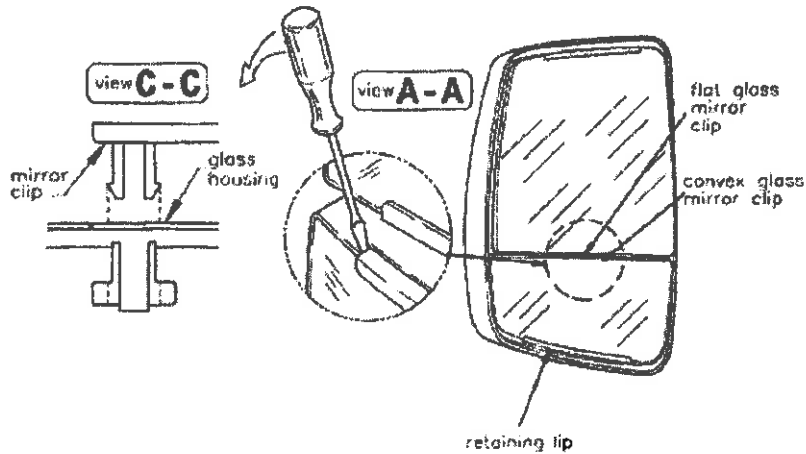
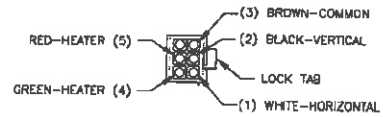
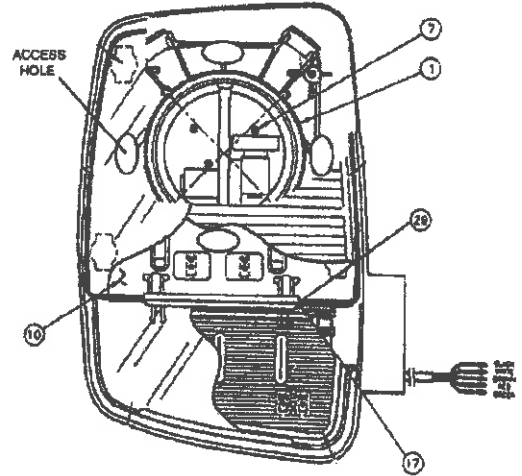


