



INSTALLATION INSTRUCTIONS
POLARIS RZR XP 1000 2024
TINTED UPPER DOOR PANELS - VENTED
PART # 252480-LT

IMPORTANT NOTICES

READ AND UNDERSTAND THESE INSTRUCTIONS COMPLETELY BEFORE INSTALLATION TO AVOID INJURY TO YOURSELF, DAMAGE TO THE VEHICLE OR ACCESSORY.

- For proper installation, **TWO** people are required.
- Torque specifications must be followed when tightening bolts. **Over-tightening any and/or all screws will cause cracks around mounting holes which is not covered by any warranty.**
 - As specified on carton label, once protective film on shields is removed, product cannot be returned.
- As specified on carton label, damage caused by packaging staples is not covered by warranty. All staples must be removed prior to removing product from carton.
 - ANY cutting, trimming, drilling or altering of this product as delivered is not covered under warranty.
- Failure to follow these installation instructions completely may void any warrantable components and result in product damage or personal injury.
- Do not use Loctite/Super Glue or any other similar fastener adhesive. These types of products react to plastics and cause cracking. Not covered by any warranty.
 - Our windshields are made from the highest quality material providing optimum transparency and clarity. Blurriness and/or extrusion marks may or may not appear when looking through windshield from a wide, side-angle. This is normal for all extruded clear plastic materials.
- The application of improper cleaners, abrasive and/or dirty cleaning towels can severely damage the product. Failure to follow cleaning recommendation (provided herewith) may void any warrantable components.

DEALER

These instructions contain important information for future reference and must be given to the customer at time of purchase or upon completion of installation.

Parts List (parts available with kit only and not available separately)

| ITEM | PART NAME | DESCRIPTION | QTY | |
|-----------------|--|--|---|---|
| A | Upper driver door panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 | |
| B | Upper passenger door panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 | |
| C | Driver front filler panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 | |
| D | Passenger front filler panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 | |
| E | Co-extruded bulb seal (1/4") | Includes: 24" Co-extruded bulb seal [end user to cut to exact length] | 1 | |
| F | Co-extruded SIDE bulb seal (1/4") | Includes: 216" Co-extruded SIDE bulb seal [end user to cut to exact length] | 1 | |
| G | Edge guard strip (1/2") | Includes: 42" edge guard strip [end user to cut to exact length] | 1 | |
| INSTRUCTION BAG | H | Driver vent (#LT5) | CNC cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 |
| | I | Passenger vent (#LT6) | CNC cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 |
| | J | Driver rear filler panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 |
| | K | Passenger rear filler panel | CNC panel cut-out made of 1/4" thick tinted GE MR10 polycarbonate or equivalent | 1 |
| | L | Pull strap | Includes: 2 pull straps 8 1/2" | 2 |
| | M | Grab Handle | Strap mount molded handle | 2 |
| | N | Nuts & bolts | Includes: 4 P-clamp 1 3/4", 2 philips truss head screws M6 x 16, 12 philips truss head screws M6 x 20, 4 philips truss head screws M6 x 24, 4 plastic shoulder washers M6, 14 sealing washers M6 x 25, 4 rubber washer M6, 18 flanged locknuts M6, 8 push type retainers 5/16" and 2 rectangular grommets | 1 |
| | O | Magnet holder bag | Includes: 4 nylon magnet holder assemblies | 1 |
| P | Vent hardware | Includes: 4 carriage bolts M6 x 30, 4 thin plastic washers, 8 plastic washers M6, 4 rubber washers M6 and 4 female thread knobs M6 | 1 | |

SPECIAL NOTE:

OEM doors are not pre-adjusted to accommodate door accessories. It is very common and strongly recommended to adjust door positions **AFTER** installing door accessories.

For easier installation, proceed with the complete upper door installation with the door open. After and only after completing the installation, close the door and adjust OEM hinges/catch if required.

We do provide additional information on how to make adjustments at the end of the installation instructions.

WARNING / STRONG MAGNET!



- Can be harmful to pacemaker wearers and others with medical implants.
- Stay clear.
- Keep tools and other metal objects away. This magnet is strong enough to pull them out of your hand.
- To avoid damage, keep magnetic media such as computer disks, credit cards and tapes away.

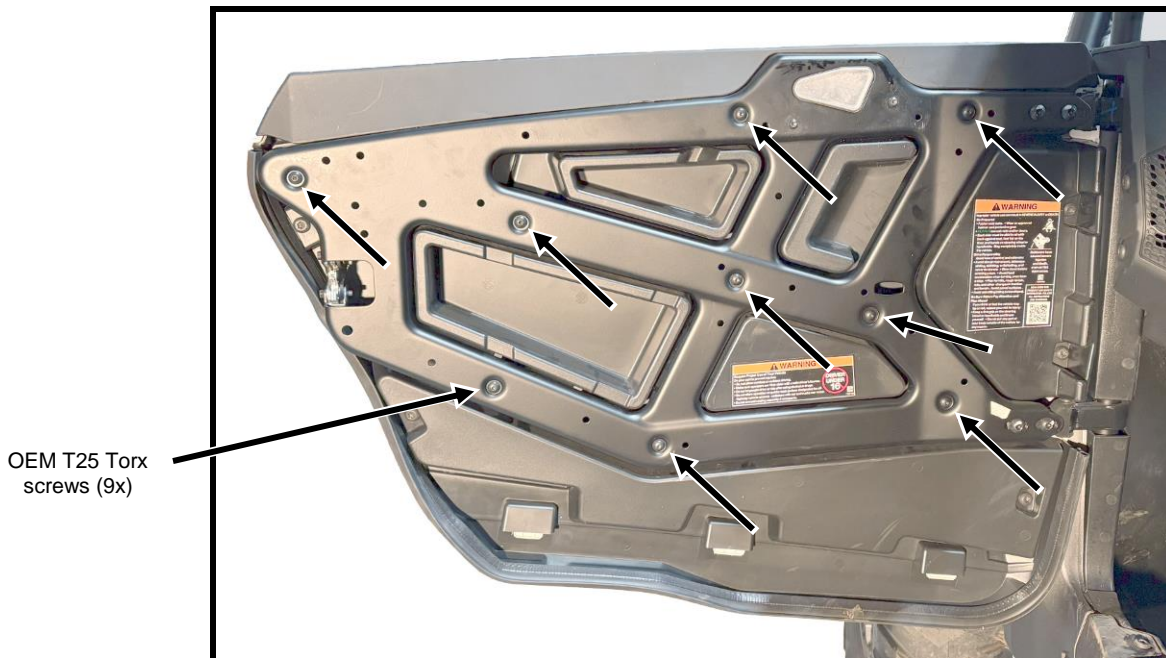
Failure to follow this warning can result in serious injury.

Installation Tools Required:

- Safety Glasses
- Adhesive tape
- Cutting tools (Ex: Scissor, knife, ...)
- Awl
- Drill, drill bit 1/4 in and drill bit 5/16 in.
- Screwdriver and/or socket set:
 - Phillips #3
 - T25, T40 Torx
- Wrench or socket set:
 - 10mm
 - 13mm

1. Door preparation and exterior pull strap installation (Driver side shown)

- a) Temporarily remove the OEM outer panel assembly from the driver side lower door as shown below (9 x T25 Torx screws).



IMPORTANT NOTICES

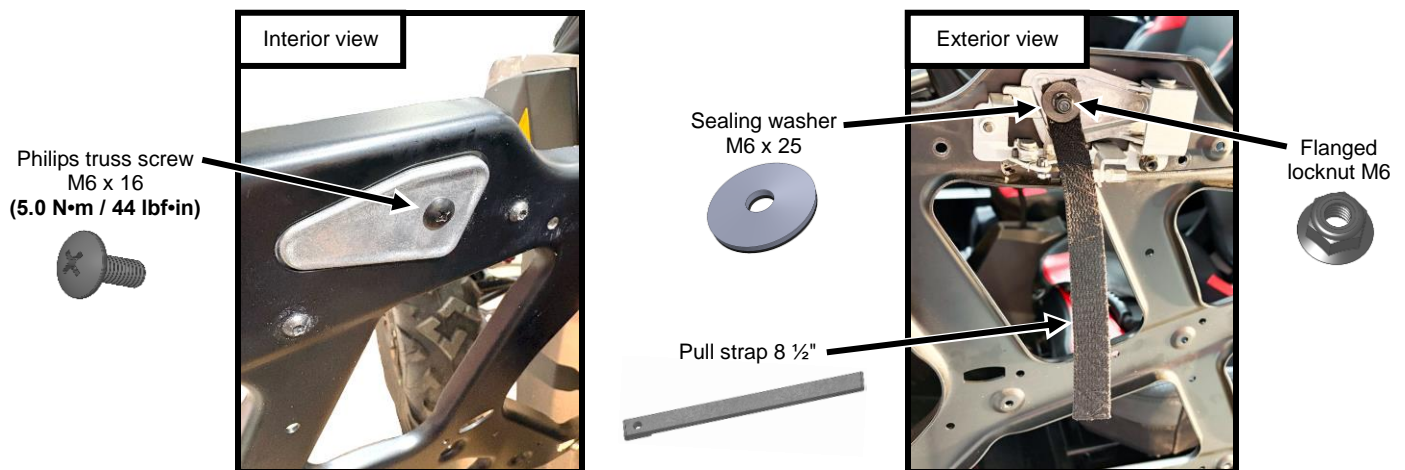
Torque specifications must be followed when tightening bolts.

