

1953-55 SOLID SIDE CURVED GLASS KIT

#@\$!*@#\$\$% INSTRUCTIONS
MID FIFTY F-100 PARTS 1-800-252-1956

INST-91724

PART NUMBERS

91724

91725

PAGE NUMBER

1 OF 1

CAUTION

EMPTY TOTAL CONTENTS IN BOX
BEFORE REMOVING THIS CHANNEL

Thank you for choosing one of our kits. We are especially proud of our 1 piece Ford bent glass truck kit. By the use of our *patent pending* design and the ease of installation instructions we know this product will give you years of care free operation. By the use of simple tools you should be able to install your windows on finish painted trucks because of our new design bent glass. Please read over the entire directions before attempting to install this product. By following each step it will help you stay away from the frustrations many people experience working inside a door. Please set out a weekend to do this project.

Step #1: Remove old glass, vent assembly and channel. The removal of the regulator is recommended in step #4.

Step #2: The two brackets under the vent assembly are to be cut in half. Bend them straight down into the door. This will give you an area to glue your lower felts to as described in #10 later in the directions. There are also two upper tabs in the vent area in the way of the new glass line. The upper tab has a small hole in it. Drill a 1/8" holes through that holes and straight out through the metal on the edge of the door. This hole is to fasten a channel in step #7. Now remove the upper two tabs in the glass line. These two tabs unlike the lower tabs are to be cut flush with the bottom edge of the pocket. This is easily done with a die grinder or careful use of a hacksaw. The tabs are connected by a strip of metal that is spot welded to the door. After cutting remove the tabs and strip by prying it back and forth and breaking the welds. Take your time and it will eventually break loose. Now you should have an open pocket in the entire vision area of the upper half of the door.



Step #3: It is important to have a 3/4" gap in the glass opening. This gap, where the window passes through, is necessary in order for the windows to roll up and down properly. If the gap is too small use a body spreader to open the opening to the proper 3/4" gap. Some doors we have done have had a smaller opening although most doors are 3/4". If your door is less than 3/4" take the time to correct the problem. Failure to do this may result in sticking glass.

Step #4: The stock channel on the locking side of the door has to be modified just a bit. Remove the two lower screws and loosen the upper one holding the channel. Swing the channel towards the outside skin and refasten it using only one screw making the channel angle more toward the outside. The end of the channel will be approximately 3/4 of an inch from the door skin. Examples, on the driver's side door use the left hole to screw into the right hole of the bracket another simpler way to do this procedure is to simply switch the channels. Left driver's door to right passenger door to left drivers door. Doing this puts the angle of the glass into the proper parallel making the end of the channel 3/4" from the door skin.

Step #5: Tighten (if possible) the three top hinge bolts that fasten the door to the hinge. Close the door and check that it is hung properly. Make any adjustments if necessary. Now remove the single bolt in the hinge: the bolt closest to the center of the door. Set the bolt aside for you will be reusing it later.

Step #6: Look down into your 3/4" gap on the vent side of the door. Notice that the top hinge and some sheet metal is in the way. This material can be removed by the use of the template provided. Tape the template to the door lining up on the edge of the door and sliding it over the regulator post. Please remove the handle first. The solid line of the template represents the existing hinge hole and the dotted line is the hole to cut. Mark the panel where the dotted line is in the corners.

SEE PICTURE #1

Note when you are making this cut that you will be cutting two pieces of metal at the same time. You can use a jigsaw by drilling a series of small holes in the corner to start the blade. The use of a die grinder with a thin also works quite well. In any case the metal under the panel plate is the metal you are trying to remove. The distance under the panel plate is the metal you are trying to remove. The distance in-between the metal is up to 2 1/4 inches apart. Keep that in mind when making your cut. Try to cut straight down as possible. The outer panel will be reused and refastened so try to do a neat job. Once you have cut through both metals you will have an upside down "L" shaped hole.

