



INSTRUCTIONS

Product: Acrylic Rear Window

Models: All

(For model shown below only)



Subject: Rear Window Installation Instructions

Estimated Completion Time: .25 Hour

Parts: See Page # 5, & 6

REQUIRED TOOLS & SUPPLIES:

(1 Pair) Safety Glasses	(1) 10oz Hammer
(1) Drill	(1) Scissors
(1) Ø5/32" Drill Bit	(1) 6" Rule or Tape Measure
(1) Pencil	(1) 2 Ft. Step Ladder
(1) # 2 Phillips Screw-driver	(1) Craftsman 2-1/2" Handi-Cut or Hacksaw
(1) Unibit	

The following instructions are for installing the rear acrylic window to all models of GEM vehicles. To install the rear window, proceed as follows.

1. Remove and discard rear roof strip. (See Fig # 1)

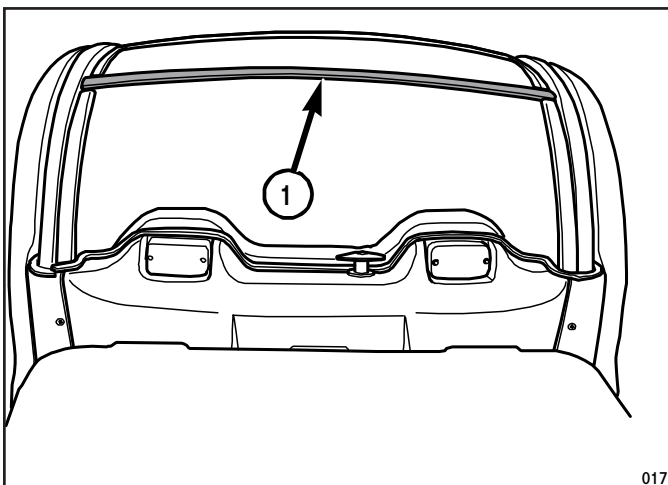


Fig. # 1 Remove and discard rear roof strip

2. Prepare the rear window assembly by attaching (Qty. 2) strips of vinyl foam approx. (13.5" per side for 2 Passenger) and (12.5" per side for the 4 passenger vehicle) to the inside of the rear window assembly as (Shown in Fig. 1, 2 , & 3)



Fig. # 2 Install vinyl foam

3. Cut vinyl foam to length. (See Fig. # 3)



Fig. # 3 Cut vinyl foam to length.

4. Remove backing from vinyl foam. (See Fig. # 4)



Fig. # 4 Remove backing from vinyl foam

5. Place rear window assembly in place and mark the seal at both sides where it is to be cut. (See Fig. # 5)



Fig. # 5 Mark the seal where it is to be cut

6. Cut the seal with a pair of scissors at both sides of the window at the pre-marked locations. (See Fig. # 6)



Fig. # 6 Cut the seal at the marked location

7. Install the window by first inserting the seal edge of the window first. Tuck the seal under the rear roof support. (See Fig. # 7)



Fig. # 7 Install window seal edge first

8. Note that the window seal lays underneath the rear roof support. (See Fig. # 8)



Fig. # 8 Window seal properly installed

- With a $\text{Ø}5/32$ " drill bit, drill (Qty. 4) holes into the roof rails at the locations provided by the 4 holes in the acrylic window. Attach rear window assembly with (Qty. 4) # 10 X $3/4$ self tapping screw and (Qty. 4) neoprene washers. (See Fig. # 9)



Fig. # 9 Attaching window to roof rails

NOTE: Do not compress the vinyl foam or neoprene washers when tightening the screws.

- Use a Handi-Cut to cut the molding to the proper length. Approx. 15.0" for a two passenger GEM and approx. 13.0" for a four passenger GEM. The side molding should be cut long enough to cover the acrylic part of the window only.
- Place the rear window side moldings in place, tap the molding with a hammer at the screw locations which will make an impression on the underside of the molding, indicating the location to be drilled to $\text{Ø}1/2$ ". (See Fig. # 10, & 11)



Fig. # 10 Tap molding with hammer

- Peel backing from molding and apply to window. Screw heads should be seen at the $\text{Ø}1/2$ " holes previously drilled. (See Fig. # 11)



Fig. # 11 Side molding installed correctly

- Install the top rear window molding (approx. 38.00"). Cut molding to the proper length with a handi-cut tool.



