



**RV EXTERIOR WINDOW
OEM INSTALLATION MANUAL**

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Introduction

This document outlines the common procedures for preparing and installing all Lippert series windows.

For addition product support please go to: <https://support.lci1.com/windows/>

NOTE: Images used in this document are for reference only when assembling, installing and/or operating this product. Actual appearance of provided and/or purchased parts and assemblies may differ.

Safety Information

WARNING

The “WARNING” symbol above is a sign that an installation procedure has a safety risk involved and may cause death or serious injury if not performed safely and within the parameters set forth in this manual.

Always wear eye protection when performing this installation procedure. Other safety equipment to consider would be hearing protection, gloves, and possibly a full face shield, depending on the nature of the installation procedure.

CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

Resources Required

- Cordless or Electric Drill or Screw Gun
- Appropriate Drive Bits
- Installation Tape or Putty Tape
- #8 - 3/16" x 1" max. UNC non-self-tapping screws

Preparation

Rough Opening

The tolerance for the manufacturer's rough opening is $\pm 1/8"$. The opening must be square, level and plumb. The opening must be free from protrusions, uneven surfaces, or jagged edges.

CAUTION

Improper rough openings, protrusions, uneven surfaces, or jagged edges can impede proper seating of the window which can lead to leaks.

Walls and Radius

Lippert windows are designed to be installed on vertical walls. Installation on sloped walls can lead to water penetrating into the RV.

CAUTION

Installation on sloped walls can lead to water penetrating into the RV.

The radius corner block must be $3 \frac{5}{16}"$ for a $3 \frac{1}{8}"$ radius window and $4 \frac{3}{16}"$ for a 4" radius window. An oversized radius block can cause the window to be tight in the corners and can damage the window. An undersized radius block can create a gap and cause installation leaks in the radius. The exterior surface around the window opening must be smooth. If shims are used around the opening, they **MUST** be used around the entire perimeter of the window including the radius. Any raised ribs or splice joints in siding must be smooth to ensure a proper seal and window function.

Window Preparation

- If there are dents present on the window flange, they must be straightened prior to application of installation tape.
- It is recommended that window flange is clean and free of debris before applying installation tape or putty tape.
- Applied sealant seam must overlap at the bottom of the window.

CAUTION

Make sure tape is not stretched across the window as it will roll or fold in the radius, which can lead to installation leaks.

Window Preparation, Taping Radial Corners

NOTE: This is also an alternate method allowed for square windows, but the preferred method can be found at section "Window Preparation, Taping Square Corners".

If installing RV Exterior Window with radial (curved, rounded) corners, please adhere to the following:

- Installation tape must be installed on the outer edge of the window flange to maximize contact surface area between foam tape and wall.
- It is highly recommended that tape is not stretched across the window as it will roll or fold in the radius, which can lead to installation leaks.

