers with the opposite hand. Any attachments to the gripped end can be pulled into and through the palm of the gripping hand causing injury.

The single hand action strippers are to be used at all times for stripping cable ends ready for joining or connecting.

Two types of cable strippers are recommended, one operates with the pliers at 90° to the cable **(2)** the other operates in-line with the cable **(3)**.

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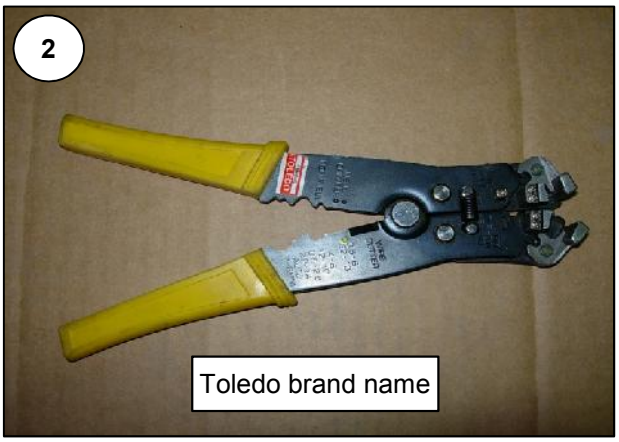
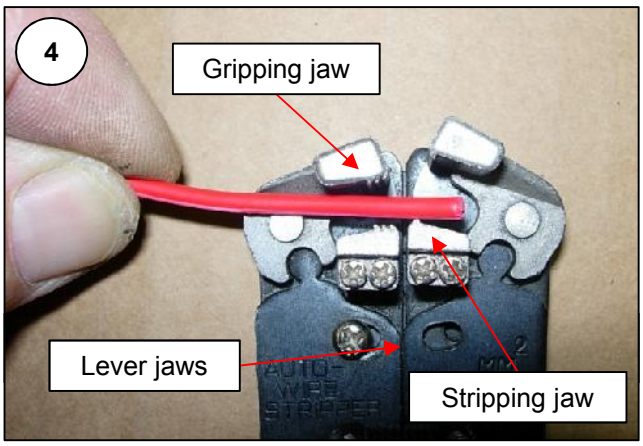


The tool in **ILL 2** is a generaly stronger and harder wearing item but the other is very useful for getting to cables in restricted space, it is therefore recommended that both types be available.

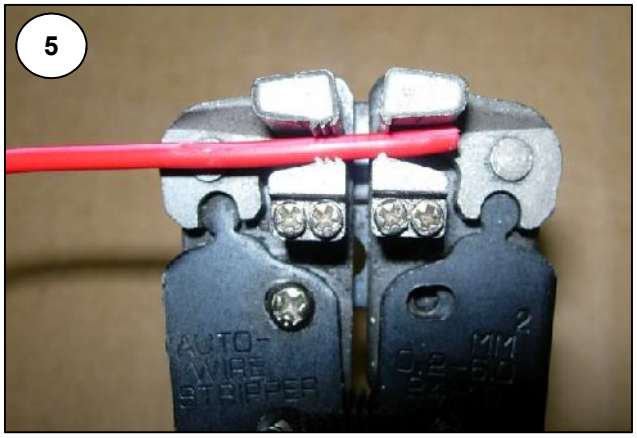
OPERATING INSTRUCTIONS

1 Squeeze handles sufficiently to bring the lever jaws together. Lay cable between stripping jaws as shown in **ILL 4.**

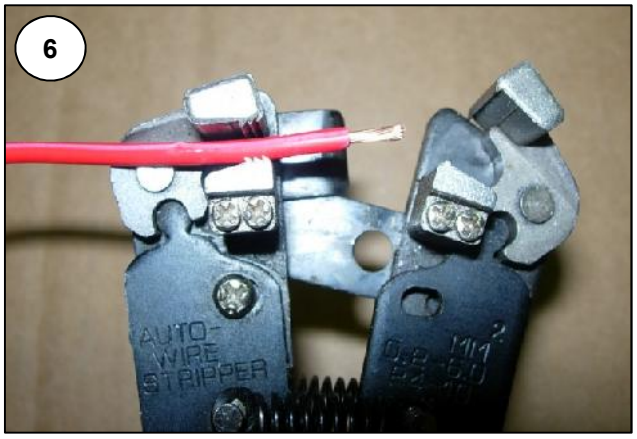
Note:
There should be no necessity to strip more than 10mm of sheathing from the cable end for any of the connectors used by Flexiglass. If for any reason a longer stripped end is required, do it in repeated 10mm bites, the pieces can then be slid off the end using the fingers.



2 Continue squeezing the handles together to engage the gripping and stripping jaws.



3 Increase the pressure slightly as you continue to squeeze. The stripping jaws will then move indipendantly of the pliers cutting and stripping the end of the wire until with a sharp click both sets of jaws will automaticaly disengage.



