



Part Number: <u>2550/25551</u> Revision: <u>B</u>		Effective Date: <u>1/04/07</u>	By/Date: <u>M.PISANI 1/04/07</u>
Document Type (indicate):			
<input type="radio"/> Bill of Material	<input type="radio"/> Drawing (may be attached)	<input type="radio"/> Specification	
<input checked="" type="radio"/> <b>Assembly Instructions</b>	<input type="radio"/> Operating Procedure	<input type="radio"/> Other	

## **GTM Side Windows Installation Instructions**

### **I. Parts Included in Kit:**

<b>25863</b>	<b>WINDOW TRACK HARDWARE</b>		
25859	DOOR FRAME - WINDOW TRACK BRACKET, PASSENGER	EA	2.00
25860	DOOR FRAME - WINDOW TRACK BRACKET, DRIVER	EA	2.00
25798	BUTTON HEAD SCREW, 6 MM X 20 MM	EA	8.00
25864	6MM NYLON LOCK NUT	EA	6.00
25865	ADHESIVE, WINDOW TRACK	TUBE	1.00

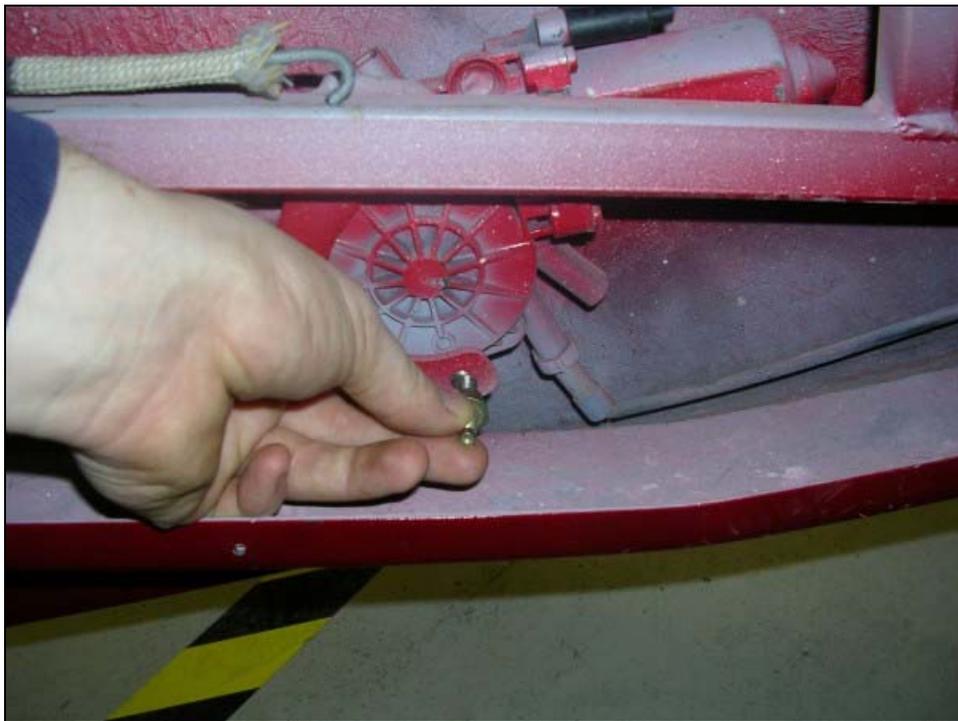
<b>25425</b>	<b>DOOR COMPONENTS</b>	<b>ASSEMBLY</b>	<b>1.00</b>
25426	POWER WINDOW SWITCH KIT	EA	1.00
25550	DRIVER SIDE WINDOW	EA	1.00
25551	PASSENGER SIDE WINDOW	EA	1.00

