

SAFARI WINDOW INSTALLATION

KIT INCLUDES:

- 1 Driver's side Safari Window assembly
- 1 Passenger's side Safari Window assembly
- 4 Latches and slide supports "attached"
- 2 Body to Safari frame seals
- 1 Mounting Hardware kit including the following;
 - 2- small dash tabs
 - 2- large dash tabs
 - 2- side weld on support tabs
 - 1- center weld on support tab
 - 4- wing bolts
 - 8- nylon friction washers
 - 22- #10 x 1/2" sheet metal screws

TOOLS NEEDED:

- Small Phillips screwdriver
- Scribe
- 1/8" drill bit
- Drill
- Welder or someone who can weld
- Knife, razor blade or tin snips
- Friend to help

REMOVAL OF OLD GLASS:

Now that you have your Safari Windows, the first step is to remove your old windshields. The easiest way to do this is to cut the old seal away from the glass with a razor blade. Cut the seal by placing your blade between the glass and the rubber on the outside of your Bus. Cut straight down and all the way around until you feel the blade hit metal. Peel the outer part of the seal out. Now have someone push the glass from the inside out and repeat the steps on the other side. Next, if your window gutters are rusted, as most are; you need to sand all the rust away and prime it with some rust retardant primer. If you are going to repaint the area, wait until you have your Safari Windows installed.

INSTALLATION:

1. After your touch-up work is finished, install your new Safari seals with the bubble facing out and the seam at the top. Do not glue them in, they will need to be taken out again. Use a small rubber or wooden mallet to tamp the seal all the way down on the lip (Fig. 1). Make sure the seals seat completely all the way around the window opening, especially in the corners. If not, the seal will be short after cutting off the excess. When you are sure the seal is completely seated around the window opening, it is time to cut the excess off. Pay attention to cutting the seal straight using a razor blade or tin snips. NOTE: We cut the seal an 1/8" longer than needed. This will allow you to trim the seam later for a perfect fit (Fig. 2). Save the excess seal material, it will assist in later steps. Now with your favorite helper, lift the Safari frame in its closed position, tuck the hinge in behind the seal and flush to the mounting surface. Two people are a must here (Fig. 4).
2. Align the frame side to side in the opening and put a mark on each end of the hinge (Fig. 3). Scribe a line on the hinge and the body to locate how far the hinge sits out as well. NOTE:

Make sure the crush on the bubble of the seal is slightly compressed by the Safari frame before scribing these lines.

3. Remove the frame and seal from the car. Put the frame in the open position and align marks on each end of the hinge. Now mark one screw hole on each end of the hinge (Fig. 5). Use a center punch to mark the holes and then drill with a 1/8" drill bit. NOTE: Just drill the outside holes. That way if you have made a mistake you can change the location later. Now set the frame in again and screw in with two screws. Don't tighten the screws all the way yet. By only installing two screws you can still move the frame around if further alignment is needed. (Fig. 6).
4. Now that you have the frame centered where you want it, it is time to utilize the extra few inches of seal material. Cut this excess seal into 4 pieces and seat them on the body lip. One on each side up near the corners and two down on the bottom where you think the latches will locate. Let the window close; **pay attention on how the frame comes down on the seal pieces. You want it even from top to bottom.** You are trying to achieve even pressure against the seal pieces without compressing the bubble completely. This can be adjusted by sliding the frame into or out at the top. Once you get it where you want it, tighten the two screws and check again. Now drill the remaining holes and put in the remaining screws (Fig. 7). Repeat all these steps on the other side.
5. With the frames closed, it is time to install the dash tabs. Center the dash tabs under the latches and push them up until they touch the seal. Have your helper keep pressure on the window when marking for the tabs. Again even pressure on the seal bubble, top to bottom for optimum sealing. Now mark them (Fig. 8). Tall tabs go to the outside and short ones to the center. Now that you have all four tabs marked, drill the holes as you did for the hinges and screw them down. Go ahead and lock the frames down so you can install the slide tabs (Fig. 9). NOTE: Original Safari Buses came with a window section stamped to accept the Safari hinge. If your Bus does not have this hinge relief in the window opening, there may be a clearance problem between the inner latch and the dash tab when latching. If the nose of the latch hits the tab base before latching you may need to file off some of the tip of the latch nose where it interferes with the tab base.
6. With wing bolts and two Nylon washers, one on each side of the slide, screw each slide tab on. Now position the tabs against the body and mark area so you can clean paint away for welding (Fig. 9). With the windows locked down, you can now drive to a welding shop if necessary. Before tack welding, remove the door seals behind the two outside tabs. Lightly tack weld the two outer slide support tabs. Be careful, the plastic friction washer melts easily. The center tab locates the inner slide on each Safari window. This distance between slides varies on every installation so it may be necessary to slightly tweak this mount by squeezing or spreading to properly meet alignment of both inner slides. Once center support tab is aligned, lightly tack weld and check window through its open and closed positions. Before welding, completely remove windows, dash tabs and seal segments. NOTE: Welding sparks can pit the glass, paint or any polished surface. Prep and paint all welded or exposed areas to your liking. Reinstall seals and trim the joining edge to get a perfect fit. Reinstall window frames, dash tabs and slide support hardware.

