

73-87 One Piece Window Conversion



BROTHERS Strongly recommends use of these written instructions in conjunction with the Video Instructions available on our website or our YouTube Channel. To quickly open our video instructions use your cell phone to scan the QR code seen here. Follow along and pause video as necessary to keep you aligned with your progress. We also suggest you watch the video once prior to beginning this project to help you get familiar with the process.



Kit Contents:

- * 2 Side Glass (Left and Right)
- * 2 Metal Front Glass Channels (Left and Right)
- * 2 Rear Channel Modification Brackets (Left and Right)
- * 1 Door Handle Modification Clip/Template
- * 2 Regulator Rollers & Hardware Kit
- * Glass Felt Channels, Felt Scraper set & Glass Tape

Tools Required:

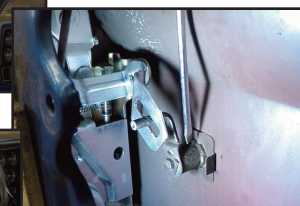
- * Hand/Die Grinder or Angle Grinder with Cut-Off Wheels and Grinding Wheels
- * Drill & Drill Bits
- * Pop Rivet Tool

This project will also require common garage tools and supplies such as Screwdrivers, Open End, Box and Ratchet Wrenches, Pliers, Paper Towels, Shop Rags, etc.

Project Overview:

BROTHERS One Piece Window Conversion Kit will walk you step-by-step through the process of eliminating your trucks original Vent Window and replace it with a One-Piece solid glass.. Our Kit will eliminate any guess-work and give you a finished product that operates like original, seals better, eliminates leaks and wind noise and is simple enough to do in your own garage!

During development and testing of this product, we have routinely been able to complete the project in a single day. With the recommended tools and supplies ready, we estimate a DIY installer can finish this project in 6-8 hours.



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Disassembly & Prep

Begin by removing your trucks door panel(s). We recommend doing one side at a time and not trying to do both doors at once.

Next, remove your old Felt Scrapers (also called Beltline Moldings or Window Fuzzies) and your old Glass Run Channels. It may be necessary to remove the rubber bumper inside the bottom of the door to allow the glass to roll down far enough to remove the Felt Scrapers. If your truck is painted, we recommend applying a layer or two of masking tape to the painted areas to avoid doing damage during this project as shown in figure #1.

Once the weatherseals have been removed you can remove the Vent Window. The Vent is held in by 3 screws at the front of the upper door frame as shown in figure #2, and two lower bolts as shown in figure #3. Pull the vent away from the top corner of the door and lift it out, twisting it inward to clear the lower bracket as shown in figure #4.



With the vent out, roll the glass all the way up and out of the door frame at the top. Make sure you are supporting the glass with your hand so it doesn't fall outward. Push the glass forward until the front roller of the regulator lines up with the opening in the glass Sash as shown in figure #5. Using a screwdriver or similar tool, pry the roller out of the Sash and lift the front of the glass away from the door and regulator. Now you can push the glass forward and off of the rear glass roller to remove the glass and the attached Sash.



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Prep Continued

Next, remove the LOWER bolt of the UPPER door hinge and the UPPER bolt of the LOWER door hinge. Replace these two bolts with the 3/8" x 1/2" bolts and washers supplied in your hardware kit as shown in figure #6.



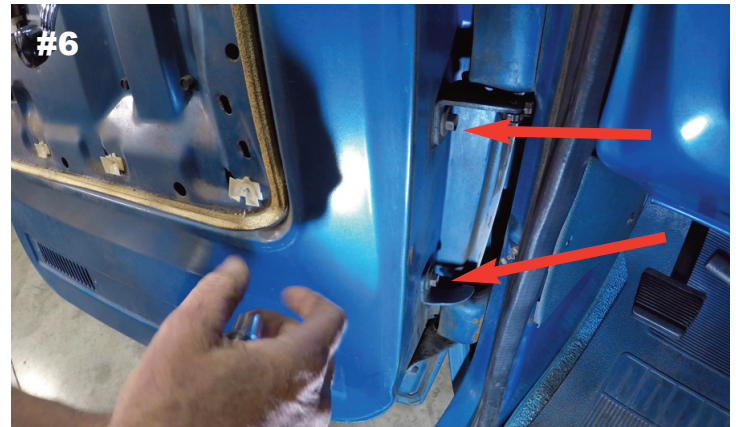
Remove the rear glass channel. There are two bolts holding it in, one at the top in the door jamb, and one at the bottom as shown by the Red arrows in figure #8.



