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## DOOR WINDOW FRAME

Part # 3912

4....5/16" x .058" DOM Tube (2 Pcs. 7', 2Pcs. 4') #MIS 1102

1....Bending Fixture #3912-1

32..Window Mount Tab (1 Pc.) #3911-1

4....1/8" Universal Tab #3895

24..10-32 x 1/2" Stainless But Socket #ABT 1903

8....10-32 x 1" Stainless But Socket #ABT 1907

32..10-32 x Stainless Nylock Nut #ABT 1105

4....3/8" x 1" Bolt (Grade 5) #ABT 1390

4....3/8" Nylock Nut #ABT 1150

4....3/8" Fender Washer #ABT 1042

**NOTE:** In this kit you are supplied with a bending fixture to bend your tubing, to secure this fixture clamp in a vice. (See Drawing 2 & 4)

**STEP 1:** Bend one of the 7 foot lengths of tubing to the shape of the window two inches in from the edge. (See Drawing 5) Once this is done bend the tubing out at the bottom to meet the door jams so the large universal tabs can be welded on the end to bolt the frame to the door jam front and back. Drill 3/8" holes and bolt to the door using the fender washer on the outside. (See Drawing 1 & 5).

**STEP 2:** Remove the frame from the door and lay it on a flat work bench suitable for welding. **NOTE:** THE SIDE THAT FACES THE WINDOW SHOULD FACE THE BENCH SO THAT THE TABS AND TUBING CAN BE WELDED FLUSH FOR THE WINDOW. (See Drawing 3). Evenly space 12 of the small window mounting tabs around the frame and weld in place. Re-install the frame in the door. (See Drawing 5)

**STEP 3:** Use one of the 4 foot length of tubing to make the window support tubes for your door window frame. Cut the tubing in half and then bend one end of each piece to a 90° angle as close to the end as possible. This will be the end that mounts to your door. (See Drawing 1 & 5)

**STEP 4:** Weld two sets of window mounting tabs together end to end. (See Drawing 1)

**STEP 5:** Attach the welded tabs to the ends of the tubing that was bent in STEP 3. These are used to support the window frame. (MAKE SURE 90° BENDS ARE CUT AS SHORT AS POSSIBLE.) (See Drawing 1)

**STEP 6:** Hold the frame even with the door weather stripping. Measure from the window frame down to the top inside of the door panel for the length of the support tubes. Cut support tubes to length and weld in place. After frame has cooled from welding bolt window in frame with 10-32 x 1/2" stainless steel button head bolts and lock nuts. (**Drill 3/16" holes in window to attach to frame**). Shut door and have a friend push the window against the weather stripping to determine where to mount inside support tubes. Mark and drill 3/16" holes, bolt in place.

**STEP 7:** Repeats steps 1 through 6 for the other side.

### Related Components:

Door Latch Linkage Kit #C/E 4125



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