

QUARTER DOOR KIT



P/N 2881429

APPLICATION

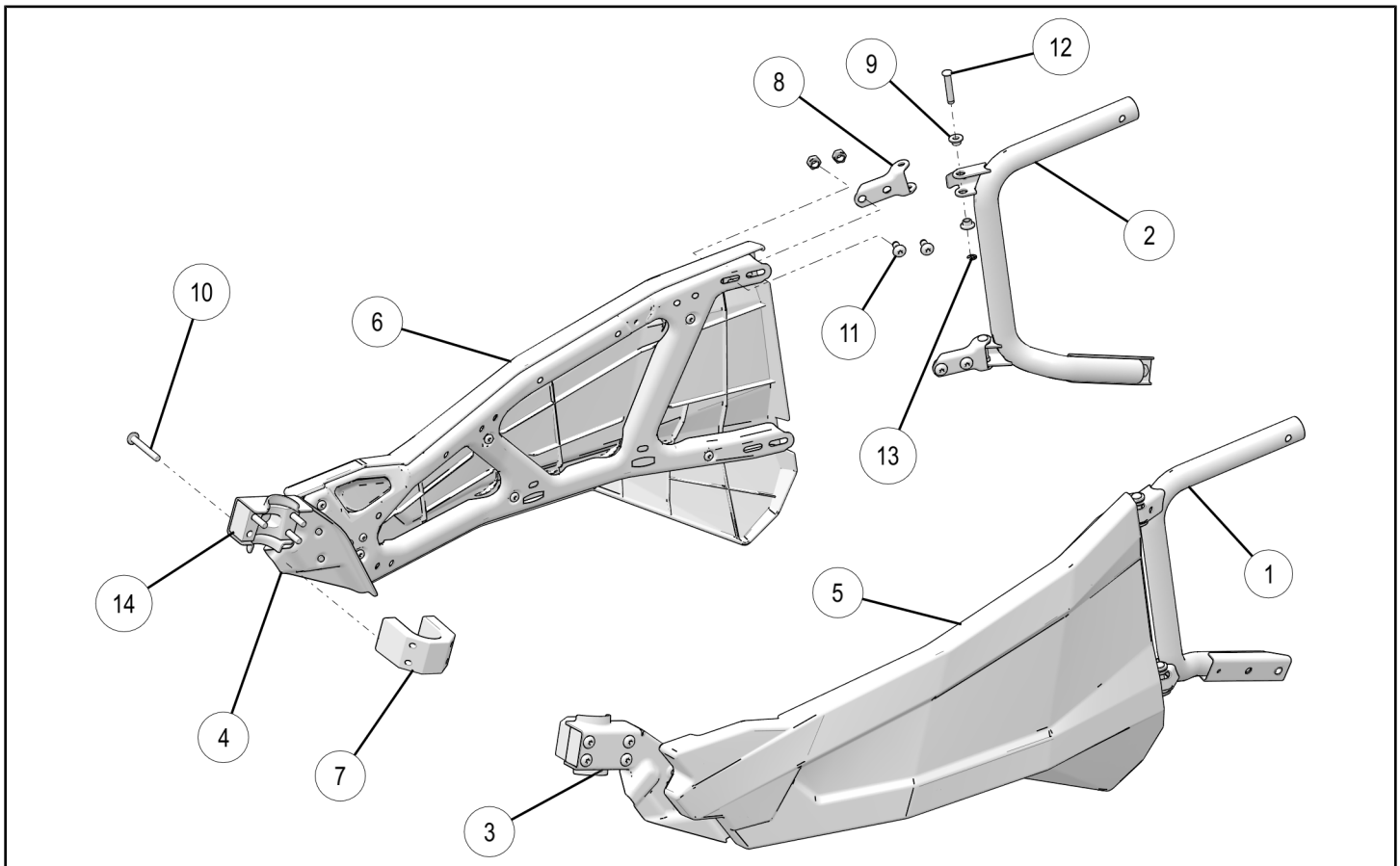
ACE Models

BEFORE YOU BEGIN

Read these instructions and check to be sure all parts and tools are accounted for. Please retain these installation instructions for future reference and parts ordering information.

