FITMENT INSTRUCTIONS

PROCEDURES FOR THE ALU-CAB TOYOTA TROOP CARRIER CONVERSION

Index:

- Parts list
- Consumables
- Job Flow
- Weigh bridge comparison before and after roof conversion
- Height increase

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Review all instructions information carefully before installation.

Any damages, direct or incidental to the installer and/or property due to incorrect installation of any parts are the responsibility of the installer. Due to the various applications and fitment options available, the responsibility lies with the user to ensure all mounting points are secure and tight before every trip. If unsure, consult with your Distributor regarding the operations of our products.
Users are advised to be mindful of the load they are carrying and drive in accordance with road conditions.

DISCLAIMER

Troopy Roof Conversion

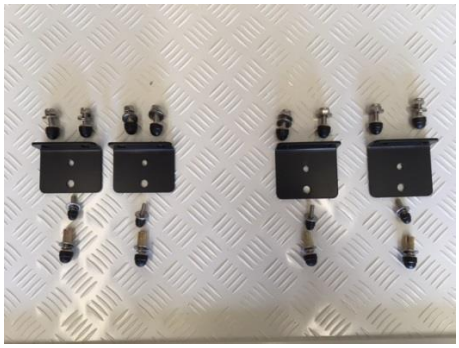
PART LIST

1. **ROOF CONVERSION**
2. **SPRING POLES**
3. **B,C PILLAR MOUNT BRACKET WITH BOLTS ANR RIVNUTS**

1.

2.

3.



Longer brackets used in the front (B Pillar), and shorter brackets used at the rear (C Pillar).

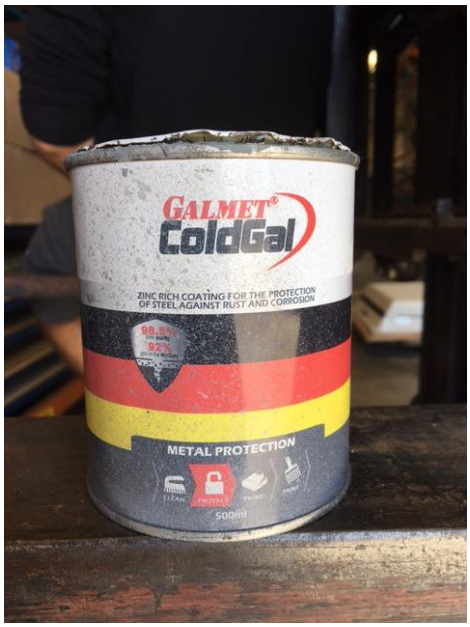
CONSUMABLES

1. **SOUDAL ADHESIVE**
2. **MASKING TAPE**
3. **PAINT METAL PROTECTION**
4. **SANDING PAPER**

1.

2.

3.



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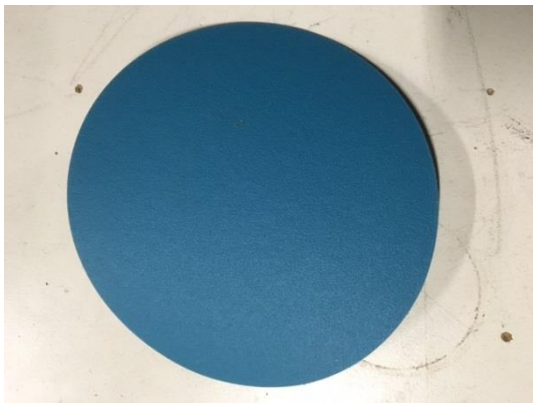


