

REAR SAFARI WINDOW INSTALLATION

FOR

55-63 STANDARD & DELUXE and FRIDOLIN

OR

64-79 LARGE REAR WINDOW

KIT INCLUDES:

- 1 Rear Safari Window frame assembly
- 2 Latches and slide supports "attached"
- 1 Body to rear Safari Window frame seal
- 1 Mounting Hardware kit including;
 - 2 - Latch tabs
 - 2 - Weld on support tabs
 - 2 - Wing bolts
 - 4 - Nylon Friction washers
 - 11 - #10 x 1/2" sheet metal screws (For the 55-63)
 - or 18 - #10 x 1/2" sheet metal screws (For the 64-79)

TOOLS NEEDED:

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

REMOVAL OF OLD GLASS:

Now that you have your Safari Window, the first step is to remove the old glass. 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 your friend push the glass from the inside out. If your window gutter is rusted, you are going to 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 dry, install your new Safari seal. Do not glue it in at this point as it will need to be taken out again. Now with your favorite helper, lift the Safari frame in it's open position and tuck the hinge in behind the seal. Two people are a must here.
2. Close the window and try to keep the seal and hinge in the proper position. Align the frame side to the side in the body and put a mark on each end of the hinge. Scribe a line on the hinge and the body to locate how far the hinge sits out as well.
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. Use a center punch to mark the holes then use the 1/8" bit to drill the two holes.
4. Set the frame in again and screw it in with two of the screws. But don't tighten the screws all the way yet. By installing just two screws, you can still move the frame around slightly if further alignment is needed.

5. Now that you have the frame right where you want it, install the seal again. Let the window close. **Pay close attention to how the frame comes down on the seal, you want it even from top to bottom otherwise you will have to much tension on the latches and will pull them right off the first time you close them.** This can be adjusted by sliding the frame in, or out at the top. Once you get it where you want it, tighten the two screws and check again. Now mark and drill the remaining holes and put in the screws.
6. With the frame closed, it is now time to install the chrome latch tabs. Center the latch tabs under the latches and push them up until they touch the seal. Mark the tab and pull the seal out of the way. Drill the holes as you did for the hinges and screw them down. Go ahead and lock the frame down so you can install the slide tabs.
7. With wing bolts and two nylon washers, one on each side of the slide, screw each slide tab on. Run tabs up the slides as far as they will go, and position the tabs against the body. Now mark the area so you can clean the paint away for welding.
8. With the windows locked down you can now drive to a welding shop if necessary. Before tack welding, be sure to remove the seal behind the two outside tabs. Now tack weld lightly. Before welding completely, remove the wing bolts and washers and hold the windows in the open position. When you are done welding, prime and/or repaint areas needed and you are ready to go!

WELDING:

It is recommended to use a heliarc (TIG) welder when welding the slide tabs. The body material is very thin, most of the heat should be applied on the thicker tab. If a MIG welder is used, put a piece of tape over each side of the nuts to prevent slag from getting in the threads of the tabs.

MAINTENANCE:

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

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

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



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