Scan this QR Code for
Handle Removal Video

Remove the Door Lock by sliding the lock retaining clip off of the lock. Use a screwdriver to push it off or grab it with a pair of pliers and pull it forward to disengage it from the lock as shown in figure #10.

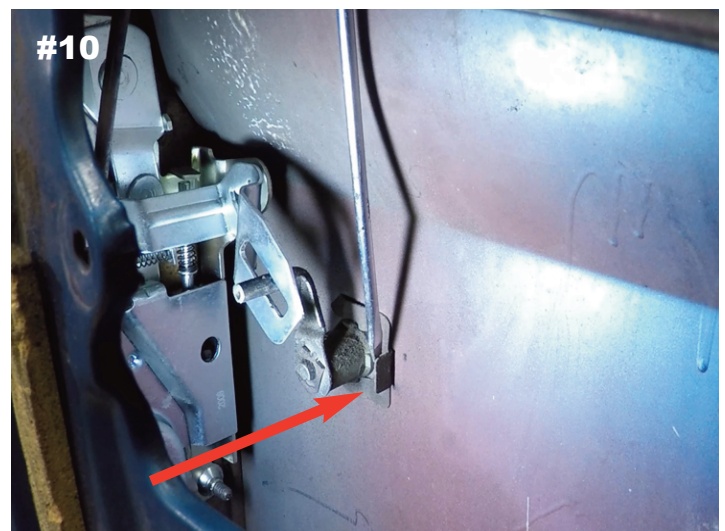
**You are now done with Door Prep
Next Up - Modifications**



Using an angle grinder or hacksaw, remove the vent window support brace as shown in figure #7. It may be necessary to remove a large sheetmetal screw before you can remove the brace, although these are often missing.



Remove the Outside Door Handle. For specific instruction on Squarebody door handle removal, check out our YouTube channel or scan the QR code shown in figure #9.



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Modifications:

Door Lock Shaft:

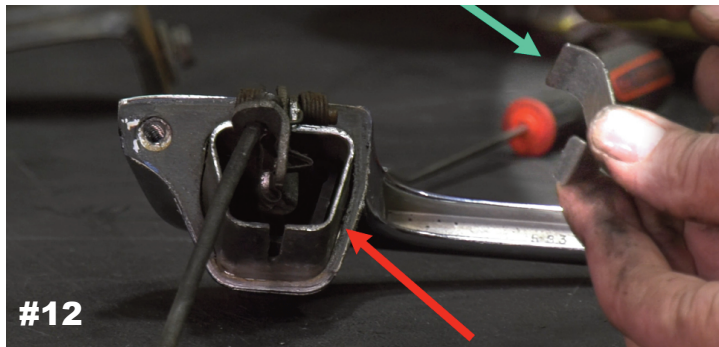
Start by cutting 3/8" off the door lock shaft as shown in figure #11. Once you have cut the extra length off the shaft, you can re-install the door lock back into the door by reversing the steps described in the Preparation section.



#11

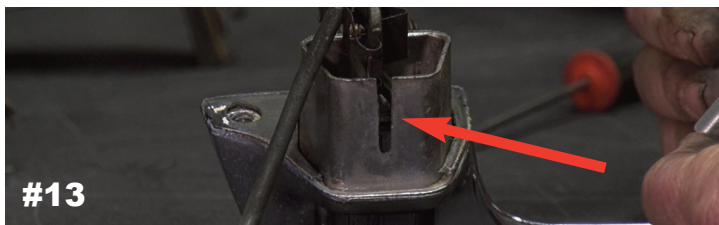
Door Handle and Button:

Locate the Door Handle modification clip/template in your kit. The clip is shown in figure #12 marked with a Green arrow, and where it mounts on the handle is marked with a Red arrow. It is **VERY IMPORTANT** that the clip is mounted on the FRONT part of the handle, or the portion of the handle that would be closest to the FRONT of your truck as the Red arrow indicates in figure #12.