SEE PICTURE #2

Notice that you have cut the end hole of the hinge completely off. In fact a properly cut hole cuts 1 1/4 of an inch off the hinge. Don't worry you will be drilling a new hole soon. You are close to having the clearance you need. The top of the hole, (SEE TEMPLATE) has to be a clearance of an additional 1 1/4 inches up. This part of your template is marked 00000000.

SEE PICTURE #3

Note: Do not cut the top metal. If you cut the top metal your door panel will not cover the cut. By the use of a die grinder or using a drill and a small drill bit remove the material underneath. You need to only remove the metal 2 3/4 inches wide and 1 1/4 inches up. I know this is a little difficult so take your time. This metal has to be removed in order that the window will have enough clearance. If your cutting device is not strong enough to cut through the 1/4" hinge, prop up the door and remove the hinge. Cut 1 1/4 of an inch of the hinge and replace the hinge.

Step #7: Take the long 38" galvanized channel. Note that there are two blocks attached to one end. This end is the top. Take the channel and feed it down the vent side of the door with the blocks up and facing the cleared vent channel. The hole in the top block needs to be positioned over the hole you drilled in step #2. Fasten the channel with the screws and nuts provided. The head of the screws goes into channel with the nuts on the outside. Cut off the excess after fastening. Note that the channel fits snug into the opening. Push the channel all the way in till the blocks are touching the metal of the top hinge. With the back of the galvanized channel pressing against the side of the cut off hinge take a tape measure across the other steel channel. You need to measure from inside of channel to inside of channel no less than the opening and remove it. You have to have from 29 1/8 to 29 1/4 inches in this area for your glass to work properly.

Note: two wooden sticks cut to 29 1/8 inches long and 3/8 inches thick can help to keep a parallel opening. Wedge the sticks in the opening inside the channel. One at top in galvanized channel just below the bend and across to the other side. The other one inside at the bottom of the two channels. Now the opening should be 29 1/8 inches all the way down. With the sticks in place take a tape measure across the middle of the opening where the hinge is. If you have 29 1/8" opening drill a 3/8" hole through the hole in the bracket through the hinge plate. Fasten the channel to the hinge plate with a 1 1/2" X 3/8" bolt and nut. Now you can take out the wood sticks and set them aside for when you do the other door.

SEE PICTURE #4

Step #8: Take the large "U" shaped channel and note there is a front and a back to it. The REAR side of the channel is marked with a yellow mark, be sure this goes to the backside of the door. Insert the channel through the 3/4" gap from the outside of the door. DO NOT try to put the channel in from the bottom of the door. Before putting the in it's final resting place, use a little silicone and glue all the spots where the channel will rest. Taking your thumb press the channel in the groove of the door until it conforms neatly to the opening. By the use of a 1/4" block of wood you can run it in the felt to open up the glass groove to help break in the new felt. Trim the felt on the lock side of the door so that the bottom clip in the metal channel can be bent up to hold the bottom of the felt. If the clip is gone use the teck screws provided and fasten it at the very bottom of the channel. Repeat the procedure to the other side. Note: Do not put teck screws where the glass is going to run. Use teck screws only at the very bottom of the felts.

Step #9: Now look at the glass. Note there is a left and a right side. The bracket on the bottom of the glass is where the regulator hooks up. This goes to the backside of the door with the more flat side of the bracket to the outside. Take the correct side and turn the glass on end (front side first) and slide the glass through the 3/4" gap in the top of the door. Once inside turn the glass the correct way with the channel at the bottom. Let the glass rest at the bottom of the door. Install the spring-loaded bushings in the groove on the bottom of the glass channel with the springs facing inside. Installing new bushings is recommended. NOTE: Do not try to put the glass up through the inspection hole in the bottom of the door. Also by taping the edge of the glass with masking tape and putting a towel in the bottom of the door helps prevent scratches to the glass. Take the tape off the edge of the glass (if used) and slide the glass up the channels taking care that the glass stays in the channel. Slide the glass all the way up. Watch carefully and see if the glass touches any unwanted metal inside the door. If it does, remove the glass and go back to step #6. If the glass slides evenly up and down with the push and pull of your hand the glass is properly installed. If the glass is a little stiff it is due to new felt and will loosen up in time. To aid in this problem use a little dry graphite between the glass and the felt to let the glass slip more freely. Lower the glass to the bottom of the door bracing it with the towel to prevent scratches. Note: You need to lower the glass only lower than 3/4 from the bottom of the glass opening in order to have room to install the lower felts.