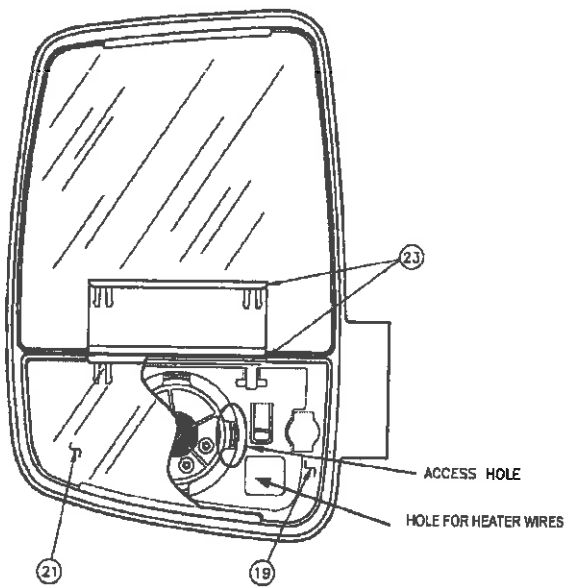
2020 XG MIRROR SYSTEM COMPONENT PARTS REPLACEMENT INSTRUCTIONS



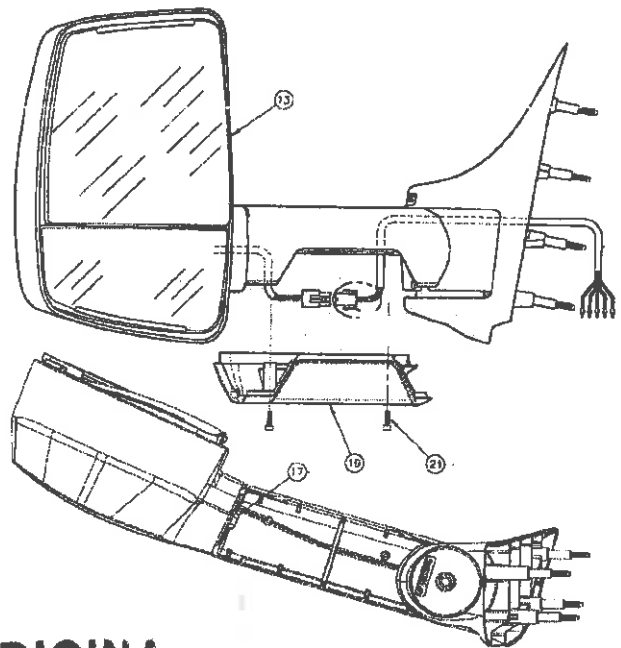
Drawing 1



Drawing 2



Drawing 3



ORIGINAL

Drawing 4

2020 XG MIRROR SYSTEM

COMPONENT PARTS REPLACEMENT INSTRUCTIONS

****CAUTION: Always wear eye and hand protection when replacing component parts. ****

Flat glass replacement (refer to drawings #1 and #2)

If the glass is still in the mirror head it will need to be removed. Locate the flat glass clip and pry off the clip #29 from the glass housing with a small screw driver as shown in view A-A and C-C. After the clip is removed take out the glass by prying out with a screw driver being careful of sharp edges. Disconnect the heater wires from the glass. In drawing #2 there are shown 4 access holes on glass housing #10 which the glass rests on. Insert a small flat screw driver into the access holes to unsnap the tabs holding the plate to the motor/pivot assembly. The new glass kit will come assembled. Connect the heater wires to the new glass. Place the glass assembly over the motor and gently but firmly push the glass downward so the tabs snap over the motor/pivot assembly.

Convex glass/housing replacement (refer to drawings #1 and #3)

Removal: If the glass is still in the mirror head it will need to be removed. Locate the curved glass clip and pry off clip #23 from the glass housing with a small screw driver as shown in view A-A and C-C. After the clip is removed take out the glass #21 being careful of sharp edges. If applicable, unplug the two wires attached to the heating element terminals on the back of the glass. The glass housing, part #19, has 4 rectangular access holes. Insert a small flat screw driver into the access holes to unsnap the tabs holding the housing.

Installation: First place the glass into the new housing making sure the lower edge of the glass slides into the lower retaining lip of the housing. Snap the upper curved glass clip over the top of the glass and into the inner housing. Plug the wires into the terminals on the back of the new glass, then gently but firmly push the housing/glass assembly downward so the tabs snap over the cup assembly.

Mirror arm covers (refer to drawing #4)

Support the mirror arm cover and using a 5/32" hex wrench, remove the cover screws #21.

Replacement covers will come with new cover screws. Tighten until snug. **Do not over tighten.**

Mirror head (refer to drawing #4)

Remove the mirror arm covers as instructed above. If remote controlled disconnect the connectors for the wiring harness inside the mirror arm. Support the mirror head and using a 1/2" socket wrench remove bolt #17. The mirror head will detach from the arm. Reinstall using the new head screw tighten to 75 inch pounds. If remote controlled re-connect the plug connectors and install the mirror arm cover using the supplied new cover screws #21. Tighten the screws until snug. **Do not over tighten.**

Mirror motor (refer to drawing #2)

Remove the flat mirror glass as instructed above. The motor #1 is held in the head with 3 phillips head screws #7. After removing the screws the wires need to be cut. The new motor wires should be cut and stripped to proper length; then soldered or butt spliced to the wires inside the mirror head, matching color to color. Reinstall the motor using the 3 screws until snug. **Do not over tighten.** Reinstall flat glass.

For technical support contact Velvac directly:

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