

SLIKFIT™

BUTTONLESS TONNEAU SYSTEM

MANUFACTURING MANUAL

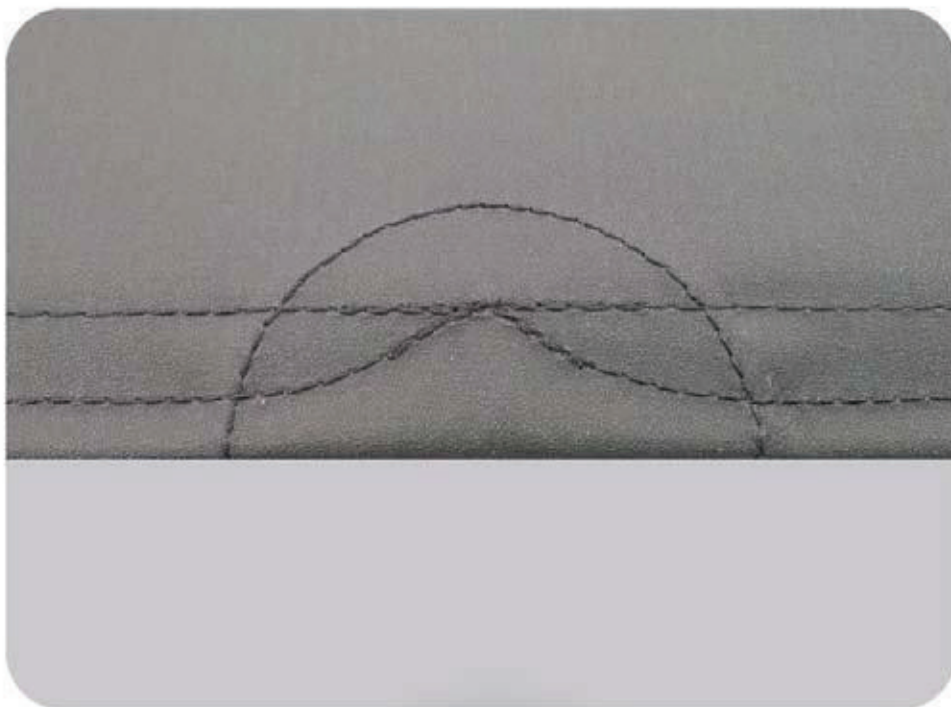
Table of Contents

- 2 General Notes
- 4 Manufacturing Instructions
- 6 Tray Back Utes
- 7 Sports Bars
- 8 Rounded Style Side
Corners

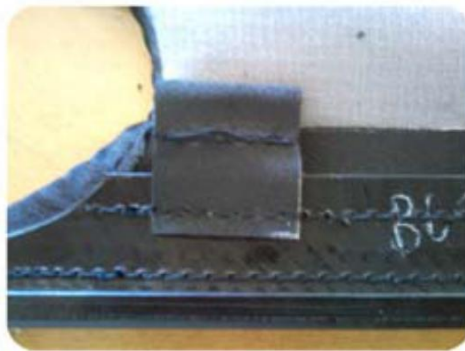


GENERAL NOTES

- Use good quality tonneau fabric.
- You may have to wind your top thread tension up. If you don't you may get looping on the outer side (especially over lugs). GET THREAD TENSIONS RIGHT BEFORE YOU START.
- Lugs must be strong enough to last but not too thick to sew over. It will work with terylene but it is pushing the limit. You can use a 20mm wide polyester, pebble weave, or 900 gsm PVC (single thickness). Don't use a single thickness of tonneau material because it will break and the edges will fray. If using tonneau material use double thickness.
- In the interest of the cover being practical, it is a good idea not to have the plastic strip in one long length on all three sides. Dividing the back in two halves and the sides in half or even thirds means you can fold the cover back or lift a corner without unclipping the whole cover and if you remove it completely, the cover can be folded up easily. Sew an extra 2 thicknesses of material inside the fold over where the ends butt together to strengthen where it folds. When sewing the first row of stitching and approaching where two pieces of plastic butt together, swoop the stitching up on a 45 degree angle towards where the second row will come through, back-stitching each side with both rows. This takes the pressure off the stitching when a corner of the tonneau is folded back.