Window Preparation, Taping Square Corners

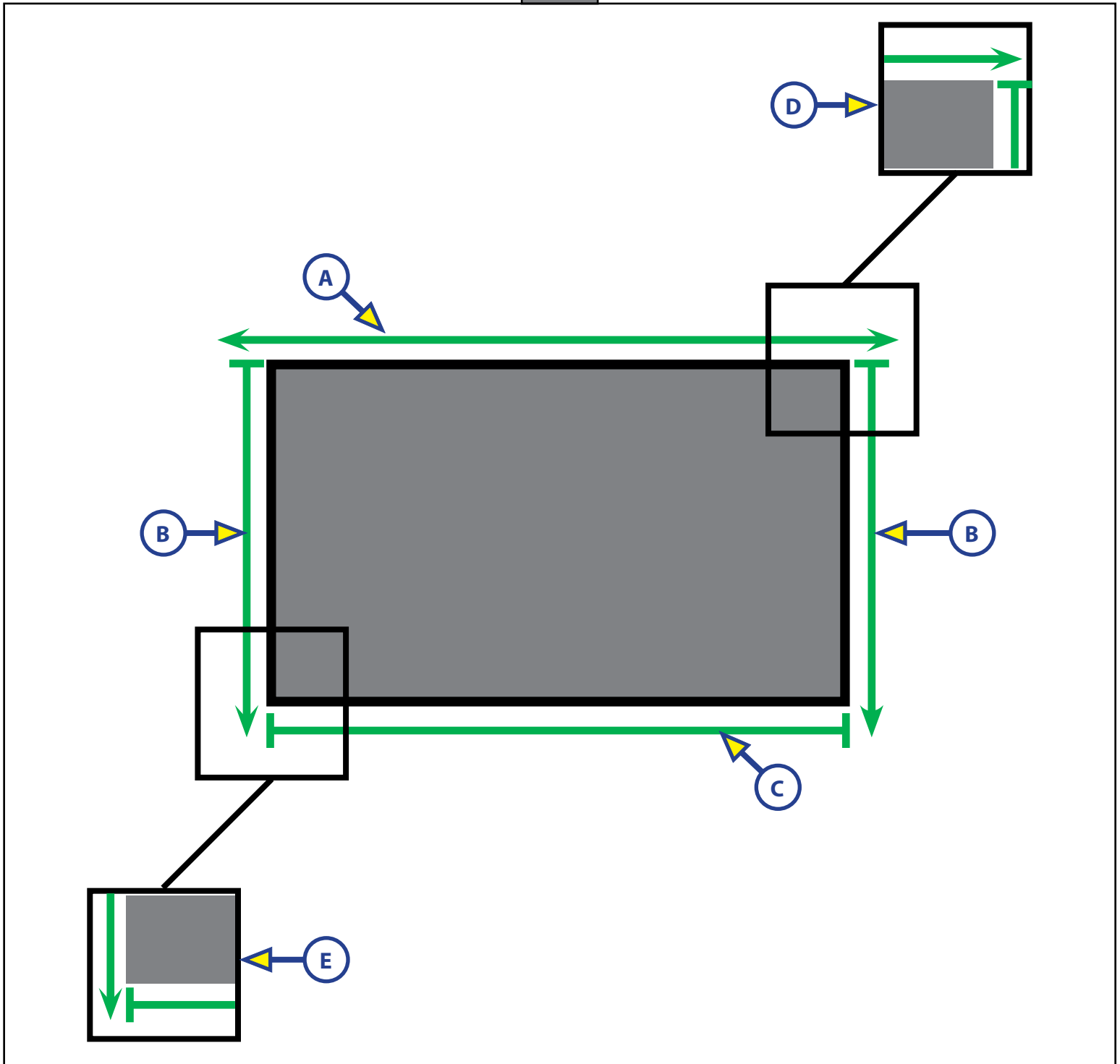
NOTE: It is highly recommended that tape is applied in a weatherboard pattern.

NOTE: Make sure there are no gaps in the tape, while ensuring there is no overlap of the tape in the corners (Fig. 1D and 1E).

As of January 2023, Lippert developed and released the 4000 Series of RV Exterior Windows with square corners. Adhere to the following:

1. Install tape across the entire top of the window (Fig. 1A).
2. Install tape vertically down both sides of the window (Fig. 1B).
3. Install tape across the bottom of the window (Fig. 1C).

Fig. 1



Installation

The window should be installed into the opening from the exterior of the RV without the use of any tools. If resistance is experienced, the window should **NOT** be forced into the opening. If resistance is experienced, remove the window and check for correct opening size and requirements. See the Preparation section.

NOTE: Install window into RV in the CLOSED position.

NOTE: The fixed pane on the horizontal slider window must be installed toward the front of the RV.

⚠ WARNING

Risk of Critical Fail on 3000 Series and 4000 Series split pane dual operating windows if the pane spacer has been removed prior to installation. DO NOT remove the pane spacer until the installation is complete.

⚠ CAUTION

Make sure the fixed pane of the horizontal slider window is installed toward the front of the RV. If the window is not installed correctly, there is the potential for water infiltration past the mullion bar seal. This could occur from wind pressure during transportation. Water infiltration could cause damage to the RV.

