



721 W. Monroe St. New Bremen, Ohio 45869

(419) 629 1969

## Remove Vent Windows and install One Piece Door Glass

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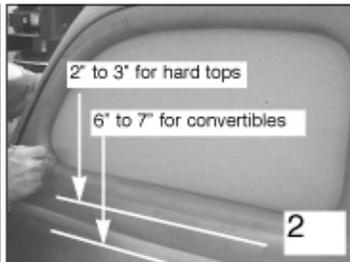
- 4- VERTICAL CHANNELS
- 4- UPPER MOUNT SHAFTS
- 4- LOWER FLAT BRACKETS
- 4- LOWER L BRACKETS
- 4- SPEED NUT CLIPS
- 4- BOLTS
- 4- 1/2" X 6" 18 GA. STRIPS



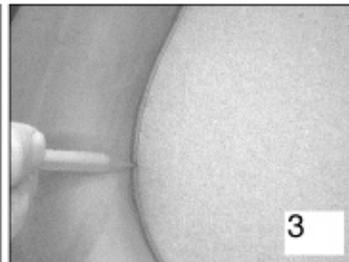
### STAGE 1 MAKING THE DOOR GLASS PATTERN



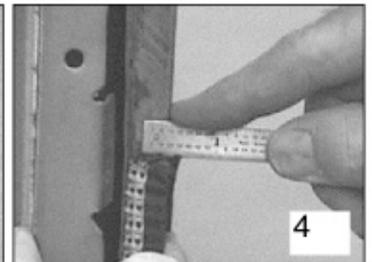
1 Remove all the hardware from the door. Cut away any metal that interferes with the glass where the vent window was.



2 Trace the window opening onto a poster board or thin cardboard. The pattern must be long at the bottom.



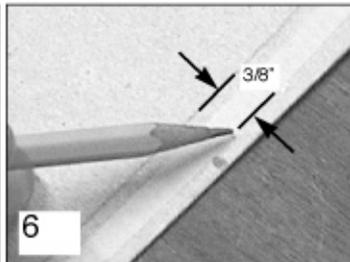
3 Use a sharp pencil and be accurate.



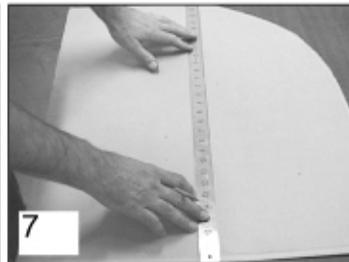
4 The glass will set in 3/8" from the edge of the opening so you have to increase the size of the pattern 3/8".



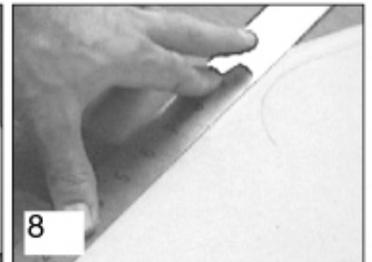
5 To do so tape a line 3/8" from your traced line. For best results use 1/4" masking or fine line tape.



6 This line is the outer edge of your glass. You will need to trim this very accurately so the glass shop can cut your windows.

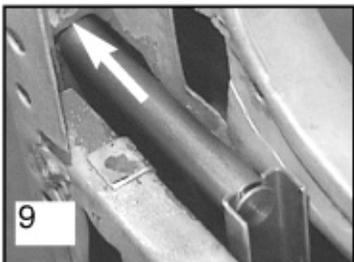


7 The back line of your pattern should be square. Measure from it to get a **parallel line** at the front.

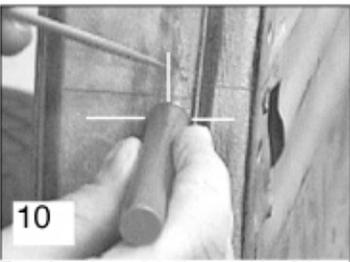


8 Draw your parallel line at the front straight down from your 3/8" offset line.

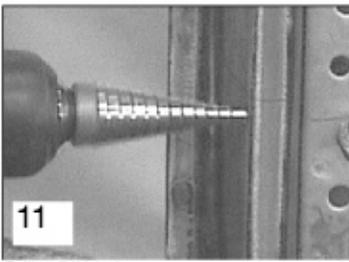
### STAGE 2 INSTALLING THE WINDOW CHANNELS



