



INSTALLATION INSTRUCTIONS

P/N: C4900

WINDOW FRAME KIT

This kit is complete with all hardware necessary to complete the job of fabricating and installing a set of window frames for your vehicle. A tube bending tool is also provided for your convenience. Please read and follow the instructions carefully.

PARTS LIST

- | | |
|--|-------------------------------------|
| (2) Window Frame Main Tube, 7' Long | (16) 1/4-20 x 1 HHCS GR5 Clear Zinc |
| (2) Window Frame Support Tube, 4' Long | (16) Washer F Z .281ID. 1"O.D. |
| (40) Window Tab | (16) 1/4-20 Nylon Ins. Locknut |
| (40) 10-32 x .5 S/S BHCS | (1) Tube bender |
| (40) 10-32 S/S Nylock Nut | (8) Bracket Window Frame |

INSTALLATION

- (1) a. Begin by bending one of the 7ft. pieces of tubing to conform to the shape of the window, at a point in 2" from the edge of the window. **A template can be cut from a large piece of cardboard.** Bend the tube using the Tube Bender supplied in the kit. See Fig. (1). **Place the Tube Bender in a bench vise.** See Fig. (2). After bending the tubing to match your template, bend both ends of the tubing out at the bottom so they will just reach the front and rear door jams. Some trimming of the tube ends may be required.
b. Next weld the window frame brackets to the end of the tube so that they will lay flat against the door jams. See Fig. (3).
c. Bolt the Frame to the door jam, front and back. Do this by drilling (2) 9/32 holes in each bracket and using the 1/4-20 x1, hardware supplied in the kit. Use the 1"O.D. washers on the outside of the door and secure with the 1/4-20 Nylon Ins. Locknut.
- (2) a. Remove the window frame from the door and place it on a welding bench.
Note: Place the window Frame on the bench so that the side that will face the window will be down on the bench. This will ensure that the Window Tabs and the tubing will be welded flush, guaranteeing a good fit against the window. See fig (4)
b. Evenly space 20 of the window tabs, supplied in this kit, around the Window Frame and weld in place.
c. Now re-install the Frame and Bracket assembly on the door.
- (3) a. Make the Window Support Tubes for your window frame, using (1) of the 4FT. lengths of tubing. Cut the tubing in half and bend a 90 deg. angle **as close to (one end) of each tube as possible.** See fig, (5)

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COMPETITION ENGINEERING

80 Carter Drive • Guilford, CT 06437

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- b. Weld a Window Frame Bracket to the ends of each tube, at the 90 deg. bend. These will be additional attaching points to mount the window frame to the door.
- (4) a. Using whatever means available to you, I.E. a buddy or clamps, hold the Window Frame even with the door weather stripping and measure from the frame to the top inside portion of the door panel. This measurement will be the length you will need to make your support tubes.
- b. Cut the support tubes and weld in place.
Permit the Window Frame to cool before continuing.
- (5) a. Bolt window into the frame by first placing the window in position. Mark and drill, with a 3/16" drill bit, the hole positions for each of the (20) Window Tabs. Next utilizing the supplied 10-32 x.5 stainless steel button head cap screws and Loc-nuts, fasten the window to the frame.
- b. Close the door and have a helper push the window against the weather stripping to determine the correct locations for the support tubes. Again mark the window, drill, and bolt in place.
- (6) a. Repeat all steps for the other side.