#12

Align the little tab on the clip with the slot shown in figure #13 and press the clip onto the door handle. Using a scribe or a marker of some type, mark the handle all the way around the clip to give yourself a path then remove the clip.



#13

Next you will cut off the section of the door handle you just marked. We recommend using a Dremmel with a cut-off wheel, but you can also use a Die or Angle grinder or a hacksaw. Once you have made your cut and removed the material, clean any burrs off the cut area and make sure you still have smooth operation of the push button before proceeding. Your results should look like the handle shown in figure #14.



#14

The final step in the modification of the handle is to cut the plastic button. Press the button until the end of the plastic "slider" is flush with the end of the housing on the handle as shown in figure #15 and cut that section of the plastic off of the button.



#15

Once you've cut the plastic slider there should be a little of the base of the slider left as shown in figure #16. At this point you should check again for smooth movement, add some grease and re-install the handle into your trucks door.



#16

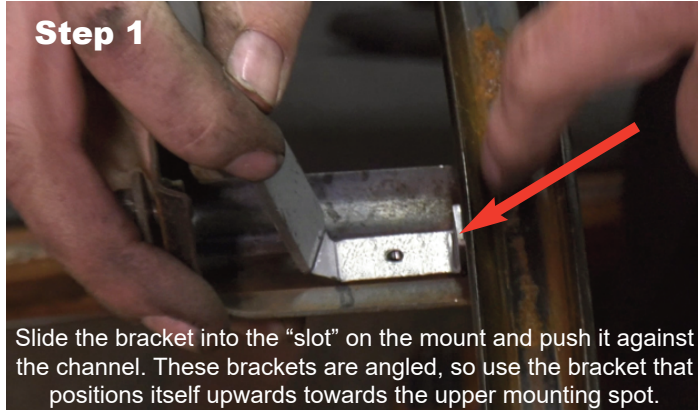
**Modifications continued
next page**

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Modifications cont:

Rear Glass Channel:

You will be modifying the lower mounting bracket of the rear glass channel. You will use the supplied bracket to mark where to cut the channel and to drill a couple of mounting holes for the bracket itself. Use steps #1-4 below to guide you through this modification.

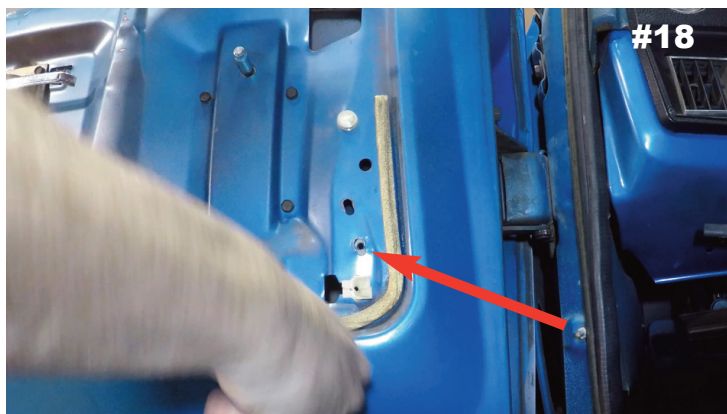


This is what your channel should look like when you are done with this modification. Notice the new bracket extension is angled upwards towards the upper mount and the bolt that holds the new bracket extension to the channel is screwed in from the back, which will allow it to clear the door latch assembly.

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Installing the Front & Rear Channels

Install the rear channel exactly as it came out using the original mounting holes and hardware that you removed from your truck during disassembly as shown in figure #17.



Install the new front glass channel into the door from the top using the wide area just behind where the vent window used to be. Hanging on with your fingers, move the channel forward and dangle the channel in the door while aligning the lower mount of the channel with the lower hole where the bottom of the vent window was attached as shown in figure #18. Attach the lower mount using one of the 1/4x20 Phillips Pan Head bolts supplied with your kit.