Over-tightening any and/or all screws will cause cracks around mounting holes which is not covered by any warranty.

- b) Using adhesive tape, place and tape the cut-out Driver Latch Drilling Template on the driver side lower door actuator latch. With a ¼" drill bit, pierce a hole through the actuator latch using the Driver Latch Drilling Template as a guide as shown below.

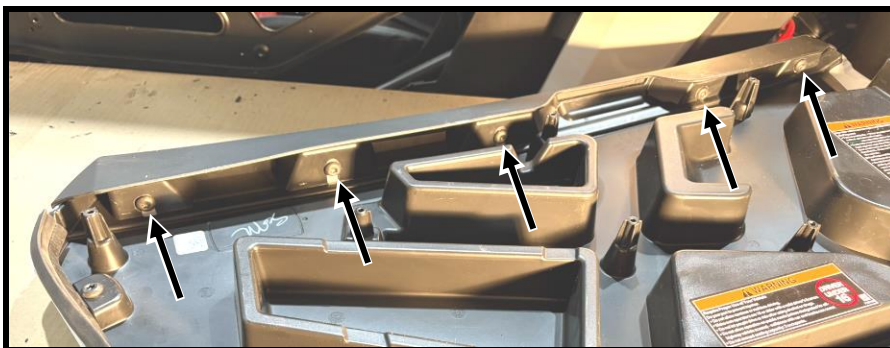


- c) Install the pull strap (Item L) with supplied hardware (Item N) to the driver side door actuator latch as shown below. **Tighten to specified torque 5.0 N•m / 44 lbf•in.**

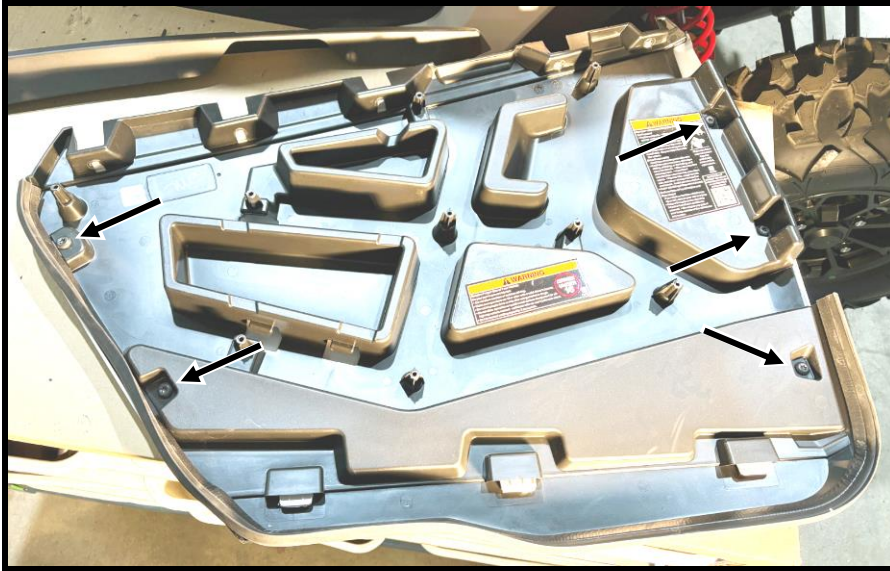


- d) Temporarily disassemble the OEM driver side outer panel assembly removed in step a) as shown below.

- To disassemble the upper cap, remove the 5 OEM T40 Torx screws as shown below.

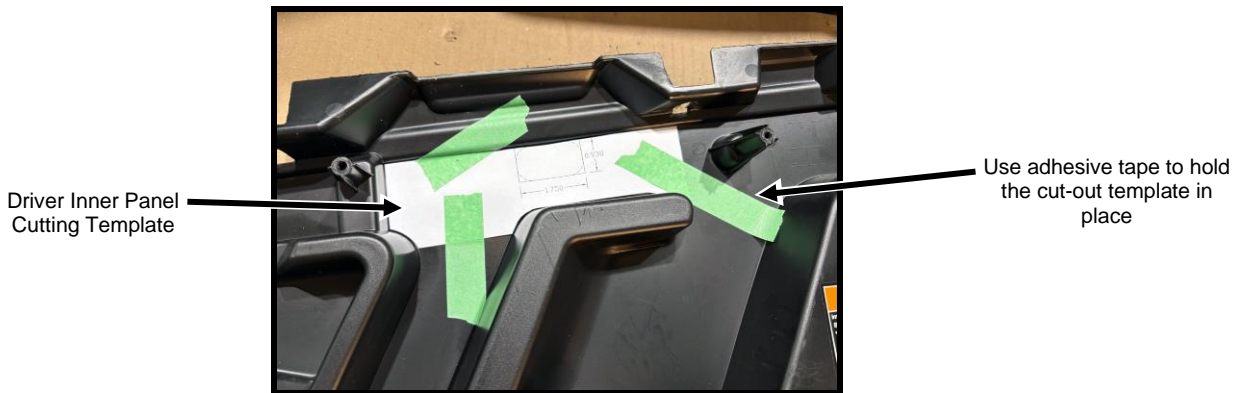


- To disassemble the outer panel, remove the 5 OEM T40 Torx screws as shown below.



e) Driver side lower panels latch hole cut-out steps:

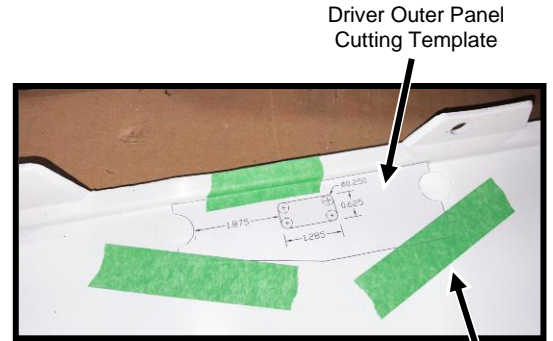
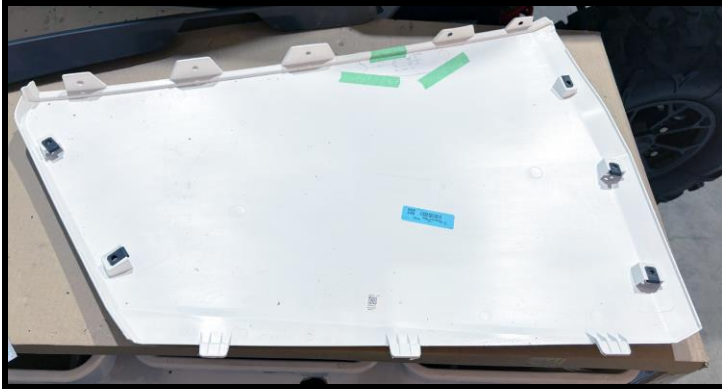
- Inner panel (black panel):
 - Using adhesive tape, place and tape the cut-out Driver Inner Panel Cutting Template to the inside of the OEM Inner panel (black panel) following the panel lines as shown below.



- Cut/clean/deburr a rectangular hole through the inner panel following the cutting lines of the template. This operation can be achieved using different cutting tools (drill bit, knife, jigsaw, rotary tool, files ...). Note that the template shows both sharp corners and radius corners for the cutout. Depending on the cutting tool used, choose the corner shape that is easiest to achieve. The final cut through the inner panel will not be visible after completing the installation.

