Camper Van Body Flare Fitting Instructions

Mercedes Benz Sprinter MWB 2006 on | Rear Left Hand 346710 (Low Profile) and Rear Right Hand 346711 (Extended Type)

We recommend a professional installer. A capable DIYer can also fit the flare. Find your nearest installer at empriseglobal.com.au/find-the-nearest-installer

Before you start

- Check you have the right flare. The Rear Right Hand flare (346711) only suits vans with one sliding door, on the left hand side.
- The flare fits in exactly the same place as a factory side window.
- Your sliding door will still open fully. If your rear doors open to 270°, you will need an extended door stop.
- Read the safety data sheets for the adhesive, primer and cleaner. Wear gloves and eye protection, and work in a well ventilated area.

What you need

Body Flare Fitting Kit	Tools and other items
1 x TEROSON MS 939 white sealant and adhesive, 570ml	Sausage type caulking gun
1 x soft foam dam, 10mm x 10mm, 15m roll	Masking tape
1 x TEROSON all in one primer, 100ml	Clean lint free cloths
1 x TEROSON VR 10 solvent cleaner, 1 litre	Marker pen
	Panel cutting tool and file (panel vans only)
	Rust preventative paint for cut metal edges

Fitting steps

1. **Paint the flare (optional)**
   The flare is UV stabilised 4mm ABS thermoformed plastic, supplied uncoloured. If you want it to match your van, have it painted before fitting.

2. **Dry fit**
   Hold the flare in place over the window area and check the fit. Mark its position with masking tape so you can line it up again.

3. **Cut the opening (panel vans only)**
   On a panel van with no factory windows, cut the opening along the factory window lines (also called the double panel line). File the cut edges smooth and treat any bare metal with rust preventative paint. On vans with a factory side window, the window comes out first.

4. **Clean**
   Clean the van around the opening and the flare flange with TEROSON VR 10 solvent cleaner and a lint free cloth. Let it flash off.

5 **Prime**
Apply TEROSON all in one primer to the bonding area on the van and on the flare flange. Let it flash off, which takes about 30 seconds. Always check the instructions on the primer bottle.

6 **Foam dam**
Run the soft foam dam around the outside edge of the flare flange. It sets the adhesive gap and stops the adhesive squeezing out.

7 **Adhesive**
Run a continuous bead of TEROSON MS 939 around the flange, on the inside of the foam dam, with no gaps.

8 **Fit the flare**
Line the flare up with your tape marks and press it firmly into place. Tape it to the van to hold it while the adhesive cures.

9 **Cure**
Leave the adhesive to cure for at least 12 hours before driving or washing the van. 12 to 24 hours is ideal.

10 **Finish**
Remove the tape, check the seal all the way around, and water test. Insulate behind the flare from inside the van for the most comfort.

Questions? Call us on 1300 318 718, 7:30am to 5:00pm, Monday to Friday (AWST), or email sales@globeparts.com.au.

These instructions are a general guide. Always follow the adhesive and primer manufacturer's instructions.