TOOLS

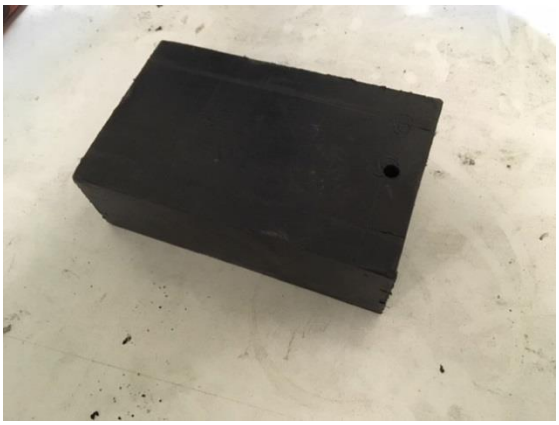
1. **DRILL**
2. **NIBBLER**
3. **IMPACT WRENCH**
4. **ELECTRIC ADHESIVE APPLICATOR**
5. **RIVNUT GUN**
6. **GRINDER**
7. **STAR SCREWDRIVER**
8. **10, 12, 13 SPANNER**
9. **ALLEN KEY**
10. **PLASTIC BLOCK**
11. **HAMMER**
12. **CENTRE PUNCH**

1.

2.

3

4



JOB CARD

1. **REMOVE A,B,C PILLAR COVERS**
2. **UNBOLT A,B,C PILLARS BRACE**
3. **REMOVE A,B,C PILLAR BRACE**
4. **REMOVE B PILLAR ROOFLIGHT**
5. **REMOVE HEADLINER**
6. **REMOVE REAR UPPER STOP LIGHT**
7. **MEASURE AND MARK ROOF – 70mm ABOVE RAIN SKIRT**
8. **DRILL DOUBLE HOLES IN CORNERS**
9. **CUT LONG ENDS BETWEEN HOLES**
10. **PUT FLATBAR FRONT AND BACK SO ROOF DOES NOT FALL IN**
11. **CUT SHORT PIECE BETWEEN HOLES**
12. **REMOVE ROOF**
13. **DRILL AND REMOVE A-PILLAR MOUNT**
14. **CUT 20MM OF TOP OF B AND C PILLAR**
15. **DRILL 2^{ND} HOLE ON B AND C PILLAR FOR RIVNUT**
16. **PAINT EXPOSED METAL**
17. **FIT RIVNUTS IN 2^{ND} HOLE ON B AND C PILLARS**
18. **FIT B AND C PILLAR BRACKETS SUPPLIED**
19. **DRY FIT ALU-CAB ROOF POSITION AND MARK**
20. **MARK OVAL HOLES ON ALU-CAB FROM BRACKETS SUPPLIED**
21. **REMOVE B AND C PILLAR BRACKETS FROM VEHICLE**
22. **REMOVE ALU- CAB ROOF**
23. **SAND SURFACE WHERE ADHESIVE WILL BE APPLIED**
24. **CLEAN ALL DUST AND MAKE SURE SURFACE IS DRY**
25. **CENTRE PUNCH MARKS FOR DRILLING**
26. **DRILL HOLES IN ALU-CAB ROOF AT PILLAR B AND C**
27. **FIT PILLAR BRACKETS (SUPPLIED) LOOSE ON CONVERSION**
28. **APPLY SOUDAL ADHESIVE ON VEHICLE OUSIDE AND ALU-CAB INSIDE**