### **II. Tools Required:**

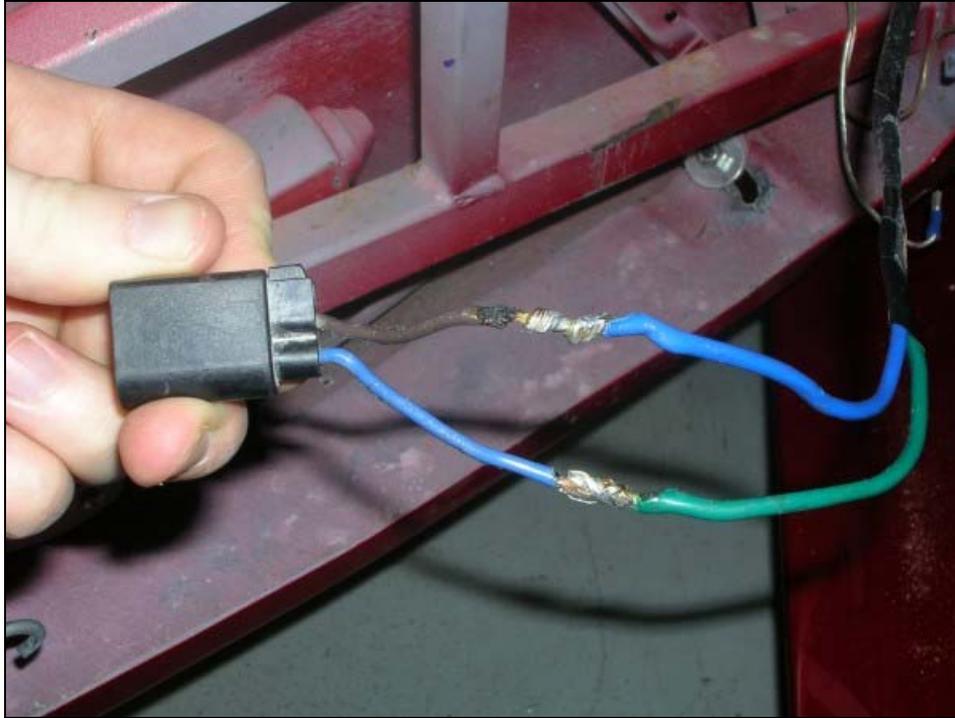
- Wire cutters
- Wire crimpers
- 4 mm allen key
- 13 mm socket
- Ratchet
- 6mm (or 1/4") drill bit
- Drill

### **III. Installation Instructions**

1. With the door frames installed and the doors adjusted, set the window tracks in the door.
2. Using the Corvette window motor screws, mount the window motor to the bracket on the door frame using the three holes in the bracket.



3. Splice the Corvette window motor plug into the wires that you ran earlier in the build from the window switches.



4. Position the front lower track mount tab to the recess in the bottom of the door so that the hole in the bracket is centered about the recess. Using the track bracket as a template, mark the position for the hole. Drill a 6 mm (approx 1/4" if you don't have a 6 mm drill bit) hole in the bottom of the door. Then, using a grinder or saw, slot the hole so you can adjust the window track in and out. Bolt the track to the door with the supplied hardware (FFR# 25798, 25864), but do not fully tighten yet.



5. Place the lower portion of the rear track into the molded recess on the inside of the door near the back of the door.
6. Position the track so that the mounting hole in the track is in the approximate location shown in the picture below (shown already bolted in position).



7. Drill a 6 mm (approx 1/4" if you don't have a 6 mm drill bit) hole in the door pocket.
8. Bolt the track to the door with the supplied hardware (FFR# 25798), but do not fully tighten yet.



9. Adjust the tracks by pivoting them about the lower bolts. Start by positioning the rear upper track so that the bolt will be approximately 10" from the rear edge of the door and the bolt in the front track will be about 27" from the rear edge of the door.

***ATTENTION: The actual measurement from the edge of the door may vary car to car, but the important things to be sure of are that both tracks are below the opening in the door and they are as CLOSE TO PARALLEL AS POSSIBLE! It is very critical that the tracks are parallel to prevent them from working against each other which will cause the tracks to bind and prevent smooth transition of the glass.***



10. Before mounting the Window Track Brackets (FFR# 25859, 25860), notice that the brackets should rest against the window track, and sit flat against the top edge of the door frame (shown bonded and bolted in place).



11. Squeeze a small amount of the supplied adhesive (FFR# 25865) onto a flat surface like a piece of cardboard (something you are willing to discard). The epoxy is a two part epoxy, so be sure that both parts A and B are coming out of the tube. Mix part A and B together with a nail, rivet or something similar (also something you are willing to discard). Once mixed, you should have a pool of adhesive about the diameter of a quarter and about 1/8" – 3/16" thick.

