

# Work Recommendation for professional installation as a complement to the installation instructions for train- and bus antennas



OmPlecs®-  
TOP 200 AMR

OmPlecs®-  
TOP 200 RA

## 1. Preparation

Required material:

- Rubber Gloves
- Cutter knife
- Scriber
- Assembly aid (drilling template with hardened drilling sleeves)
- (Stepp) drill and cup brush (Ø18mm, stainless steel) to create the drilling pattern
- Torque wrench
- Zinc spray (Type Henkel Teroson®, electrically conductive)
- Sealing compound and primer- (Sikaflex® 268 and Sika®Primer-207)  
(Container e.g.: 600ml tabular bag and 30ml / 100ml / 250ml can)
- Tubular bag applicator gun (with translation, battery or compressed air)
- Puller for sealing material (size 10)
- Acetone / non-aggressive cleaner
- Brush / melamine foam
- Rags / towels

## 2. Procedure

Note:

It is certainly advantageous to assign before mounting the serial no. of the antenna to the vehicle no. to facilitate later researches.

Use our train- and bus antenna installation instruction for proper preparation of the drilling pattern to the desired position on the roof (drilling template with hardened drilling sleeves).

[See details in our Installation Instruction for train- and bus antennas](#)

Check the O-ring on the correct, firm place on the antenna underside (in case of train antennas).  
If necessary, stretch gently the O-ring until it is firmly seated in the nut.

Clean the mounting surface and the antenna (with acetone or non-aggressive cleaner; test on vehicle and aerial before (varnish) compatibility!).

Avoid cleaners with too much alcohol!

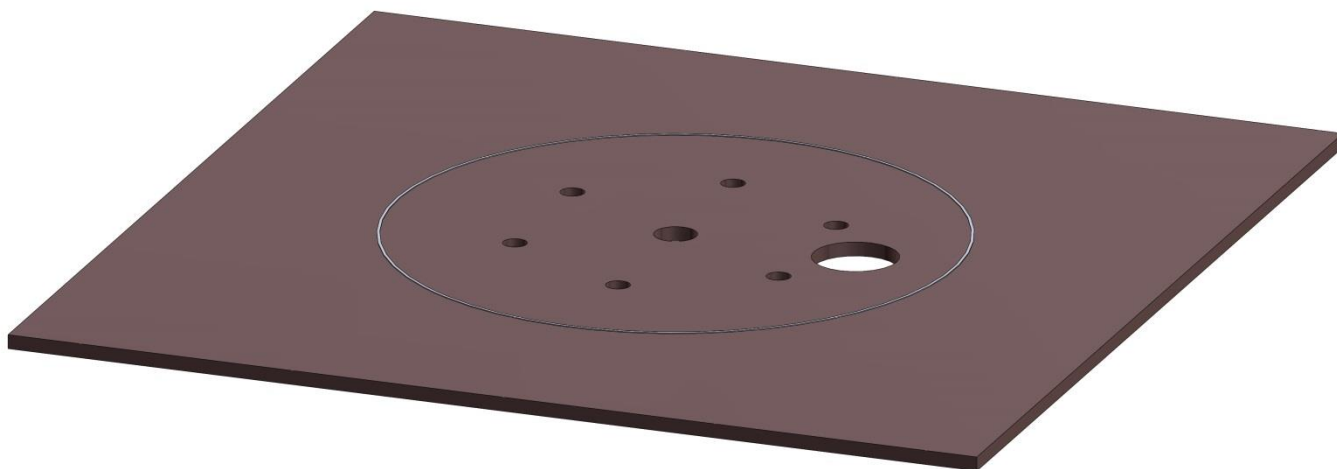
Please observe the relevant instructions for use of the products used.

Remove the M8 nuts and ratchet washers from the bolts.

Install the antenna in the roof without mechanical damage to the bolts. Trace the outline with a scribe circumferentially.

Note: Trace the surface lightly, to avoid deep damage!

Take the antenna back down.



