

SIDE SLIDING / FIXED WINDOWS

ILLUSTRATED FITTING MANUAL



You will need:

- General workshop tools
- Cloths and a mild cleaning agent
- Latex gloves, eye and ear protection
- An electric drill with an appropriate bit for metal
- A sealant applicator gun
- A jig-saw
- Stylus knife/Scissors
- A rubber mallet or hammer

SIDE SLIDING/ FIXED WINDOWS

Thank you for purchasing Masai side sliding/ fixed windows. Please read these instructions carefully before commencing work. After the installation is complete, we do not recommend that you wash your vehicle or leave it out in the rain for 24 hours.

If you have a panel van and need to remove the apertures, please watch our online video at <https://bit.ly/2FrB5Bz> (www.masai4x4.com) and study the instructions supplied; make sure you have all the tools and other equipment ready before you start, including a large table near your vehicle. Please follow appropriate safety precautions. You may skip straight to page 4 if your Land Rover has side windows. PLEASE NOTE: the window catch should be at the front top corner of the window on each side and make sure drain holes are on the bottom.

Your kit includes:

- Side windows - off and near side
- Rubber beading strip to cover rivets
- Paper Template (if purchased)
- Replacement rivets (if purchased)
- Silicone sealant (if purchased)
- Rear quarter lights (if purchased)
- Rear door glass (if purchased)



Removing Existing Factory-fit Windows

If your vehicle is fitted with original side windows, these will need to be removed.

For riveted type:

- Remove the outside rubber beading strip from your frame using your stylus knife or any screw driver. This should come off from the aluminium frame very easily.
- Drill off the rivet heads using your electric drill. Your frame will become loose
- Take out the aluminium window frames from both sides of your vehicle.

Clean the surfaces surrounding the aperture to remove any dirt or grease.

For bonded type:

- Use your stylus knife to cut the bonding between the frame and vehicle side panel. Eventually your frame will be loose and will come away from the vehicle body
- If in the process, the surfaces are dented or damaged, flatten them out as best you can.

Clean the surfaces surrounding the aperture to remove any dirt or grease.



Panel Vans – Cutting out the Aperture

If your vehicle is a panel van type - i.e. not fitted with original windows from the factory, you will need to cut out an aperture on the sides of your vehicle using our template.

Using scissors cut out the window aperture from the template. Make sure you are cutting for either 50/50 or 50/70 radius windows. Verify which side windows you have purchased from Masai!

Stick the template to the side of your vehicle using Blu-Tack or masking tape - making sure when doing the driver's side that the template says *Right Hand Side* at the top; when doing the passenger side it must say *Left Hand Side* at the top. Please refer to our template.

Parallel align the top of the paper template so that it just touches the rim of the roof all along its length.

Using a fine permanent marker pen accurately draw the section to be cut out following the inside edge of the template. You can then remove the template and attach it to the other side of your vehicle, by positioning as per the instructions on the template.

Using your drill take the heads off the rivets that hold the two struts inside the vehicle behind the template area, use a mallet to knock the struts sideways and remove them – they won't be needed any more. Get a drill and make a pilot hole within the middle of the marked section. Draw a line and a couple of curves to practice cutting along with the jigsaw before you start cutting the actual rectangular aperture.

Once you are confident you can cut out the aperture accurately, drill a hole for the blade near the marked line, within the marked area in the chosen place you want to start cutting. Make sure you are tall enough to reach the top part for cutting – if not get a sturdy box or chair to stand on.

When you start cutting, it is important to follow the line as best you

can within 1 mm tolerance – do not cut inside the marked area or else you will have a lot of filing to do. We recommend that you get an assistant to hold the other end of the cut-out section steady whilst you finish the final cutting. Lightly file the edges to remove burrs.

You may need someone to also help you offer up the windows to make sure they fit in the aperture and are parallel with the roof edge, if they aren't you simply file the relevant edges of the aperture so that the window fits neatly in.



Drilling out the aperture rivet heads.



Drilling a pilot hole ready for cutting.



Cutting out the panels.

Preparing Surfaces, Drilling Rivet Holes and Applying Silicone Sealant

Offer the side window to the side of the vehicle and drill the rivet holes by using 4 mm drill bit. You will need assistance from a friend who can hold the frame in the aperture whilst you are drilling the rivet holes. Clean all the excess aluminium from the frame and any burrs around holes on the vehicle.

Lay the first window on a table - so that the inside is facing up. Protect both table and the glass using the Masai cardboard box.

Clean the outside surfaces of the side of your vehicle surrounding the aperture and the window frame surface that will be bonded to the side of your vehicle.

Wearing latex gloves apply silicone sealant over the back of the replacement aluminium window frame where the rivet channels meet the edge of the cut out on the side of the vehicle.

Make a continuous line along and around the back of the frame. Make sure there are no gaps - particularly the top edge - to ensure no leaks.



Fitting the Windows

First priority is to make sure the top edge is parallel to the rim of the roof and the rear side is parallel to the vertical side of the vehicle.

Place the window on the side of the vehicle with a friend's help. Rivet the frame all the way around. 24 rivets on each side.

You may need to adjust some of the internal trim if necessary to fit around the window.

Now fit the rubber beading strip over the rivet heads in the channel starting at the bottom, making sure you do not stretch the rubber – if you stretch it, it may shrink over the years and a gap will appear.

Allow for an overlap of the rubber trim of 3mm and neatly cut off the surplus rubber trim. Gently squeeze the two ends into the channel so that the ends butt together tightly. See photo above. This trim is purely to cover the rivets and to make a nice finish.

Repeat the whole process for the other side of the vehicle.

Fitting The Rear Quarter Lights

Fitting Masai tinted rear quarter light windows is a lot simpler. Using an implement such as a large screwdriver, take out the window beading strip seal from the inside and remove the seal and glass from both sides of your vehicle.

Use the new seal kit provided for the rear quarter lights. The rubber seal has 3 different slots they are approximately 1 mm, 5 mm and 8 mm wide. Place the rubber seal on to the aperture where the 1 mm thin channel is.

Feed the rubber channel through the cut out. Once this is done, place the glass into the other side of the rubber channel-the wider side which is approximately 5 mm thick.

Once the glass is in situ, you will need to place the beading or locking strip provided through the wider part of the channel to lock the glass into its final position. The installation is now completed.

Customer Feedback

Your feedback is very important to us.


We would love to hear any suggestions or recommendations you may have about the Masai product range. If you have any feedback you think may help us improve the services or products we offer, then please use the details found on the reverse page of this booklet to contact us.

Thank you for choosing Masai.





Unit 5, Eastern Park, Eastern Avenue, Lichfield,
Staffordshire, WS13 7SY. United Kingdom.
Tel: +44(0)1543-254507 Fax: +44(0)1543-418665
Email: info@masai.co

www.masai  **.co**