Fig. 2



Fig. 3



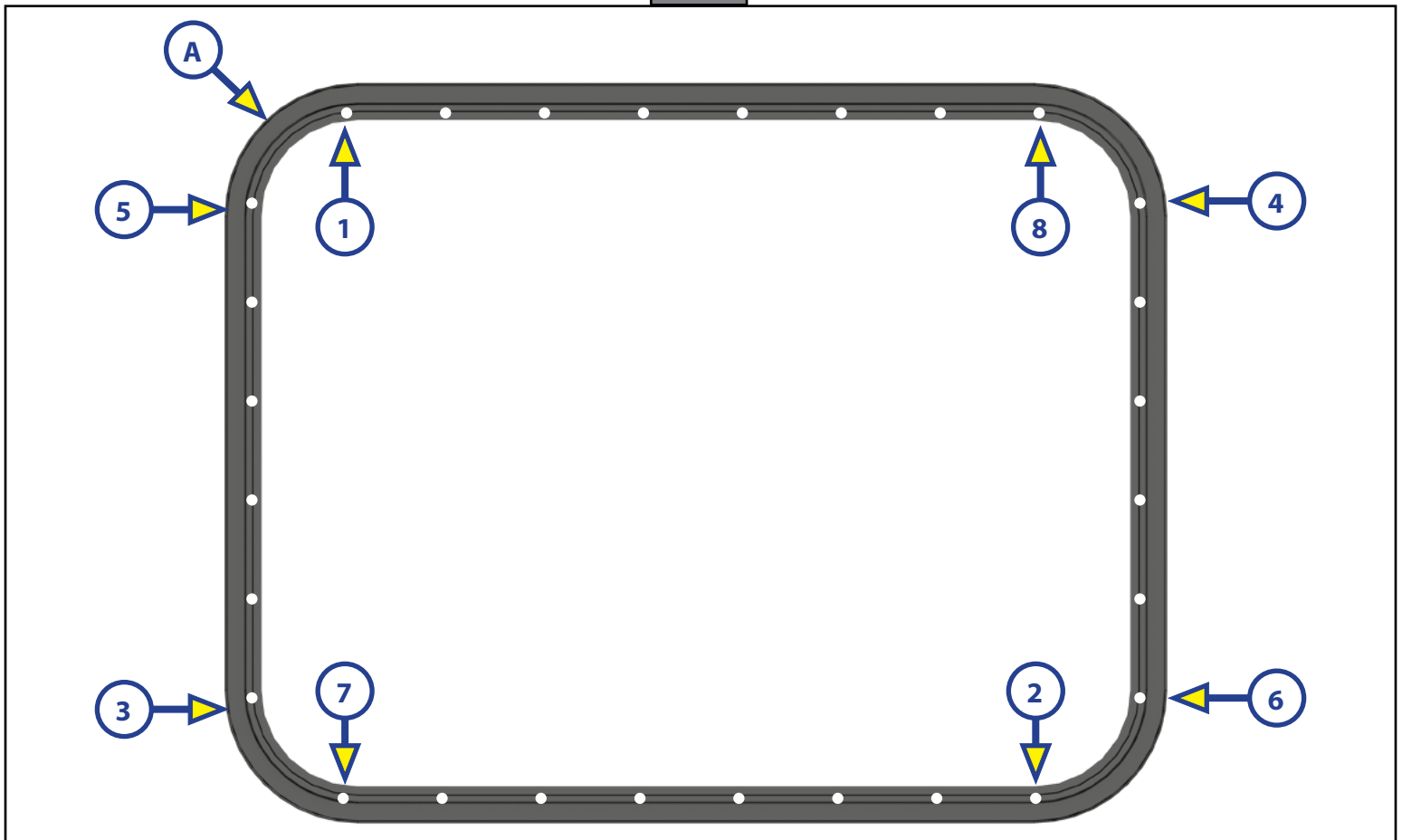
NOTE: Figure 2 shows the RV Exterior Window with radial corners. Figure 3 shows the 4000 Series window with square corners. Regardless of corner type, the installation of the window will be the same.

Clamp Ring Installation

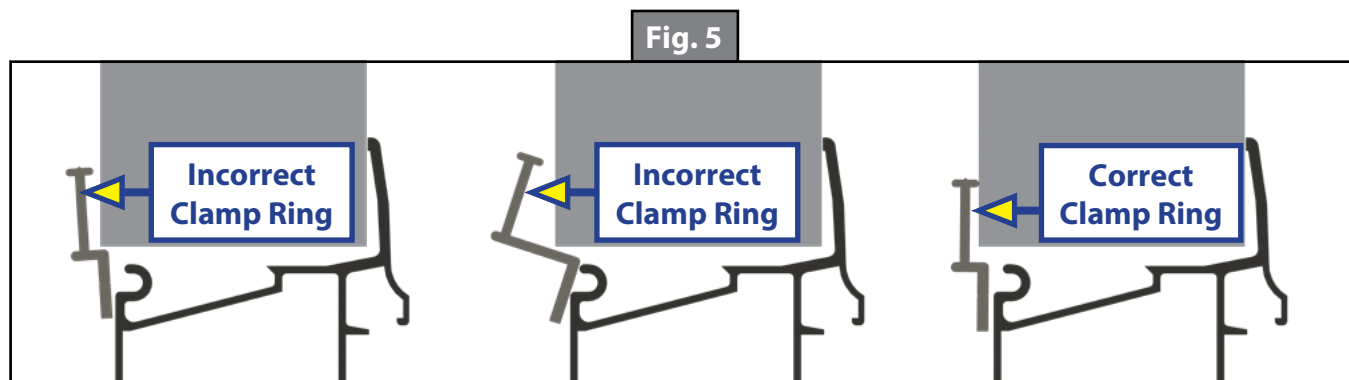
NOTE: Regardless of installing a radial or a square corner window, installing the clamp ring and the screw pattern along the perimeter will be the same.

