

# **SPECIAL INSTRUCTIONS FOR MAHOGANY**

## **WINDSHIELD ASSEMBLY**

This guide is intended to help you with the special handling and assembly of your mahogany windshield. Since we ship the windshield partly unassembled, it is not uncommon for it to arrive with splits or cracks. Do not be alarmed, this is common and will not become an issue with the final product. **The reasons:** 1.) In order to be able to cut the groove for the acrylic and gasket, the windshield must be made in several pieces, then epoxied back together. This is the only way to be able to cut a groove inside of a “closed edge”. 2.) Since the windshield is shipped unfastened to the console, the structure becomes severely compromised because it is missing the “base” which prevents it from twisting and shifting. 3.) The windshield assemblies structure is also impaired before final installation because the acrylic is not yet bonded to the mahogany. These 3 factors combined make it very difficult to transport safely. Please follow the steps below to ensure proper installation and years of enjoyment.

- 1.) If the windshield arrives with slight cracking due to shifting or twisting in transit, simply use any “mahogany color” sandable wood filler. If this is your situation, skip to step 3.
- 2.) If the windshield arrives completely separated in one or more areas, you will need to use any 2 part epoxy to bond it back together (you can find 2 part epoxy at any local hardware store). This will usually happen where it was originally bonded together during initial construction. Apply epoxy to BOTH edges of where the windshield became separated and clamp together using clamps long enough to span the height of the windshield. Keep clamps in place until the epoxy has fully cured. If clamps are not available to you, then you can use the “5 minute epoxy” version, so that you can manually hold it in place until the epoxy cures (This epoxy is no less stronger than the regular version). Once the windshield is repaired and back in one piece, use wood putty to fill any voids or imperfections from the repair.
- 3.) Remove the protective paper on each piece of acrylic **only on the side facing inward.** The reason for this is you will be bonding the acrylic to the mahogany frame with 3M 5200 Marine Adhesive/Sealant. This step quadruples the strength and integrity of the windshield assembly. Once the protective paper is removed, apply a thin bead of 3M 5200 only to approximately 1/8” of the inner surface perimeter. This is where the acrylic comes in contact with the mahogany. You can also place the acrylic in place and trace the border with a pencil so that you know where to apply the 3M 5200. Also apply a thin bead of 3M 5200 to the

inner surface of the mahogany frame where it comes in contact with the acrylic. Bond one panel at a time in place.

- 4.) Once all 4 panels are cured and bonded in place, you will need to tape off the portion of the acrylic that was removed in the previous step so it does not become scratched or venerable from spills from the varnish. You will not be installing the gasket at this time. Lightly sand the entire windshield assembly (if needed. The assembly is already pre-sanded when we ship it from our facility).
- 5.) Choose a varnish you will be using for both the console and windshield. Follow the application instructions provided on the product you choose. We recommend Z-Spar 1015 Captains varnish. This product can be brushed or sprayed on. If spraying on, be sure to thin the varnish with compatible thinner. Once the windshield is varnished, you may install the rubber gasket provided. Be sure to remove the protective paper coating before doing this. You may use soapy water as a lubricant to get the gasket into place.
- 6.) Once the windshield is completed, it is now time to fasten to the console. You will see 8 pre-drilled holes on the top panel of the console. These holes are used to fasten the windshield with screws coming from inside the console, up through the top of the console and into the bottom of the windshield. Place the windshield in place so that the holes are centered along the base of the windshield. You can trace the outline of the windshield once positioned. It is also recommended to bond the windshield to the top of the console for added strength. Apply a thin coat of epoxy or 3M 5200 to both the top of the console and bottom edge of the windshield. When fastening, fasten one screw at each side of the windshield so that the windshield stays in place while fastening the other screws. These methods above will ensure a product that will endure years of use. Enjoy!