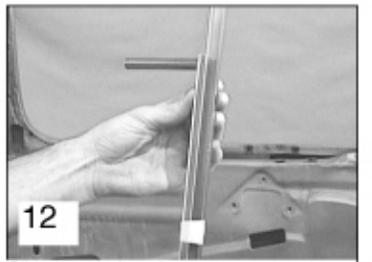
9 Hold the channel and shaft in place and mark the center position of the shaft.



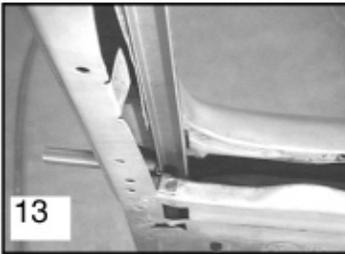
10 Transfer this mark to the out side of the door.



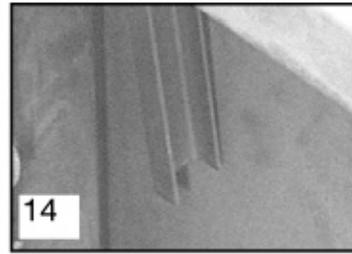
11 Drill a 5/8" hole so you can slide the shaft through.



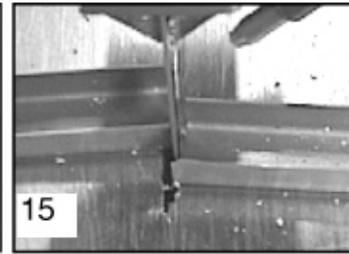
12 Slide the shaft on to the channel and then tape another channel to it as shown.



13 Slip this set up into place and check the fit.



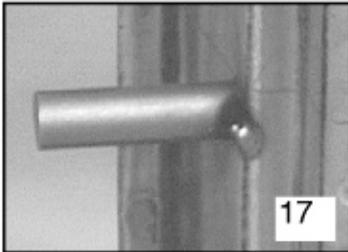
14 If the channel is hitting the door skin at the bottom, trim the channel back.



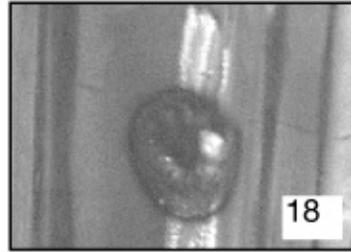
15 Our installation on this '40 Ford required the removal of 4". **Note: trim all four channels.**



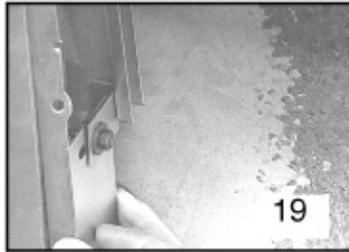
16 Slide the assembly back into the door. Align the channel and tape or clamp in place.



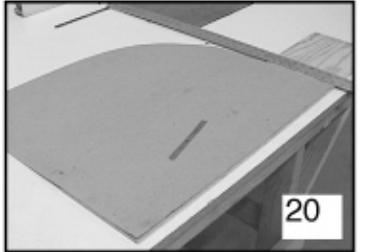
17 Tack weld the shaft then cut it off flush with the door.



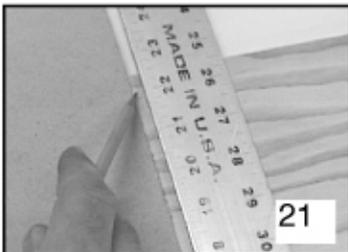
18 Weld around the shaft and be sure to get good penetration.