1. Insert the clamp ring (Fig. 4A) into the opening from the interior of the RV. The ring should fit inside the opening around the entire perimeter. If there is interference, remove the ring and check for correct rough opening size.
2. Make sure the part of the groove the screws get inserted into is visible through the clamp ring holes along the perimeter.
3. Install eight #8 screws following Figure 2 screw pattern (Fig. 4, 1-8). Partially tighten these screws. Driving the screws in all the way can cause a stripped-out or broken screw head.
4. After the eight screws are partially installed, follow the screw pattern (Fig. 4, 1-8) and completely tighten the screws.
5. Install and completely tighten the screws in the remaining clamp ring holes, going all the way around the perimeter of the window.

Fig. 4

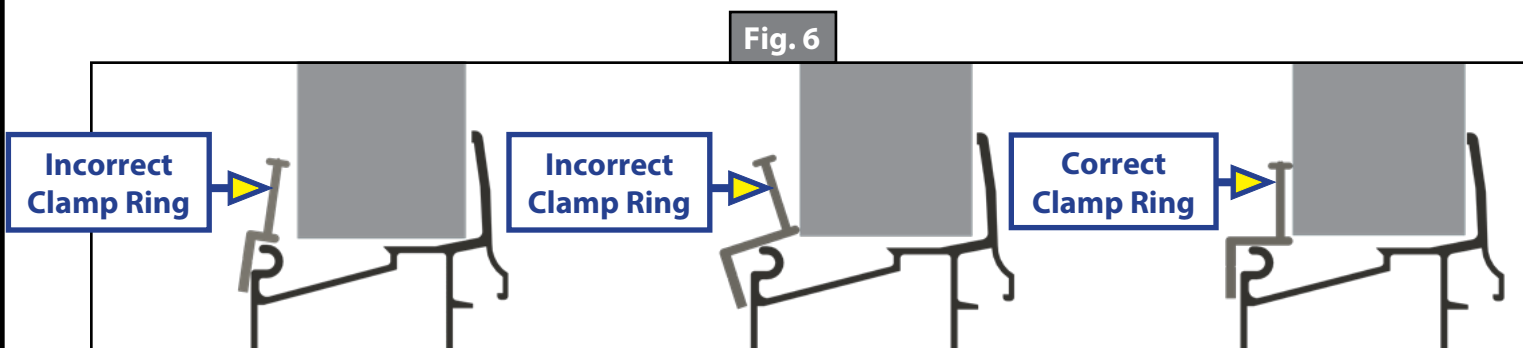


NOTE: The clamp ring should fit parallel to the opening after installation is complete. See Figure 5 for examples of correct and incorrect clamp ring installation.