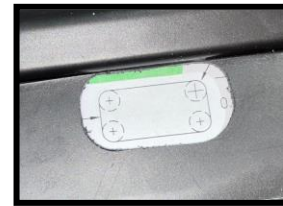


- Outer panel (colored panel):
 - Using adhesive tape, place and tape the cut-out Driver Outer Panel Cutting Template to the inside of the OEM Outer panel (colored panel) following the panel lines/circles as shown below.



Use adhesive tape to hold the cut-out template in place

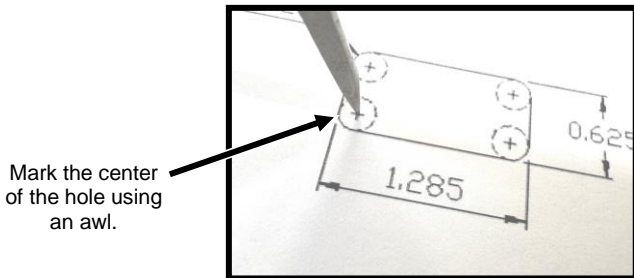
- The rectangular cutout lines of the outer panel should be centered in the existing rectangular hole of the inner panel from previous step as shown beside.
Note: To verify proper alignment prior to cutting, place both inner & outer panels together.



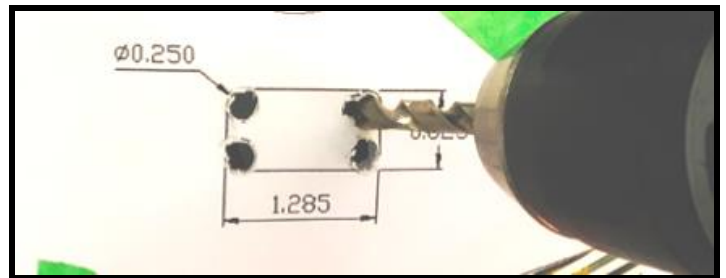
- After confirming the position of the Driver Outer Panel Cutting Template, separate both panels and mark the center of all 4 holes using an awl. With a 1/4" drill bit, pierce 4 holes through the outer panel of the driver side lower door using the Driver Side Drilling/Cutting Template as a guide as shown below.

Warning: Be sure to use proper tool size and follow guides. If the hole/opening is too large, the finishing grommet will simply not hold in place. Take your time to do it correctly to ensure proper fitment. Smaller holes can always be re-worked and enlarged if needed.

Drilling plastic requires care and caution. To avoid damaging the doors, use light drill pressure to avoid tearing or damaging the outer panel.

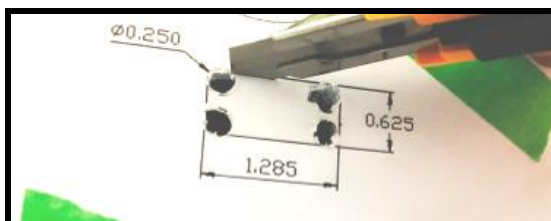


Mark the center of the hole using an awl.



- Cut/clean/deburr the remaining section of the rectangular latch hole opening by following the Driver Outer Panel Cutting Template lines as shown on next page. This operation can be achieved using different cutting tools (knife, jigsaw, rotary tool, file ...). Clean/deburr the rectangular hole and ensure that the hole size is +/- 0.625" x 1.285". Rework the hole size, if needed.

Warning: Be sure to use proper tool size and follow guides. If the hole/opening is too large, the finishing grommet will simply not hold in place. Take your time to do it correctly to ensure proper fitment. Smaller holes can always be re-worked and enlarged if needed.



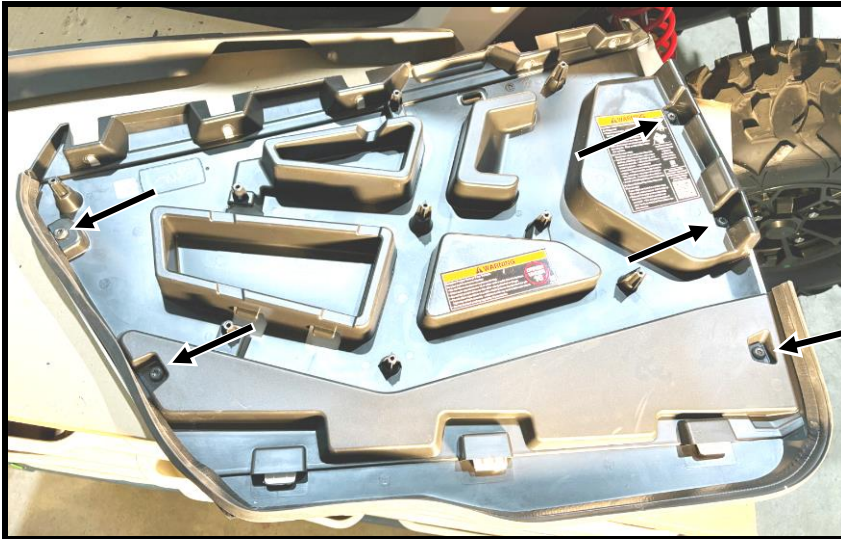
IMPORTANT NOTICES

Torque specifications must be followed when tightening bolts.

Over-tightening any and/or all screws will cause cracks around mounting holes which is not covered by any warranty.

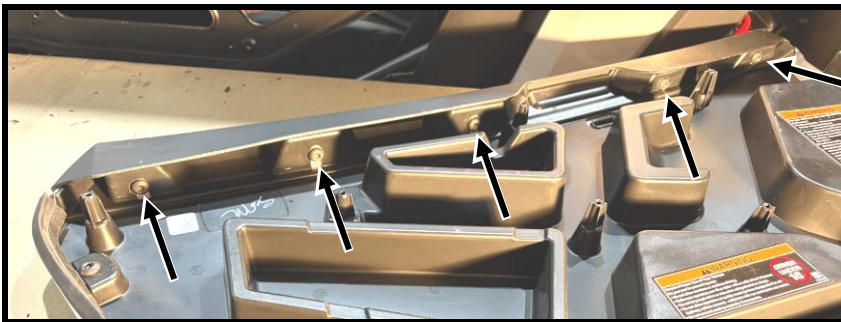
f) Reassembly of the OEM driver side inner panel, outer panel and upper cap as shown below.

- Re-assemble the inner and the outer panels together, with the 5 OEM T40 Torx screws removed in previous step d) as shown below. **Tighten to specified torque 10 N•m / 88 lbf•in.**



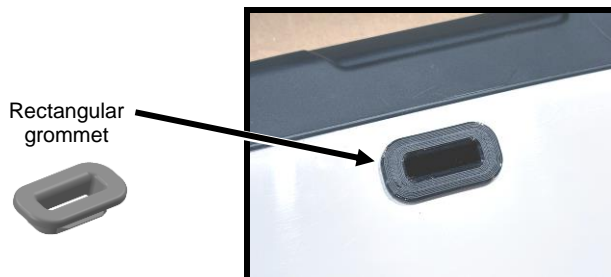
5 x OEM T40
Torx screws
(10 N•m / 88 lbf•in)

- Re-assemble the OEM upper cap with the 5 OEM T40 Torx screws removed in previous step d) as shown below. **Tighten to specified torque 10 N•m / 88 lbf•in.**



5 x OEM T40
Torx screws
(10 N•m / 88 lbf•in)

- Install the rectangular grommet (Item N) supplied through the cleaned and deburred opening of the outer panel (colored panel). It should simply snap/clip into the outer door panel and hold in place. If not, rework the hole size and reinstall the rectangular grommet to ensure secure fit.



g) Repeat steps a) to f) for the passenger side door.

