



\*Patent Pending

\*Trademarked

# One Piece Products

1973-1991 GM TRUCK FLUSH FIT WINDSHIELD

[www.OnePieceProducts.com](http://www.OnePieceProducts.com)

## (888)One Products

(888)663-7763

## Installation Manual





First and foremost, we wanted to thank you for your purchase of our Flush Fit Windshield conversion kit for the 1973-91 Chevy Truck bodies. This kit is designed to be a direct glue on kit with very little modifications.

In the next following pages you will find a detailed description on the installation process of our Flush Fit Windshield conversion kit. The pictures will include a short one or two sentence description of the step mentioned.

If for any reason you have difficulties during the installation process please feel free to contact us at **(888)663-7763** or email us at [info@onepieceproducts.com](mailto:info@onepieceproducts.com). You can call during normal business hours 9:00 a.m. to 4:00 p.m. Pacific Standard Time.

#### **INSTALL DISCLAIMER:**

Due to the nature of vehicle manufacturing and the aftermarket auto parts industry, there will ALWAYS be tolerance differences throughout many vehicles. Because of those differences we have made adjustment points on our kits, but they might also require more adjusting. Meaning one side door glass might be different than the other on adjusting. (**TECHNICAL/MECHANICAL APTITUDE IS REQUIRED FOR INSTALLATION OF OUR KITS.**)

## Kit Contents

- **Standard ¼ " Laminated Curved Glass - Quantity: 1**
  - **Note** the glass colors is **ONLY** available in standard factory  
**Green with Shade Band**
- **Glass Interior Trim Channel (Pinch Weld Gasket)- Quantity: 1**
  - This is used to cover the perimeter of the pinch weld area and also used to take up the gap left from the new position of the glass
- **Urethane Glue - Quantity: 2**
  - Used as the primary adhesive to attach the new glass to the body of the truck.
    - **Helpful Tip**: use a Popsicle stick for paddling the glue inside of the perimeter of the glass when glass has just been decked.
- **Glass Underside Trim - Quantity: 1**
  - Used as a barrier between the body and glass

## Tools needed

- **High Viscosity caulking gun**
  - Preferably 18:1 compression.
- **Suction cups for Decking the Glass**
- **Blue painters masking tape**
- **100% Mineral Spirits( Paint Thinner) for cleanup.**
- **Metal Shears for cutting interior trim**
- **Primer**
  - We recommend Dow Betaprime All-In-One Primer
- **Daubers**
- **Double Sided Tape**
  - We recommend 3M High Strength ½" Wide
- **OPTIONAL: 6 Pack and a lawn chair**



# Remove the Windshield:

## **#1. Prepare the Area:**

- Place blankets or padding on the dashboard and hood to prevent damage.

## **#2. Remove the Windshield Trim:**

- Use a trim removal tool or a flathead screwdriver to carefully lift and remove the trim surrounding the windshield.



## **#3. Cut the Seal:**

- With a utility knife or a windshield removal tool, carefully cut along the edge of the rubber seal. For older seals, you may be able to peel them back instead.



#### **#4. Apply Gentle Pressure:**

- From inside the truck, use your hands to gently press on the windshield. Start from one corner and apply steady, even pressure to loosen the glass.