Step#10: Install the two weather strips. Note there is an inside and an outside. The ends of the strips tuck behind the U shape channels. Hold the strips and mark where the strips slip behind the upper felt.

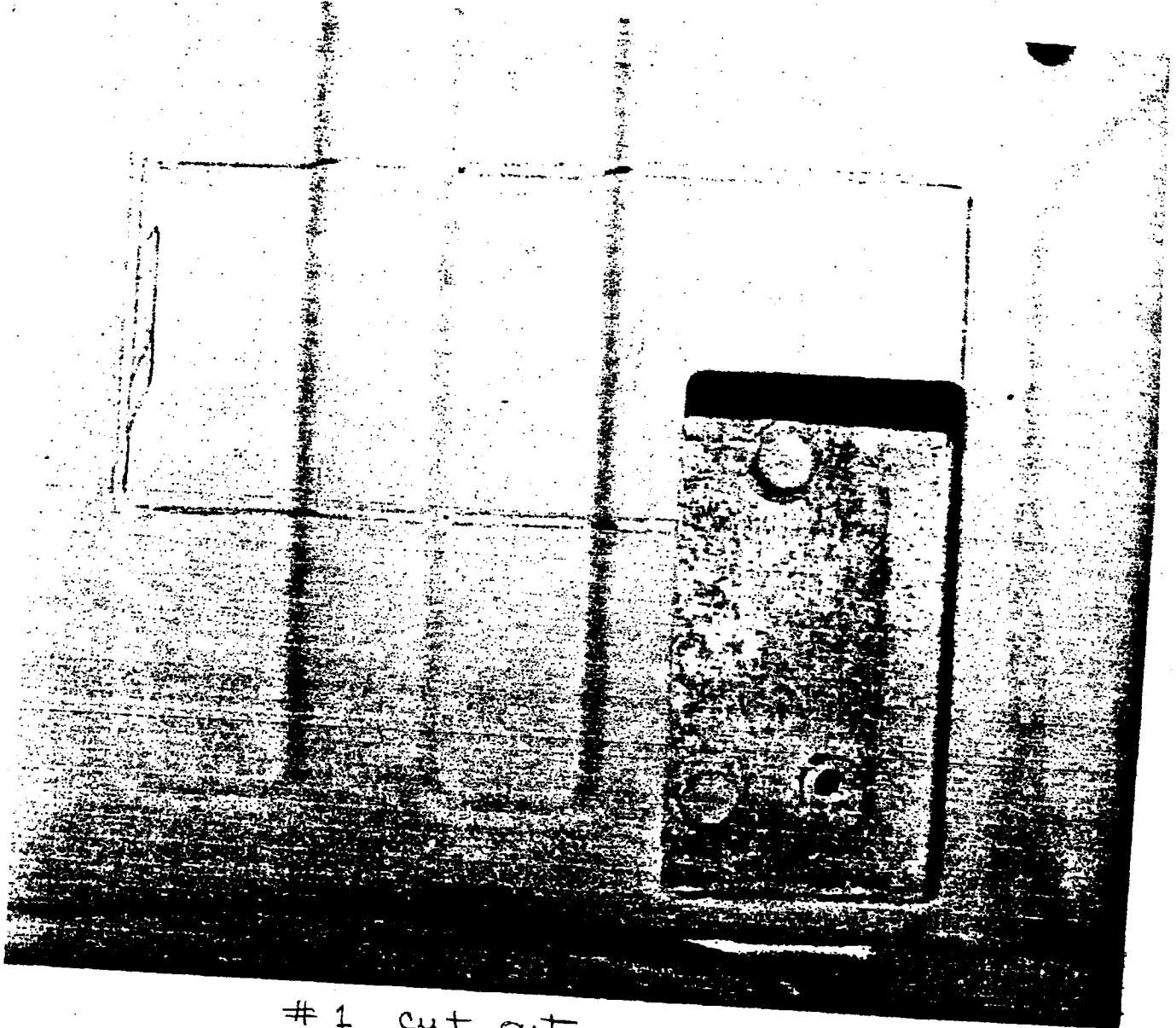
Take the felt on a hard surface and hammer the end that tucks behind the upper felt flat. Do this on all four ends. Failure to do this will cause the glass to stick in the corners where these three felts meet. Snap the felts in. Silicone can be sued on he end of the strips of the vent side where there is no green clip. To have nice looking lower felts make sure they fit your truck as close as possible before snapping them in. Take your time and hold them up checking the bends and location of the clips before installing into the opening. If they need to be bent more, gently bend it with your thumb and fore finger. Do this before you flatten then ends. After you flatten the ends the felt will not bend. The use of a little grease on the green clips helps them snap in a little easier. Once the felts are snapped in they can not be removed so be careful and take extra time to do this procedure. It also helps to mark where the clip holes are because you can not see the holes once the channel is in place. To snap the clip in push your thumb at the face of the felt till you hear it snap in.

