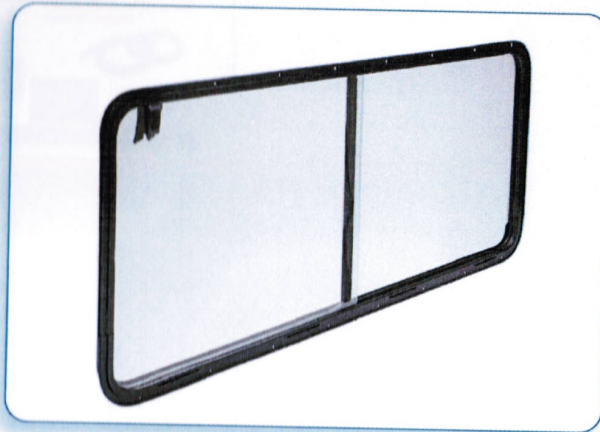


RUBBER WINDOW CHANNEL HARD TOP INSTALLATION GUIDE



Series-Defender Outfitters LLC • 6 Ashleigh Lane • Saratoga NY 12866
www.SeriesDefender.com • 202-656-9749 • sdo@seriesdefender.com

www.SeriesDefender.com



Our company was founded based on an enthusiasm for Land Rover vehicles, and helping to fill a void in upgraded factory parts as well as no longer available accessories. Our goal is to provide a substantial upgrade to originally under-designed Series and Defender parts, and enable your Land Rover to enjoy many more years of use and enjoyment...both on- and off-road.

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We have created a video supplement
to this installation guide which can be seen at:
www.youtube.com/channel/UCV4dwmlNdyXqE-LG2Vf3ngw

OR by searching
"Series-Defender Outfitters"
on YouTube.com



**READ ALL INSTRUCTIONS FULLY BEFORE
ATTEMPTING INSTALLATION**



What is Included:

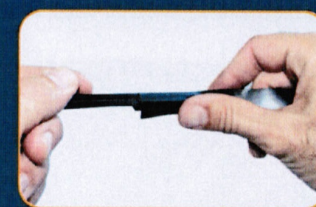
2 – 5ft long sections of rubber window channel
50 sealed POP® rivets
3M® Scrubbing pad
3 fl oz bottle of Goo-Gone®
Wooden width gauge disc
#2 Pozidriv ACR bit

What you will need:

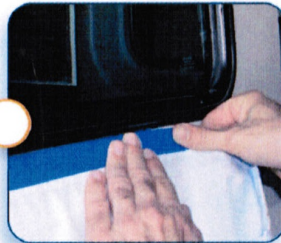
Power drill
5/32" metal drill bit
Universal screwdriver or power screw gun
POP rivet gun
Needle-nose pliers
Household scissors or snips
Utility knife
¾" electrical tape
Eye Protection
Paper towels or rags
Soap and water solution
Household cleaner / degreaser

BEFORE YOU BEGIN

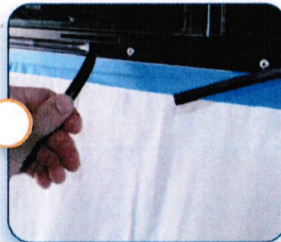
One aspect that can contribute to rattling windows in Defender vehicles is the amount play the sliding window glass has in the bottom plastic track. Before you remove the window from the vehicle, check the amount of play the glass has from side-to-side within the plastic track. Later in the installation you can limit the amount of play while still maintaining the sliding characteristics of the window by removing the plastic track from the frame and affixing ¾"-wide electrical tape to one side of the track in-between the drainage slots. This will reduce the tolerance slightly while still allowing the glass to slide freely in the track. You can experiment with this later on in the process.



1) Affix drop cloth to side of vehicle to prevent metal shavings from accumulating on the body work.

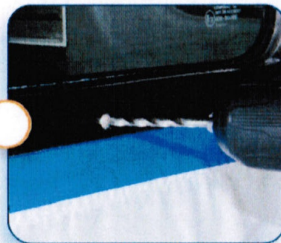


2) Remove rubber trim around perimeter of frame.



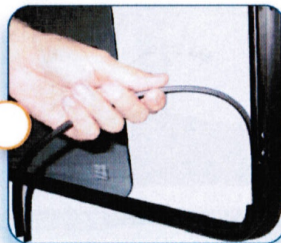
!! Wear Eye Protection !!