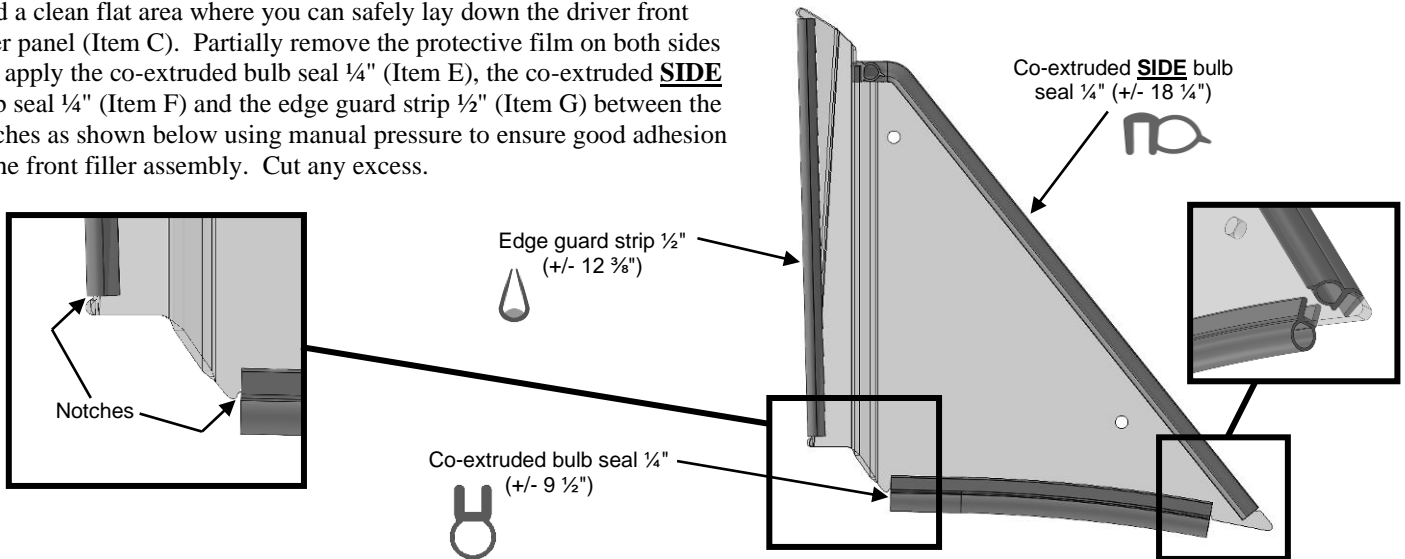
IMPORTANT NOTICES

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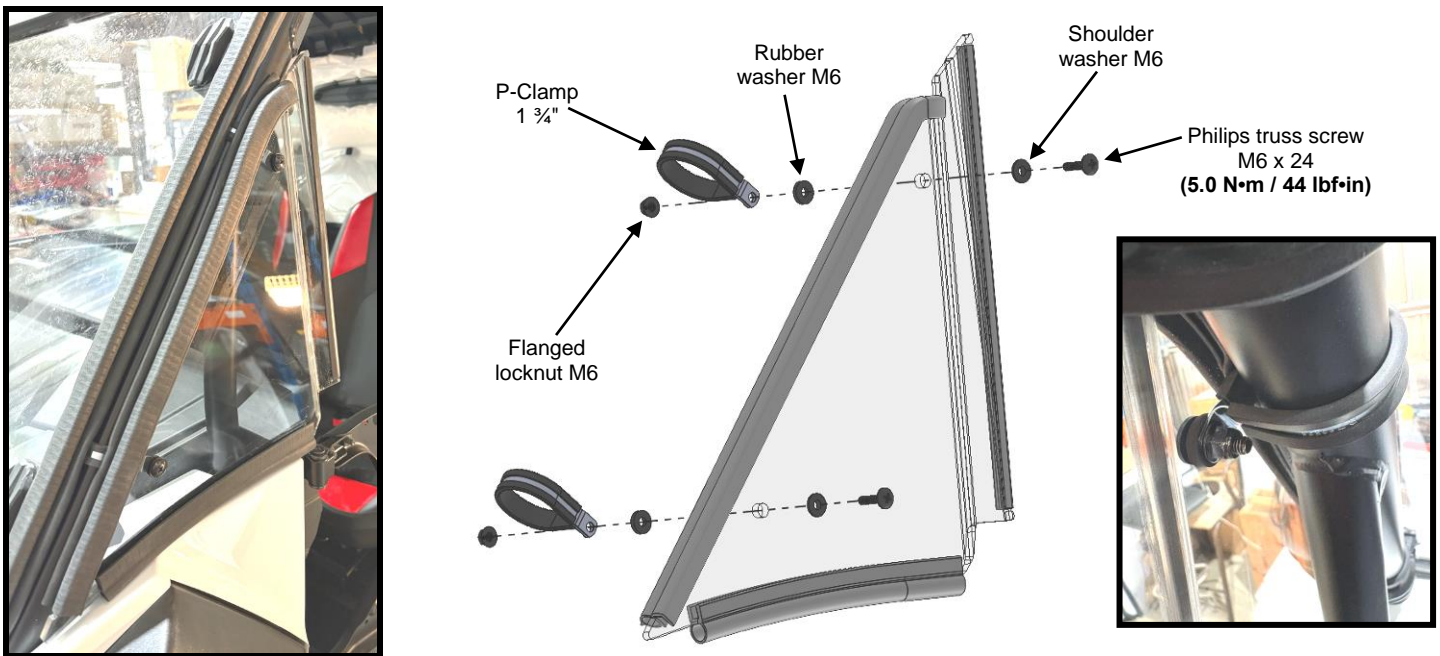
2. Installation of the front filler panel (Driver side shown)

- h) Find a clean flat area where you can safely lay down the driver front filler panel (Item C). Partially remove the protective film on both sides and apply the co-extruded bulb seal $\frac{1}{4}$ " (Item E), the co-extruded **SIDE** bulb seal $\frac{1}{4}$ " (Item F) and the edge guard strip $\frac{1}{2}$ " (Item G) between the notches as shown below using manual pressure to ensure good adhesion to the front filler assembly. Cut any excess.



- i) Install the pre-assembled driver front filler to the vehicle using supplied hardware (Item N) as shown below. **Do not overtighten.** Over tightening could cause parts failure.

Note that if your vehicle is equipped with a front windshield, you may need to temporarily remove it to install the front filler.



- j) Repeat steps h) to i) for the passenger front filler.

IMPORTANT NOTICES

Torque specifications must be followed when tightening bolts.

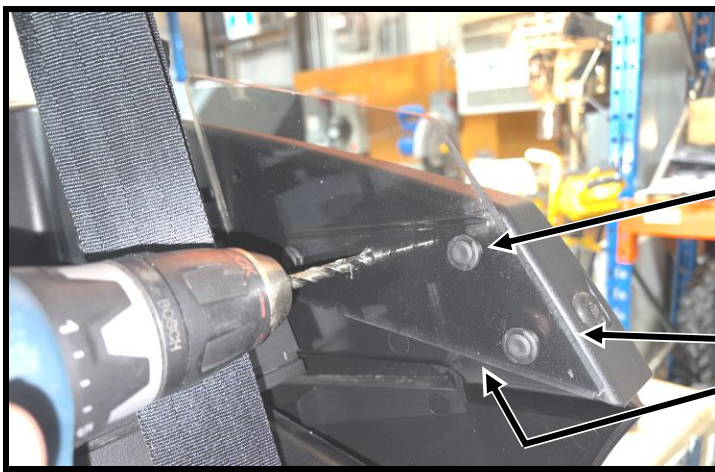
Over-tightening any and/or all screws will cause cracks around mounting holes which is not covered by any warranty.

3. Installation of the rear filler panel (Driver side shown)

k) For easier installation of the driver rear filler panel, we recommend temporarily removing the seats from the vehicle.

- From the interior of the vehicle, align and hold in place the driver rear filler panel with the interior surface of the vehicle box side panel as shown below.
- Mark and pierce the interior of the vehicle box side panel holes using a $\frac{5}{16}$ " drill bit. Secure in place with supplied hardware (Item N) as shown below.

Warning: For each hole, a single (1) layer of OEM box side panel should be drilled / pierced. Drilling plastic requires care and caution. Use light drill pressure to avoid tearing or damaging the vehicle.