29 REFIT ROOF ON SPACERS ABOVE POSITION

30 DROP ALU-CAB ROOF DOWN, BACK SIDE FIRST THEN FRONT

31 POSITION NEW ROOF, HOLD STEADY WITH CLAMPS

32 BOLT ROOF DOWN AT B AND C PILLARS

33 FIT FINISHER CAPS

34 DRILL HOLES IN BACK PANEL TO HOLD KNOCKOVERS DOWN

35 PUT MASKING TAPE DOWN AT TOP AND BOTTOM OF SEAM

36 APPLY FINISHING ADHESIVE BETWEEN MASKING TAPE

37 FINISH ADHESIVE SMOOTH AND PEAL MASKING TAPE OFF

38 PREPARE EXISTING ROOFLIGHT WIRE FOR SOLDERING

39 SOLDER NEW INTERIOR LIGHT TO EXISTING WIRES

40 ISOLATE WIRES

41 PUT FINISHER ON VISIBLE OLD ROOF CUT LINE

42 PUT FINISHER ON PILLAR A MOUNTS REMOVED

43 LEAVE VEHICLE FOR 48 HOURS FOR ADHEASIVE TO CURE

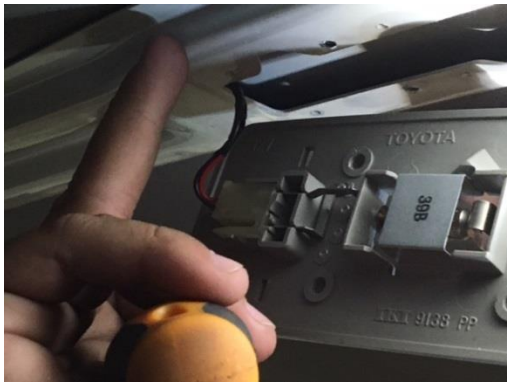
44 CLEAN VEHICLE AND CHECK IF NEW ROOF CONVERSION IS IN WORKING ORDER

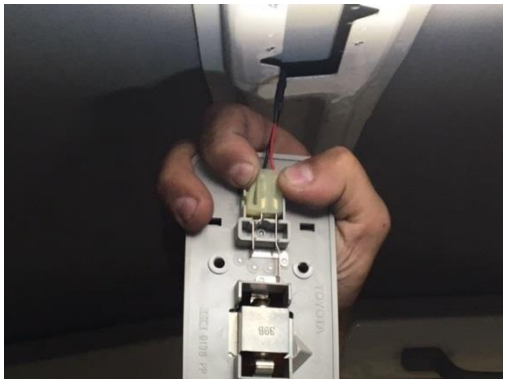
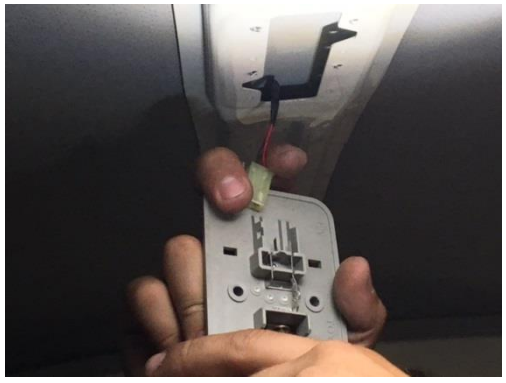
1 .1. REMOVE A,B,C PILLAR COVERS