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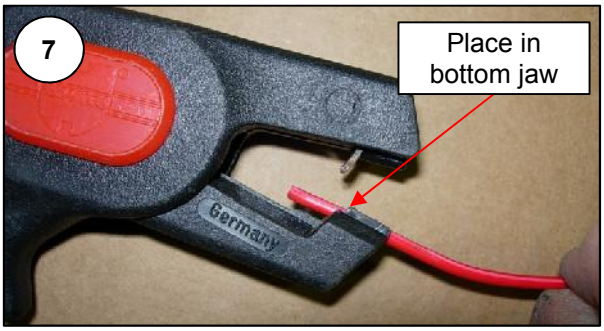
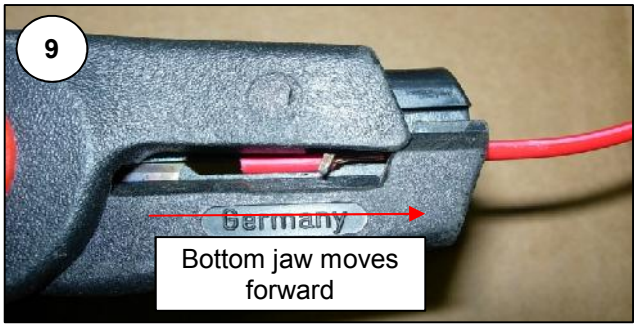
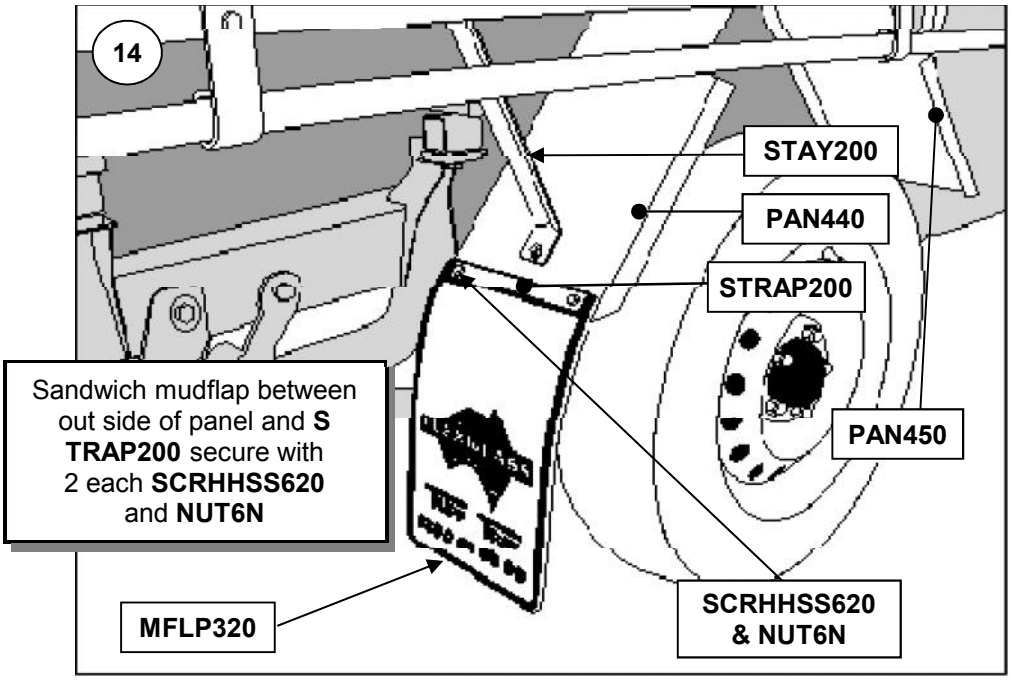


4 The Wurth pliers are simpler in operation.
After placing the cable in the "V" of the bottom jaw, **ILL 7,** squeeze the handles together.
The squeezing action brings the jaws together and forces the bottom jaw forward both cutting and pulling the sheath from the cable.
See **ILL 8** & **9**.



FIT INSTRUCTIONS (cont…)

25 Attach both **MFLP320** mud flaps to the mudguards using 4 of **SCRHHSS620** & **NUT6N** as well as 2 of **STRAP200**. See **ILL 14**.
Note: ILL 14 only shows one side and requires only 2 screws, washers, nuts and 1 strap.



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25 Refer to instruction **3-1B Licence plate fit.** To fit the **LIGHT280** & **GLOBE281** to **BKT660.**

26 Attach **BKT660** Number plate bracket in the centre at the rear end of the tray as shown in the image to the right. Use 2 of M6x20 SS screws and M6 Nylock nuts to fit to the underside of tray. See **ILL 15**.

