

## Removal and Installation

### General Equipment

|                                              |
|----------------------------------------------|
| Adhesive Tape                                |
| Direct Glazing Removal/Replacement Equipment |
| Knife                                        |
| Laminated Card                               |

### Materials

| Name     | Specification |
|----------|---------------|
| Adhesive | WSK-M11P57-A3 |
| Adhesive | WSS-M11P57-A5 |

### Removal

1.  **NOTICE:**

Refer to: [Window Glass Health and Safety Precautions](#) (100-00 General Information, Description and Operation).

2.

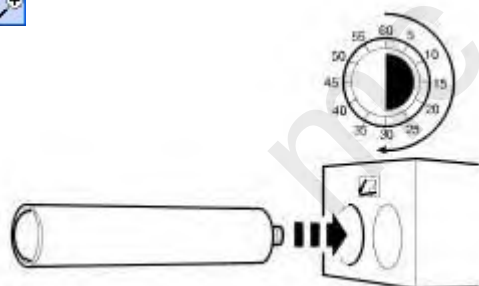
1. *Material:* [WSK-M11P57-A3 \(Adhesive\)](#)

2. Remove the polyurethane (PU) adhesive cap and heat the 2K-PU adhesive for a minimum of 30 minutes.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)

3. Repairs under warranty:

*Material:* [WSS-M11P57-A5 \(Adhesive\)](#)



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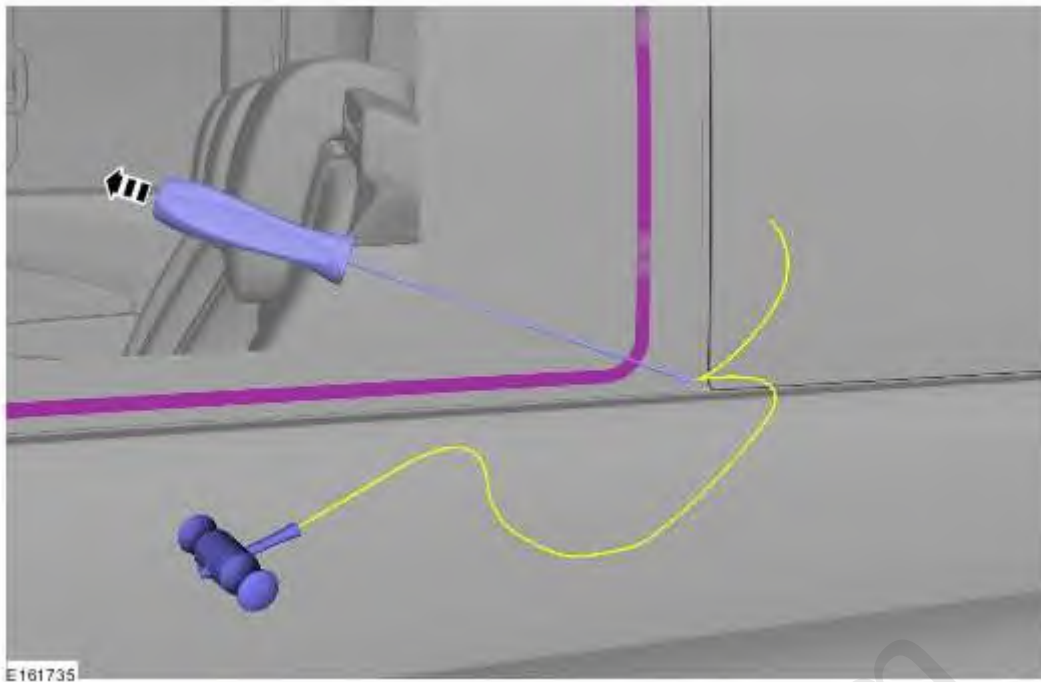
3.



**WARNING:** Make sure that the component paintwork is not damaged.

Use a suitable awl to thread the cutting wire.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)