2.1 UNBOLT A,B,C PILLARS BRACE

3.1 REMOVE A,B,C PILLAR BRACE

4.1 REMOVE B PILLAR ROOFLIGHT

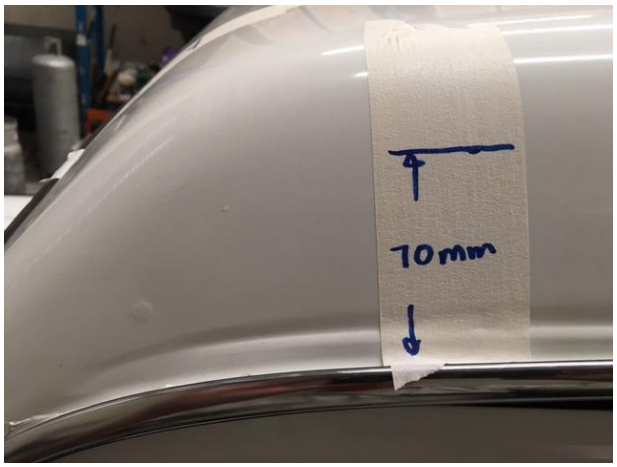


5.1 REMOVE HEADLINER

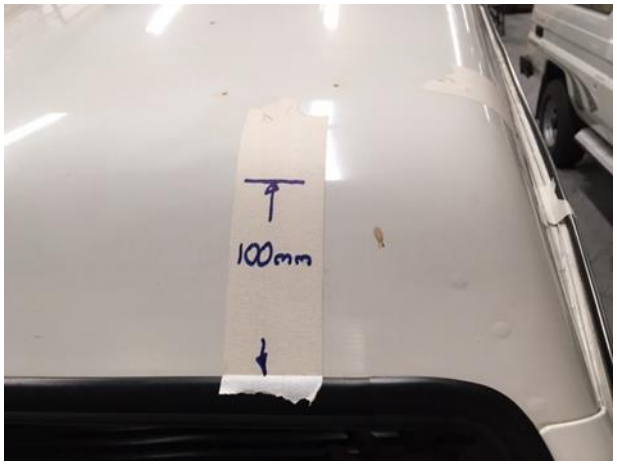
6.1 REMOVE REAR UPPER STOP LIGHT

7.1 MEASURE AND MARK ROOF – 70mm ABOVE RAIN SKIRT SIDES AND REAR ,AND 100mm FRONT FROM WINDOW RUBBER.

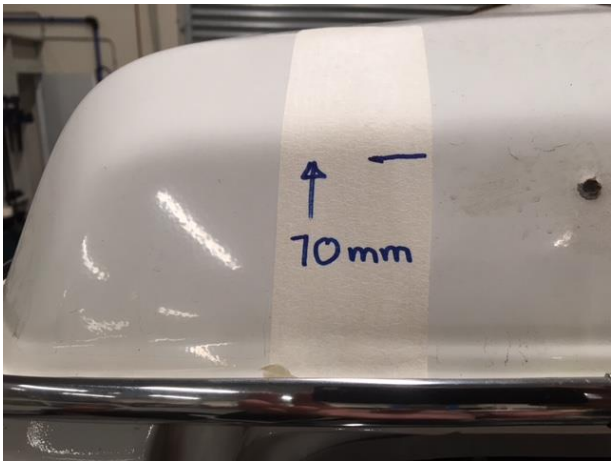


SIDE FRONT

SIDE BACK



FRONT



REAR

8.1 DRILL DOUBLE HOLES IN CORNERS

9.1 CUT LONG ENDS BETWEEN HOLES

10.1 PUT FLATBAR FRONT AND BACK SO ROOF DOES NOT FALL IN

11.1 CUT SHORT PIECE BETWEEN HOLES

12.1 REMOVE ROOF

13.1 DRILL AND REMOVE A-PILLAR MOUNT

DRILL ON SPOTWELD TO SEPERATE

14.1 CUT 20MM OF TOP OF B AND C PILLAR

15.1 DRILL 2ND HOLE ON B AND C PILLAR FOR RIVNUT

DRILL TO RIVNUT SIZE

16.1 PAINT EXPOSED METAL

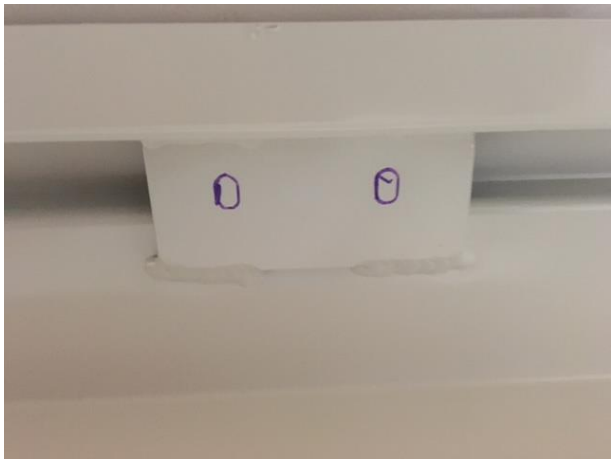
17.1 FIT RIVNUTS IN 2ND HOLE ON B AND C PILLARS

18.1 FIT B AND C PILLAR BRACKETS SUPPLIED

19.1 DRY FIT ALU-CAB ROOF POSITION AND MARK

20.1 MARK OVAL HOLES ON ALU-CAB FROM BRACKETS SUPPLIED