Push type
retainer $\frac{5}{16}$ "
(4x)



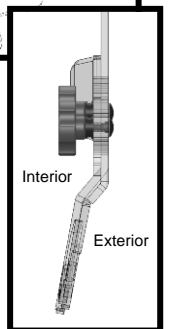
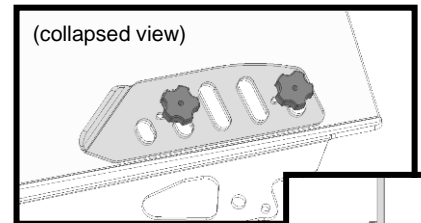
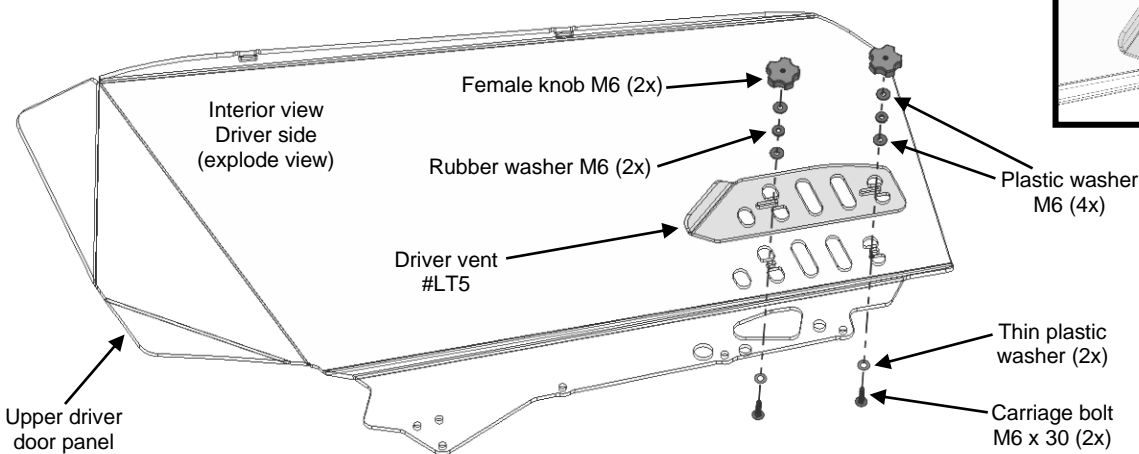
Align with side and
lower edges of the
vehicle box side panel



l) Repeat steps k) for the passenger rear filler panel.

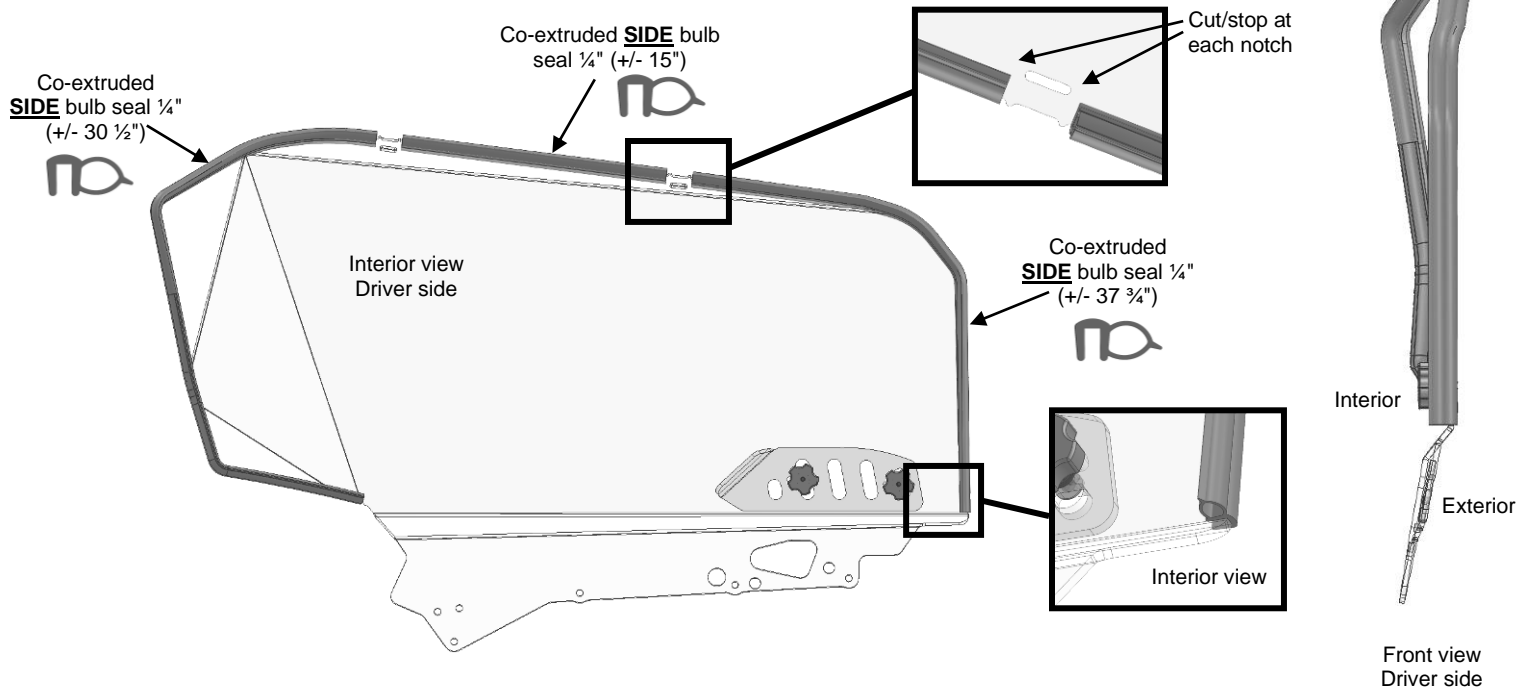
4. Installation of the upper door panel (Driver side shown)

m) Find a clean flat area where you can safely lay down the upper driver door panel (Item A). Partially remove the protective film on both sides and assemble the driver vent #LT5 (Item h) with supplied hardware (Item P) as shown below.



SIDE VIEW

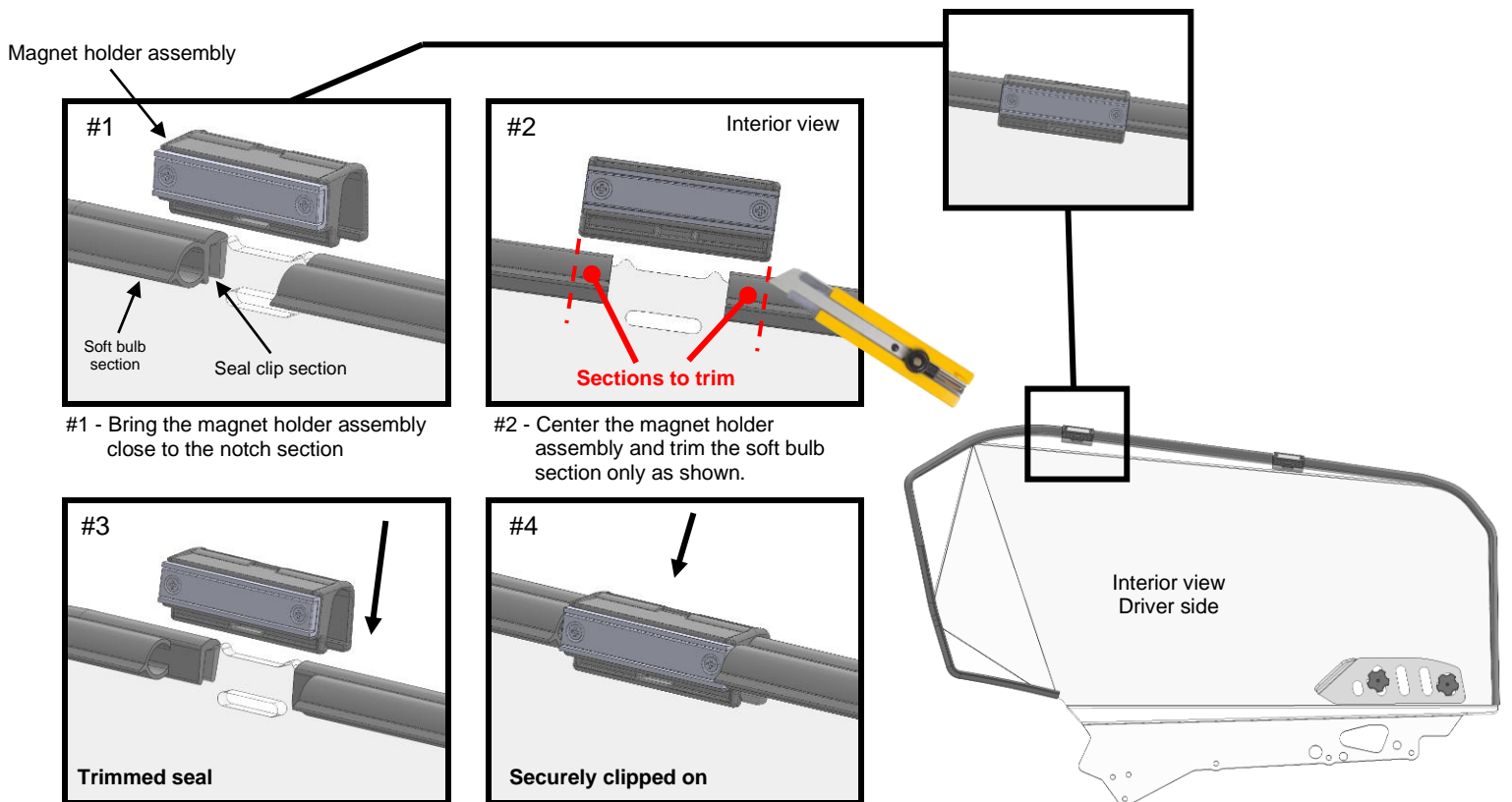
- n) Partially remove the protective film on both sides and apply the co-extruded **SIDE** bulb seal (Item F) to the pre-assembled upper driver door panel as shown below using manual pressure to ensure good adhesion to the panel. Cut any excess. Note that multiple cuts are required.