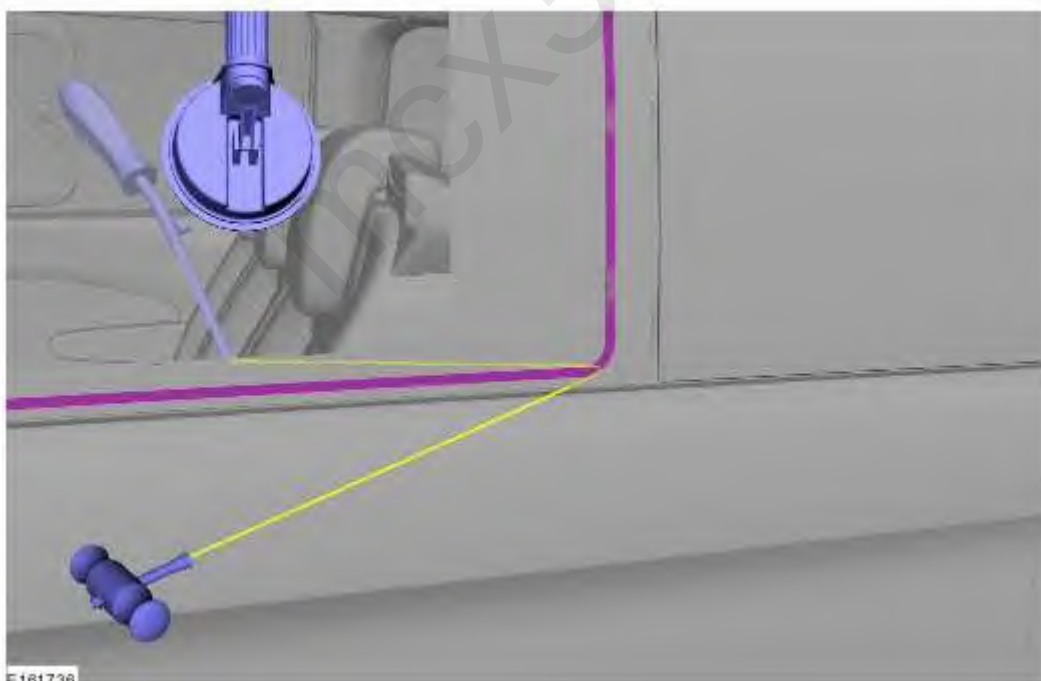
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4.



**WARNING:** Make sure that the component paintwork is not damaged.  
Use a suitable brace to prevent paintwork damages.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)



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5.



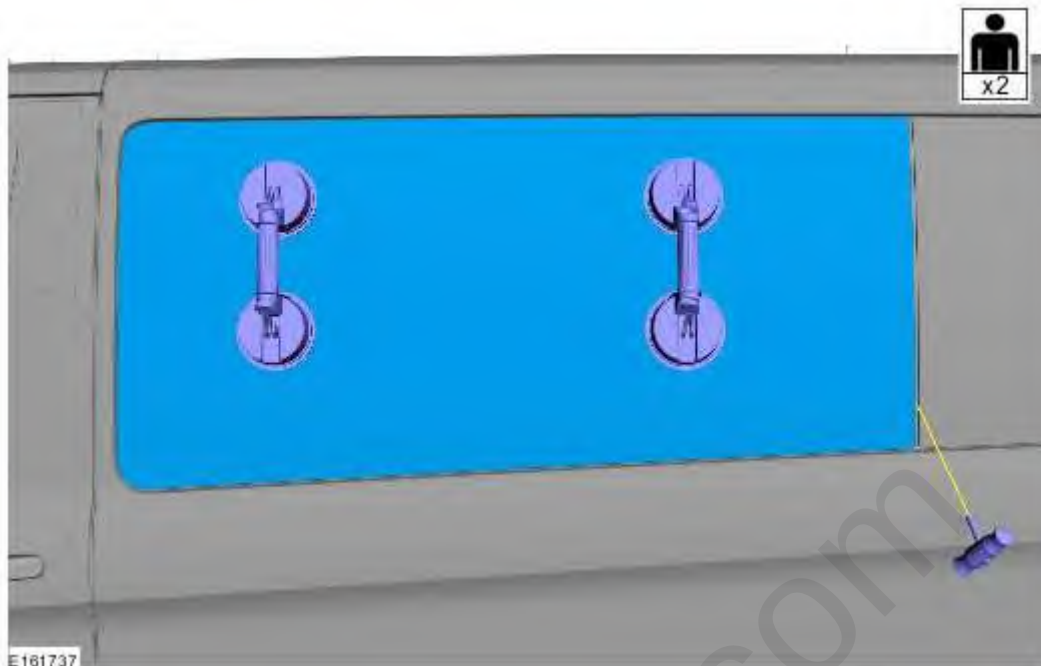
**WARNING:** Make sure that the component paintwork is not damaged.

**NOTE:** This step requires the aid of another technician.

**NOTE:** Some resistance may be encountered when cutting through the glass locating spacers.

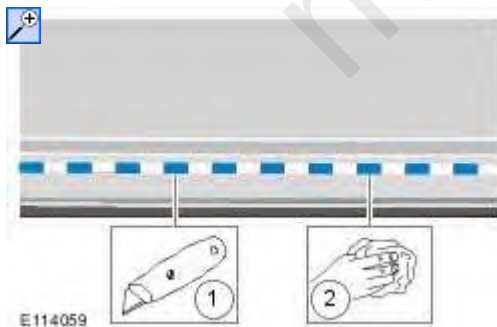
Use suitable adhesive tape or a laminated card to prevent paintwork damages.