Note: One of the biggest mistakes made in the 1 piece glass installation is the installing of these felts prior to this step. Do not do this. You will ruin the felts when you try and put the glass in the door!

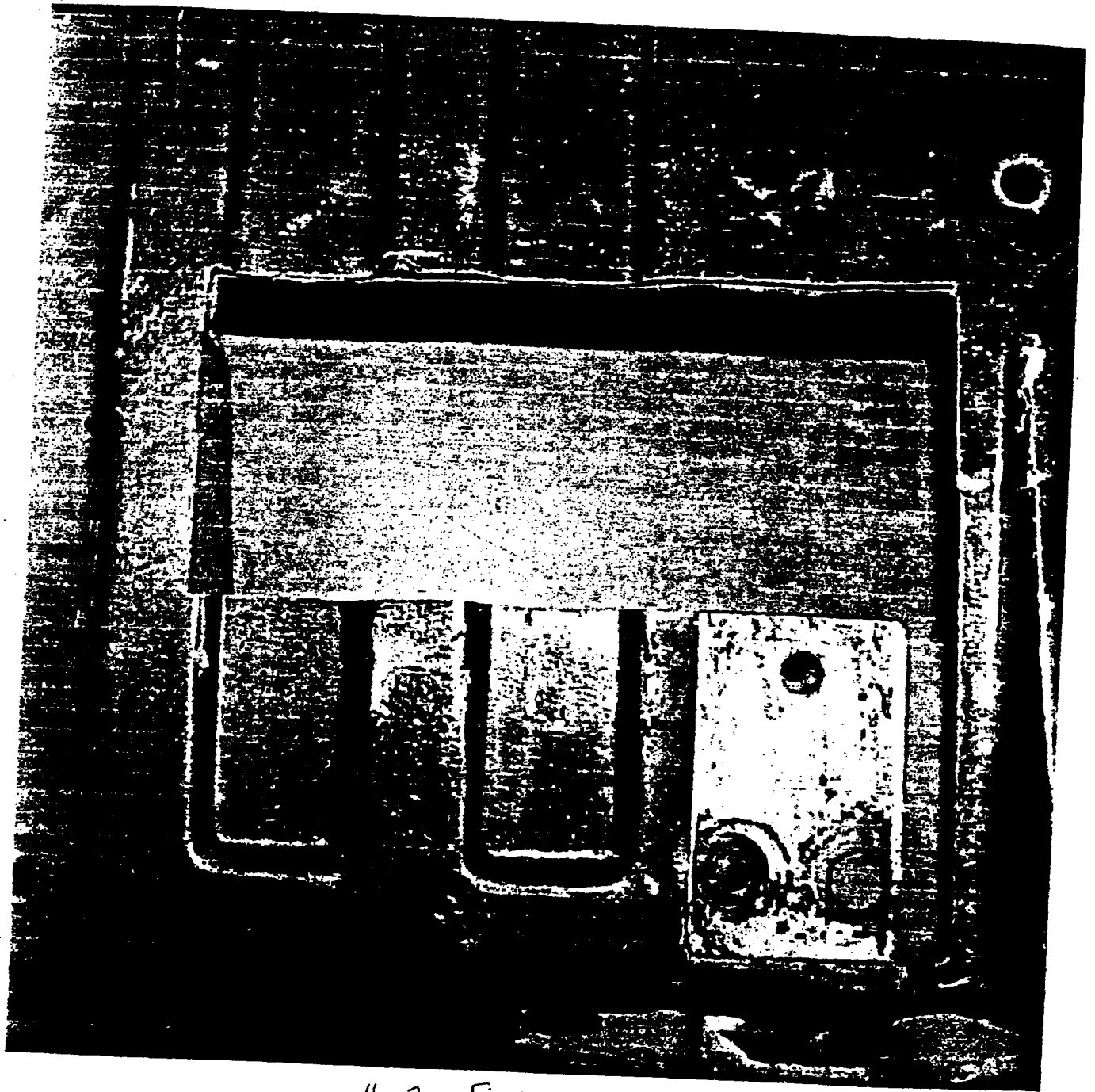
Step # 11: Slide the glass upwards making sure it stays in the U shape channel and the glass does not dislodge the weather strips. Install the regulator and fasten the bushings you installed in step #9 to the regulator. Crank the window al the way up.