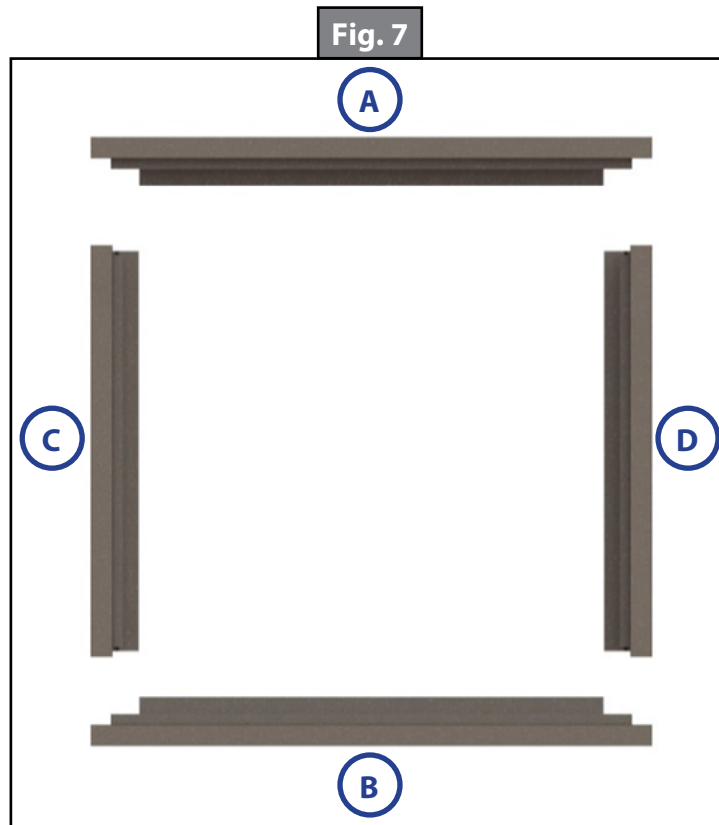
Thin Wall Clamp Ring Installation

1. Flip the clamp ring (Fig. 4A) 180° and insert it into the opening from the interior of the RV so that it "cups" over the window. The clamp ring should fit inside the opening around the entire perimeter. If there is interference, remove the clamp ring and check for correct rough opening size.
2. Do steps 2-5 of the Clamp Ring procedure in the Installation section.
3. The clamp ring must fit parallel to the opening after installation is complete. See Figure 6 for examples of correct and incorrect clamp ring installation.

