WORK INSTRUCTION OVERVIEW

WARNING

- DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.
- Do not rely, in any way, on the components of this product to protect against injury or death in the event of an accident.
- Make sure all fasteners are torqued and properly tightened. Failure to do so could result in dislodged windshield and/or loss of control of the vehicle.
- Read and follow all instructions provided when installing this product. Failure to do so may result in a poor fit and could place occupants at risk of serious injury or death.
- To protect bystanders and the service technician(s), shut vehicle off; remove key; place vehicle in gear and APPLY PARKING BRAKE to prevent vehicle from rolling.
- Never operate the vehicle in excess of manufacturer’s specifications.

NOTICE

- To clean windshield, wash gently with mild soap or detergent, using a soft cloth or sponge. Dry to prevent water spotting.
- Do not use scrub brushes or squeegees.

THIS INSTALLATION PROCEDURE IS BROKEN INTO 3 SEQUENTIAL SECTIONS

1. Install the Front Header Panel Kit - P/N 2303CUA00031N
2. Install the Windshield Assembly Kit - P/N 0111AUA00071N (Sold Separately)
3. Install the Full Soft Cab Enclosure Kit - P/N 0117AUA00021N

TOOLS REQUIRED

- T30 Torx Bit
- T40 Torx Bit
- 1/4” to 3/8” Drive Adapter
- 13 mm Socket
- 14 mm Socket
- 14 mm Wrench
- 3 mm Allen Wrench
- Drive Ratchet
- Drive Torque Wrench
- Extension
- 3/8” Socket
- 3/8” Wrench
- 8 mm Socket
- Pliers-Snips
- Protective Eye-wear
- Safety Step Ladder (Optional)

TORQUE SPECIFICATION

Tighten each Windshield fastener to the torque specification below:

- M8 Bolts – 24.5 N•m (±3.5) - 18 ft lb (±3)
- M6 Screws – 5 N•m (±1) - 66 ft lb (±9)

FRONT HEADER PANEL KIT

Kit Number - 2303CUA00031N

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Front Header Panel</td>
<td>PN-2303CUA00031N</td>
<td>1</td>
</tr>
<tr>
<td>Nylon Tie Straps 530 mm x 8.9 mm</td>
<td>PN-0000AUA00471N</td>
<td>12</td>
</tr>
<tr>
<td>M6 U-Nuts</td>
<td>PN-0000AUA00881N</td>
<td>5</td>
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</tbody>
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INSTALLATION PROCEDURE

Install Front Header Panel

1. Install Front Header Panel over front upper ROPS as shown.
2. Install (12) zip ties thru holes in Front Header Panel then wrap all zip ties around upper ROPS bar before tightening them.

3. Begin tightening zip ties from the middle outward. Secure all (12) zip ties before snipping off the loose ends.

4. Install (5) U Clips to hole positions on Header Panel as shown.

**WINDSHIELD INSTALLATION PROCEDURE**

1. Cut foam seal along perforations into lengths specified.
   a. #1 and #8 to 6.75" (170 mm) ea.
   b. #2 and #7 to 9.50" (240 mm) ea.
   c. #3 and #6 to 29.50" (750 mm) ea.
   d. #4 and #5 to 1.00" (25 mm) ea.

2. Install #1 and #8 between Windshield Assembly Step and lower side ROPS Clamp. Press down while installing seal to ensure proper adhesion.

**WINDSHIELD KIT**

Kit Number - 0111AUA00071N

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Windshield Assembly</td>
<td>P/N-0111AUA00111N</td>
<td>1</td>
</tr>
<tr>
<td>Roll-Over Protective Structure (ROPS) Adjustable Clamp</td>
<td>P/N-0000AUA00021N</td>
<td>5</td>
</tr>
</tbody>
</table>
3. Install remaining seal material to back side of Windshield Assembly along outer edge of frame leaving a 2’ gap where holes are as shown.

4. Remove (4) 8 mm bolts, two from each side of Windshield Base. Retain bolts for later use, Windshield Base is no longer required.

5. Loosely secure (2) ROPS Clamps to “A Pillar” ROPS one on each side.

6. Install Windshield Assembly aligning lower bolt holes with weld nuts on lower ROPS, then loosely install Windshield Assembly using (4) 8 mm bolts removed previously.

7. Line-up ROPS Clamp to lower hole on Windshield. Using (2) 6 mm Screws, loosely install side rails for Soft Enclosure on outside surface of Windshield as shown, on both sides.

8. Loosely Install Top Rail to Windshield Assembly with (3) 6 mm Screws with flat side facing up.
9. Torque (7) T30 Screws around Windshield Assembly and (4) 8 mm Bolts at Windshield Assembly bottom to specifications.