KIT CONTENTS

This Kit includes:



REF	QTY	PART DESCRIPTION	PART NUMBER
1	1	Bolster Weld, LH, ACE	1021748
2	1	Bolster Weld, RH, ACE	1021749
3	1	Latch Weld Mount Bracket, Door, LH, ACE	1021750
4	1	Latch Weld Mount Bracket, Door, RH, ACE	1021751
5	1	Door Assembly, LH	2635400
6	1	Door Assembly, RH	2635401
7	2	Door Mach Clamp	5140136

REF	QTY	PART DESCRIPTION	PART NUMBER
8	4	Door Hinge Bracket	5258008
9*	8	Door Pivot Bushing	5450592
10*	8	Screw M8 X 1.25 X 60, TXTH	7520367
11*	8	Screw M8 X 1.25 X 20, TXTH	7519997
12*	4	Door Hinge Pin	7662138
13*	4	M6 E-Clip	7710466
14	2	Door Mach Clamp	5140310
	1	Instructions	9926317

Items marked (*) are included in Hardware Kit PN 2206070.

TOOLS REQUIRED

- Safety Goggles
- 6 mm Allen Wrench
- 13 mm Wrench Socket
- T40 Torx®
- Pliers for E-clip

IMPORTANT

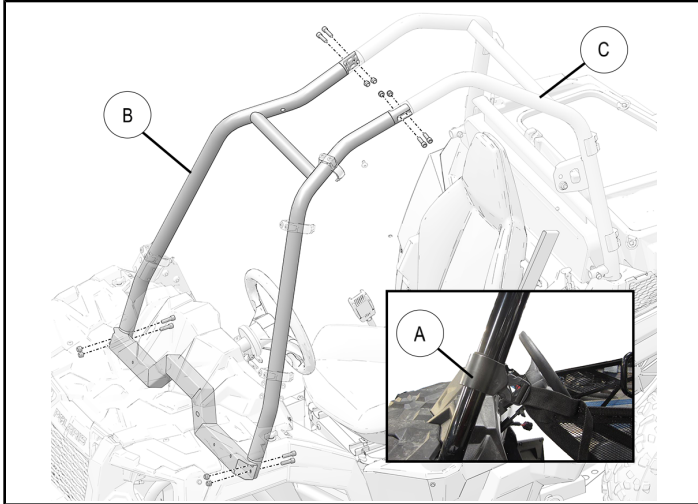
Your QUARTER DOOR KIT is exclusively designed for your vehicle. Please read the installation instructions thoroughly before beginning. Installation is easier if the vehicle is clean and free of debris. For your safety, and to ensure a satisfactory installation, perform all installation steps correctly in the sequence shown.

ASSEMBLY TIME

Approximately 30 minutes

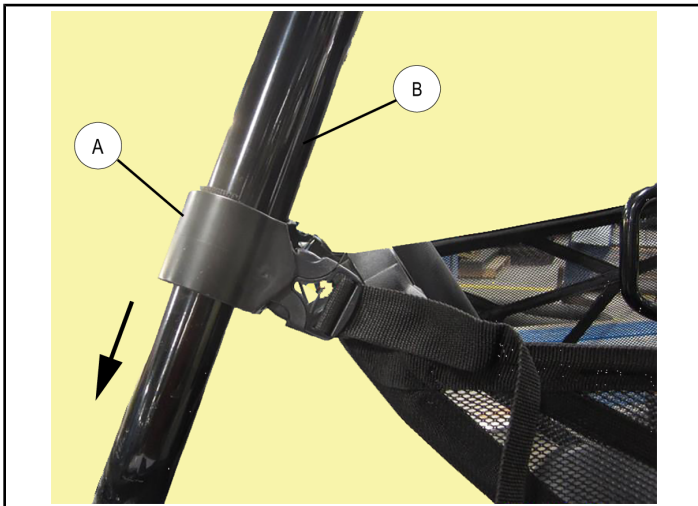
INSTALLATION INSTRUCTIONS

1. Place vehicle in "PARK". Turn key to "OFF" position and remove from vehicle.
2. To remove buckles (A) from front ROPS (B) on both sides, first remove the front ROPS (B) from vehicle by removing eight bolts securing front ROPS (B) to vehicle frame and rear ROPS (C) as shown.



