

# 1954-67 FRONT SAFARI FITTING INSTRUCTIONS

Thank you for purchasing our Safari Windows. It is important to read and understand these fitting instructions before you start the installation.

## Trial fit before installing.

Please offer the frames to your bus **BEFORE** you glaze or paint them. This allows you to check the fit of our frames in your bus. If your bus has a perfect aperture that has never been repaired due to rust or accidents you should have no problems with fitment. If you have had repairs and they have retained the factory size, you should also not have any problems. If your bus has been repaired and the aperture is distorted in anyway, the damage will show up immediately. We will not accept returns and offer refunds if the frames have been painted, glazed or damaged. This includes scratches so please handle with extreme care.

Hold our frames up to the top of the window aperture and with them centred left to right you should have a gap of approximately 4-5mm on both vertical sides and at the top. The gap at the bottom is larger at approximately 5-8mm. On buses without a pressed hinge recess, the gap at the bottom will be reduced by approximately 2mm. The larger gap at the bottom is normal. (see our detail notes). If you are happy with the fit you can proceed. If you have a fitment problem please measure your aperture using our Dimension Check Diagram and then call us for advice.

## Continuing with the Installment.

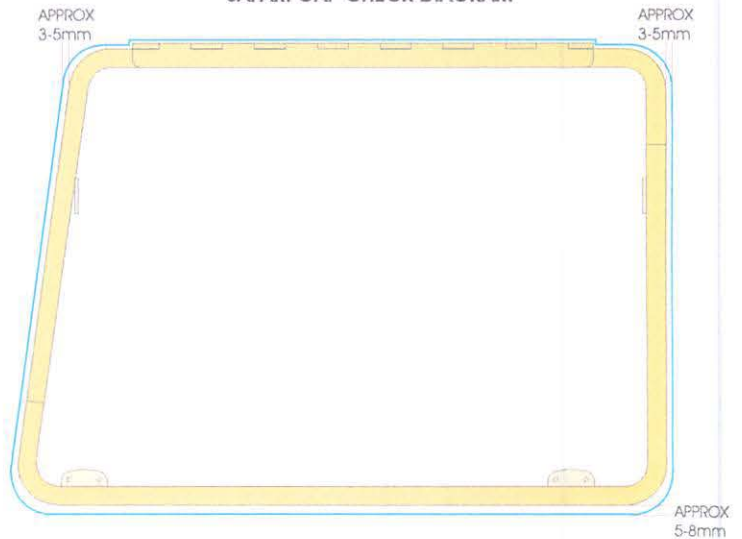
We recommend you install both frames without glass and remove them afterwards for painting and glazing. If your safaris were supplied by us in black primer, they have been acid etched and had a coat of 2k primer. They should be keyed with Scotch pad, primed and finally top coated.

**DO NOT POWDER COAT YOUR SAFARIS OR EXPOSE THEM TO EXCESSIVE HEAT.** We glue and screw the two slide brackets onto the frame and whilst the screws will keep the brackets in position, the excessive heat used powder coating them could damage the bond. It is perfectly OK to use 2pack paint that is cured in a low bake oven.

APERTURE CHECK DIAGRAM



SAFARI GAP CHECK DIAGRAM



## CE Safari Observations.

25 years ago Creative were loaned an absolutely pristine NOS set of Original VW Front Safari windows that had never been fitted. They were too valuable as a museum piece to actually use so we replicated them and gave the owner a new pair to use in his bus in payment of the loan. We built our master Jig around the NOS frames. We also currently have 5 original VW Safari Windows that are solid and straight that we have acquired over the years that we also use for reference. Its interesting to note that no two are exactly the same even though they are original. This would indicate several similar but not identical sets of tooling were used to cope with supply.

We have fitted these reference windows into several of our own builds to check aperture fit.

It is normal for the two vertical side gaps to be between 4-5mm, with the lower gap at the base of the frame being larger at 5-8mm. see diagram. This is not a mistake but how they were. This lower gap can of course be different again if the front sheet metal on your bus has been repaired and no longer is factory size. Please check your bus aperture against our diagram.