3) Using a 5/32" drill bit, drill out all rivets around perimeter of window frame and remove window.

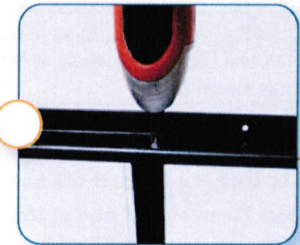


Be sure to keep the drill straight as to not bore out the holes.

4) Remove the rubber channel cover at each end of the window.

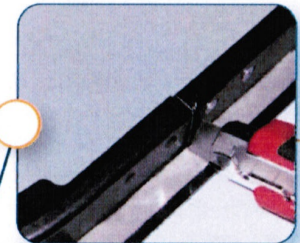


5) Using the supplied Pozidriv bit, remove the single screw on the top of the frame that connects the center pillar.



Do not remove the corresponding screw on the bottom of the frame.

6) Using a utility knife, slice the foam weather seal at each end of the window frame where the upper and lower frame sections meet.



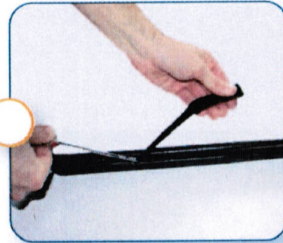
7) Remove the two screws at each end of the window frame.



8) Disassemble upper and lower frame sections and remove sliding window.



9) Remove old felt from frame channel. A small, flat-head screwdriver can be helpful here.



10) Using the supplied 3M® scrubbing pad and Goo-Gone®, remove all of the old felt and grime from inside of the window frame channel.



NOTE: The longer the Goo-Gone® is left to soak, the easier it will be to remove the residue; 1 hour or more is best.

Final Prep

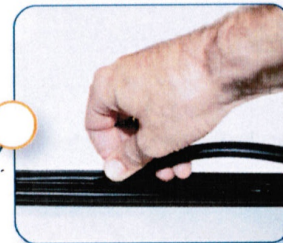
11) Using a household cleaner / degreaser, remove all remaining oils from the Goo-Gone®.



NOTE: Window channel must be completely dry and free of oils before installation of rubber extrusion.

WARNING!

Do NOT cut rubber extrusion to line up with the seam between the upper and lower frame sections! Leave in one piece until after the frame has been re-assembled.



12) Beginning at the back of the sliding window frame channel, work the rubber extrusion deep into the channel along the entire horizontal length.

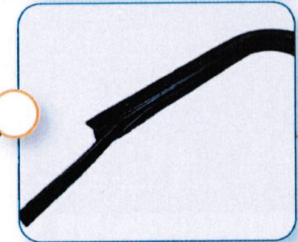


13) Using needle-nose pliers and working 2-3 inches at a time, 'rake' the rubber extrusion into the window channel by applying downward pressure allowing the tapered shape of the pliers to exert outward pressure to seat the rubber in place.

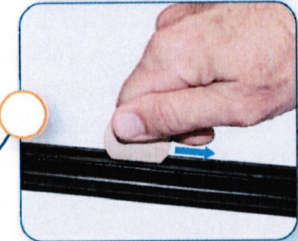
14) Using the supplied wooden disc, work the rubber extrusion into the corner by applying downward pressure while rolling the disk back and forth and rocking it side to side.



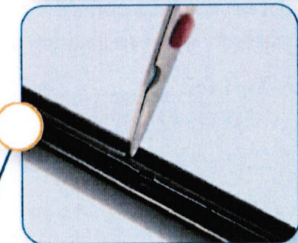
15) Continue installing the remainder of the rubber extrusion into the frame and leave the slack hanging out of the end of the frame section.



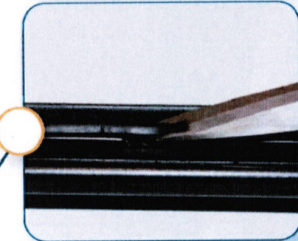
16) As a final check, drag the wooden disc through the entire channel looking for any spots where the extrusion has not seated properly and adjust if necessary.



If the disc slides cleanly through the channel then there is more than enough room for the window glass.



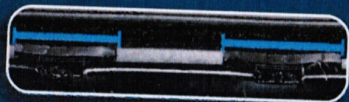
17) Using scissors or snips, slice the upper flange of the rubber extrusion to either side of the window lock notches in the frame.