Fig. # 12 Install top molding

14. From the inside of the vehicle, push the rear window seal outward to form a tight seal. (See Fig. # 13)

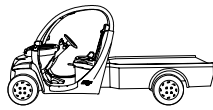


Fig. # 13 Push seal outward to form a tight seal

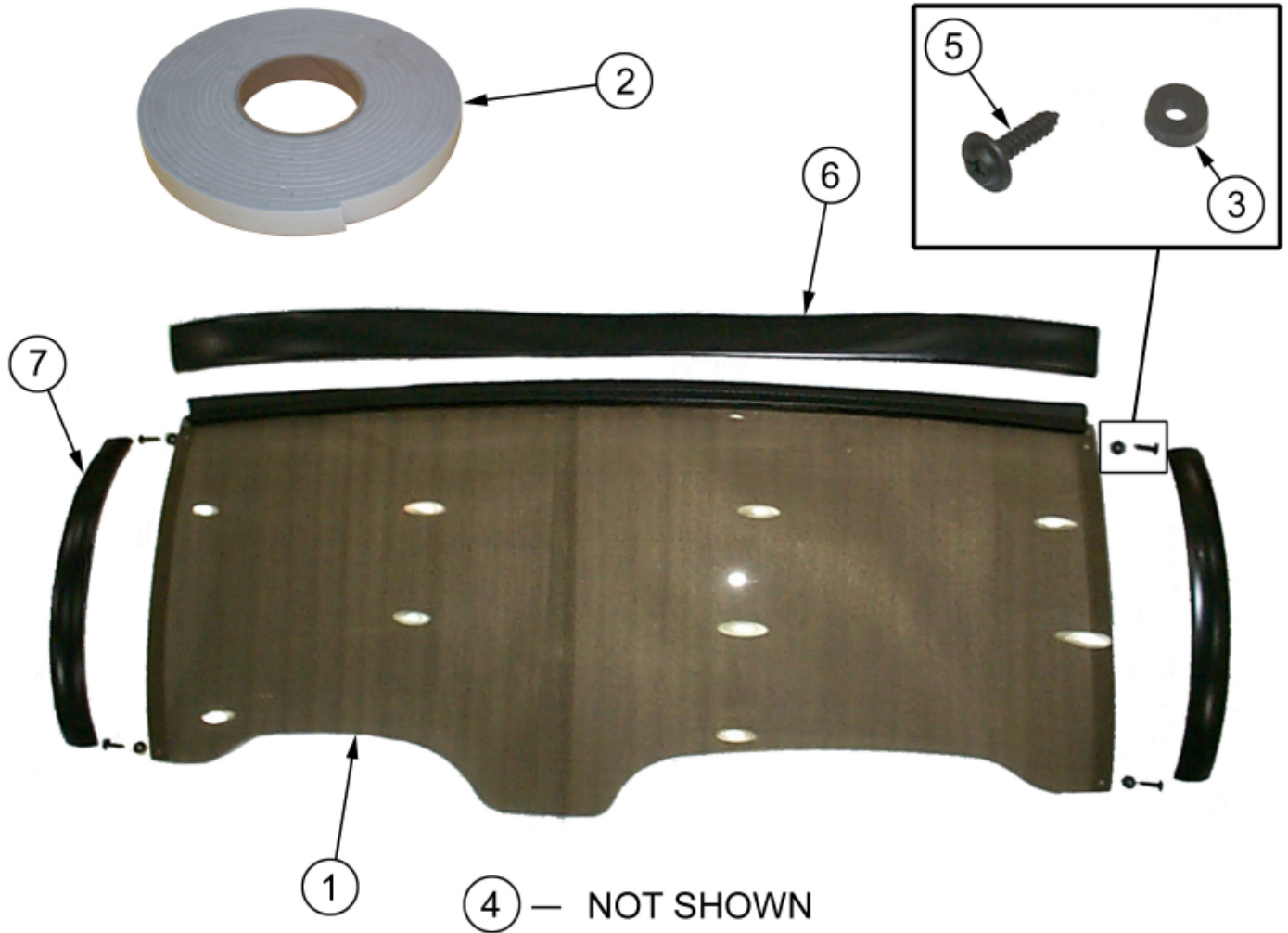
15. Installation complete.