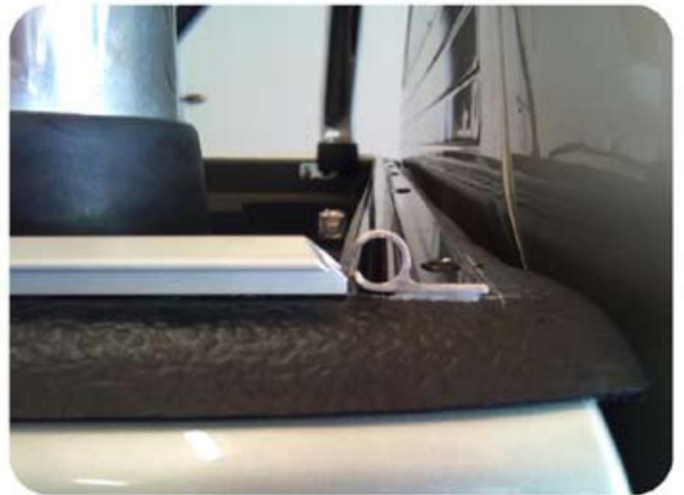
- It is common for a style side ute to have a curve in the sides and back. If so, the aluminium snaptrack can follow the curve of the outside of the tray lip.
- We recommend using Sikaflex 227 as an adhesive sealant under the track and stainless steel 6.4 rivets.
- If done correctly, the cover will be reasonably tight and should loosen slightly over the first few days.
- Plastic ute liners and spray on liners are not a problem, just do a slightly thicker bead of Sikaflex before riveting the track down because of the texture.
- It is a good idea to have a back-up system in place for when the tray has an odd load and the cover cannot be clipped down as usual. We recommend catching 40mm wide, folded strips of tonneau hoarding in with the inside row of stitching for 6mm shock cord to thread through. Then you will need to cut 40mm pieces of the plastic strip, punch a 7-8mm hole, and thread them on in-between the lugs. The two lugs at each end must have a row of stitching to stop the shockcord pulling through done before you start the second row.



- On a ute canopy, try not to put the aluminium snaptrack on the indent on tray side, keep it above the indent on the tray side
- Don't make windows in canopies too big. Keep as small as possible to avoid shrinking issues with clear PVC.
- *Finally:* Your customer should be informed that the product should not be left off the track for any extended period of time, to minimise any chance of shrinking issues. As a general rule; it is recommended if you are not getting things in or out of the tray, leave it fully hooked down.

MANUFACTURING INSTRUCTIONS

- Fit sailtrack at front. If there are sports bars, you may have to make it a centre feed by carefully raising the top section of the sailtrack using multi-grips and some scrap material for about 80mm. If there is room to slide in from the ends, run the sailtrack to the outside of the Slikfit track, and cut the Slikfit track on a 35 degree angle and run right up to the sailtrack. Remove all sharp edges on the aluminium track.



- Fit tracks on the other 3 sides. Rivets should be approximately 200mm apart. Pre-drill your holes in the track. Remove the burr on the under-side so you don't scratch the top of the tray while positioning the track. Pre-drill your holes in the tray. If you are following the curve of the tray, the ends will want to pop up, so while drilling and riveting run a piece of tape over the track.



- Remove the track and filings and run a thin bead of Sikaflex where the track sits on the tray. Rivet track down.



- Fit support bows.
- Sew rope at front and slide cover into sailtrack.
- Run 12mm double- sided tape along the track, spread the cover out and stick down. Be careful with the tension – no sags or wrinkles, but not overly tight.
- Mark just below the outer-most point of aluminium snaptrack. Don't forget to mark the ends of the aluminium snaptrack.



- Take the cover off the tray and spread out on the bench. Mark 50mm away from line and cut back.
- Pre- fold the hooding. Fold the line to the outside to loosen the cover those couple of millimetres.
- If it is a style side, sew the back corners. If it has sports bars, bind the cut-outs. If the cover will be folding in the middle of the back or sides, sew the reinforcing.
- Cut plastic snaptrack. Spray silicone spray along inside of each plastic strip which helps with the initial fit. Sew plastic strips on. The outside edge of the plastic snaptrack should be flush with folded edge. If it's a tray back you will probably have to do the back first then the two sides. Don't forget your pull lugs. Also, remember to catch your lugs for your back up system in with your second row of stitching.
- Thread shock cord and clips in your back up system then fit your tonneau.