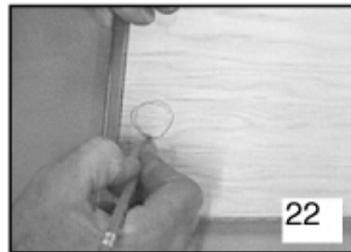
19 Set up the lower brackets centered on the slots and weld in place. If your door is not open like this one you will have to slit the door like we show in picture #32



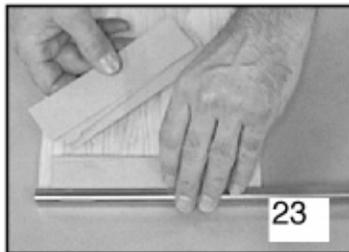
20 Make a 1/4" plywood template of the bottom end of your pattern.



21 Cut the Plywood 1/4" larger than the poster board pattern. This compensates for the thickness of the felt channel.



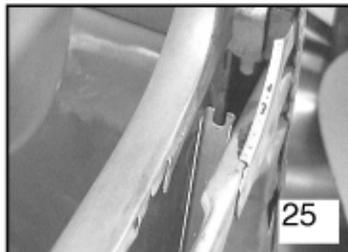
22 At the back of the board drill a large hole 3" from the bottom. This is so you can clamp the board to the channel.



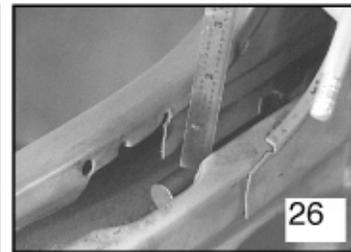
23 Slide the front channel on the board and keep it flush at the bottom. Stuff cardboard strips between to make the channel very tight against the board.



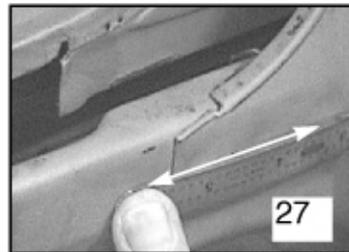
24 Slip it into the door and slide it into the back channel keeping the board flush with the bottom of the channel. Stuff cardboard strips and clamp the board to the channel where you drilled the hole.



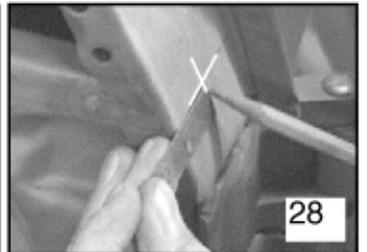
25 If every thing is good and tight the front channel will be suspended in the proper position.



26 Slip the shaft onto the channel backwards. This way you can measure the depth and transfer the position onto the inner door.



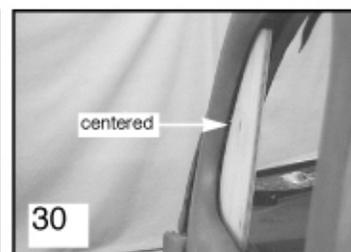
27 Here is the horizontal center position of the shaft.



28 Continue around to the front of the door and mark the center. Now drill and weld the shaft into place as shown in pictures #17, #18



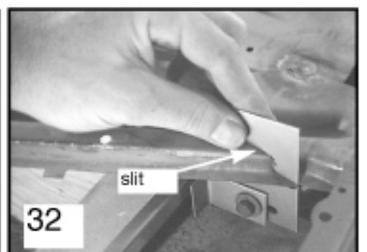
29 From your pattern cut out a board to represent the front of the glass.



30 Wedge the board into the channel with cardboard strips. Move the bottom of the channel until the board is centered.



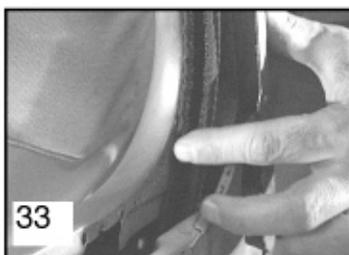
31 With the board centered determine the position of the lower mount brackets.