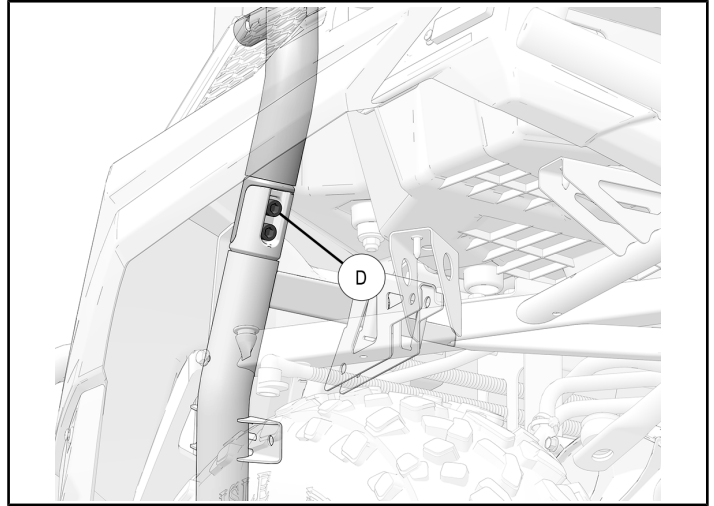
NOTE

Once front ROPS (B) are removed, slide door buckles (A) loop off the ROPS.



NOTE

For easy removal of front ROPS bolts, you may need to loosen rear ROPS bolts (D).

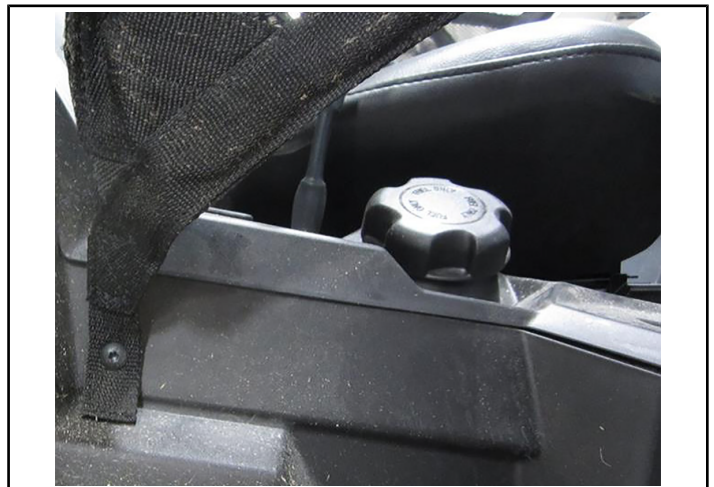


3. Reinstall front ROPS removed in Step 2. Torque to below specification.

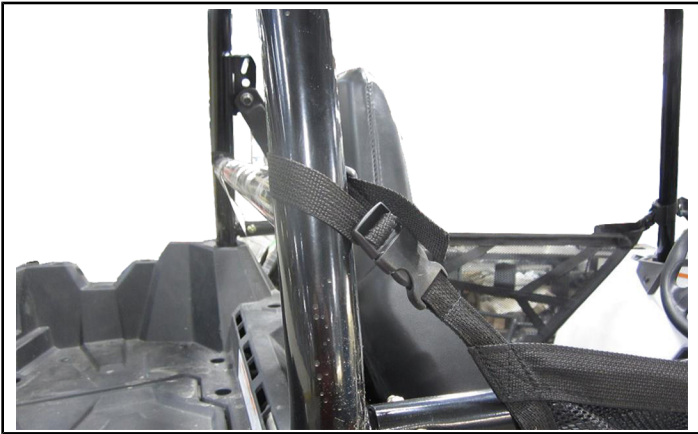
TORQUE

30 ft. lbs. (40.7 Nm)

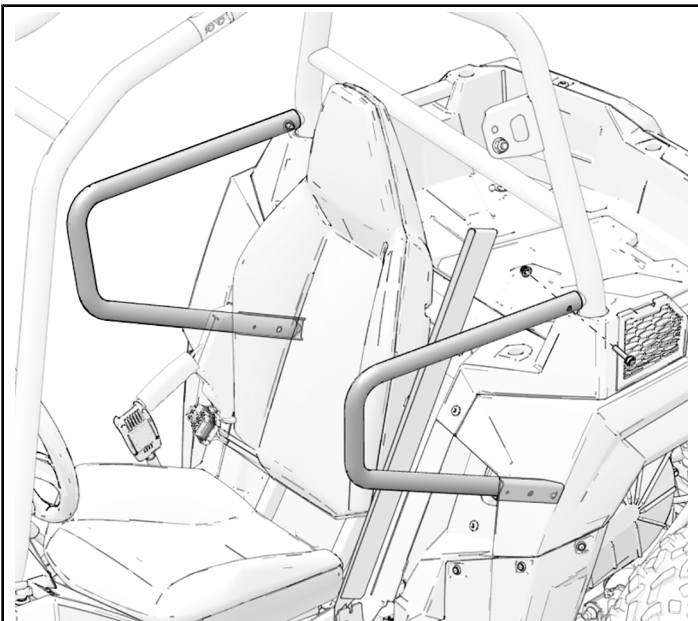
4. Remove screw securing side net onto bottom as shown in figure.



