

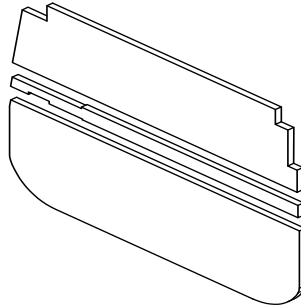
INSTALLATION GUIDE
BALLISTIC DOOR PANEL
'07 CHEVY TAHOE

Pro-gard[™]
PRODUCTS LLC.

STRONG | RELIABLE | SECURE

pro-gard.com
800.480.6680

THESE COMPONENTS ARE REQUIRED
TO INSTALL THE PRO-GARD BALLISTIC DOOR PANEL SYSTEM



BDP56C06D/P

I. Refer to the diagram on the last page of these instructions to verify all parts were received.

II. The following tools will be required to complete the installation.

- Caulking gun
- Small (#0) flat-head
- Socket Wrench, extension, and 10mm socket
- Door Panel Clip Removal Tool
- Clean cloths
- Chemical-resistant gloves

III. Safety

A. An adhesive (SikaFlex 255 FC Elastic Adhesive) is used to secure the three (upper, middle, and lower) Ballistic Door Panels to the inside of the Tahoe door skin when installing the Chevrolet Tahoe Ballistic Door Panels Kit. In this installation, the adhesive holds the panel to the door while the impact force of the bullet is trying to push the armor door panel away from the door, and therefore must absorb the entire force of the bullet. Preparation of the inner door surface, application of adhesive to the Ballistic Door Panels, and installation of these door panels to the Tahoe door skin must be performed EXACTLY as specified below and subject to all precautions in the adhesive Data Sheet. Failure to comply will degrade or nullify the protection available to the end user.

Therefore read and follow ALL safety precautions specified on the adhesive Data Sheet Sika Primer Chart, and Material Safety Data Sheets furnished with the Sika products

B. Sikaflex 255FC Elastic Adhesive is the ONLY adhesive tested and approved for the application. DO NOT SUBSTITUTE ANY OTHER ADHESIVE. Failure to comply will degrade or nullify the protection available to the user.

C. Sika Aktivator - TOEM is needed to prepare the inside surface of the Tahoe Door to receive the adhesive. DO NOT SUBSTITUTE ANY OTHER CLEANING/ACTIVATING AGENT. Failure to comply will degrade or nullify the protection available to the user.

D. The Sikaflex Aktivator – TOEM has a 12-month shelf life, and the 255 FC Adhesive has a 9-month shelf life. Apply only RECENTLY PURCHASED Aktivator –TOEM and 255 FC Adhesive. Failure to comply may degrade or nullify the protection available to the user.

IV. Removal of Inner Door Panel and Moisture Barrier

A. Using Panel Clip Removal Tool, remove trim pieces. Using small flat-blade screwdriver, carefully pry up edge of door control unit and lift it out of the armrest. Remove 10 mm bolt over door latch.

B. Disconnect door control unit from door cables at the connectors.

C. Using panel clip tool, remove inner door panel and set aside.

D. Carefully (to avoid tearing) remove moisture barrier and set aside for re-use.

V. Removing Window from Door

A. Re-connect control cables to door controls. Turn ignition ON, then use window control to move window half-way down. Turn ignition OFF.

B. Loosen (but do not remove) window holding bolts.

C. Remove window seals at the bottom of window opening by pulling up.

D. Remove forward window mounting track fastener, then push in track stud and move it towards the front of door to enable window removal. Remove Window Track Retaining Bolt

E. Push Window Track Slightly Forward. Pull up window, CAREFULLY turn it clockwise 90°, and remove window from door.

F. Remove speaker fasteners, then remove the speaker.

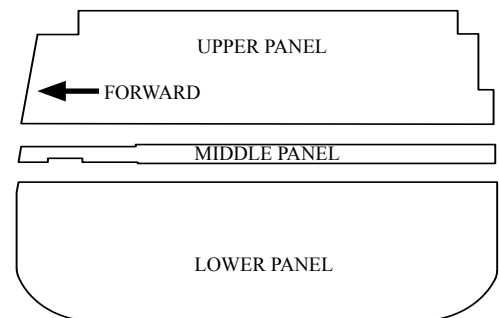
VI. Test Fit of Ballistic Panels

A. Hold the Lower Panel so the forward edge is pointing up (Fig.1).

B. Using your knee, bend the center of the Lower Panel slightly out so the Lower Panel will fit in the concave lower section of the Tahoe door.

C. WITHOUT ADHESIVE test fit the Lower Panel through the window slot and work it into the lower section of the door without the outside of the Lower Panel (which will later have adhesive) touching any part of the window slot. Fit the Lower Panel into the lower section of

FIG. 1



the door to make sure it matches the curve of the door. The top of the Lower Panel should touch the bottom of the “C” Channel. When done, lift the Lower Panel from the door through the window slot. Repeat as necessary until the Lower Panel is curved to touch all of the lower door skin. When done, remove the Lower Panel and set aside.

