



#1 Direct Source 4 GEM Car  
Performance Parts  
&  
Accessories  
ride4fun@optonline.net  
631-544-9572



Please note that these instructions are available online at the following address with other information that may assist with the installation process:

[www.ride-4-fun.com/instructions](http://www.ride-4-fun.com/instructions)

### **Tools needed**

- 1 Drill.
- 1 sharp 1/8" drill bit.
- 1 sharp 9/64" drill bit.
- 1 #1 Phillips head screw tip.
- 1 #1 Phillips screw driver.
- 1 #2 Phillips head screw tip.
- A pencil and a tape measure.



### **Packing List**

<b><u>QTY</u></b>	<b><u>Description</u></b>
1.....	Driver Side door
1.....	Passenger Side door
2 pcs. ....	55" Flex-Rail
24.....	Flex-Rail screws (#6 w/ #4 head)
26.....	Common-Sense studs
52.....	1/2" pan head screws

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This is a full picture of a finished product.

1. Install a 55" piece of Flex-Rail to the inside of the tube-frame as shown. (Adhesive tape is provided on the back of the Flex-Rail to help position it before securing.)
2. Start Flex-Rail tight at front bottom as shown, making sure the Flex-Rail is at the inside bottom of frame.
3. Remove tape and stick into position.
4. Using a 1/8" bit, drill holes approximately every 6" through center of Flex-Rail into frame. Be sure to drill a clean hole with a sharp bit as it will enable the screws in the next step to be installed easier. Do not go to the next larger bit as the screws will be too loose.
5. Use the #6 w/#4 hd screws provided to secure Flex-Rail. (Repeat on apposite side.) NOTE: It is Ok to start these screws with a power tool however they can not be over tightened as accidental over tightening will split the flex rail or brake the screws. It is best to start the screws with a power tool and then finish off with a Phillips screw driver. You want the screws snug but not over tightened.
6. Slide door into place.
  - a. Optional – welt can be secured into Flex-Rail by using a 1/2" pan-head screw on either side pulling taut in-between.

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Exterior common sense screws can now be installed.

7. Pull door into position making sure it is reasonably centered as possible.
8. Mark 1 crucial snap at a time. Be sure the door is not too taut. It will stretch in heat and tighten in cold weather. We recommend that the installation is not done in direct hot sunlight or excessive temperatures.
9. Use a pencil and draw inside shape of snap.
10. Center stud over mark (in the same position as the elongated hole).
11. Use 1/8" bit and drill each hole.
12. Secure with 1/2 " pan hd screws.
13. Once enough studs have been installed to position door correctly, all in-betweens can be done.

Finish by installing upper inside studs. Use the 9/64" drill for these holes.

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## 2 Door Gem Car Rear window installation process

1. Line up the rear window in the rear window opening of the car to determine best placement of the Velcro strips.
2. Install the Velcro strip across the inside top edge of the rear window opening.
3. Install the rear window with the window attached up to the upper Velcro.
4. Make note of the positioning of the remaining Velcro strips to secure the window – if you have a 07' or newer GEM please read the note below

### Important note for 07' and newer 2-Door GEM vehicles

1. On these models a slight modification is required for the rear window to fit around the rear swivel pak latch.
2. When installing the bottom part of the window an upside down “U” shape will have to be cut out of the bottom of the window and a break gap will need to be cut in the bottom Velcro strip.
3. Line up the window to carefully determine where the material will need to be cut.
4. Use a marker to outline the upside down “U” shape that will need to be cut and use scissors to remove the “U” shape piece of material from the rear window.



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