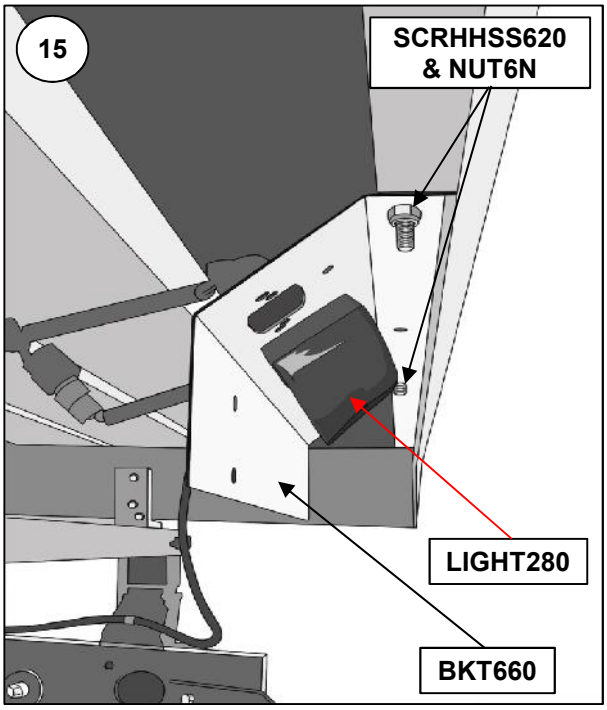
27 Fit a **LIGHT460 & REFL10** to each of the **BKT670 R&L**. Ensure that the indicator light goes to the opposite end of the bracket to the reflector.

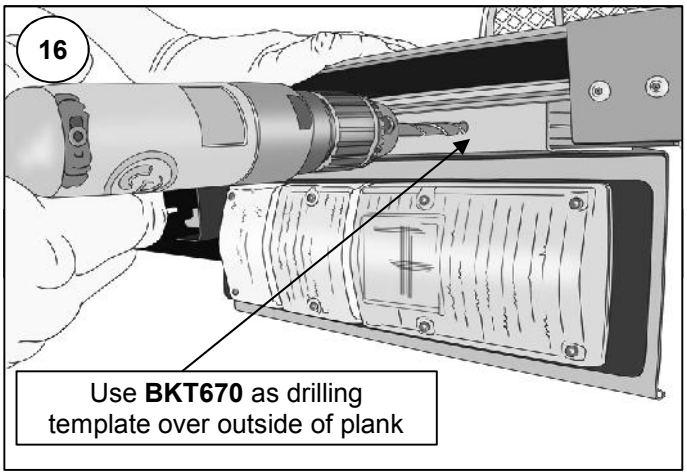
28 Use the bracket as a template over the **outside** of the rear plank, locating the drill point in the groove on the centre line of the bottom channel and drilling two 1/4" holes for each tail light unit. See **ILL 16.**

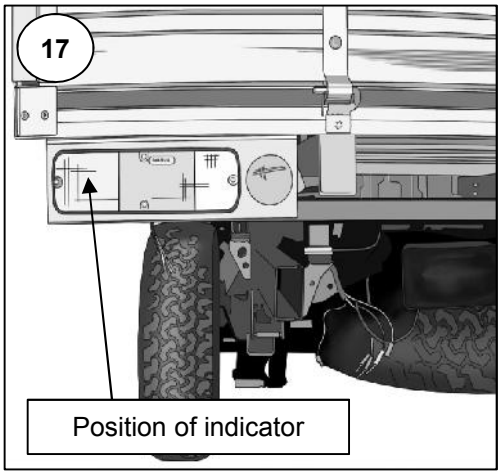
29 Attach the tail lamp clusters to the tray rear as shown in **ILL 17** & **18**.

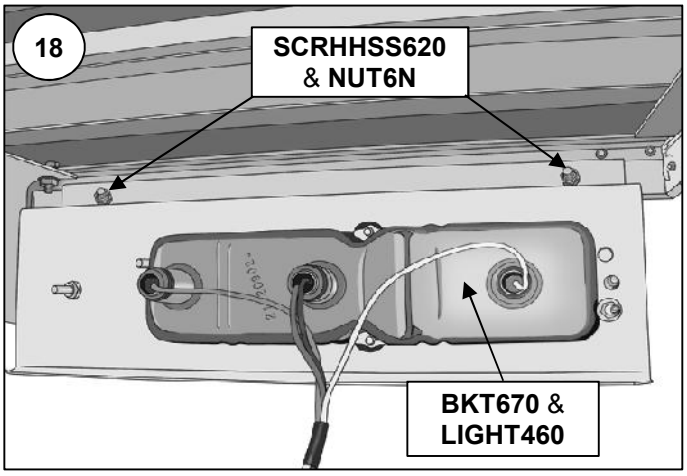
30 Connect the replacement rear lights to the wiring on the vehicle multi-connectors cut off when removing the well body, using the **CON110** supplied.

31 Pass wiring harness over the top of crossbars etc and re-connect using the original multi-connectors, check for correct operation then attach to the tray underside with **TIE100** provided to prevent movement.









32 If alterations to the wiring need to be made it is recommended that you consult an auto electrician first.

33 Detail and clean the tray for delivery to the client.