5. Unbuckle and remove net from rear ROPS tube on both sides of vehicle.



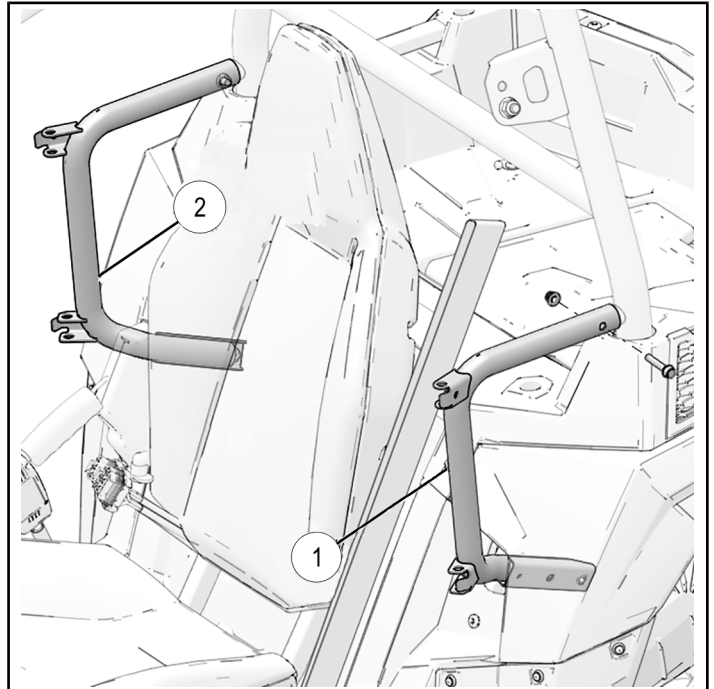
6. Remove existing side bolster bars from vehicle by removing two bolts on each bolster bar. Retain hardware for later use.



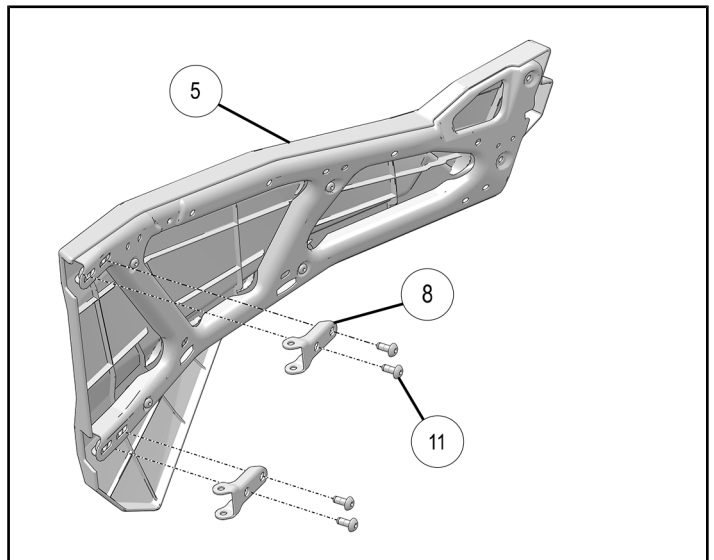
7. Install new bolster bars (LH ① and RH ②) to vehicle by using hardware removed in Step 6. Torque to below specification.

TORQUE

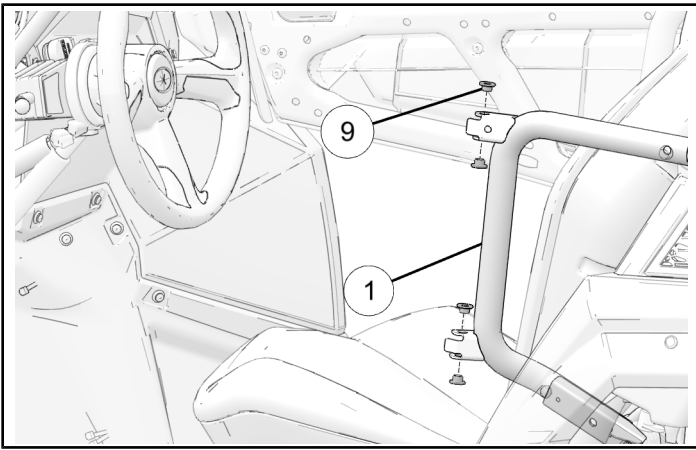
16 ft. lbs. (21.7 Nm).