Now you are ready to cruise.

NOTES:

WELDING:

It is recommended that you use a heliarc (TIG) welder to weld the slide tabs. The body material is very thin; most of the heat should be applied on the thicker tabs.

WIPERS:

We offer two types of wiper shafts that allow you to rotate your wiper arms out of the way of the windows. The one eyed duck holds the blades in the center. Both are sold separately.

MAINTENANCE:

Safari windows may leak even when installed properly. Yes, even the factory windows did. If you do, we recommend using a petroleum jelly on the seal to frame surface. This will help stop any leaks and is easy to wipe off in the summer time.

We have found that if you push down on the slides before you latch the windows closed it will relieve stress on the latches. Never attempt to take the frame apart, if glass is damaged please contact us for repair. The frames are pressed onto the glass in a special press, making it very difficult for you to do it yourself.

**NEVER DRIVE VEHICLE WITH WINDOWS IN OPEN POSITION OR WITH
WINDOWS IN UNLOCKED POSITION!
THIS KIT IS FOR SHOW OR OFF-ROAD VEHICLES ONLY.**

Thank you for your purchase of the Safari windows. If you have any questions, please don't hesitate to contact us.



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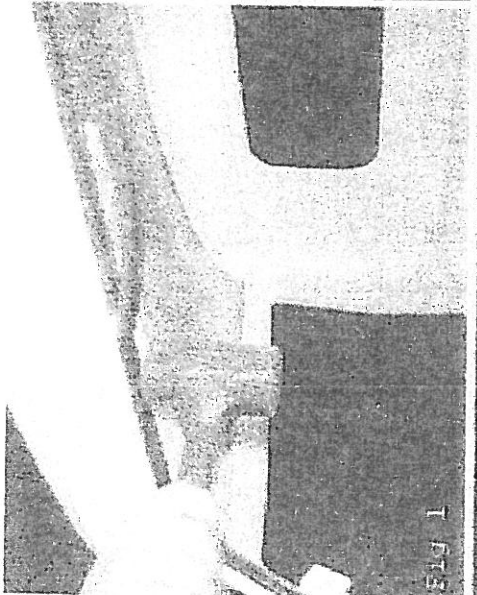


