

IMPORTANT Read all installation instructions before beginning installations.

Section 1

The Simson ISR 70-09 adhesive supplied with Marinelite windows has been tested by the manufacturer and by Marinelite Windows Limited and has been proven to securely bond to Aluminum, Stainless Steel, Galvanized steel, Zinc, Copper, Brass, Glass, GRP (fiberglass), Paint and Gelcoat.

Please be aware that any bare metal surface like Aluminum, Steel, Brass and Stainless Steel etc. must be sanded clean and the adhesive must be applied before metal oxidization begins. Oxidization can begin in just a few hours in some conditions so installation should be done soon after preparation.

Also, be aware that any protective or cosmetic coating applied to the surface of the structure (example: Paint, Epoxy, Gelcoat etc.) needs to be prepared and applied as per the manufacturer's instructions and fully cured before window installation is attempted.

If there are any doubts that the surface coating has been properly prepared and applied in the specified temperature and conditions, or is fully cured, it is advised that you take the appropriate steps to ensure secure bonding. For example, if the wheelhouse consists of GRP (fiberglass) and coated with paint or gelcoat, the coating can be sanded down until the bare fiberglass is exposed. Once the fiberglass is exposed, the surface needs to be cleaned with wax and grease remover or 99% Isopropyl Alcohol to remove dust and contaminants before the window is installed.

Marinelite Windows Limited is not responsible for any leaking or adhesive separation or any damages resulting from adhesive separation due to improper surface preparation or improper window installation.

Section 2



Begin installation by dry fitting all the windows. You may have to grind away a little of the bulkhead to get the window to fit into the opening. You may also need small wood shims to help center the window in the opening. Wash these shims ready before you begin installing. Wash the bulkhead with wax and grease remover available at any automotive paint supplier. (See Section 1) Automobile painters use this to wash a car body before painting. Wash with wet paper towel and wipe dry before it air dries. This is a good practice when installing any marine window, even if it's not a Marinelite Window. Clean window flange with 99% Isopropyl Alcohol before applying sealant. (Must be 99% as less than 99% Isopropyl like rubbing alcohol contains lotion and will leave a residue).



Apply a V shape bead 3/8" tall with the special V-tip supplied with the 70-09 adhesive. Holding the gun directly upright and the tip in contact with the window, make your bead as close to the outside edge of the window as possible. Slide your tip along the outside lip of the window frame. This will give you a straight and properly placed bead. A battery operated caulk gun like the Ryobi 18v Model P310 works perfectly. If you do not have a battery operated gun you will need a good quality industrial caulk gun as the adhesive has a high green strength and therefore is very thick and hard to pump.



Once the window is centered, press firmly on the window until all sides are flat against the bulkhead.
You are now ready to install the inside trim.



Place the window in the hole and have someone on the inside ready with small wood shims you have prepared earlier. The person on the inside will need to position the window in the center of the cutout and place shims at the bottom and possibly on the sides to hold the window at the most centered location.



To install the inside molding, start by setting and fastening one corner at a time.

IMPORTANT:

If for any reason that you need longer screws to attach the moulding, be certain that the screws do not reach through the frame of the fixed window as the screw tip will contact the glass. On the sliding windows the screws should thread into the frame no deeper than about 1/2".

Slider installation is the same as the fixed windows except you will only need a 1/4" tall bead of sealant instead of a 3/8" bead. It is important to take care when installing sliding windows so that the meeting posts align properly when closing the window. The sliding windows should not be twisted or curved during the installation. When setting the window into the opening, apply pressure by hand to set the window.

Keep an eye on the alignment of all the frame sections to be sure the window is not curved or twisted. Immediately after the sliding window is pressed into place, open and close the window several times to confirm proper operation. If the window opens and closes properly and the latch engages and disengages properly you can now install the inside molding.

Only tighten the molding screws until the molding reaches its home position. Over tightening the screws will further set the window and can change the alignment and cause improper operation.

Note: It is normal for the sliding glass to be tight and difficult to slide due to the pressure of the seals on either side of the glass. In time the seals will relax and let the glass slide more easily and will also slide more easily when water wets the window. This tight fit will help the window stay put in any open position while traveling in rough conditions.

If you have any questions relating to installation instructions or any of our products, please contact us at:

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