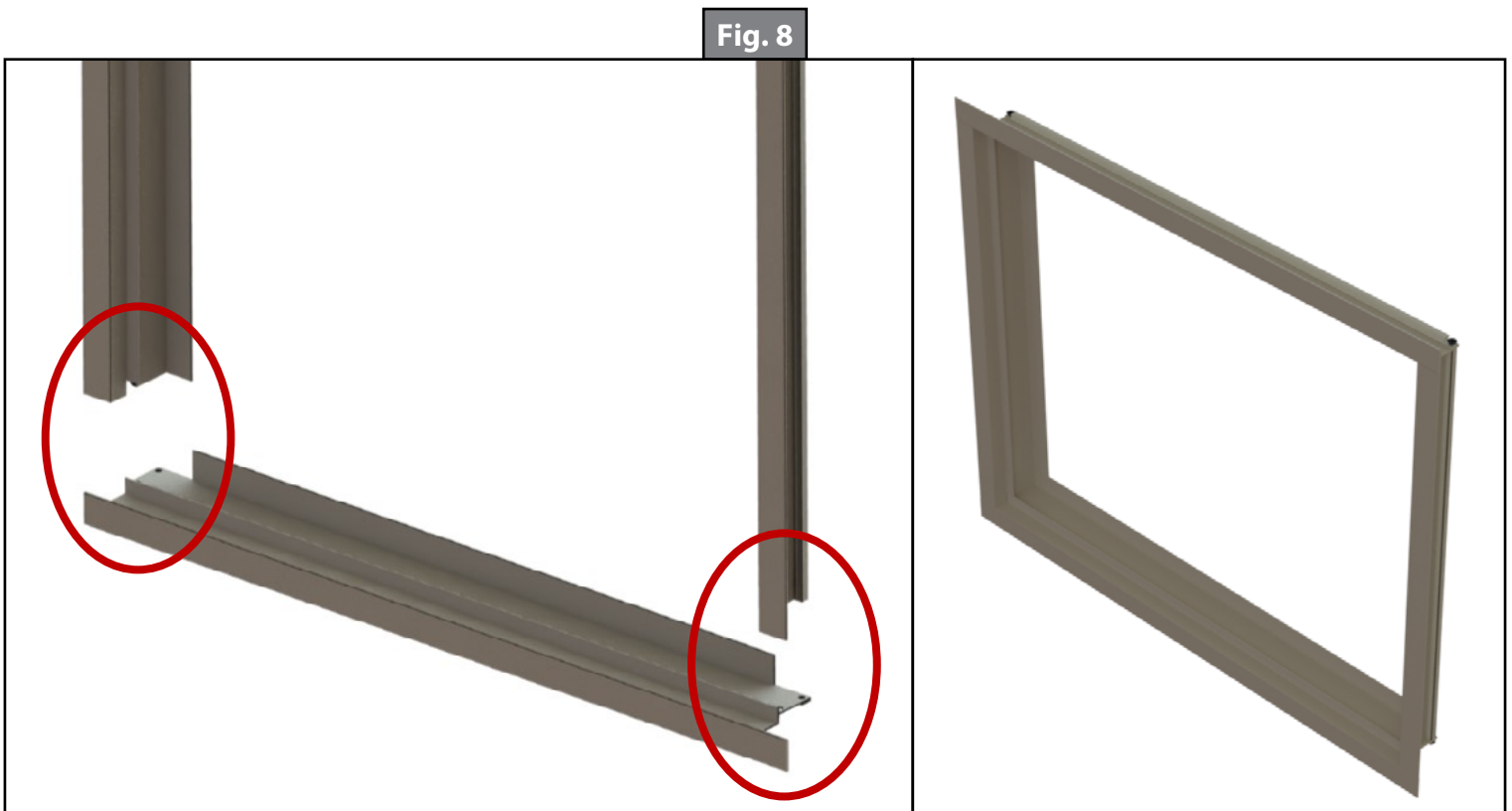


Trim Piece Installation

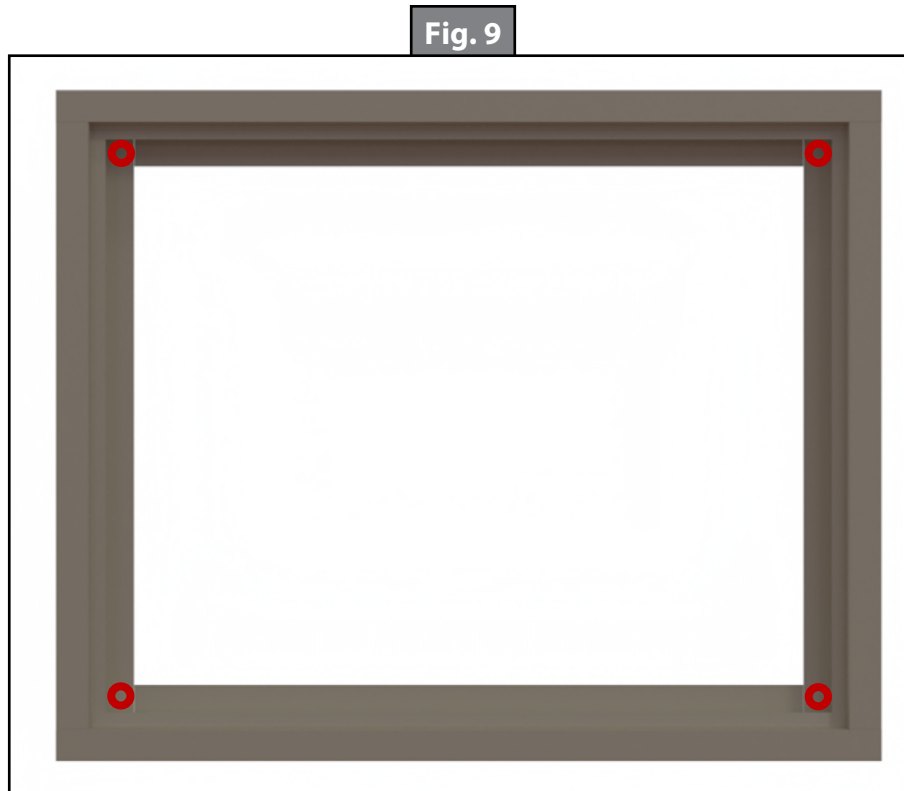
1. Install the Top/Bottom pieces (Fig. 7A and Fig. 7B) centered in the rough opening.



2. Install the side pieces (Fig. 7C and Fig. 7D) as shown in Fig. 8.



3. Loosely insert a screw into each end of each piece where overlapping, as shown in red in Fig. 9, to hold the pieces in place. Adjust parts as needed. Once all pieces are properly aligned to be square and level, tighten the screws in a star formation.



Post-Installation Check

Check box when all items are completed on checklist.

- Window openings are cleanly routed out.
- Window openings are square measured corner to corner.
- Corner radius blocks are correct and flush to the edge of the opening.
Radius block 3 5/16" for a 3 1/8" radius and 4 3/16" for a 4" radius.
- Measuring the width first, opening matches the call size on the label of the window.
Tolerance is +/- 1/8". Up to +/- 3/16" is a Fail. Over 3/16" is a Critical Fail.
- Windows are not installed on a sloped surface unless they are 2000 or 3000 series non-sliding windows.
- Sealant is applied around the edge of the mounting flange.
Sealant should overlap at the bottom of the window.
- Window is installed in the closed position.
- Trim ring is installed with #8 screws by starting in the corners.
Screw pattern is followed during the installation process.
- Window is pulled tight against the out side of the RV.
- Trim ring lays flat on the wall. Are there gaps in the corners.
- Window opens and closes properly.



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