Apply Sika®Primer-207 with a brush or melamine foam to all surfaces to be sealed (housing, gasket, roof).

Observe the ventilation time (over 5 ° C: at least 10 minutes to a maximum of 24 hours)!

Perform the following three steps sequentially within max. 60 minutes from initial application of Sikaflex®!

Skin-forming time: 60 minutes (at 23 ° C and 50% relative humidity)

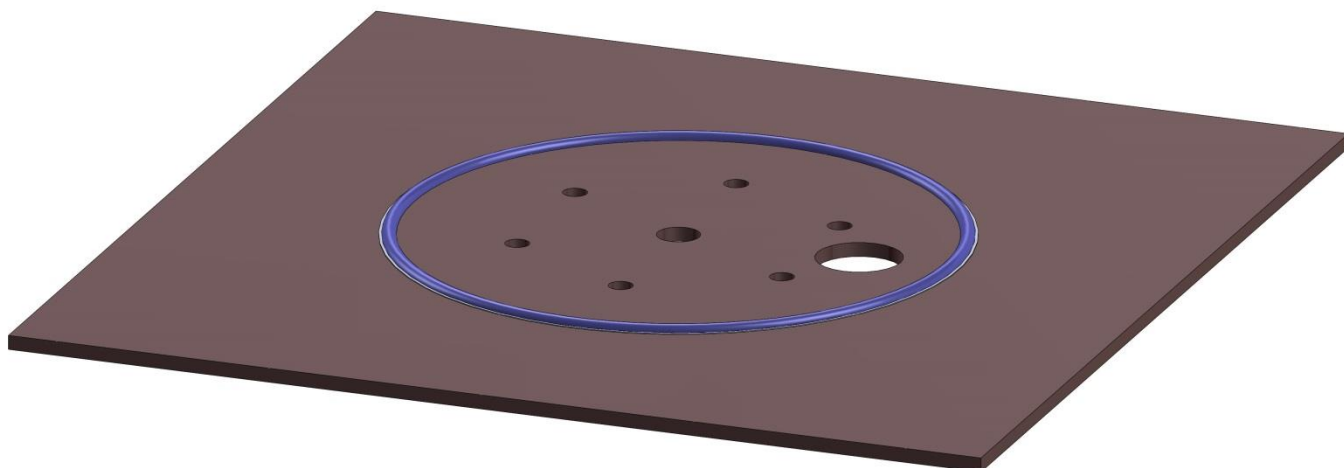
Cut the nozzle / nozzle tip of the gun according to the joint width at 45 ° degrees.

Apply Sikaflex® with a tubular bag applicator gun (with translation, battery or compressed air) air-free in a thickness of about 5 mm circumferentially within the marked circle.

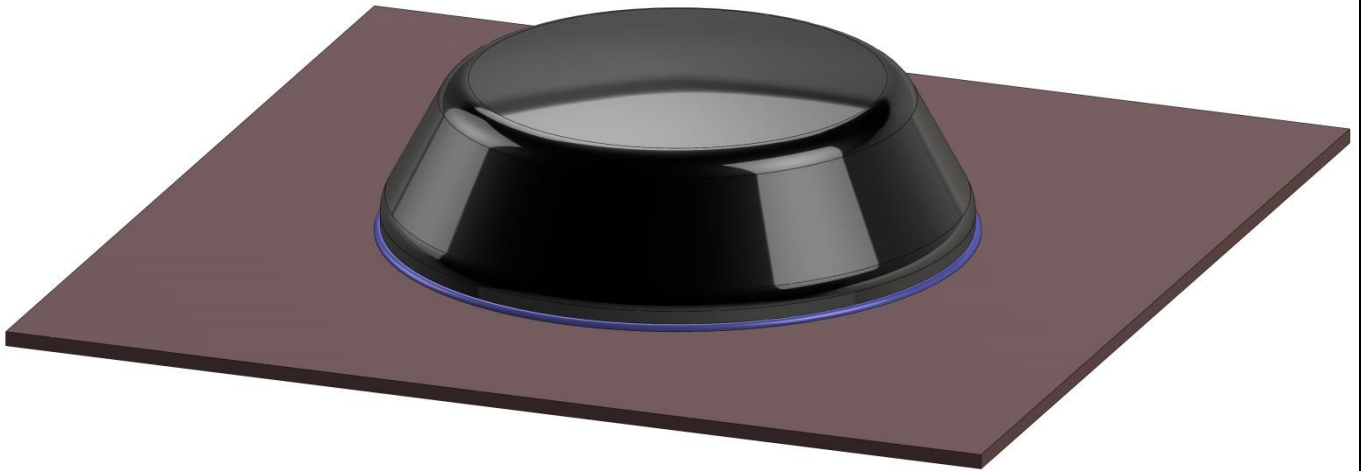
The processing temperature must not be lower than 10 ° C and can't exceed 35 ° C.