### FULL SOFT CAB ENCLOSURE KIT

Kit Number - 0117AUA00021N

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
<th>Qty</th>
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<tbody>
<tr>
<td>Top Deck Assembly (includes Center and Rear Bow)</td>
<td>P/N - 569.60</td>
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<tr>
<td></td>
<td>P/N-0117AUA00041N</td>
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<tr>
<td>Rear Window Panel</td>
<td>P/N - 569.59</td>
<td>1</td>
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<tr>
<td></td>
<td>P/N-0117AUA00051N</td>
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<tr>
<td>Left Door Assembly (includes Wire Door Frame)</td>
<td>P/N - 569.45</td>
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<tr>
<td></td>
<td>P/N-0117AUA00061N</td>
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<tr>
<td>Right Door Assembly (includes Wire Door Frame)</td>
<td>P/N - 569.44</td>
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<tr>
<td></td>
<td>P/N-0117AUA00071N</td>
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<tr>
<td>Left Quarter Window</td>
<td>P/N - 569.57</td>
<td>1</td>
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<tr>
<td></td>
<td>P/N-0117AUA00081N</td>
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<tr>
<td>Right Quarter Window</td>
<td>P/N - 569.58</td>
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<td></td>
<td>P/N-0117AUA00091N</td>
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<tr>
<td>Front Bow Assembly</td>
<td>P/N - 566.06</td>
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<td></td>
<td>P/N-0117AUA00101N</td>
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**Rear Bow Assembly**
- P/N - 570.23
- P/N-0117AUA00111N

**Door Hinge - Outer**
- P/N - 569.53
- P/N-0117AUA00201N

**M8 Button Head Flange Screw**
- P/N - 586.78

**M6 Flat Washer**
- P/N - 536.56

**M6-1 x 30 Socket Cap Bolt**
- P/N - 440.67

**M6-Nylon Lock Washer**
- P/N - 434.11

**M6-1 x 30 Button Head Screw**
- P/N - 517.48

**Strap Assembly**
- P/N - 574.24
## Work Instruction: Install ROXOR Soft Cab Enclosure

### Soft Cab Enclosure (P/N 2302FUA00061N)

<table>
<thead>
<tr>
<th>Kit Component</th>
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<th>Qty</th>
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</thead>
<tbody>
<tr>
<td>QUICK SLIP 1&quot;- Strap Keeper</td>
<td>P/N - 338.24</td>
<td>3</td>
</tr>
<tr>
<td>Bracket Assembly - Bow End Band</td>
<td>P/N - 570.19&lt;br&gt;P/N-0117AUA00121N</td>
<td>2</td>
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<tr>
<td>Bracket Assembly - Bow End</td>
<td>P/N - 570.18&lt;br&gt;P/N-0117AUA00131N</td>
<td>2</td>
</tr>
<tr>
<td>Upper Windshield Channel Bracket</td>
<td>P/N - 570.15&lt;br&gt;P/N-0117AUA00141N</td>
<td>1</td>
</tr>
<tr>
<td>Side Windshield Channel Brackets</td>
<td>P/N - 570.13 (Left)&lt;br&gt;P/N-0117AUA00151N&lt;br&gt;P/N - 570.14 (Right)&lt;br&gt;P/N-0117AUA00221N</td>
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<tr>
<td>Press In Plastic Rivet</td>
<td>P/N - 317.71</td>
<td>2</td>
</tr>
<tr>
<td>Belt Rail 'C' Clamps</td>
<td>P/N - 569.50&lt;br&gt;P/N-0117AUA00161N</td>
<td>8</td>
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<tr>
<td>Tailgate Brackets</td>
<td>P/N - 569.51 (Left)&lt;br&gt;P/N-0117AUA00171N&lt;br&gt;P/N - 569.52 (Right)&lt;br&gt;P/N-0117AUA00231N</td>
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<thead>
<tr>
<th>Kit Component</th>
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<tr>
<td>Side Belt Rails</td>
<td>P/N - 569.54&lt;br&gt;P/N-0117AUA00181N</td>
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<tr>
<td>Belt Rail Corner Brackets</td>
<td>P/N - 231.90 (Left)&lt;br&gt;P/N-0117AUA00191N&lt;br&gt;P/N - 570.08 (Right)&lt;br&gt;P/N-0117AUA00241N</td>
<td>1 EA.</td>
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**INSTALLATION PROCEDURE**

**Install Belt Rail Attachments**

1. Install the Belt Rail Brackets in the positions shown.

2. Install R & L Tailgate Brackets as shown and secure with (2) Press In Plastic Rivets (P/N - 317.71).

3. Install R & L Belt Rail Corner Brackets over the Tailgate Brackets. The right side bracket is slightly longer than the left side.