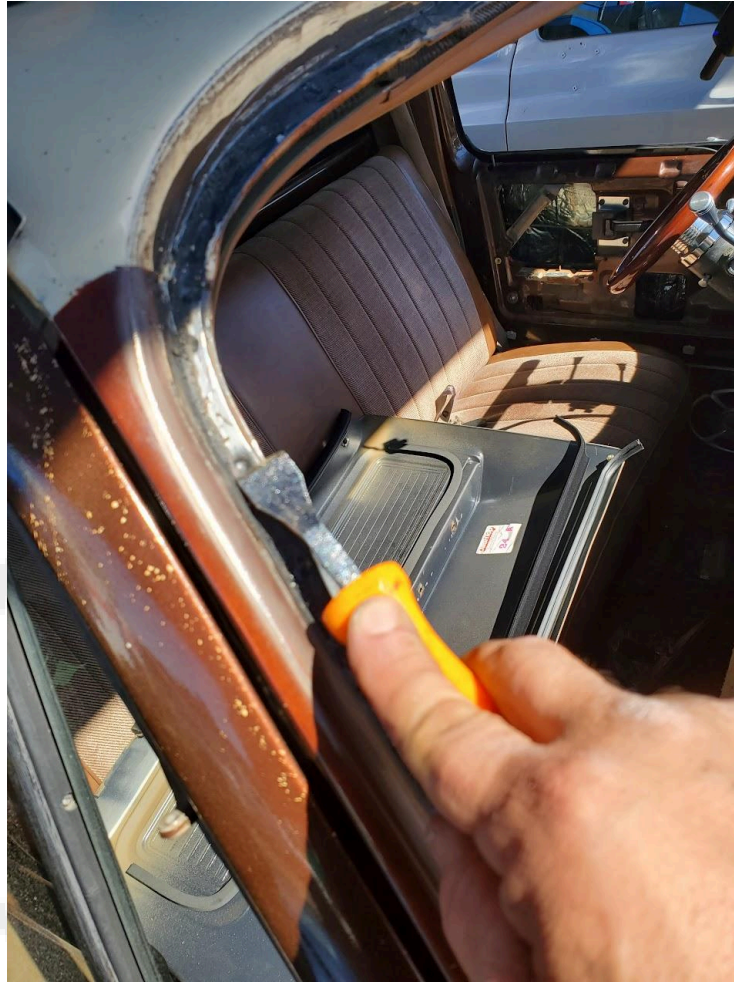
#### **#5. Lift Out the Windshield:**

- Carefully lift the windshield out of the frame. Avoid using excess force, as old glass can be brittle and crack
  - We recommend that you have someone to help you from the outside.

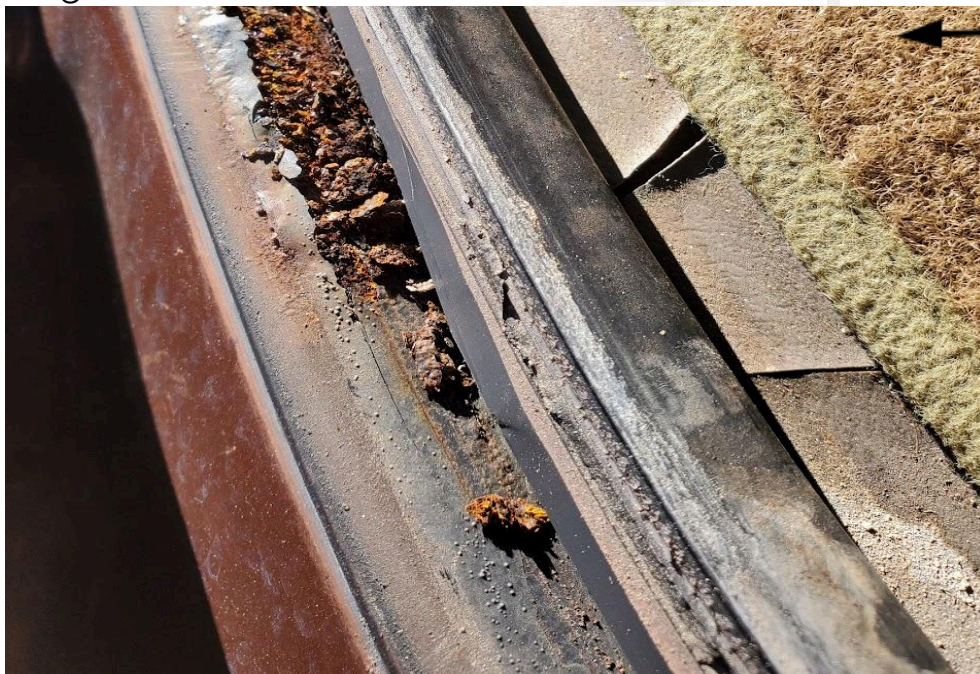
#### **#6. Clean the Frame:**

- Once removed, scrape off any old adhesive or remaining rubber from the frame, prepping it for the new windshield or seal.
- Use plain rubbing alcohol, mineral spirits or acetone to clean the area.