Step #12: Roll the glass up and down to make sure the glass is in the same plane and goes up and down smoothly. The glass should be snug from side to side but not too tight that the opening is too small for the glass to pass freely. Probably a little loose is better than too tight. NOTE: If your glass will not roll up and down properly your sides are not parallel to each other or you have not cut enough metal material under the vent. If you are experiencing this problem take some time and correct the problem by checking these two things. A properly installed glass will role up and down in a smooth motion. Be sure to grease, (white type) on the lower slide where the regulator slides back and forth. Also a little graphite (dry type) in the felt will make the window go up and won a littler easier until the felts wear in. Install the panel plate you cut out using the four steel brackets provided. The use of pop rivets is recommended. You may need to use some washers to properly shim the panel in line with the rest of the panel.

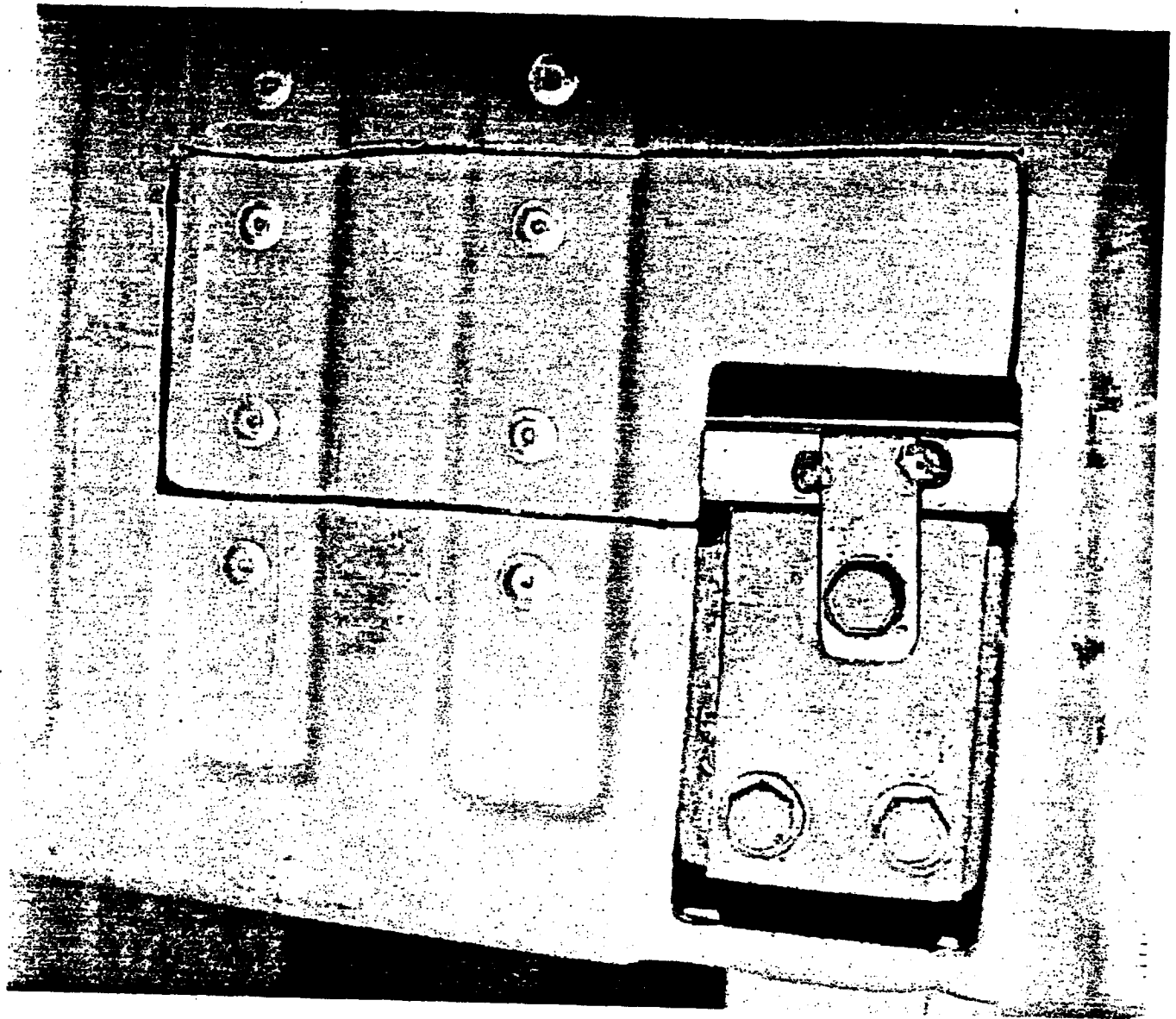
See Picture #4



1 cut out



2 Finish cut



#4 Finished product

Cut out hole



Line up to 3/4" Regulator hole

Do not cut top metal!

2 3/4

1 1/4

Cutting 1/4" off hinge

2 1/2

6 1/8

3"