***ATTENTION: When applying the adhesive to the brackets, if the location on the track that you will bond the bracket to has a hole, place a piece of duct tape over the hole on the backside of the track to prevent the adhesive from seeping through the hole (if the adhesive seeps through the hole and is allowed to harden, it can interfere with the window guide movement).***

12. Apply to the back of one the supplied Window Track Brackets.
13. Using a set of clamps and a small straightedge, clamp the bracket to the window track and allow the adhesive to harden (Driver side rear shown). Repeat for front bracket.



14. If you haven't done so already, install the adhesive-back weatherstrip (FFR# 12750) along the door opening on the body.



15. Using the same adhesive-back weatherstrip (FFR# 12750), install a strip along the rear door post so the bulb faces toward the front of the car. This will allow the rear edge of the glass to rest against the bulb, sealing the rear edge.



Window Down



Window Up

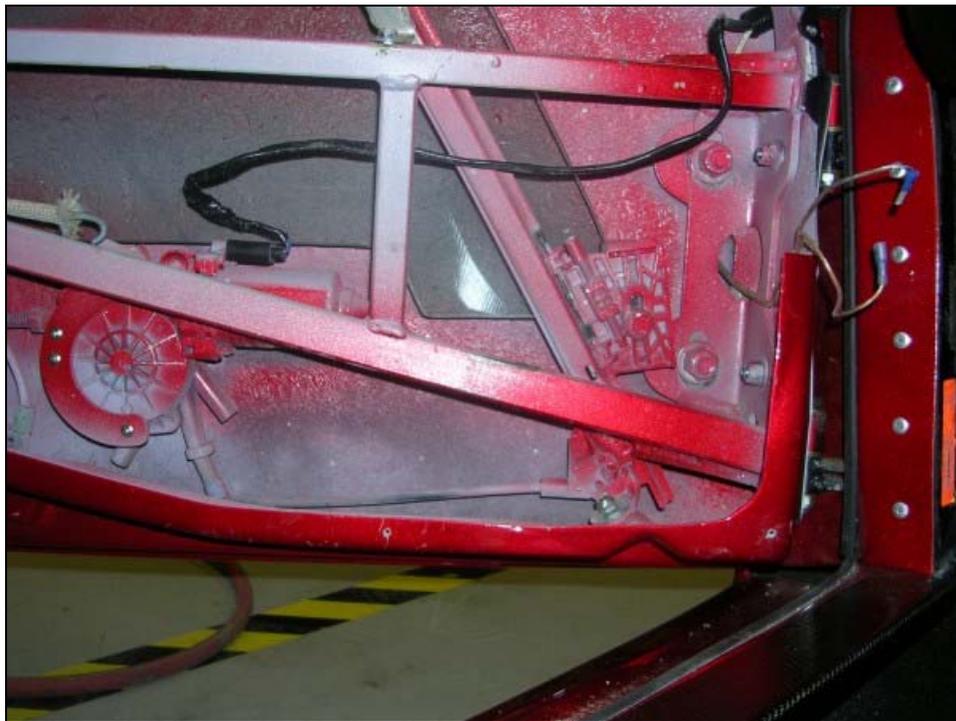
16. Install the weather strip on the inner and outer edges of the window slot in the top of the door. The weather strip with the flat edge is for the outside, and the weather strip with the bulb is for the inside. Also install a piece of the bulb weather strip on the flange at the edge of the front door post.



17. Slide the glass through the slot in the top of the door.



18. Set the bottom edge of the glass in the two guide clamps. Do not tighten the clamps yet.



19. Using the switch, move the window up and check its position in the window opening around the door and also along the body. Make sure it is contacting the weatherstripping. Also, make sure that the glass clears the door linkage and moves up and down smoothly. Adjust as needed.
20. Depending on the position of the window track brackets, you may have to bend the bracket over the top of the door frame to clear the door panel once it's in position.



21. Once you are sure the window will move freely, tighten the window tracks and the guide clamps to the window.
22. Screw the window track brackets to the door frame using the supplied screws.

