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## CLUSTER-CRNR-KIT

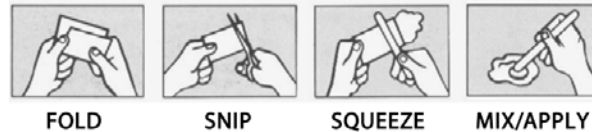
### Vanagon Gauge Cluster Corner Repair Kit

This kit will allow you to repair broken corners on your gauge cluster. You will need to remove the gauge cluster from the vehicle, carefully remove the blue foil from the back of the gauge cluster, and remove the gauges from the cluster.

### INSTALLATION

For broken **cluster** corners:

1. Drive the screw through the hole in the metal cluster reinforcement to form the threads.
2. The gauge cluster corners are not exactly 90° angles. Bend the metal cluster reinforcement to match the angle of your broken cluster corner. **NOTE:** If the cluster corner is **not** entirely broken out, you may need to trim the remaining plastic so that the tab on the metal reinforcement is flush with the back of the cluster.
3. Clean and dry the gauge corner areas to be repaired.
4. Fold the included epoxy packet along the center seal, snip the end, squeeze out the contents, and mix thoroughly.



5. Apply epoxy to the inside of the metal reinforcement and press the reinforcement onto the gauge corner.
6. Set the gauge in place and use the screw to align the holes.
7. Tape the cluster reinforcement to the cluster and **remove the gauge** before the epoxy sets.
8. Clean up any excess epoxy, and allow epoxy to fully cure.  
(Working time = 3 hours @ 77°F. Full cure = 18 hours @ 77°F.)
9. After the epoxy has fully cured, remove the tape.

For broken **gauge** corners:

1. Place the corner repair tab over the broken gauge corner. If the gauge corner is completely broken out, use the included spacer between the repair tab and the cluster. If the gauge corner is **not** entirely broken out, discard the spacer. The protective cover over the repair tab can be removed by using your fingernail.

*Optional: Epoxy can be applied to the the plastic corner tab before assembly to permanently affix it to the gauge. We recommend cleaning and scuffing the surfaces for better adhesion.*

Reassemble gauge cluster and foil. **WARNING! Do not overtighten screws!**



Cluster Corner Reinforcement



Gauge Corner Repair