Fig. # 14 Installation complete



PARTS - 2 PASSENGER, SHORT BACK, & LONG BACK ONLY

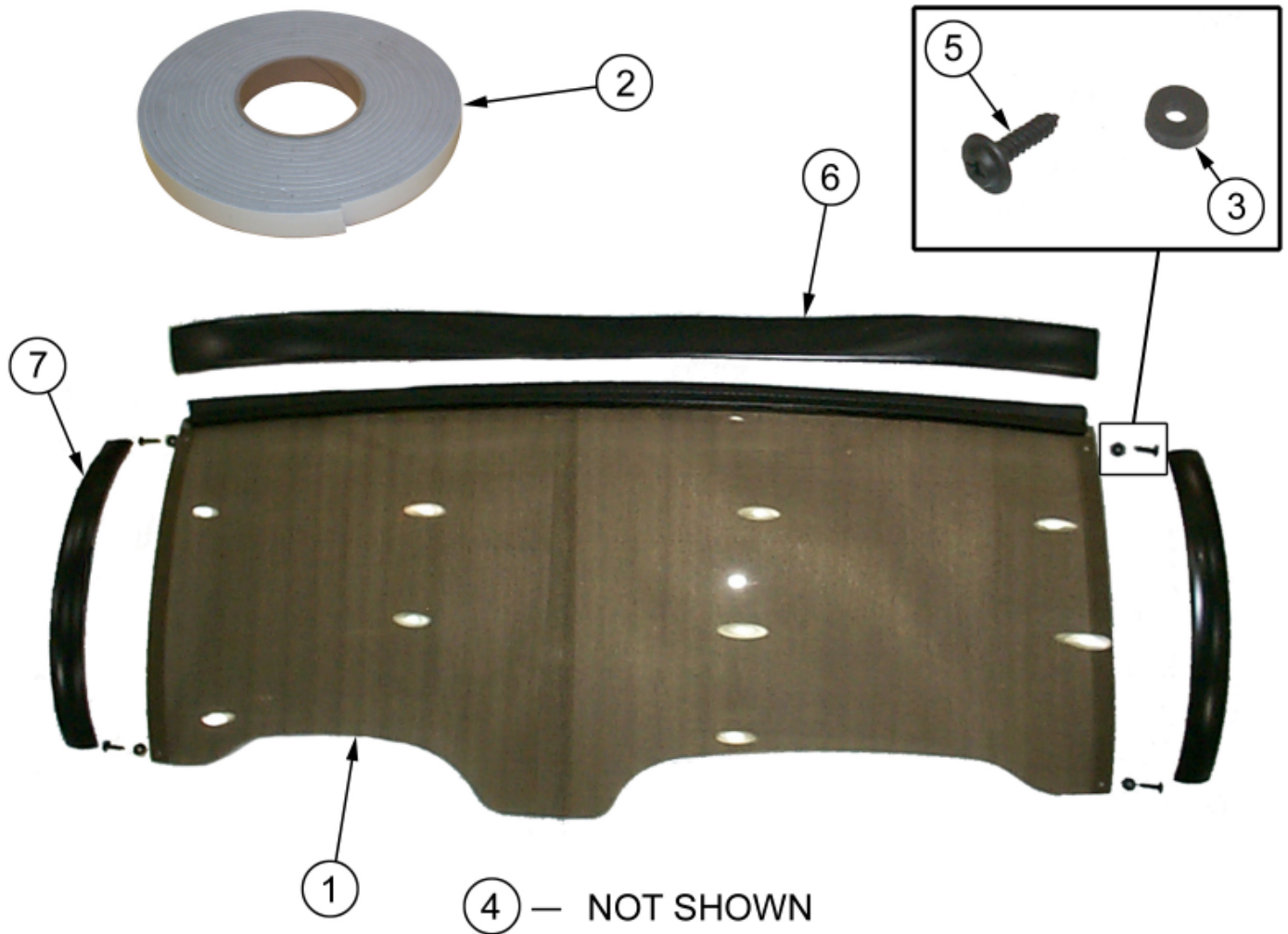


0105-00958 ASSY, REAR WINDOW - 2P HARD DOOR-SERVICE

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>QTY.</u>
1	0105-00651	ASSY, REAR WINDOW- 2 PASS	1
2	0317-01081	STRIP, VINYL - FOAM - 13.5"	2
3	0524-00324	WASHER, FLAT - NEOPRENE - 0.5" OD - 0.18	4
4	1010-00091	INSTRUCTIONS, ACRYLIC REAR WINDOW INSTALLATION	1
5	0523-00308	SCREW, REAR WINDOW MOUNTING	4
6	0317-00935	MOLDING, REAR WINDOW, TOP - 38"	1
7	0317-00936	MOLDING, REAR WINDOW, SIDE - 15"	2