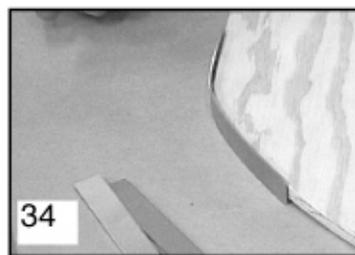
32 Here we had to slit the door to position the mount brackets. Once everything is centered go ahead and weld the brackets in place.

### STAGE 3

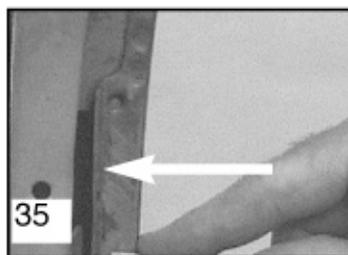
## MODIFYING THE VENT WINDOW AREA TO ACCEPT THE NEW GLASS



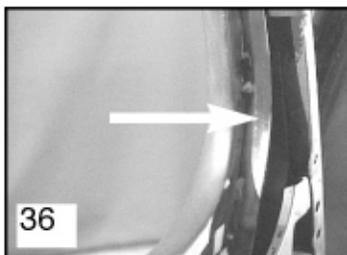
33 At the front where the vent window was you will need a bracket to hold the felt in place.



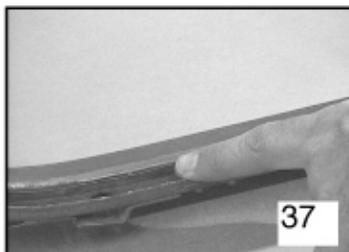
34 Use your wood template of the front of the glass and the metal strips provided to bend a bracket the proper shape.



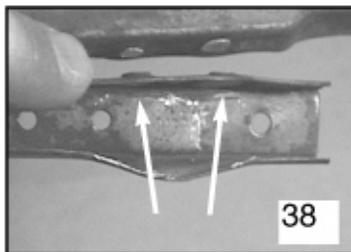
35 The bracket sets back about 1/2" from the edge of the opening.



36 Use the wood template to position the bracket and weld it in place. Install as many brackets as necessary.



37 If your inside window trim has the vent window support channel you will need to remove it. To do so.....



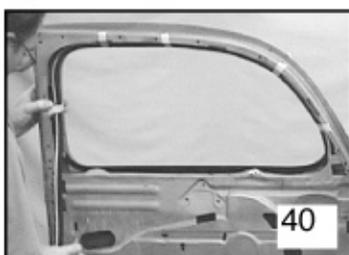
38 grind the heads of the spot welds from the inside of the channel and wiggle the channel. The spot welds will break loose.



39 The channel will come off mangled but the trim will stay straight. Clean up the edge of the trim then check the fit on the car.

### STAGE 4

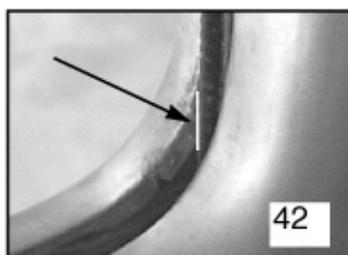
## INSTALLING THE GLASS RUN CHANNEL AND WHISKER SEALS



40 Press the Glass Run Channel (GRC) into the new steel channel at the front and rear and tape the GRC around the top.



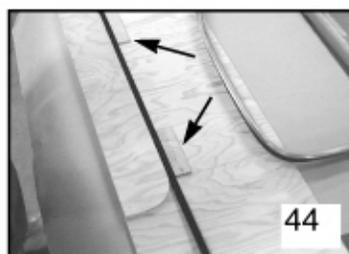
41 Drill 1/8" pilot holes and install the screws. After you drill its a good idea to slide a scribe into the hole to keep it located. Note: you can also glue the GRC in place.