Center the top of the front channel with the channel of the door as shown in figure #19, and mark the hole in the top of the channel using a marker or a punch. Using your mark, drill a 3/32" hole and attach the upper part of the channel using the #10 Sheetmetal Screw supplied with your kit.



For best results, the slotted "extension" on the upper channel mount, shown in figure #20, should be tucked **BEHIND** the metal "lip" of the outer door skin when mounted. Your new Felt Scraper will be attaching to this extension later in the project, so having it behind the lip will allow it to sandwich the lip and provide additional support for your seal.

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Install your new Glass Run Channel. Make sure the slotted or relived portion of the channel gets positioned in the upper rear corner of the door like the original channel was installed.

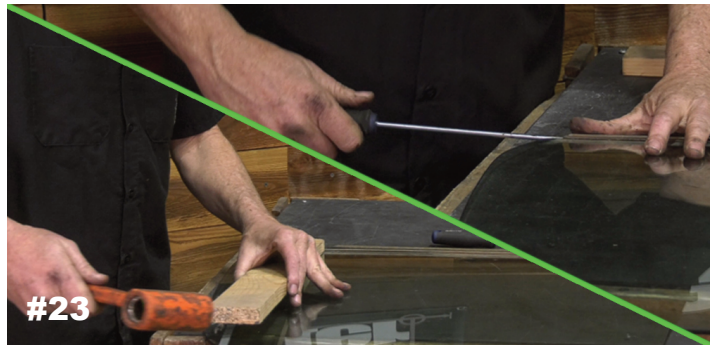
NOTE: It is often difficult to push the new seal into the new front glass channel so **BROTHERS** recommends the use of a wooden ruler or paint stir stick to help reach into the door to push the seal into place.



Next, you'll be removing the sash from your factory glass and installing it on your new One-Piece glass. Caution needs to be taken so no damage is done to the sash or the channel the rollers glide in. Remove the sash using one, or both of the methods pictured in figure #23. One is using a thin screwdriver to pry the sash at the end, and the other is using a piece of wood and a light hammer to tap the sash off the glass. Sometimes a soak with Acetone a few hours ahead helps to soften the glass tape that holds the glass in the sash.



Next, roll your window regulator all the way up and out of the door to gain access to the rollers. You will be removing the REAR roller from the regulator. Using a grinder, grind the rivet head off the roller and punch the roller out with a hammer and punch. Alternatively, you can use a 1/4" drill to drill the roller shaft to remove the roller. Removing the roller will make it easy to install the glass in the door. You will be replacing the roller later with one supplied in your kit.



Before installing the sash onto your new glass, make sure it is clean and free of any of the glue or setting tape from the old glass. Measure 1.5" from the back of the glass and make a mark, that is where you will align the sash on the new glass. Using the setting tape supplied with your kit, place the tape on the new glass and start pressing the sash on from the rear of the glass as shown in figure #24. **IMPORTANT NOTES:**

1. Make sure the opening for the regulator rollers is towards the INSIDE of the glass.
2. Your kit came with two thicknesses of setting tape. Use the tape that works with **your** sash. **BROTHERS** recommends starting with the thick tape and switching to the thin tape if the thick tape is too thick to fit the glass into the sash.

Using a plastic or rubber mallet, tap the sash onto the glass as shown in figure #25 working from the back to the front. It's recommended to use a piece of wood to distribute the impact of the mallet to reduce the possibility of damage to the sash. You aren't trying to smack it down all at once, take your time and tap the sash onto the glass. When the sash bottoms out you should start to hear a different tone from the mallet as you make connection with the glass, this means you are done.

It should take some effort to work the sash down, if it goes on really easy, then you have probably used the wrong tape thickness.



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#26



You are finally ready to install your new one-piece glass into the door. The glass will go in from the OUTSIDE of the door frame. First roll the regulator up as shown in figure #26 so you can see the front window regulator roller.

IMPORTANT NOTE: If your truck is equipped with power door locks you MUST complete the steps in the power door lock supplemental instructions BEFORE installing your new one-piece side glass.

#27



Coming from the outside of the door frame, drop the front of the glass into the rubber glass channel at the front of the door and slide the sash onto the front regulator roller as shown in figure #27. As the roller enters the sash start to roll the window down and lower the rear of the glass into the rear channel at the same time.

