

Note:

Do not remove the front protective caps(1) before fitting the twin cartridges in the glue gun.



If these protective caps are not present, the gun presses directly on the plastic pistons and compresses the mastic and activator before it strikes the cartridges.

As the products are of different densities, the two cartridges do not burst simultaneously and the mixture of the two products is no longer guaranteed.



[Repair-00x04x03x31-01x79-1-1-1.xml](#)



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WINDOW BONDING: DESCRIPTION

1. PREPARATION AND BONDING PROCEDURES

Special notes on the preparation and bonding operations for windows

For cutting([see 54A, Windows, Window detachment: Description](#)) operations.

On bodywork components	
Original bodywork component: Example: "removal - refitting" and/or replacement of windows	Procedure 1
Bodywork component repaired and/or replaced: Example: replacement of roof, windscreen frame	Procedure 2
New bodywork component(Parts department): Example: bare body supplied painted, cataphoretic steel tailgate, primed plastic tailgate	Procedure 3

On windows	
New windows(Parts Department)	Procedure 4
New POLYCARBONATE windows(Parts Department)	Procedure 5
Removed window (with residual bead)	Procedure 6
Removed POLYCARBONATE window(with residual bead)	Procedure 7

2. PROCEDURE 1: ON ORIGINAL BODYWORK COMPONENT

1- FOR ALL BODY TYPES

Carefully clean the bonding area with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products) avoiding the cement bead.

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Grind the residual beading (leave a thickness of 1 to 2 mm of cement bead).

Note:



In the case of paint damage larger than 1 mm, apply a layer of primer (green and red marking) with a single, uniform stroke over the entire damaged area.

Let it dry for a minimum of 10 minutes.

Apply the primer with a single, uniform stroke onto the entire bonding area (residual/lacquer beading).

Let it dry for a minimum of 10 minutes.

Prepare the window (see procedure 4 or 5).

Apply the cement bead (preferably onto the window).

Bond the window immediately.

3. PROCEDURE 2: ON REPAIRED AND/OR REPLACED BODYWORK COMPONENT

1- BEFORE PAINTING

Carefully clean the bonding area with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products) avoiding the cement bead.

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Before applying the paint range, protect the bonding area with masking tape.

2- AFTER PAINTING

Remove the masking tape.

Clean the bonding area carefully with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Grind the residual beading (leave a thickness of 1 to 2 mm of cement bead).

Apply the primer with 2 uniform strokes over the entire bonding area, waiting a minimum of 10 minutes between strokes.

Let it dry for a minimum of 10 minutes.



Note:

Apply the primer 1 hour after the component is completely dry and cooled.

Prepare the window (see procedure 4 or 5).

Apply the cement bead (preferably onto the window).

Bond the window immediately.

4. PROCEDURE 3: ON NEW BODYWORK COMPONENT (PARTS DEPARTMENT)

1- BEFORE PAINTING

Sand lightly using a grey pad [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Clean the bonding area carefully with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Before applying paint range, protect the bonding area with masking tape.

2- AFTER PAINTING

1) FOR ALL BODY TYPES

Remove the masking tape.

Clean the bonding area carefully with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Apply the primer over the entire bonding area.



Note:

Apply the primer 1 hour after the component is completely dry and cooled.

Let it dry for a minimum of 10 minutes.

Prepare the window (see procedure 4 or 5).

Apply the cement bead (preferably onto the window).

Bond the window immediately.

5. PROCEDURE 4: ON A NEW WINDOW (PARTS DEPARTMENT)

Ensure you have the correct window.

Check that there are no faults or cracks.

Clean the bonding area carefully with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Fit the trims (according to the vehicle).

Carry out a test assembly for the vehicle window.

Apply the glass cleaner/activator with a pre-soaked wipe.

Clean immediately with the dry wipe.

Apply the primer with a single, uniform stroke around the outside edge of the window, along the bonding line.

Let it dry for a minimum of 10 minutes.

Apply the cement bead.

Bond the window immediately.

6. PROCEDURE 5: ON NEW POLYCARBONATE WINDOWS

7. PROCEDURE 6: ON REMOVED WINDOW (WITH RESIDUAL BEADING)

Check that there are no faults or cracks.

Carefully clean the bonding area with heptane [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products) avoiding the cement bead.

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Grind the residual beading (leave a thickness of 1 to 2 mm of cement bead).

Fit the trims (according to the vehicle).

Carry out a test assembly for the vehicle window.

Note:

If there is an area with no residual beading on the window (for example: difficulty in adhering):



- apply the glass cleaner/activator using a pre-soaked wipe along the bonding line,
wipe with a dry cloth.

Apply the primer (green and red marking) with a single, uniform stroke over the entire bonding area.

Let it dry for a minimum of 10 minutes.

Apply the cement bead.