- o) As shown below, align the magnet holder assembly (Item O) close to the notched sections without the seal (image #1), center it and trim the soft bulb sections of the seal (bulb part only), on both sides (image #2), allowing magnet holder assembly to slide-in.

WARNING: DO NOT trim wider than needed. DO NOT trim the seal clip section. Trim bulb only.

Once bulb is trimmed, clip the magnet holder assembly (2x) onto the upper driver door panel using manual pressure (Image 3 & 4). Ensure the magnet holder assembly is properly clipped on the same side as the bulb. Repeat for upper passenger door panel.



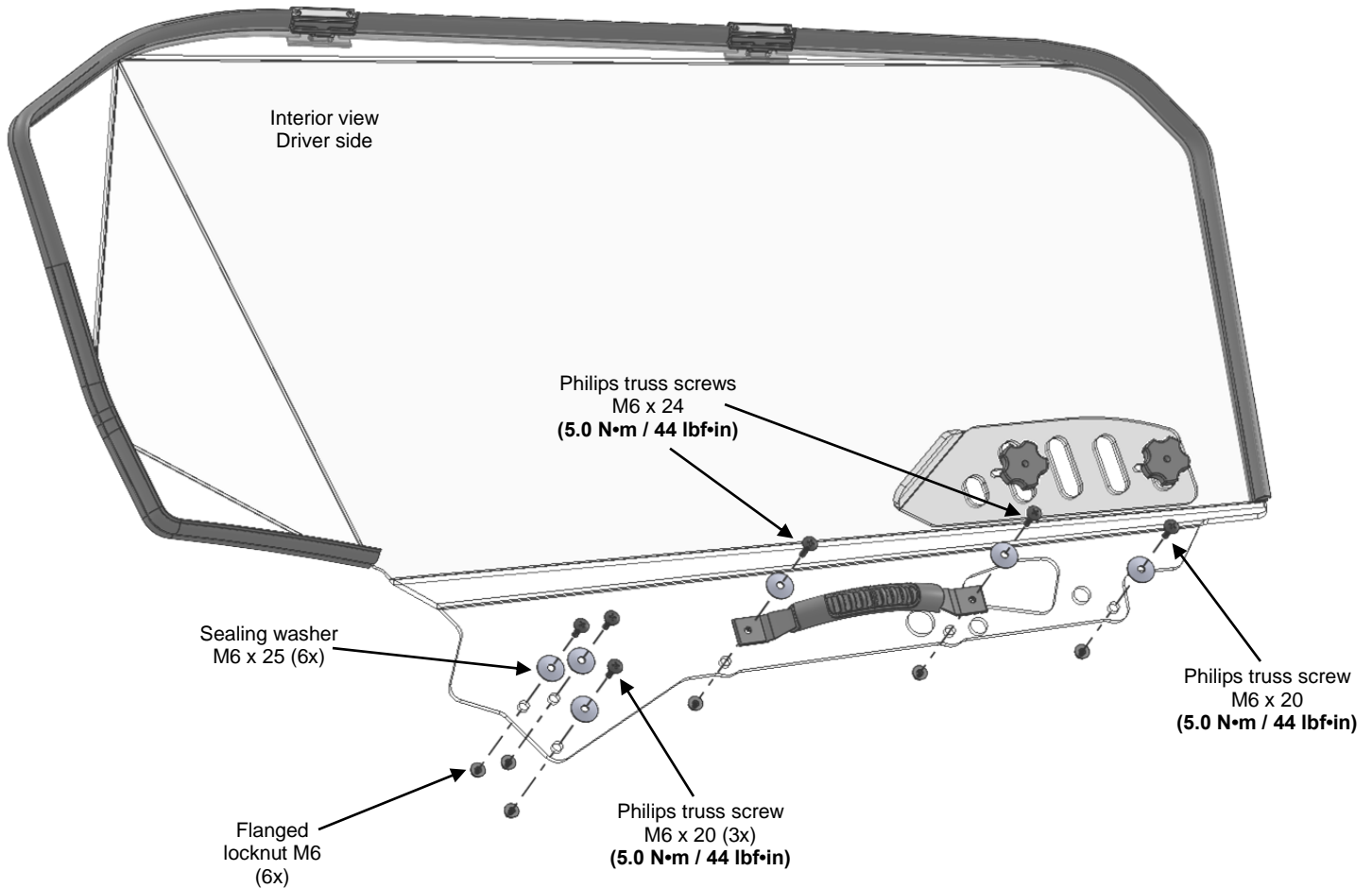
IMPORTANT NOTICES

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Over-tightening any and/or all screws will cause cracks around mounting holes which is not covered by any warranty.

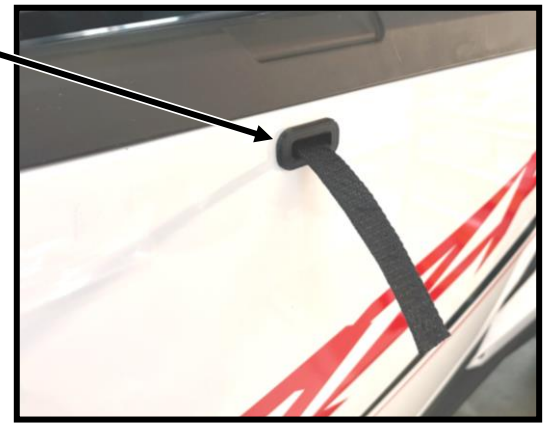
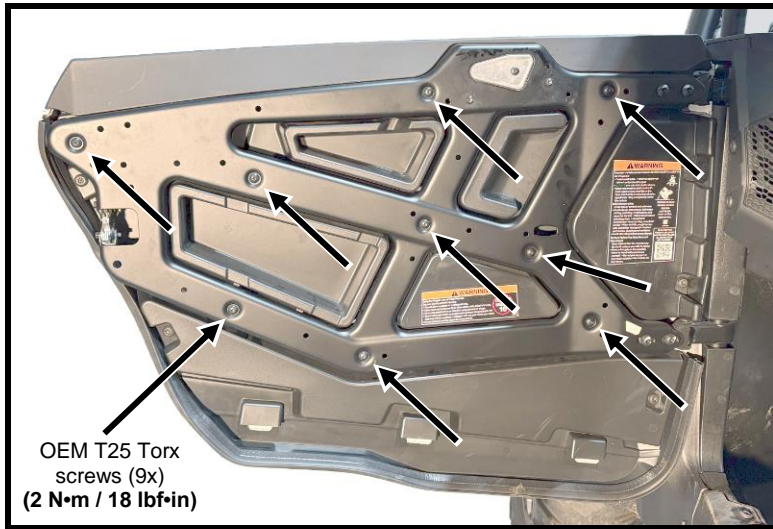
- p) Install the pre-assembled front driver upper door panel to the vehicle using supplied hardware (Item M & N) as shown below.

Do not overtighten. Over tightening could cause parts failure.



- q) Re-install the OEM outer panel assembly to the driver side lower door with the 9 OEM T25 Torx screws removed in step a) as shown on next page. **Tighten to specified torque 2 N•m / 18 lbf•in.**

Be certain to insert the pull-strap through the rectangular grommet.

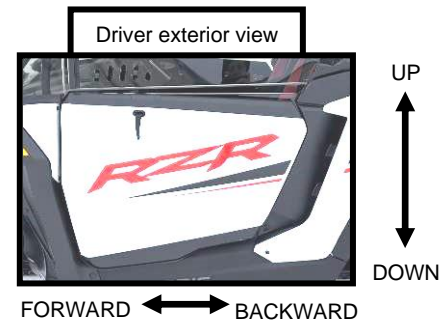


r) Repeat steps m) to q) for the passenger side door.