**NOTE:** Check for any rust damage. If present, remove it before proceeding.





# Pre-fit the Molding to the New Glass:

## **#7. Add the Trim to the Windshield**

- Locate the inner trim provided in the kit. Peel off the white backing from the trim. Apply the trim to the inside edge of the windshield.



## **#8. Apply a Thin Guide Coat to the Glass**

- Apply a **THIN** guide coat between the inside trim and the glass.



- We like to start on one of the bottom corners and work my way around taking my time to make sure that the bead of glue is consistent and even around the perimeter of the glass.

**NOTE:** The surface must be flat, to achieve this put on a latex glove and flatten it out.





### #9. Add the double sided molding

- Once the glue has cured for about 1 hour, please add the double sided tape.
  - Apply double-sided tape **only** to the sides of the windshield molding to help secure it to the body.





# Install the NEW Windshield:

## #10. Test Fitting the Glass

- Use blue masking tape to **TEST FIT** the new glass.

**IMPORTANT:** Do **NOT** use glue on this step

- Position the glass where it will be installed. Mark the body with tape to indicate the exact resting position of the glass. Once marked, remove the glass and place it on a stand with the inside facing up.



**NOTE:** The distance of the edge of the molding and the edge of the body



**NOTE:** Mockup Picture

### **#11. Primer the Body**

- Dip the dauber in the primer and prime the body

### **#12. Install the Glass Interior Gasket onto the Pinchweld**

- Starting from one end, press the trim channel firmly along the interior edge of the windshield frame, ensuring it aligns evenly for a tight, secure fit.









### #13. Shoot the Glue on the Body

- You will proceed to shoot the glue onto the body between the gap of the gasket and body. We like to start on one of the bottom corners and work my way around taking my time to make sure that the bead of glue is consistent and even around the perimeter of the glass.

**NOTE: MAKE SURE** that the perimeter of the glass and the body is completely clean.





### #11. Shoot Glue to the Glass

- Using the V cut tip, shoot a ¼ inch bead all around the glass







**NOTE:** When you connect the glue to itself use a popsicle stick or paddle to connect it.



#### **#14. Decking the Glass:**

- Use guide tape to center the glass before shooting the urethane. This helps installers to eliminate guessing for alignment of glass.
- Normally use suction cups for this process,
  - **Option #1:** Take it to a local glass shop
  - **Option #2:** Purchase a simple set of suction cups for this purpose.





**NOTE:** YOU DON'T WANT ANY DAYLIGHT FROM THE INSIDE LOOKING OUT!

#### **#15. Clean up the Glass**

- After the glass has been decked you will need a couple of rags and Paint Thinner or 100% mineral spirits for the cleanup.
  - You will get some oozing on some parts of the outside perimeter of the glass. CLEAN IT QUICK.

**NOTE:** Usually the tack free time on the glue is about 20-30 minutes depending on weather conditions.

#### **#16. Let Glass Cure**

- Once cleaned and mounted in the position you like, let the glue **CURE FOR 24 HRS.**



**GREAT JOB!!!!**  
**DOESN'T THAT LOOK BETTER!!!**



**Thank You Again** for purchasing our 1973-91 Chevy truck Flush Fit Windshield Conversion Kit. We hope you found this kit to be easy to follow and would gladly appreciate any comments you have.

Now, for all your hard work, crack a cold one and relax!

Hope you enjoy your purchase! We'd love to hear your thoughts and see pictures.

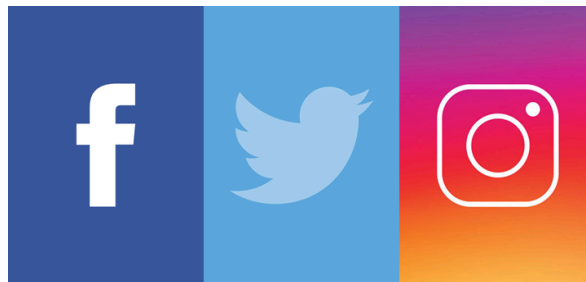
\*30 DAY RETURN – 20% Restocking Fee May Apply\*

\*MECHANICAL SKILLS REQUIRED FOR INSTALLATION

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