- D. WITHOUT ADHESIVE test fit the Middle Panel into the “C” slot in the door. Repeat until you can install it without the outside of the Middle Panel touching any part of the window slot. When done, remove the Middle Panel and set aside.
- E. WITHOUT ADHESIVE test fit the Upper Panel above the “C” slot in the door. Mark on the upper edge of the Upper Panel where it touches the plastic piece affixed to the inner door skin – you cannot place adhesive there. Repeat test fitting until you can install the Upper Panel without touching the window slot. When done, remove the Upper Panel and set aside.

VII. Applying Adhesive to Ballistic Panels and Installation

- A. ENSURE the temperature of the door, the 255FC Adhesive, and the Ballistic Panels are between 50° F and 90° F before applying Adhesive. (The Aktivator-TOEM can be applied between 40°F and 110°F.)

WARNING

FAILURE TO ENSURE THE DOOR, THE 255FC ADHESIVE, AND THE BALLISTIC PANELS ARE BETWEEN 50° F AND 90° F WILL DEGRADE ADHESION, DEGRADING OR NULLIFYING THE PROTECTION AVAILABLE TO THE USER.

- B. Using the Sika Aktivator-TOEM and clean cloths, clean the inside skin of the door where the Upper, Middle, and Lower Ballistic Panels will touch it, then clean the outside surfaces of the Ballistic Panels. Follow the directions which come with the Aktivator-TOEM and observe all safety precautions listed in the Material Safety Data Sheets. ENSURE that the both the inside skin of the door where each Ballistic Panel will touch and the outside surfaces of the Ballistic Panels are completely dry and free of any dust, grease, or oil. Observe the drying time requirements on the Aktivator-TOEM instruction sheet.

WARNING

THE INSIDE SURFACE OF THE DOOR AND THE OUTSIDE EDGE OF THE BALLISTIC PANELS MUST BE COMPLETELY DRY AND FREE OF ANY DUST, GREASE, OR OIL TO ENABLE THE BALLISTIC PANELS TO ADHERE TO THE DOOR. FAILURE TO COMPLY WILL DEGRADE ADHESION, DEGRADING OR NULLIFYING THE PROTECTION AVAILABLE TO THE USER.

- C. Using a sharp knife, cut the plastic applicator “funnel” on the front of the Adhesive tube so the hole is ¼” wide.

Note

When the Adhesive leaves the tube, it starts curing immediately. Once you apply the Adhesive to a Ballistic Panel, install it into the door immediately (this is why you were instructed to practice installing each Ballistic Panel without Adhesive).

- D. Using a caulking gun, apply an even ($\frac{1}{4}$ "") bead of Adhesive in a wide "S" pattern across the width of the Lower Panel. Insert the Lower Panel into the door without touching the Adhesive to the window slot and install it into the bottom of the door as you practiced. Press the entire Lower Panel firmly to "squish" the Adhesive into contact with the inside surface of the door.
- E. Using the caulking gun, apply two even lines of Adhesive across the length of the Middle Panel. Insert the Middle Panel into the door without touching the Adhesive to the window slot and install it into the "C" channel in the middle of the door as you practiced. Press the entire Middle Panel firmly into the "C" channel to "squish" the Adhesive into contact with the inside surface of the door.
- F. Using the caulking gun, apply an even ($\frac{1}{4}$ "") bead of Adhesive in a wide "S" pattern on the front and rear sections outside of the marks you made showing where the Upper Panel touches the plastic piece. Insert the Upper Panel into the door without touching the Adhesive to the window slot and install it above the "C" channel as you practiced. Press the entire Upper Panel firmly to "squish" the Adhesive into contact with the inside surface of the door.

VIII. Reinstalling the Window into Door

- A. Ensure the window track is still "slightly forward".
- B. Install the window into to door, turn it 90° counter-clockwise, and seat it in the window holding clamps. Don't tighten the clamp bolts yet.
- C. Once the window is seated in the clamps, move the track to the rear to secure the window and LOOSELY (to prevent binding and breaking the window) install the track retaining bolt.
- D. Tighten the window clamp bolts a little bit (just enough to hold the hold the window).
- E. Turn ignition ON and carefully operate the window control to check that the window can slide smoothly up and down in the track without binding. Adjust the position and angle of the window in the clamps as needed to ensure the window slides smoothly to the top and bottom of the track without binding.
- F. When the window is positioned correctly, turn ignition switch OFF, tighten the window clamp bolts (Figure 6), then tighten the window track retaining bolt .

IX. Replace Window Seals

X. Reinstall Speaker

- A. Install the speaker into the door and secure it with the fasteners removed earlier.

- XI. Disconnect the Door Control Unit from the door cables
 - A. Disconnect the door control unit from the door cables and set unit aside.
- XII. Replace Moisture Barrier
 - A. Align the moisture barrier and thread the door cables through it. Press the moisture barrier into place.

NOTE

If you ripped the moisture barrier while removing it, to prevent water damage to the inner door panel and door control unit, it is strongly encouraged to install a new moisture barrier.

- XIII. Replace Inner Door Panel
 - A. Position inner door panel and seat it into place.
 - B. Install fasteners to secure the inner door panel to the door. Install trim panels.
 - C. Re-connect door control cables to door control unit.
 - D. Install door control unit into armrest
- XIV. Installation of the Ballistic Door Panel is now complete.