Just to complicate matters, not all buses produced had a recess for the hinge to locate in. Original and our Safaris will fit buses with or without the recess. The buses without the recess can on occasion make it necessary to remove around 1mm off the lever catches on either side of the centre post. This is not unusual on Brazilian or Knock down Kit buses from other countries.

We have also discovered that its not uncommon for your body to have dissimilar size aperture ie the one on the left is different from the one on right. You can test this by fitting your right Safari into the left aperture. The gap will differ if your body has either been damaged or just welded slightly out of shape. There were no computers used on the production line.

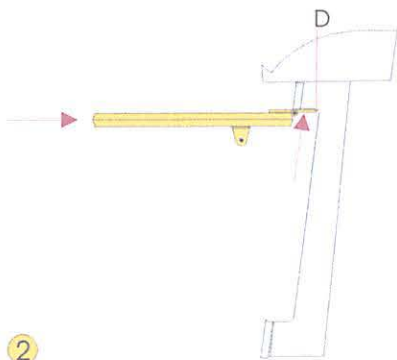
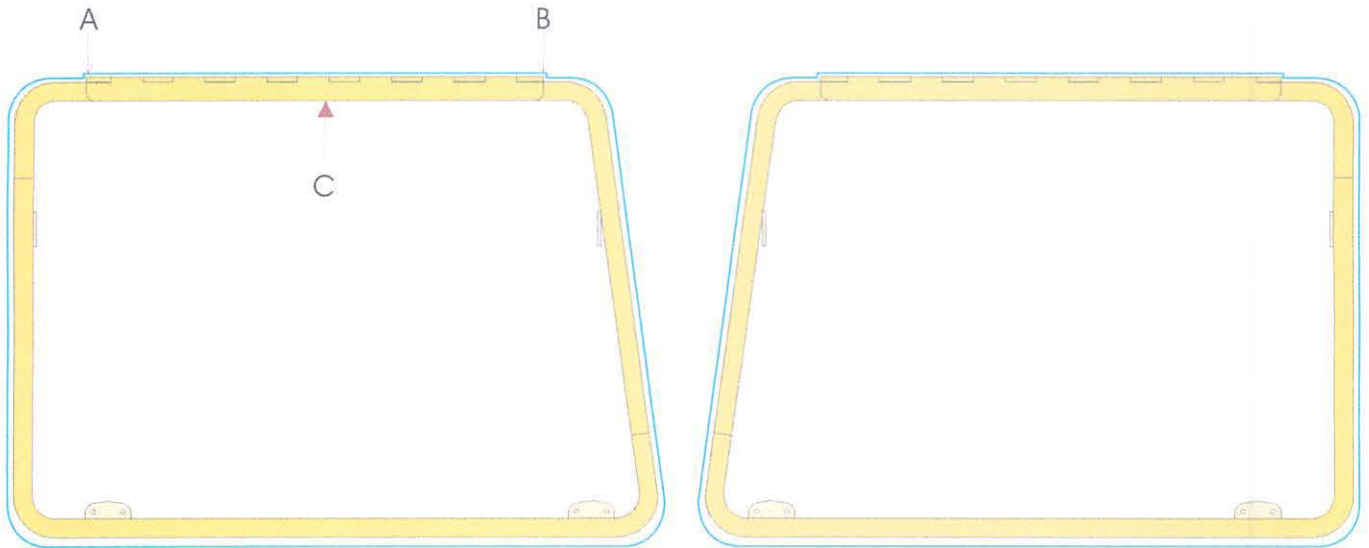
To surmise, we check every frame we make in our master and secondary production jigs for fit. We have a maximum tolerance of +/- 1mm on our frames in our jigs. That's 0.5mm at the top and 0.5mm at the bottom of a frame. That's a tighter tolerance than the original VW frames we own !! Its this attention to detail and 25 years of production that makes our Safaris the best available.

Our frames are CNC machined for tight tolerances and **EVERY** frame is checked in two jigs before they are offered for sale so we are confident our frames are accurate.