18) Cut off the upper flange over the notches in the frame.

Options for the Window Lock Notches in the Frame

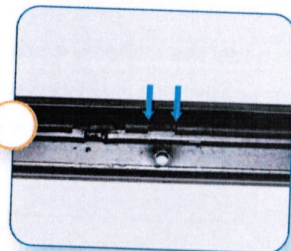
A. You may choose to cut individual notches in the rubber extrusion to match the notches in the frame as shown in the image below; however you will need to hold the window lock in the open position as you slide the window back and forth.



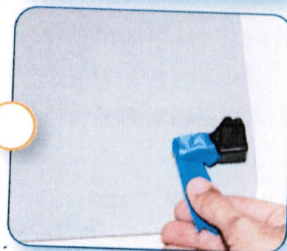
B. If you prefer to let the window lock tab drag along the frame in-between the notches, then you can cut off the upper flange along the entire length between the first and last notches.



19) Cut out a notch just either side of the hole in the center of the upper window frame section. This is to stop the center pillar from pushing on the upper flange which will reduce the clearance for the window glass.

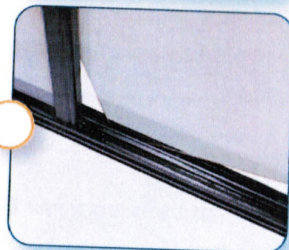


20) Using tape or a rubber band, secure the window lock in the open position. This makes for easier re-assembly of the window frame.

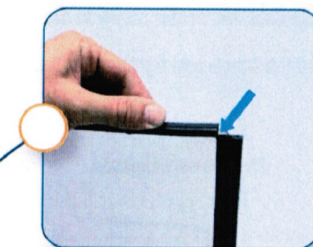


See "Before You Begin" at the start of these instructions before completing the next step

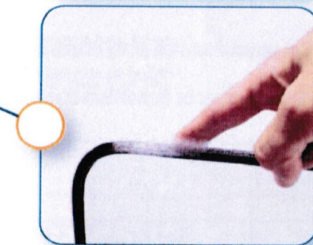
21) Set the sliding window glass back into the track in the bottom frame section.



22) Replace the rubber seal around the perimeter of the fixed window glass stopping just before the center pillar.



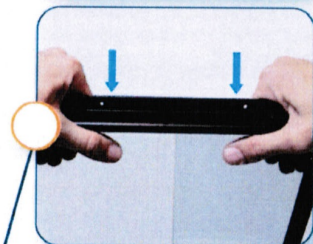
23) Apply soapy water along the entire length of the rubber seal on the fixed window glass.



24) Insert the windows into their corresponding tracks in the upper frame section and re-assemble the upper and lower sections at each end of the frame.



Be sure to leave the slack of the rubber extrusion hanging out the end.



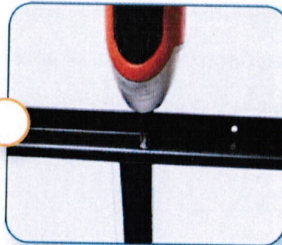
25) Push down hard on the upper frame above the fixed glass to be sure it is fully seated.



26) Replace the screws at each end of the frame and tighten.

27) Replace the center screw in the top of the frame and tighten.

Do not overtighten



28) Set remainder of rubber extrusion into lower corner of frame and trim for best fit to meet up with plastic track.



29) Replace the rubber channel cover at each end of the frame.



!! Wear Eye Protection !!

30) Return window to vehicle and rivet in place using the supplied rivets.



31) Replace rubber trim around perimeter of frame.



Repeat Steps 1-30

for second window.



WARRANTY

Series-Defender Outfitters Replacement Rubber Window Channel comes with a 1-year replacement warranty.

In the unlikely event your rubber window channel rips, tears, or is damaged in any way that prevents the windows from functioning properly, simply contact us at

sdo@seriesdefender.com for an RMA# and return, postage-paid, the entire length that contains the damage. We will return to you a brand new piece of the same length (plus extra to trim for best fit) and we will cover the shipping cost of the new piece (US Parcel Post only, including tracking number).

Please provide a tracking number for the piece being returned as we cannot provide a replacement if we do not receive the damaged item. Please allow 7 days after we receive your item for processing.

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