



S&W Race Cars and Components, Inc.

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CAUTION!!! - *The most important requirement for a successful installation of this, or any, S&W chassis component is that you take your time and use good common sense. Check & recheck all measurements before cutting or welding. If you have any questions, before or during the installation - STOP - and call our tech line at 610-948-7303 and we will gladly explain in more detail any step in the installation.*

Please read complete instructions thoroughly before beginning! **Installation Instructions for 95-654 Door Window Frame Kit**

- 1) Place your fitted window on a workbench, and mark the tubing pieces to bend the new window frame, following the shape of your window. Place one of your 6' long pieces of 5/16" tubing up to your window, marking the tubing with a black marker at the points on the tubing where you will need to make the bends.
- 2) Clamp the tubing bender, supplied in your kit, into a vise, and slide the 5/16" tubing into the bender, bending the tubing a little at a time where you made the black marks in step #1.
- 3) Position your fitted door window on the door at the proper location for your car. With the window in place, mark the window and the door, so you can drill 4 mounting holes along the bottom of the window, to install four 10-32 pan head mounting screws through the window and the door. Remove the window and drill the holes in the door and the window that you marked.
- 4) Reinstall the window and secure it in place with four 10-32 screws, washers and nylock nuts.
- 5) With the door closed and your window pushed tight against the top window seal of the car, position the formed window frame against the window in the car, (If your windows are bowed in for your body style car, you will need to mark the window frame and bend it in at the same angle as the window, **see drawing #2**) and locate where the three angle brackets and center support tube will go, at the bottom of the window frame, (**see drawing # 1 and# 2**). Mark the brackets and support tube for welding.
- 6) With the window frame removed from the door, tack weld the center support tube and the angled brackets in place to the bottom of the window frame.
- 7) Reinstall the frame to the door and mark the door for installation of the 10-32 mounting screws. These screws go through the brackets & door, and secure the frame to the door. After the door has been marked remove the frame and drill the door. Reinstall the frame to the door this time securing the frame to the door with the 10-32 screws and nylock nuts.
- 8) Mark the window frame for the 16 window frame mounting tabs, evenly spacing the tabs apart, (**See drawing #1.**)
- 9) Remove the window frame and tack weld the mounting tabs to the window frame at the locations you marked in step #9. **Caution should be taken when welding these mounting tabs because they are very small, thin pieces and will burn up very quickly.**
- 10) With all the tabs welded on the frame, reinstall the window frame to the door. Push the window against the window frame (checking the fit and angle of the mounting tabs you tack welded in step # 10), mark and drill the window so you can install the 6-32 screws through the window and mounting tabs.

- 11) Remove the window frame and finish welding all your brackets and tabs in place.
Note: before your final installation of the window frame, now is the time to paint or coat your window frame to keep it from rusting.
- 12) For the final time, reinstall the window frame securing it in place with the 10-32 screws and nylock nuts (you may choose to fiberglass the brackets to the door) and the window to the frame with the 6-32 screws and nylock nuts. With the window frame installed close the door slowly, so if there is a clearance problem you will not damage the door or window.
- 13) Repeat steps 1 through 13 for the opposite side window.

Parts list for window frame mounting kit part # 95-654

<u>QTY</u>	<u>PART#</u>	<u>DESCRIPTION</u>
1	95-655	Tube bending tool
6	FC-041	Angled bracket
32	60-337	Window mounting tab
2	3125x058DOMx72	5/16" x .058 DOM tubing 6 ft long
2	3125x058DOMx48	5/16" x .058 DOM tubing 4 ft long
32	65-501	6-32 x 1/2" flat head screw
32	65-500	6-32 nylock nut
20	65-507	10-32 nylock nut
20	65-511	10-32 x 1/2" pan head screw
8	65-509	10-32 flat washer