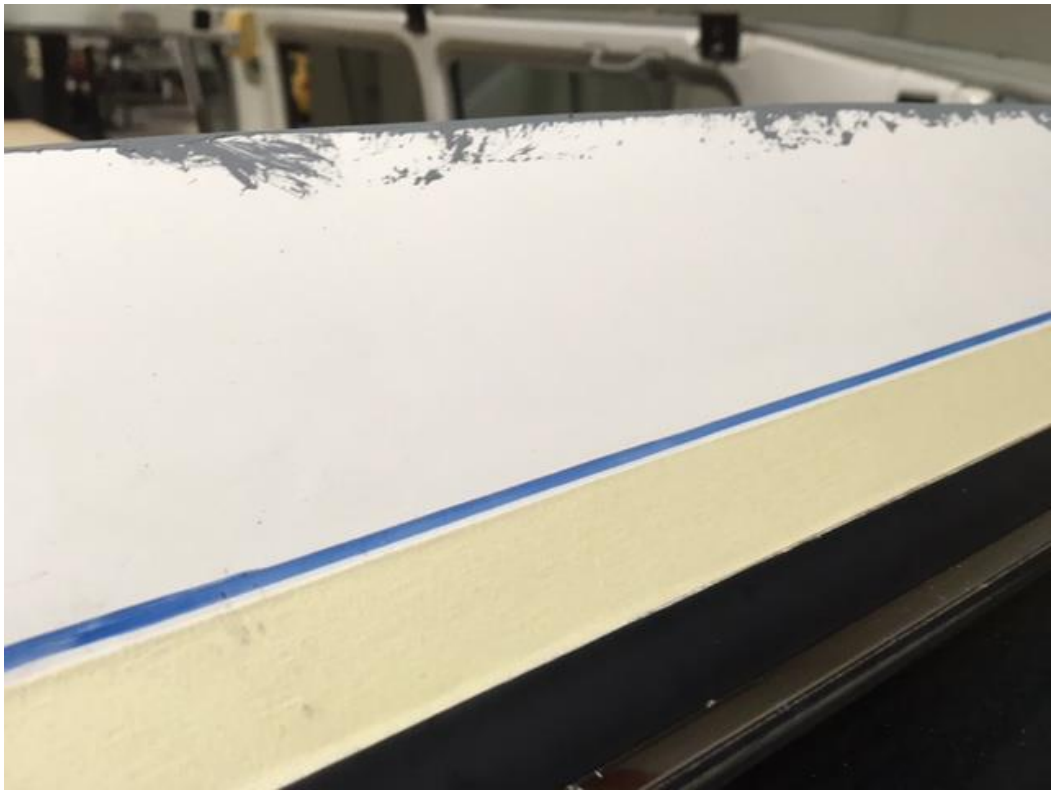
21.1 REMOVE B AND C PILLAR BRACKETS FROM VEHICLE



22.1 REMOVE ALU- CAB ROOF

23.1 SAND SURFACE WHERE ADHESIVE WILL BE APPLIED

24.1 CLEAN ALL DUST AND MAKE SURE SURFACE IS DRY



25.1 CENTRE PUNCH MARKS FOR DRILLING

26.1 DRILL HOLES IN ALU-CAB ROOF AT PILLAR B AND C

27.1 FIT PILLAR BRACKETS (SUPPLIED) LOOSE ON CONVERSION

28.1 **APPLY SOUDAL ADHESIVE ON VEHICLE OUSIDE AND ALU-CAB INSIDE**

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38 / 39 /40 PREPARE EXISTING ROOFLIGHT WIRE FOR SOLDERING
SOLDER NEW INTERIOR LIGHT TO EXISTING WIRES
ISOLATE WIRES

41.1 PUT FINISHER ON VISIBLE OLD ROOF CUT LINE

42.1 PUT FINISHER ON PILLAR A MOUNTS REMOVED

1. **TARE OF VEHICLE – 2.66t (Stock Vehicle)**
2. **TARE MINUS ORIGINAL ROOF – 2.62t**
3. **TARE OF VEHICLE PLUS ROOF CONVERSION – 2.74t**

80kg added to Original stock vehicle TARE

Height increase:

Standard vehicle = 2115mm

After roof conversion = 2164mm

Increase in height = 49mm