

Kip Motor Tech Tip

Installing One-Piece Rear Window

The one piece rear window is the most challenging of all the glass to install. This operation requires a minimum of three people to install properly. Please read through instructions before you begin.

Required Items:

Original glass and stainless trim (these may be hard to acquire so make sure you keep them)

New rear window seal part number ALH 2451

New belt moulding retainer clips ALH 1592(14) and ALH 1593

10-24 nuts (we prefer Keps nuts)

Urethane sealant (optional, part number 121-8810)

Liquid Soap

Masking Tape

Tools Needed:

Phillips head screwdriver

Glass hooks

3/8 wrench

Cut-off wheels or saw

Drill with a 3/16" drill bit

Before you begin, make sure the wheelhouse trim (panels) are removed. Clean the pinchwelds where the glass seal rests against the body. If you are replacing the headliner, now is the time to do it.

Procedure:

1. Insert the upper stainless trim into the upper rubber seal (the one with the smaller profile.). You may need to spread open the trim a little to get it to fit properly.
2. Fit upper rubber/trim to upper window opening and hold in place with strip of masking tape every 4-5".
3. Place the lower rubber seal in place.
4. Lubricate upper and lower glass grooves in rubber seal and newly drilled holes with liquid dish soap (do not use silicone).
5. Install glass: Start by fitting the upper edge first, then working a little back & forth. After getting the glass started in the upper rubber, start working the lower rubber using glass hooks. Hold steady pressure along the bottom of the glass and work alternately between the lower and upper rubber. After a little work, the glass will be in place, but the lower part will not be completely pulled into place. The glass will not sit properly until the lower belt moulding is installed.
6. From inside the car, drill through the seal using the existing holes as a guide. Make sure you aim low enough and do not drill into the area the glass sits.
7. Install the new retaining clips into the lower belt mouldings. The long one is for the center and will be attached to both pieces. Offer the mouldings up to

the lower rubber, lining up the new clips to your newly drilled and soaped holes.

8. Push the clip studs through the seal (the holes you drilled) and install nuts on the retaining clips. Begin tightening the nuts, slowly and evenly, starting with the center and working your way outward (this takes some time and effort). As you tighten the nuts, the lower glass and belt moulding will gradually pull into place. Again, take your time until the glass is set properly.
9. After the glass is fully seated, cut off the retaining clips excess length.
10. Use the urethane sealant to seal any gaps where the two rubber seal pieces meet.
11. Install finishing clips and "Y" trim pieces at the corners of the glass and reinstall interior trim. Use mineral spirits to clean up any excess urethane.

As you can see from this sequence, the glass is not fully pulled into place until the belt moulding is installed. Experienced workers can perform this process in approximately three hours. If they haven't done this before, it will probably take most of the day. Don't serve beer until you're finished.

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