The optimum temperature for materials is between 15 ° C and 25 ° C.

*Please note the Sikaflex® data sheets and the corresponding safety data sheets for the products used.*

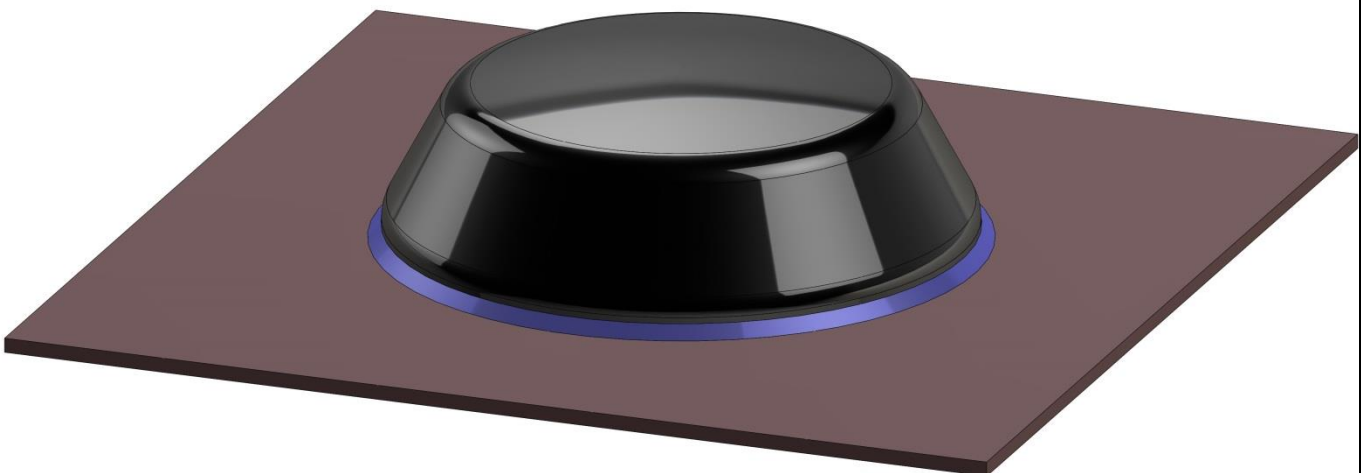


Fit the antenna, fit again the ratchet washers and M8 nuts and hand-tight it crosswise.  
Then tight the antenna crosswise using a torque wrench  
(Torque 12Nm; Sikaflex® wells gently).



Apply circumferentially Sikaflex® in a thickness of approximately 10-15 mm and at 45 ° angle pull off the surpluses with puller (size 10).

Curing time : ca. 3 days at 23 ° C and 50% relative humidity  
ca. 6 days at 10 ° C and 50% relative humidity



After tightening the screw connection, the detent-edged washer, M8 nut and the contact blank parts must be sealed (antirust) with a zinc spray (TYPE Henkel Teroson®, electrically conductive).

After about 12 hours the Sikaflex-joint should be checked to see, whether it sticks at 45°-Winkel.

Caution: The seam is not yet cured at this time and must not be subject to any mechanical test (for example peeling, pressing - not even partially)!

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