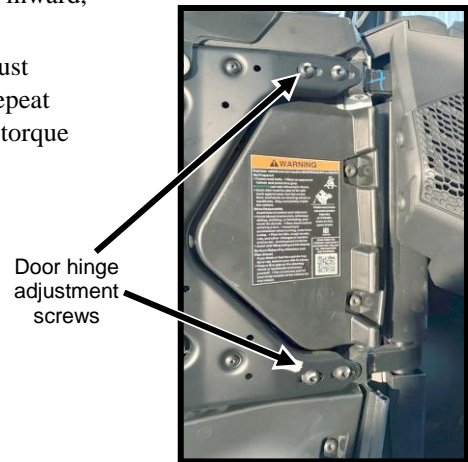
5. Door adjustments (Driver side shown)

s) After completing the installation, open and close both doors a few times. For any door adjustments see tips below:

- OEM doors are not pre-adjusted to accommodate door accessories. It is very common and strongly recommended to adjust door positions after installing door accessories.
- The assistance of a second person can be very helpful. One person can hold the door while the other person performs adjustments.
- Note that the door can be adjusted forward, backward and the rear portion of the door can also be adjusted up and down. The door catch can also be adjusted inward, outward, up and down as shown below.
- To adjust the door, loosen door hinge and/or the door catch screws, adjust position and tighten. Try closing and opening the door a few times. Repeat until proper adjustment is complete and tighten to OEM recommended torque of **12 N•m / 106 lbf•in.**



Door catch adjustment screws



Door hinge adjustment screws

ATTENTION: With the upper door installed, the required force necessary to properly close the door may be increased. It is the responsibility of the end-user to ensure that the doors are properly closed prior to vehicle use. As a reference, when closing the doors slowly, the door latch must click twice. If not, pull the door until you hear the double click. **CAUTION:** Riding while doors are not closed properly can cause major injury.

6. Maintenance and Care

Tighten all hardware after first use and periodically thereafter.

See cleaning instructions on following page.

Cleaning Instructions for Polycarbonate Products

General Purpose Polycarbonate Products-GP will mar easily with wiping action. To minimize the risk of damage, use only compatible cleaners, a soft, clean cloth, (no paper towels!) and follow proper cleaning procedure as outlined below.

Hard coated Polycarbonate Products-HC offer a higher degree of both surface hardness and abrasion resistance, providing superior protection against unintentional chemical attack/damage. However, the use of abrasive, gritty cleaners or aggressive cleaning should be avoided to eliminate the possibility of scratching or damaging the coating. PLEASE NOTE: Trailing on an open trailer can cause windshield damage due to anti-freeze, brake fluid, oil, gasoline and even battery acid from other vehicles.

Cleaning / Preventing Scratches-ALL Shields:

- Pre-rinse the polycarbonate product with water to loosen and remove surface residue, grit and grime thoroughly. Pressure-washer spray is fine but at a safe distance with a fan spray nozzle – not jet spray mode.
- Using a clean sponge, microfiber sponge or soft cloth gently wash the polycarbonate product with lukewarm water. While cleaning - Keep the sponge clean of dirt, grit and debris. Rinse it frequently and keep it loaded with soap suds. MILD, diluted car wash soap is acceptable. **Do not apply cleaners under direct sunlight or during high temperatures!**
- Immediately rinse thoroughly with water, **DO NOT** allow cleaners to dry on the shield!
- Thoroughly dry using pressurized air, a chamois or moist cellulose sponge to prevent water spots.
- Protect using a quality product such as Plexus plastic cleaner, Rain X Plastic (**not standard RainX**), or liquid car wax and a soft cloth. Plexus is a registered trademark of B.T.I chemical.

Compatible Cleaners for General Purpose Polycarbonate and Hard coated Polycarbonate Products:

The following cleaning agents have been found compatible with polycarbonate products. Follow the manufacturer's recommendations and instructions.

Compatible Cleaners: Joy®, Palmolive liquid®, or mild car wash soap diluted appropriately. **Do NOT use in sunlight or let dry!** Joy is a registered trademark of Procter & Gamble; Palmolive is a registered trademark of Colgate Palmolive.

Compatible Organic Solvents: Butyl Cellosolve, Kerosene, Naphtha (VM&P) grade.
Use these solvents only in extreme cases-All residual organic solvents should be removed with a second rinse.

Compatible Alcohols: Isopropyl Alcohol.
All residual organic alcohols should be removed with a second rinse.

Repairing Hairline Scratches (General Purpose Polycarbonate” Products Only):

Deep scratches and gouges made by sharp objects such as keys, screwdrivers, and knives cannot be repaired. Hairline scratches and minor abrasions may be minimized by using a buffing/ polishing compound. We suggest testing a small area of the product first using a compatible polish following the manufacturer's instructions, prior to using the polish on the entire product. **ALWAYS** use a soft cloth and **NEVER** use paper towels.

Compatible buffing compound: Novus Plastic Polish #1 & #2, Mirror Glaze Clear Plastic Polish.

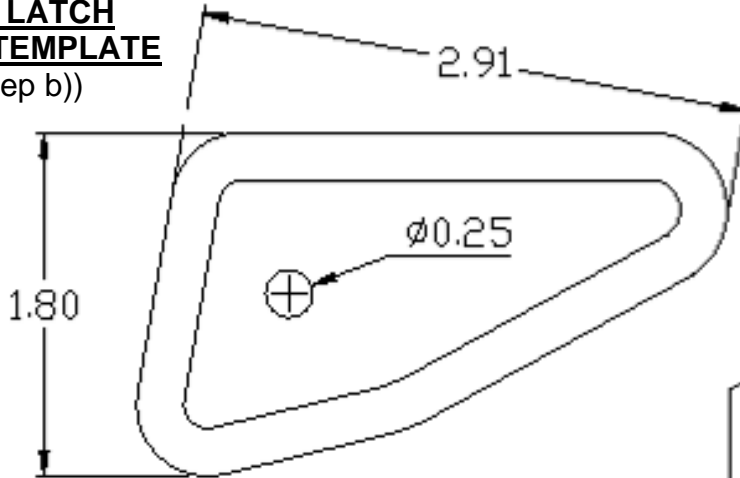
Cleaning and protecting, we recommend Plexus® plastic cleaner, Rain X Plastic (**not standard RainX**) or Liquid Car Wax.
Plexus is a registered trademark of B.T.I chemical.

For HARD COATED products, buffing the surface is not recommended. Buffing scratched areas may worsen the condition and further damage the coating. Once the coating is removed, it cannot be repaired and buffing may optically distort the polycarbonate product. Quick Spot cleaning on the trail can be done with water or window cleaner such as Sparkle etc., and a soft cloth. Rain-X can be used on HC Polycarbonate but **NOT** on GP Polycarbonate.

Some Important "Do NOT's":