Use the General Equipments: [Direct Glazing Removal/Replacement Equipment](#), [Adhesive Tape](#), [Laminated Card](#)

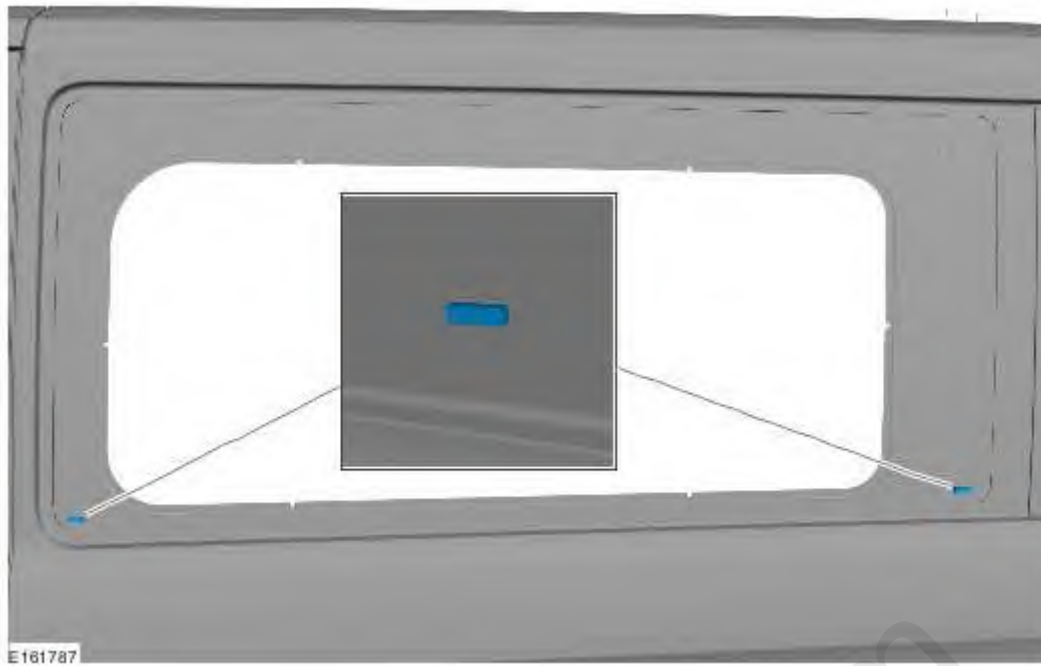


## Installation

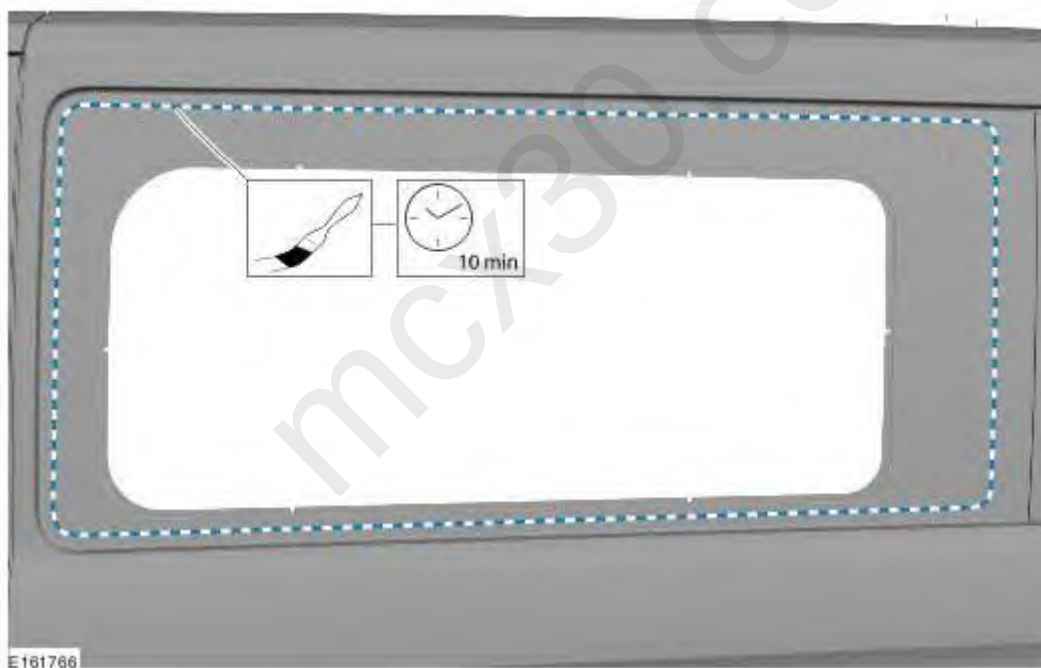
1. **NOTE:** Minimum 1 mm bead thickness.  
*Use the General Equipment:* [Knife](#)
2. **NOTE:** Make sure that the mating faces are clean and free of foreign material.
3. **NOTE:** Touching the adhesive surface will impair rebonding.  
Prepare the liftgate window glass, liftgate window glass flange and trimmed PU adhesive in accordance with the instructions supplied with the glass adhesive kit.



