

NOTE: If any of the following conditions exist, the fixed glass must be discarded. A new fixed glass is required.

- The fixed glass is the windshield glass and equipped with a camera bracket.
- The fixed glass is the windshield glass and equipped with adhesive mouldings.

NOTE: Fixed glass may have locating pins that vary in location. It may be necessary to cut these pins with a utility knife.

Remove the fixed glass.

Use the General Equipment: Power Fixed Glass Removal Tool

Use the General Equipment: Cold Knife

Use the General Equipment: Knife

4.



WARNING: Repair any corrosion found on the pinch weld. The pinch weld is a structural component of the vehicle. Corrosion left unrepaired may reduce the structural integrity of the vehicle. Failure to follow this instruction may result in serious injury to vehicle occupant(s).

NOTICE: New or reused fixed glass must be installed within 2 hours of cutting the urethane adhesive. Exposed cut surfaces of urethane become oxidized and inactive beyond 2 hours, reducing the effectiveness of the repair bond.

NOTE: Avoid scratching the pinch weld. Repair all minor scratches or exposed metal on the pinch weld following manufacturer's instructions for the product being used. Use the same brand primer and urethane adhesive.

NOTE: Touching the adhesive surface impairs the rebonding.

NOTE: Make sure the mating surfaces are clean and free of foreign material.

NOTE: If replacing the windshield glass and equipped with a camera bracket, it must have locating pins and spacers to ensure correct alignment. Do not use a replacement windshield glass, without locating pins and spacers.

Prep the pinch weld area to install the new or reused fixed glass.

1. Trim or shave down the original urethane adhesive on pinch weld flange and on glass (if reused) using a utility knife, leaving a 1 mm to 2 mm (0.04 in to 0.08 in) base on the parts, only when final installation is within 2 hours.
2. Remove any foreign material or dirt from the pinch weld using a soft brush or vacuum.
Use the General Equipment: Vacuum Cleaner

5. **NOTE:** Minimize applying primer over areas with remaining urethane adhesive and observe a minimum flash time of 10 minutes.

If the paint layer was damaged on the pinch weld extending into bare metal, apply primer to those areas only.

Material: Sika® Aktivator PRO / Dow® BETAPRIME®, 5504G / Sika® Primer-207

6. **NOTE:** Minimize applying primer over areas with remaining urethane adhesive and observe a minimum flash time of 10 minutes.

Apply primer as necessary.

1. Apply primer to those areas only previously primed with primer.
Material: Sika® Aktivator PRO / Dow® BETAPRIME®, 5504G / Sika® Primer-207
2. If the clearcoat layer was damaged on the pinch weld but not extending into bare metal, apply primer to those areas only.
Material: Sika® Aktivator PRO / Dow® BETAPRIME®, 5504G / Sika® Primer-207

7. **NOTE:** This step only applies when installing a new fixed glass.

Clean the inside of the new fixed glass with glass cleaner.

Material: Motorcraft® Ultra-Clear Spray Glass Cleaner / ZC-23 (ESR-M14P5-A)

8.



NOTE: This step only applies when installing a new fixed glass.

Apply primer according to the manufacturer's instructions to the new fixed glass. Allow at least 10 minutes to dry.