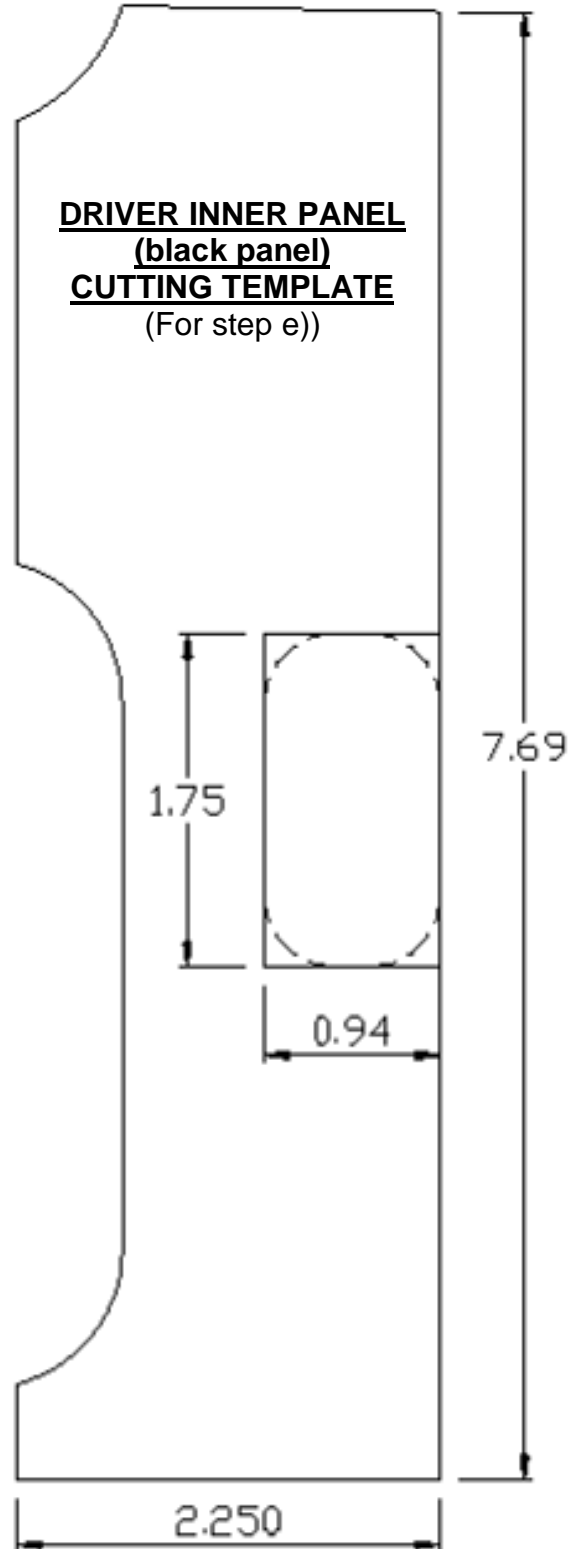
- **DO NOT** use abrasive or high alkaline cleaners on polycarbonate products!
- **DO NOT** scrape polycarbonate products with squeegees, razor blades or other sharp instruments.
- **DO NOT** use gasoline, benzene, acetone, or carbon tetrachloride on polycarbonate products.
- **DO NOT** clean polycarbonate products in direct sunlight or at elevated temperatures.
- **DO NOT** leave cleaners on polycarbonate products for a long period of time. Rinse **IMMEDIATELY**.
- **DO NOT** clean polycarbonate products with gasoline.
- **DO NOT** use any cleaners other than those specified on the approved and compatible list included in this guide.
- **DO NOT** use **Super glue or thread lockers such as Loctite-immediate damage to the polycarbonate will result!**

**DRIVER LATCH
DRILLING TEMPLATE**
(For step b))

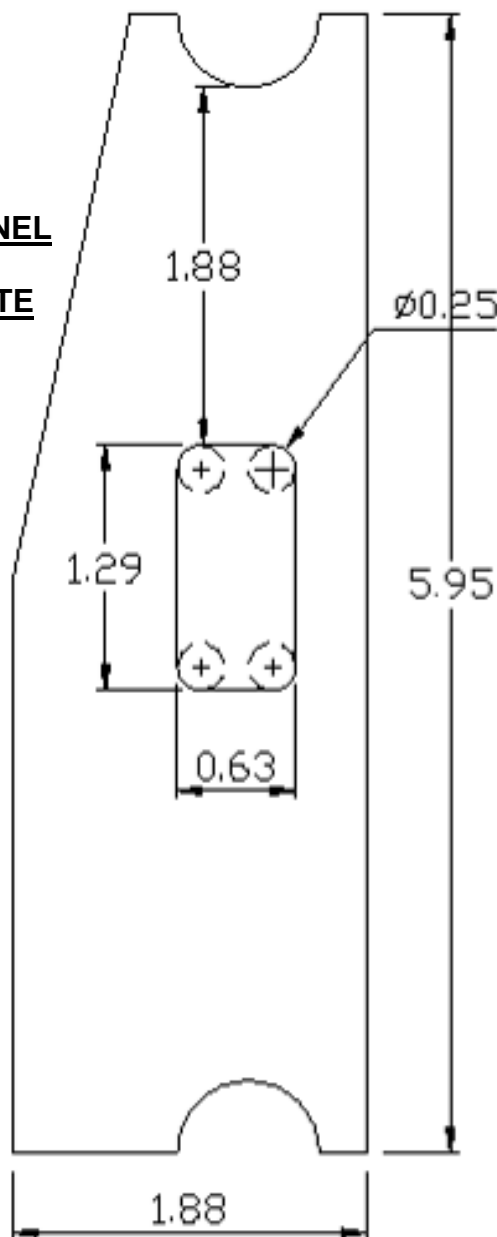


ATTENTION:
Please verify dimensions before
drilling/cutting.
Do not scale when printing.
Scaling a template can cause
incorrect printing/size.

**DRIVER INNER PANEL
(black panel)
CUTTING TEMPLATE**
(For step e))



**DRIVER OUTER PANEL
(colored panel)
CUTTING TEMPLATE**
(For step e))



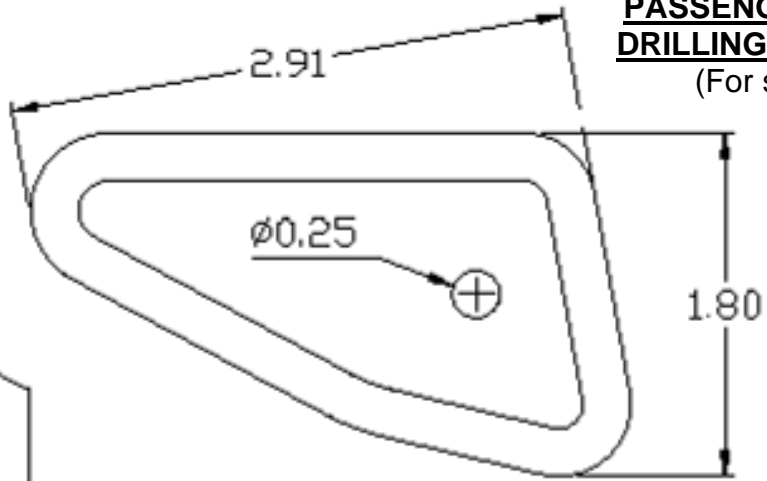
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ATTENTION:

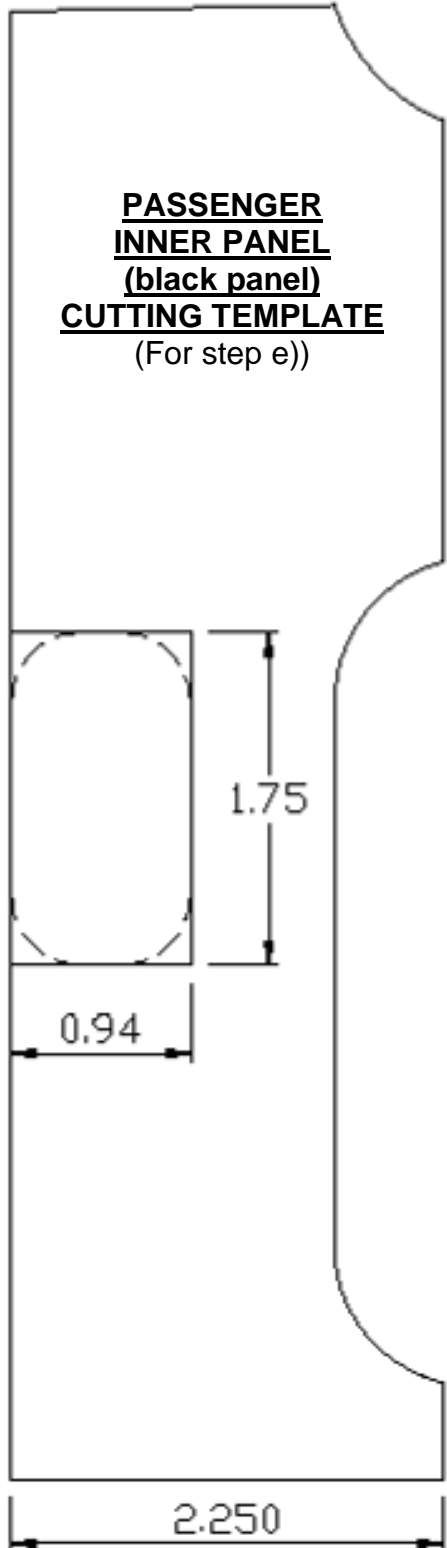
Please verify dimensions before drilling/cutting.
Do not scale when printing.
Scaling a template can cause incorrect printing/size.

**PASSENGER LATCH
DRILLING TEMPLATE**

(For step b))



**PASSENGER
INNER PANEL
(black panel)
CUTTING TEMPLATE**
(For step e))



**PASSENGER
OUTER PANEL
(colored panel)
CUTTING TEMPLATE**
(For step e))