4. Install R & L Side Window Channel Brackets over the Belt Rail Corner Brackets.

5. Install R & L Side Window Channel Brackets over the Door Assembly Brackets. Parts included with door assembly.

6. Install the Belt Rail ‘C’ Clamps over each junction of the Belt Rail Brackets. Secure with (P/N - 440.67) to 13.5 N•m (±2.7) - 10 ft lb (±2).
Install Windshield Channel Brackets

1. Mount the (3) Window Channel Brackets to the existing Windshield Clamps, and the U-Nuts supplied with the Front Header Panel. Secure with (5) Button Head Screw (P/N - 517.48) and torque to 13.5 N\(\cdot\)m (\(\pm 2.7\)) - 10 ft lb (\(\pm 2\)).

Install Full Soft Cab Enclosure

1. Make sure the Center Bow is **not** attached to the Top Deck Assembly. Then slide the Top Deck Assembly into the top Window Channel Bracket as shown. Center the Top Deck Assembly with the Windshield and flip the deck over the top of the ROXOR.

2. Begin securing the Top Deck Assembly by wrapping the (4) hook and loop flaps around the side and rear ROPS bars.

3. Finish securing the Top Deck Assembly by routing the strap on the driver’s side, through the buckle (as shown) on the passengers side. Adjust top and tighten strap as required to help center.

4. Install the Center Bow Assembly making sure it is above (and resting on) the ROPS. Then secure by wrapping the hook and loop around the front bow only.
5. Mount the Rear Bow roughly an inch behind the upper B-Pillar Cross-Car ROPS bar using the fasteners listed below and torque to 13.5 N•m (±2.7) - 10 ft lb (±2).
   a. M6-1 x 30 Button Head Screw (P/N - 517.48)
   b. Tube Clamp Assembly (P/N - 570.19)
   c. Bow End Assembly (P/N - 570.18)

6. Attach the Door Hinges to the Door Frames with the step or bend facing up and away from the Door. Use the fasteners listed below. It may be necessary to punch holes in soft cab material.
   a. M6 1 x 30 Button Head Screw (P/N - 517.48)
   b. M6 Flat Washer (P/N - 536.56)
   c. M6-Nylon Lock Washer (P/N - 434.11)

7. Slide the front window edge of a Door Assembly into the Side Windshield Channel Bracket from the bottom up. Unzip the door if it helps to install. Repeat on the other side.

8. Make sure the lower Door Frame Member is mounted on top of the Belt Rail of the body tube, and the hook features at the bottom of the door are over the threshold, securing the frame to the body. Repeat on the other side.
Work Instruction: Install ROXOR Soft Cab Enclosure
Soft Cab Enclosure (P/N 2302FUA00061N)

9. Tension the Door Straps at the top of the ROPS.

10. Attach the Door Hinges to the body using the fasteners listed below.
   a. M8 Button Head Flange Screw (P/N - 586.78)

11. Install (1) Strap Assembly (P/N - 574.24) around the ROPS Left Shoulder Guard as shown. Secure strap loosely until the Quarter Window is installed. Repeat on the other side.

12. Attach the Rear Quarter Windows to the Door Assembly with the matting zippers. The rear zipper mates with the Rear Window Panel attached later.

13. Attach the Quarter Windows to the ROPS diagonal bars using the sewn hook and loop flaps (3 per side).
14. Flip the plastic reinforcement strip under the Side Belt Rail to tension the top. Start at the rear corner and move forward toward the door. Repeat on the other side.

15. Tuck the web strap attached to the top corner of the Quarter Window over to the inside of the ROPS and then secure to the strap assembly (P/N - 574.24) from a previous step. Repeat on the other side.

16. Slide Rear Quarter Windows onto matching extrusion on back edge of Top Deck Assembly next to Rear Window. J-Hook extrusions will lock together when properly placed. Install Rear Window by starting the rear zippers about one inch on both sides.

17. Slide Rear Window onto matching extrusion on the back edge of Top Deck. J-Hook extrusions will lock together when properly placed. Make sure the rear window is centered.
18. Locate the Tailgate Bar at the bottom of the Rear Window Panel.

19. Insert the Tailgate Bar end into the channel on the Tailgate Brackets on both sides.

20. Secure the Rear Window Panel hook and loop straps to the footman loops on the Tailgate.

21. Final Adjustments - recheck all panels, mounts and attachment points and verify the following:
   a. Panels are lined up in the proper position.
   b. Buttons are snapped closed.
   c. Gaskets are properly compressed.
   d. Webbing straps are tightened.
   e. Hook and loops are properly positioned and flat.
   f. Zippers move freely from inside and outside of vehicle.