**WE RECOMMEND THAT YOU INSTALL THE FRAMES BEFORE YOU FIT THE GLASS. NO RETURNS WILL BE ACCEPTED ONCE FRAMES ARE GLAZED.**

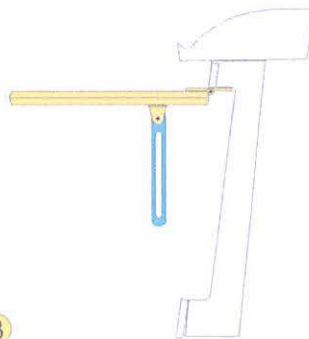
**1**

Move the frame left and right until you have equal clearance on both the left and right hand sides. Carefully make a small mark on the body with a fine felt pen at points A & B. These marks will allow you to reposition the frames in the same spot after glazing them. Be sure to keep the hinge pushed upwards against the body whilst marking. (C)



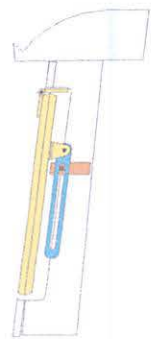
**2**

With the window centred on the marks A & B, carefully open the Safari ready to scribe through the holes in the hinge. Before you scribe the hole positions, be sure to push the window into the aperture so that the hinge "bottoms out" at the back of the recess D. Keeping the frame centred on A& B, scribe the hole locations. Drill the holes using a 2mm drill bit. When you have drilled them all, open up to 2.5mm.



**3**

With the window secured with screws, attach the slides to the bracket on the frame. Use the nylon washers provided on either side of the slide and do not over tighten the bolt so the slide can swing freely.



**4**

With the window secured and the slide attached, you can now fit the body brackets. Place the wing bolt through the slide and loosely into the body bracket. Move the bracket up the slide to the top of the slot. This is the position where the body bracket can be fixed. Repeat other side. The body bracket is best welded but will be ok if screwed or rivetted to your door.

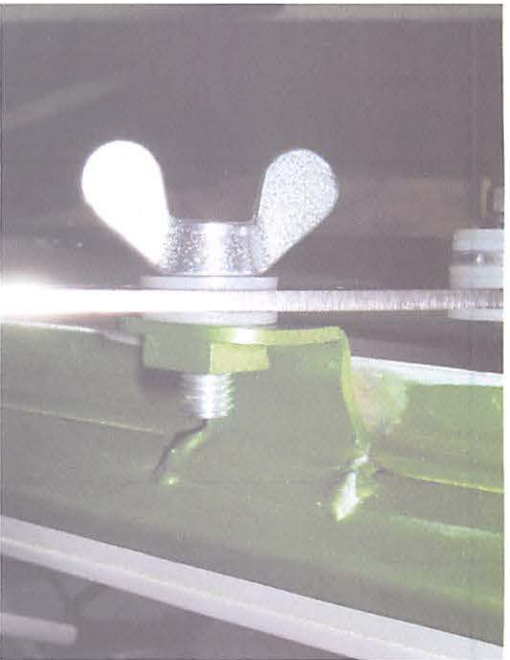
Remove window and glaze. Before fitting the rubber seal onto the glass, place the rubber seals in hot water or warm with a heater for 10 minutes. When warm quickly dry and install Rubber Glass Seal by starting dead centre at the top of the glass. Do not use lubricant when stretching the seal over the glass.

With the frame separated, fit the lower Frame onto the glass having first sprayed some Wd40 Maintenance oil on all three sides of the rubber. Every part of the rubber must be wet with oil. When fitted perfectly repeat on the top frame.

Work round the aperture with the body seal being sure to push the seal fully on to the steel lip. Use a small wooden or nylon hammer if needed. Trim the seal.

Install the glazed window. Original factory instructions show the catches fitted with the levers pointing away from each other. With the catches on the frame, position the catch clips underneath the catches, mark through holes, drill and secure. (They should be close to the rubber seal)

The "one eyed duck" fits on the buses centre line on the curved lower part of the front panel. Your installation is now complete.



Outer body bracket detail



Outer catch detail



Duck fitment



Wiper disengager detail