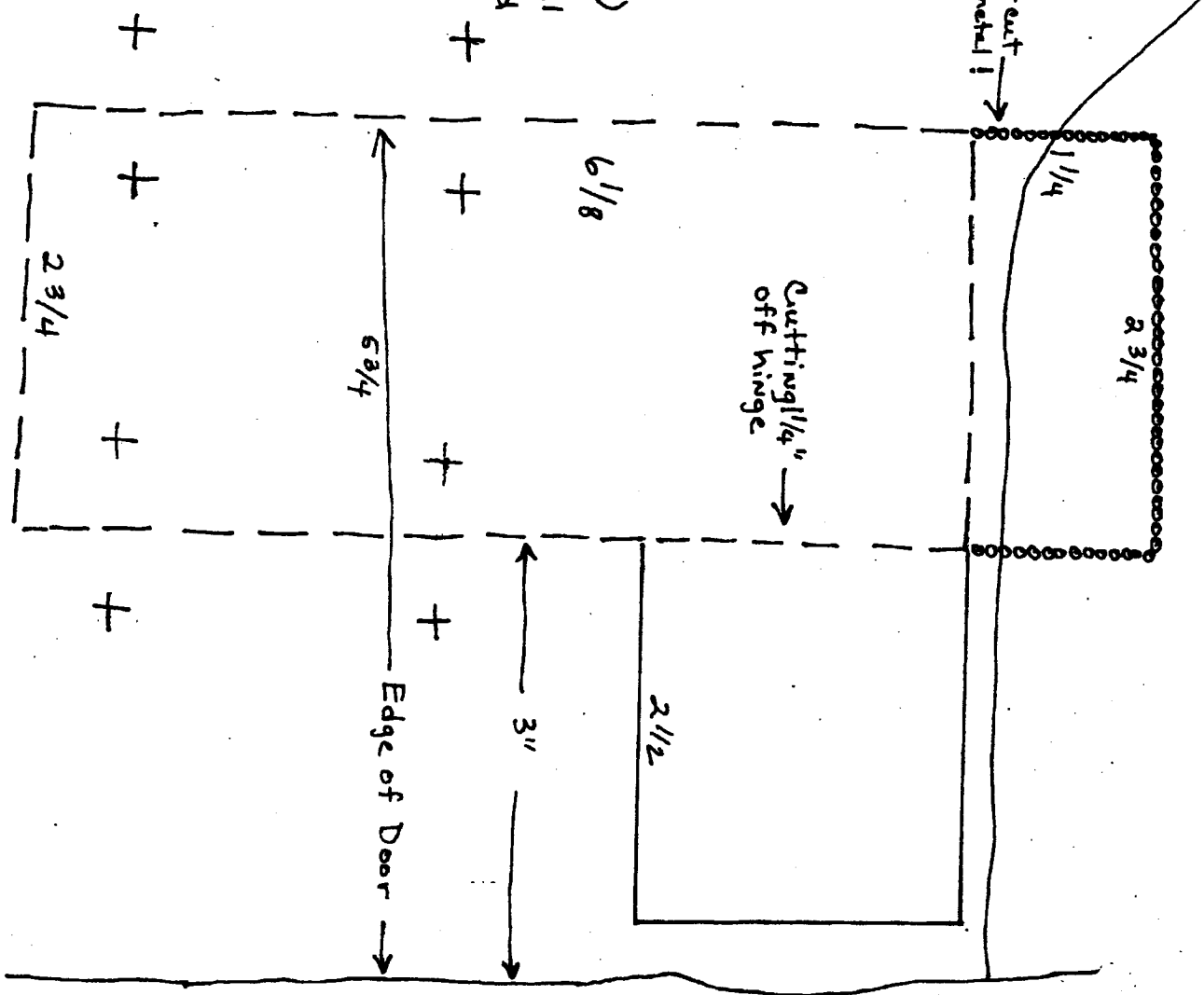
5 3/4

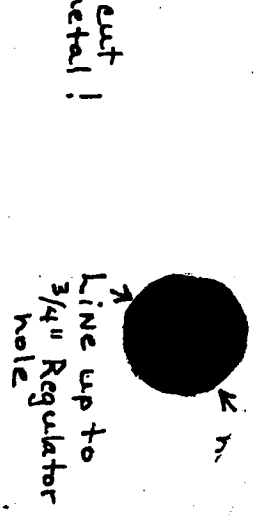
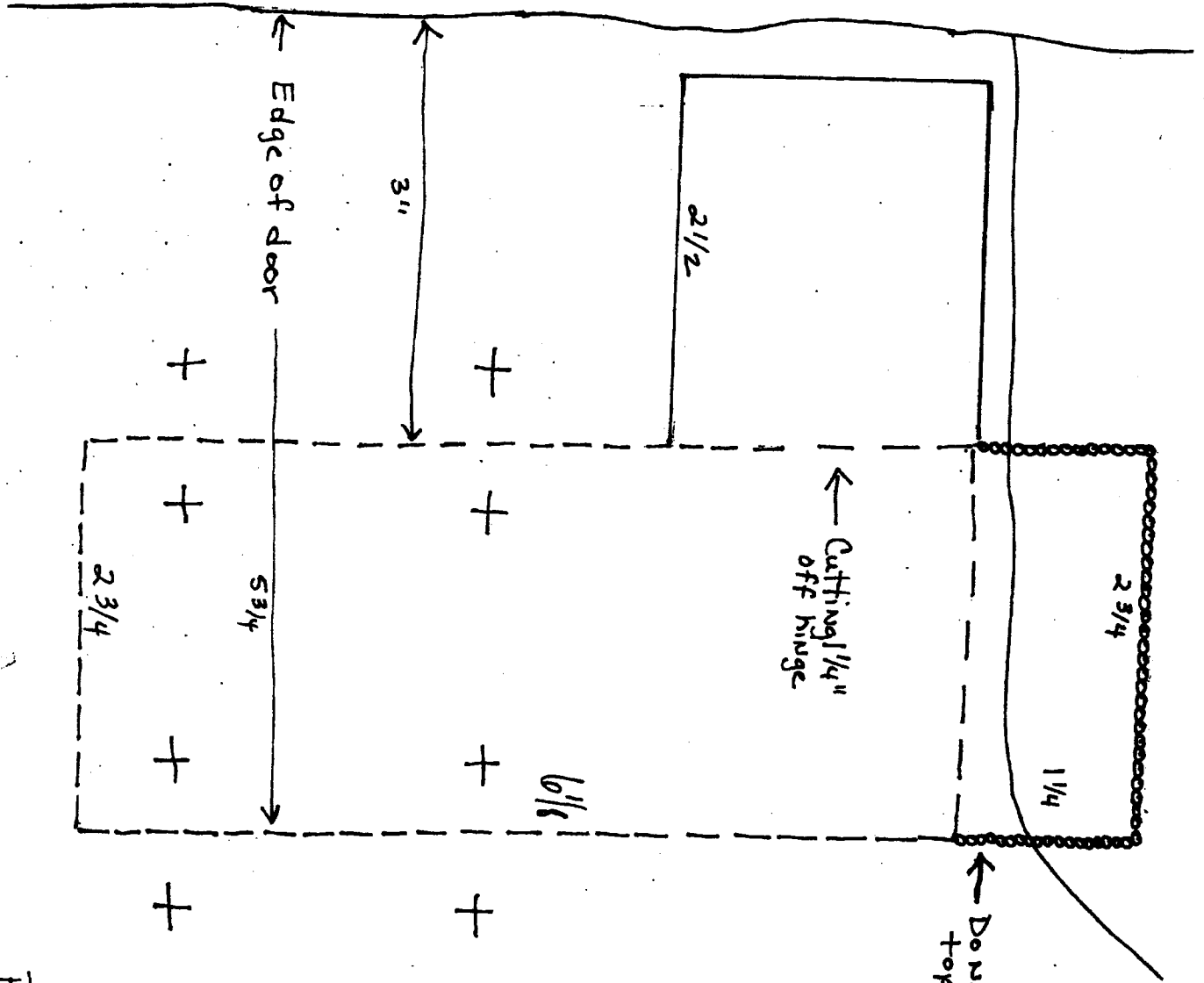
Edge of Door

2 3/4

- Existing hole
- - - Cut line (2 1/2" thick)
- + 1/8" hole (for brackets)
- ooooo Cut metal under panel This is to be removed leaving top metal in place.

Left Side





- Existing hinge opening
 - - - Cut line (2 1/2" thick)
 - + 1/8" hole (for bracket)
 - ooooo Cut metal under
- Panel. This is to be removed leaving the metal in place

Right Side