

FREEMAN MARINE EQUIPMENT COASTAL MOTION WINDOWS INSTALLATION INSTRUCTIONS

These windows are designed to install and function correctly in a flat bulkhead. If your bulkhead is not flat, you must either make it flat, or shim the windows.

Verify flatness before you proceed further.

1. Unpack windows, check for damage, and verify by measuring that what you ordered was what was built. If any of the windows are damaged, save all packaging, and call the delivering carrier immediately, to arrange for an inspection. If any windows are paired, port and starboard, mark them, so that bulkhead cutouts are made correctly.
2. If you have already made your bulkhead cutouts proceed to #6, else go to #3.
3. Separate the inner trim ring from the outer main frame. Position the window in the desired location on the bulkhead and mark the correct cutout dimensions. It is important to note that the cutout dimensions are smaller than the overall size of the window, and that the flange extends beyond the bulkhead cutout.
4. If a window trim ring appears to be of the wrong dimension, it is possibly because you have it reversed, or because on paired, shaped windows, we often pack the port trim ring on the starboard window, and vice versa. This makes for safer packing and shipping.
5. After all window locations are marked on the bulkhead, **STOP**, double check your work for correct alignment hole location and hole size. **ONLY** when you are sure that everything is correct, should you proceed.
6. Make the bulkhead cutout.
7. Insert mainframe from the outside, and verify the fit. Adjust bulkhead cutout if needed. At this time, note the correct way that the inner trim ring installs, so that if you install sealing tape on the inner trim ring, you will put the tape on the correct surface. Installing tape on the inside trim ring is optional, but helps make for a better seal, if you have the room for tape on both sides of the bulkhead.

WINDOWS INSTALL WITH THE DRAINS AT THE BOTTOM !!!

8. **NOTE:** IF YOU ARE INSTALLING THESE WINDOWS IN A **STEEL BULKHEAD**, YOU MUST PUT TAPE ON BOTH SIDES OF THE BULKHEAD, AND ENSURE THAT THERE IS NO ALUMINUM-TO-STEEL CONTACT.
9. Have someone insert the mainframe from outside and support it while you secure the inner ring, (with the taped side facing the bulkhead, if you did tape the inner ring). Tighten screws in a crisscross pattern.
10. If you have any questions, or any instructions are unclear, STOP and call before any mistakes occur.
11. On all windows, verify that all punched drain holes are not clogged. If necessary, they can be cleaned with a paper clip or wire, to remove any debris.

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