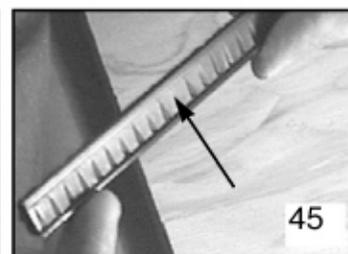
42 Now mark where the GRC sets on both the inside and outside. This is where the whisker seal will be trimmed.



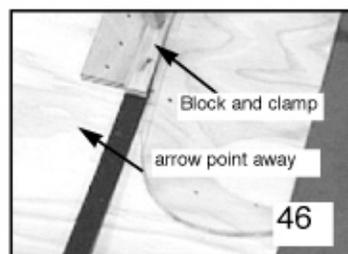
43 You need to make a forming jig out of 1/4" plywood to shape the whisker strip. Scribe the inside of the window channel onto the plywood.



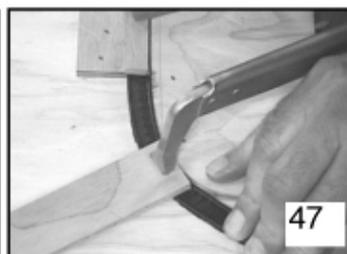
44 Cut out the form and attach it to another piece of plywood, then lay the whisker strip against it and install two blocks to hold the strip tight against the form.



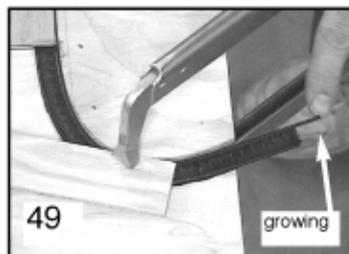
45 Look at the back of the whisker strip. The arrows must point AWAY from the form.



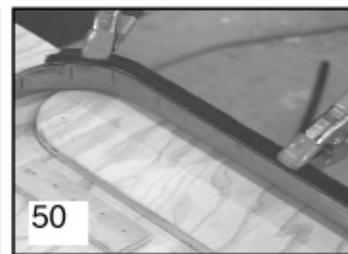
46 Hold the whisker down with a block and clamp. Make sure the arrows are pointed away from the form or the whisker will buckle.



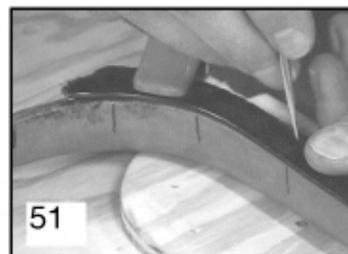
47 Begin forming the whisker. Clamp it as you go and go slow. It is easy to buckle the whisker if you are not careful. Hint: It's a good idea to practice on the end of a strip.



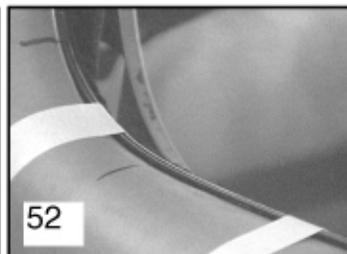
49 Wiggle the end of the whisker as you go to keep the inside bead loose. The inside bead must grow as you bend the whisker.



50 Once formed position the whisker on the window trim. Trim the whisker to the GRC line shown in picture #42.



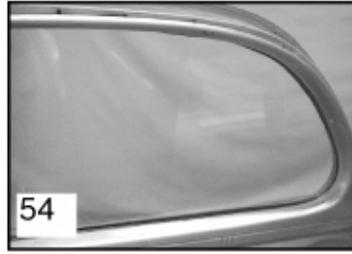
51 Mark the positions that are good for the screws and drill 3/16" holes in the whisker. Then clamp the whisker to the trim and transfer the hole positions.



52 Drill 1/8" pilot holes and install the whisker. Do the same on the door.



You are ready for the glass. Your local auto glass shop can cut the window glass from the pattern you made in the beginning.



The glass should slide easily but should also feel snug in the GRC.



Proceed with the set up of the window regulators.

If you need whisker seals, rubber seals, glass run channel or other items please call us at:

To order call 1-888-464-2426