FIG 1

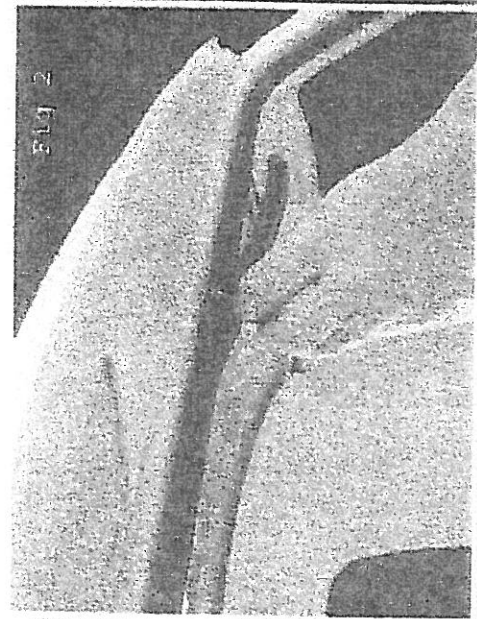


FIG 2

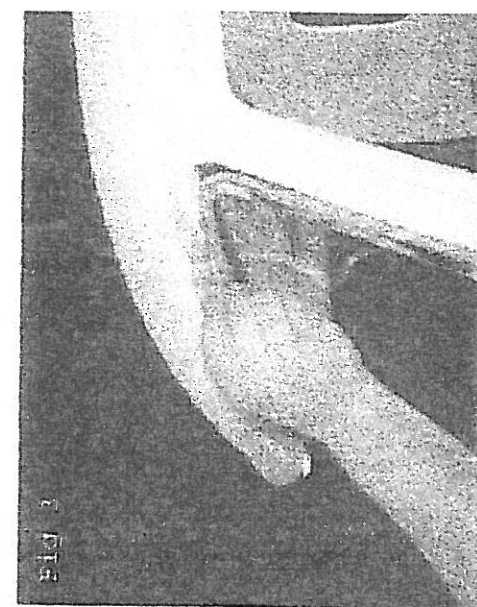


FIG 3

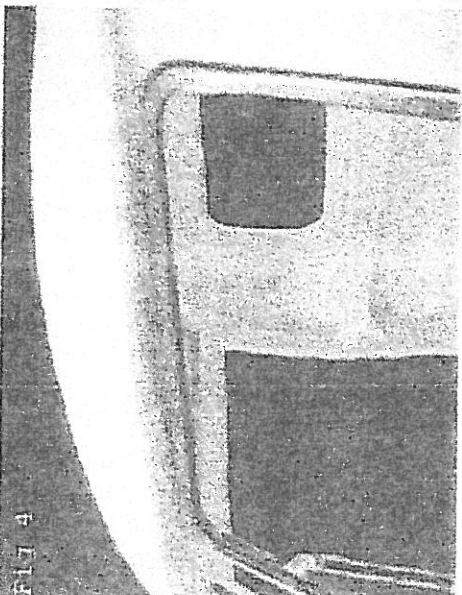


FIG 4

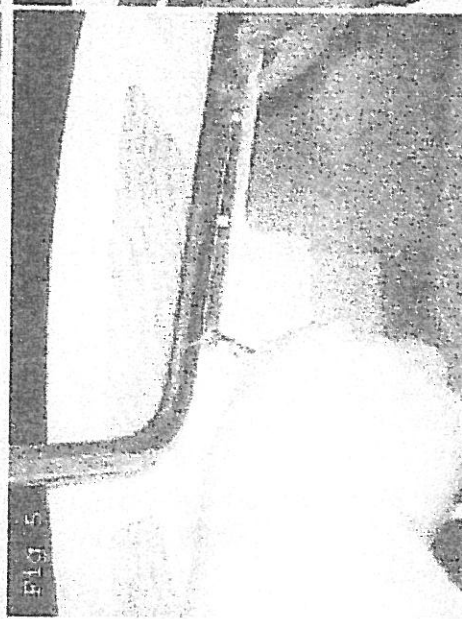


FIG 5

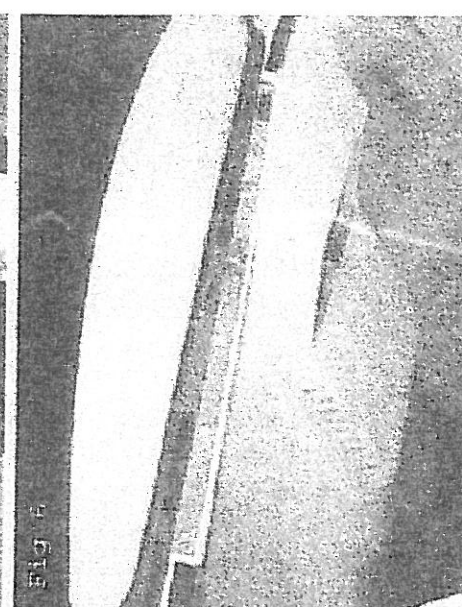


FIG 6



FIG 7

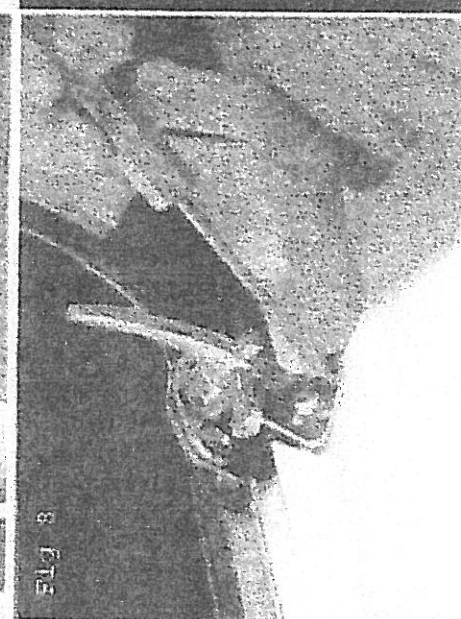


FIG 8

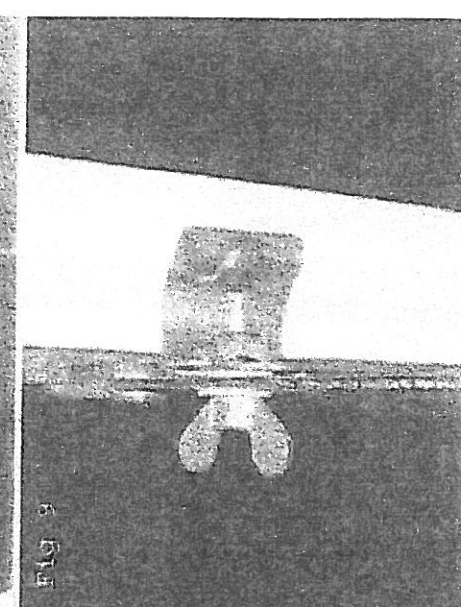


FIG 9