TRAY BACK UTEs

- This system relies on stretch in the material to clip and unclip. If you have a straight tray back with no back rack, you cannot run the plastic strip on the tonneau right into the corners with no gap. The plastic needs at least a 25mm gap in the corners, but preferably around 40mm. To do this stop your plastic strip 5 or 10mm short and cut the ends of the tracks on a 45 degree angle.



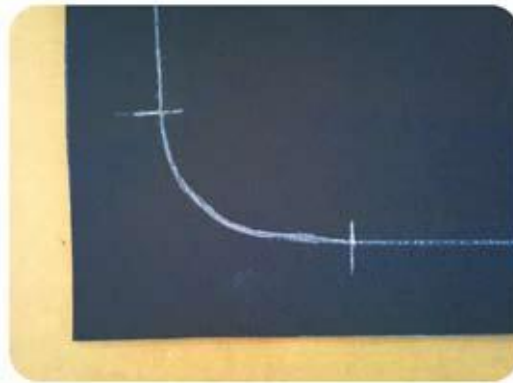
SPORTS BARS

- Sometimes the sports bars get in the way of where the snaptrack has to go. The first option is to lift the bars so they are 3 to 5mm off the top of the tray side so the aluminium snaptrack can slide under. The rubber collars at the bottom of the bars often need to be carefully trimmed to allow more room. If this is not possible, you may have to notch out a section around the bar. If you have no choice but stop and start the track between bars, it is recommended that you shape the ends as best you can to sit tight against the bar and seal any gaps neatly with silicone. If you leave gaps, it may leak.

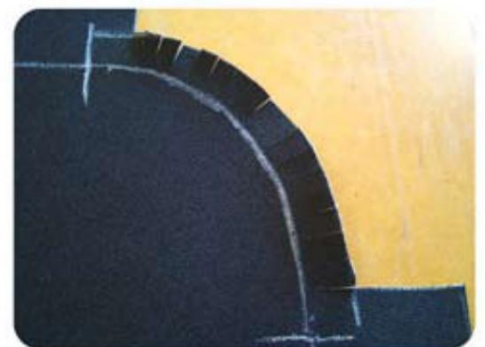
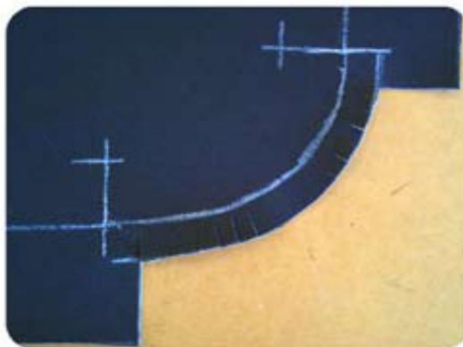
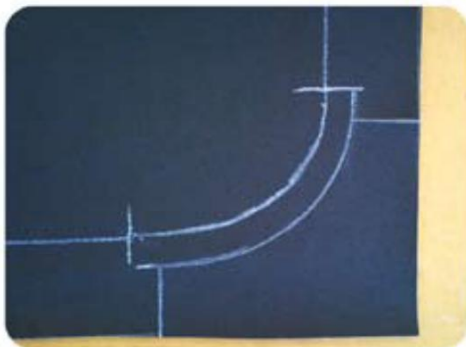


ROUNDED STYLE SIDE CORNERS

- The rounded style side corners must be sewn before sewing the track on.
- Mark around corner and mark ends of aluminium snaptrack.



- Around the curve, cut $\frac{1}{2}$ inch away from the line, put a series of cuts around the curve 5-7mm apart, stopping short of the line 2-3mm.
-



- Sewing from the top, slide a piece of scrap under the corner, fold the $\frac{1}{2}$ inch under around the corner and sew around the curve.



- Flip the tonneau over, trim back and sew the track on the sides catching the rubber around the corner. You will need to kerf (cut vee's out) the inside of the rubber to allow it to go around the corner. Cut the vee's right up to the upright section. When sewing, leave a gap between the plastic strip and the corner rubber of at least 3mm. If they are butted together, the rubber can push up against the aluminium track when the tonneau is on and raise the corner. With one row of stitching the ends of the rubber will stick out slightly. When sewing the rubber on the second row of stitching, push the ends in really well. It's the second row that holds it in place.