PARTS - 4 PASSENGER ONLY



0105-00959 ASSY, REAR WINDOW - 4 PASS HARD DOOR - SERVICE

ITEM	PART NO.	DESCRIPTION	QTY.
1	0105-00628	ASSY, REAR WINDOW- 4 PASS	1
2	0317-01081	STRIP, VINYL - FOAM - 13.5"	2
3	0524-00324	WASHER, FLAT - NEOPRENE - 0.5" OD - 0.18	4
4	1010-00091	INSTRUCTIONS, ACRYLIC REAR WINDOW INSTALLATION	1
5	0523-00308	SCREW, REAR WINDOW MOUNTING	4
6	0317-00935	MOLDING, REAR WINDOW, TOP - 38"	1
7	0317-00936	MOLDING, REAR WINDOW, SIDE - 15"	2

ADDITIONAL INFORMATION

If you have any questions or need assistance in completing this action, please contact GEM Technical Support at 866.764.0616

Remember to record the last six digits of your Vehicle Identification Number (V.I.N.) in the space provided below before calling. Use (Fig. # 15 & 16) to locate the V.I.N. plate.

V.I.N. _____

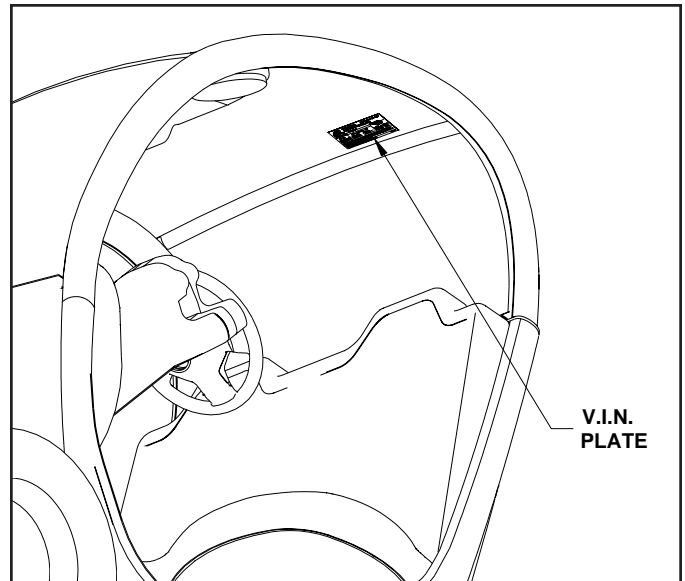



Fig. 15 V.I.N. plate location

		MANUFACTURED BY: U.S. Patent No. Des. 419,107 Global Electric Motorcars, LLC.	
		Web: www.gemcar.com	
GVWR: 953KG (2,100 LBS.)		DATE OF MFG: 1/5/01	
GAWR		TIRE - DIMENSION - RIM	
Front 468KG (1,023 LBS)	165/70R-12 T12x4J	COLD INFLATION PRESSURE	
Rear 468KG (1,077 LBS)	165/70R-12 T12x4J	KPA/PSI 207KPA (30PSI)	SGL/DUAL SINGLE
		207KPA (30PSI)	SINGLE
THIS VEHICLE CONFORMS TO ALL APPLICABLE U.S. FEDERAL MOTOR SAFETY, BUMPER, AND THEFT PREVENTION STANDARDS (FMVSS) IN EFFECT ON THE DATE OF MANUFACTURE SHOWN A			
V.I.N. XXXXXXXXXXXXXXX XXXX			
TYPE OF VEHICLE: _____			U.S. VIN

 LAST SIX NUMBERS OF V.I.N.

Fig. # 16 V.I.N. use last six numbers



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A DaimlerChrysler Company

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