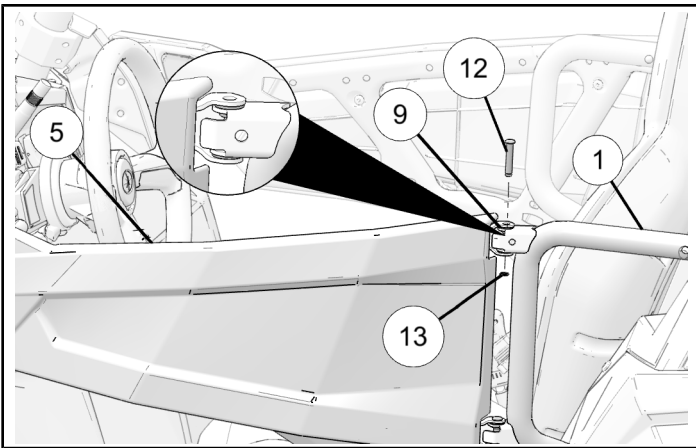
8. Install two hinges ⑧ on door ⑤ by inserting four M8 screws ⑪. Do not tighten screws at this stage.



9. Install the bushings ⑨ to the bolster bar ①.



10. Install door assembly ⑤ on bolster bar ① using hinge pin ⑫ and E-clip ⑬ through bushings ⑨.

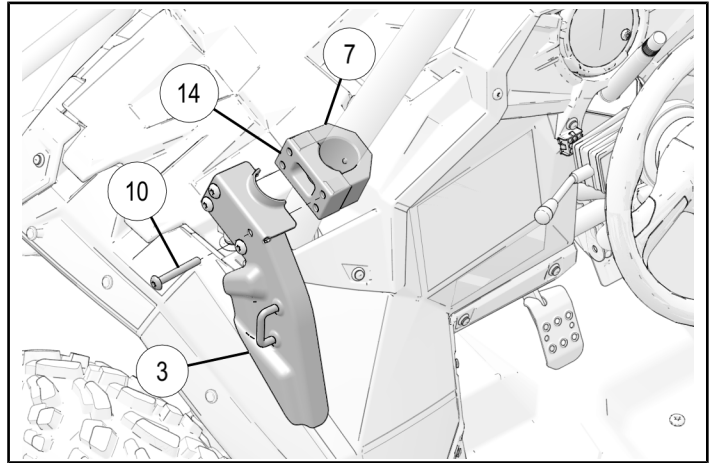


11. Install latch mount ③ on ROPS by aligning with inner latch mount ⑦ with door clamp ⑭. Clamp latch mount and inner latch mount by inserting M8 screws ⑩, but do not tighten at this time.

12. Rotate latch mount until bump on inner surface of inner latch mount aligns with hole in ROPS tube. Torque to below specification.

TORQUE

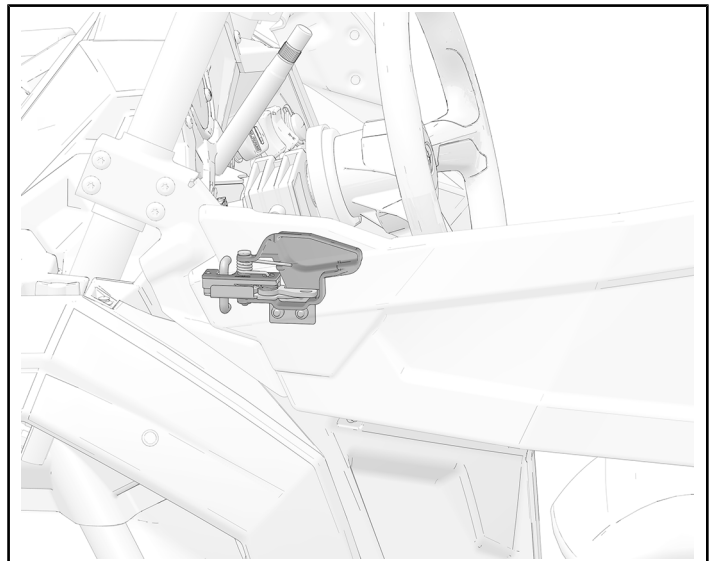
16 ft. lbs. (21.7 Nm)



13. Adjust door until latch is landing just above center of striker. Tighten hinge bolts to secure door in desired position. Torque to below specification.

TORQUE

16 ft. lbs. (21.7 Nm)



14. Repeat Steps 9 to 13 for RH door installation.