#28



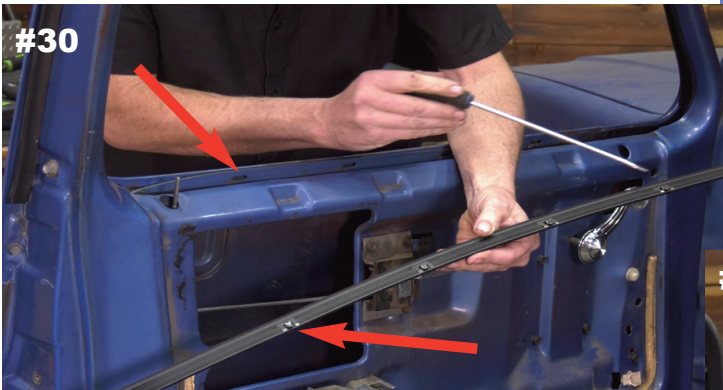
Once the regulator is rolled down approximately 5-6" you should start to see the sash aligning with the hole in the regulator where the rear roller was as shown in figure #28.

#29



Install the roller by sliding it in from the rear of the sash and align it with the hole in the regulator as shown in figure #29.

#30



Now you can install the outer felt scraper. Start by aligning the clips with the slots in the door as shown in figure #30. Once aligned, work from the rear pushing in to lock the clips into the slots.

#31



At the front of the felt scraper, locate the slot in the slotted support that is attached to the new metal front glass channel. Once you have it located, drill a 1/8" hole that is aligned with the slot, make sure to ONLY drill through the felt scraper. Use the one of the Black sheetmetal screws supplied with your kit to attach the front of the felt scraper to the support.

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Installing the inner felt requires adjusting of placement by the installer. Like the outer felt scraper, **BROTHERS** inner felt scraper is longer than the original scraper in order to cover the distance from front to rear on ALL model years of Squarebody's. For that reason, placement of the inner felt needs to be tailored to your individual truck BEFORE using the supplied Pop Rivets to attach the felt to your door panel.

Even though they look similar, there is a LH & RH for your new inner felt scraper. The difference is subtle, but as you can see in figure #32 the rear of the felt has a slightly larger/taller curve than the front does. Make sure to identify which felt belongs on the left, and which belongs on the right before proceeding with the inner felt installation.



Begin by removing the old felt scraper from your door panel by pushing down from the top of the felt to slide the original clips off the plastic panel. Once the old felt is removed, re-hang your door panel on the door and position it in it's proper mounting place by aligning one or more of the mounting holes in the panel with corresponding holes in the door. It is helpful to use a pick or an awl to help align the mounting holes as shown in figure #33.



With the panel hung, place the new felt scraper up into a place where it fits best in the door frame and mark the felt in alignment with the rear of your door panel as shown in figure #34. It is best to position the new felt to tuck-in slightly behind the Glass Run Channel you installed previously. Trimming the rubber lip off the inner and outer of the felt at the ends can be done to fine tune the fit of your new felt scraper.

Now that you have the felt marked, removed the door panel from the door and use spring clamps or standard "C" clamps to hold your felt in place as shown in figure #35.



Make sure when you clamp your felt in place that the rubber lip on the door panel side is riding on top of the door panel as shown in figure #36 and isn't being folded or squeezed between the panel and the felt scraper.

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Now flip your panel over and make 5-6 evenly spaced marks from front to rear, this will be where you place your Pop Rivets. Using a 1/8" drill bit, drill ONE of the marks you made through the felt scraper and the door panel while pulling the rubber lip back as shown in figure #37.

#37



Use one of the supplied pop rivets and washers to attach your new felt to the door panel, the washer goes on the BACK to keep the rivet from pulling through the plastic. Once the felt is securely attached with one rivet, continue drilling the remaining holes and installing those rivets and washers. Once finished, re-install your door panel onto your door in the reverse order of how you removed it.



#38

CONGRATULATIONS!!! YOU NOW HAVE ONE-PIECE WINDOWS!!!



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