FIG 1

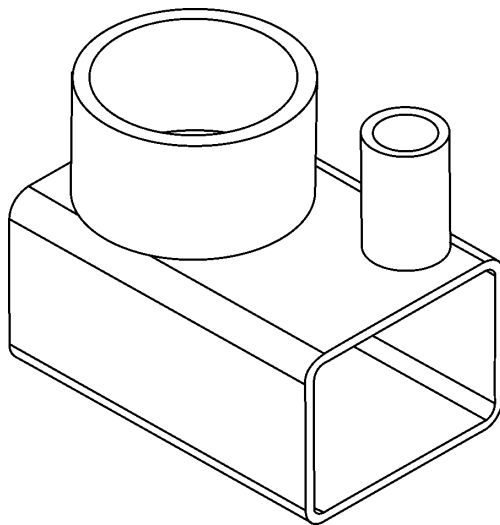
**Tube Bender**

FIG 2

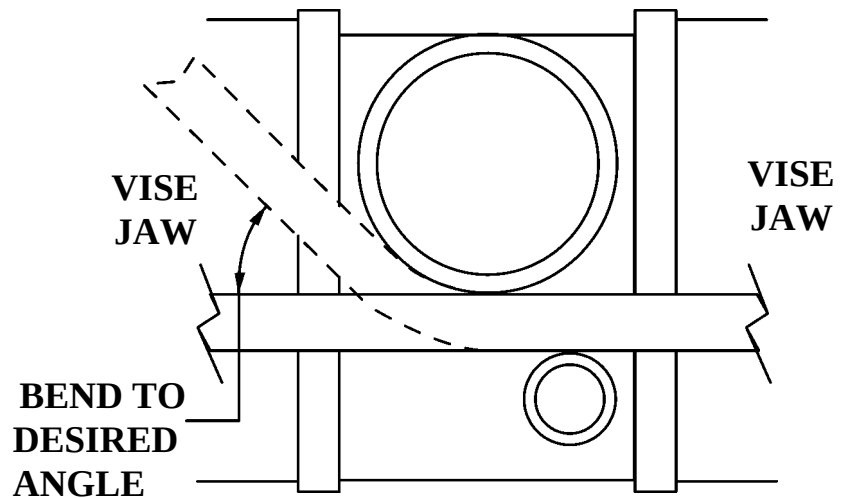
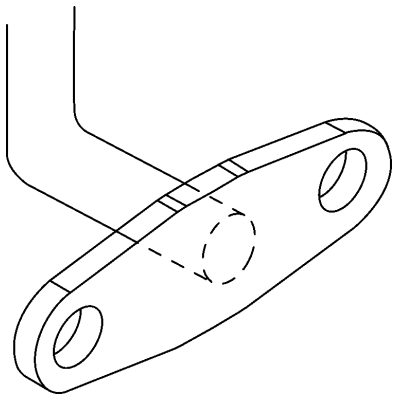
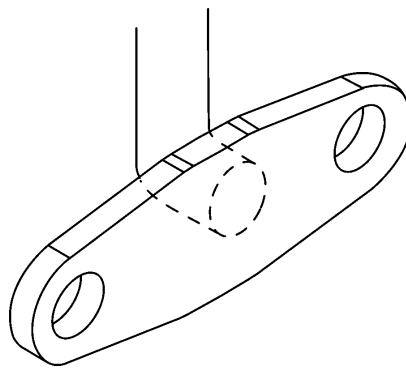
**Tube Bender**

FIG 3



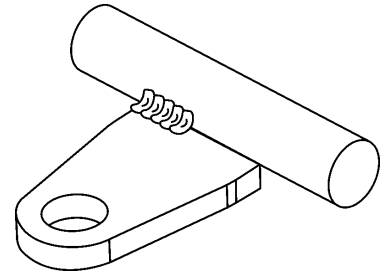
Bracket Window Frame

FIG 5

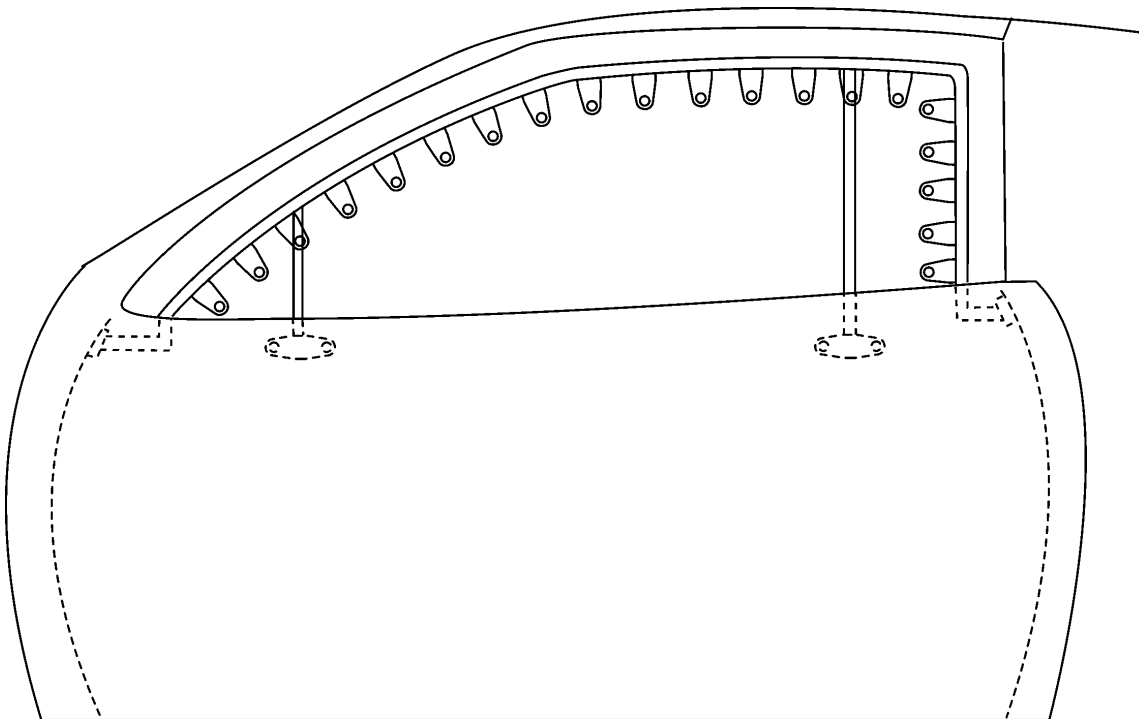


Window Support Bracket

FIG 4



Window Tab



Completed Window Frame Installation.