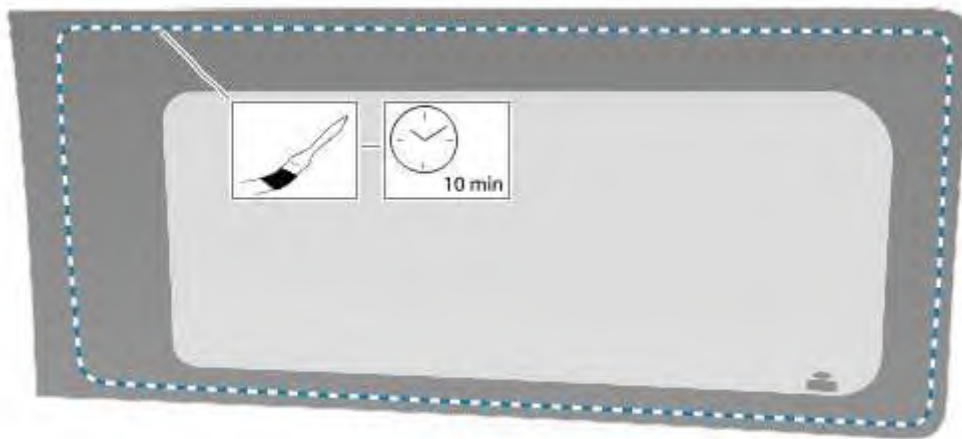
2. **NOTE:** Make sure that new components are installed.



3. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.



4. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.



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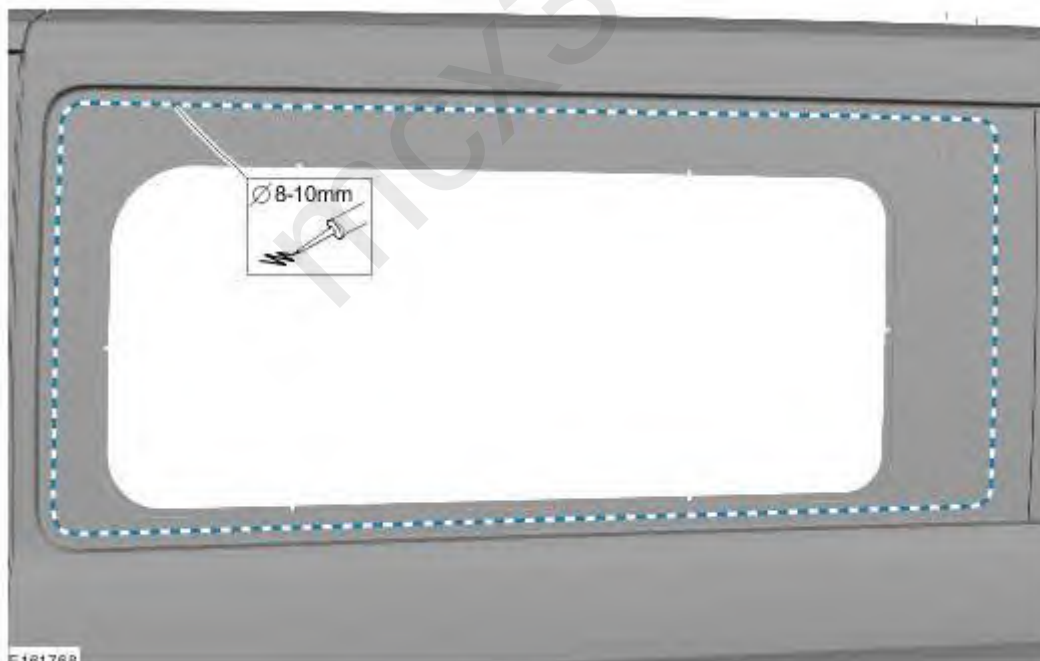
5. NOTE: Discard the first 100 mm of adhesive as this may have a reduced working time.

NOTE: Make sure that any breakage in the continuous bead of adhesive is overlapped by 20 mm.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)

*Material:* [WSK-M11P57-A3 \(Adhesive\)](#)

*Material:* [WSS-M11P57-A5 \(Adhesive\)](#)



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6.
  - Press firmly and evenly into position.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)

-  **NOTICE:** During the curing time of the polyurethane (PU) adhesive, the door windows must be left open.

Using tape, secure the liftgate window glass in the correct position until the PU adhesive has cured.

Use the General Equipment: [Adhesive Tape](#)

