

Locate the earths located near to the weld area [Earths on body: List and location of components](#) .

### 3)SPECIAL NOTES ON MATING



#### CAUTION

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).



Repair-40x06x12-02x49-1-8-1.xml



XSL version : 3.02 du 22/07/11

# WINDSCREEN:REMOVAL-REFITTING



Note, one or more warnings are present in this procedure



## Special tooling required

Universal protector

Car. 1847



parts always to be replaced:

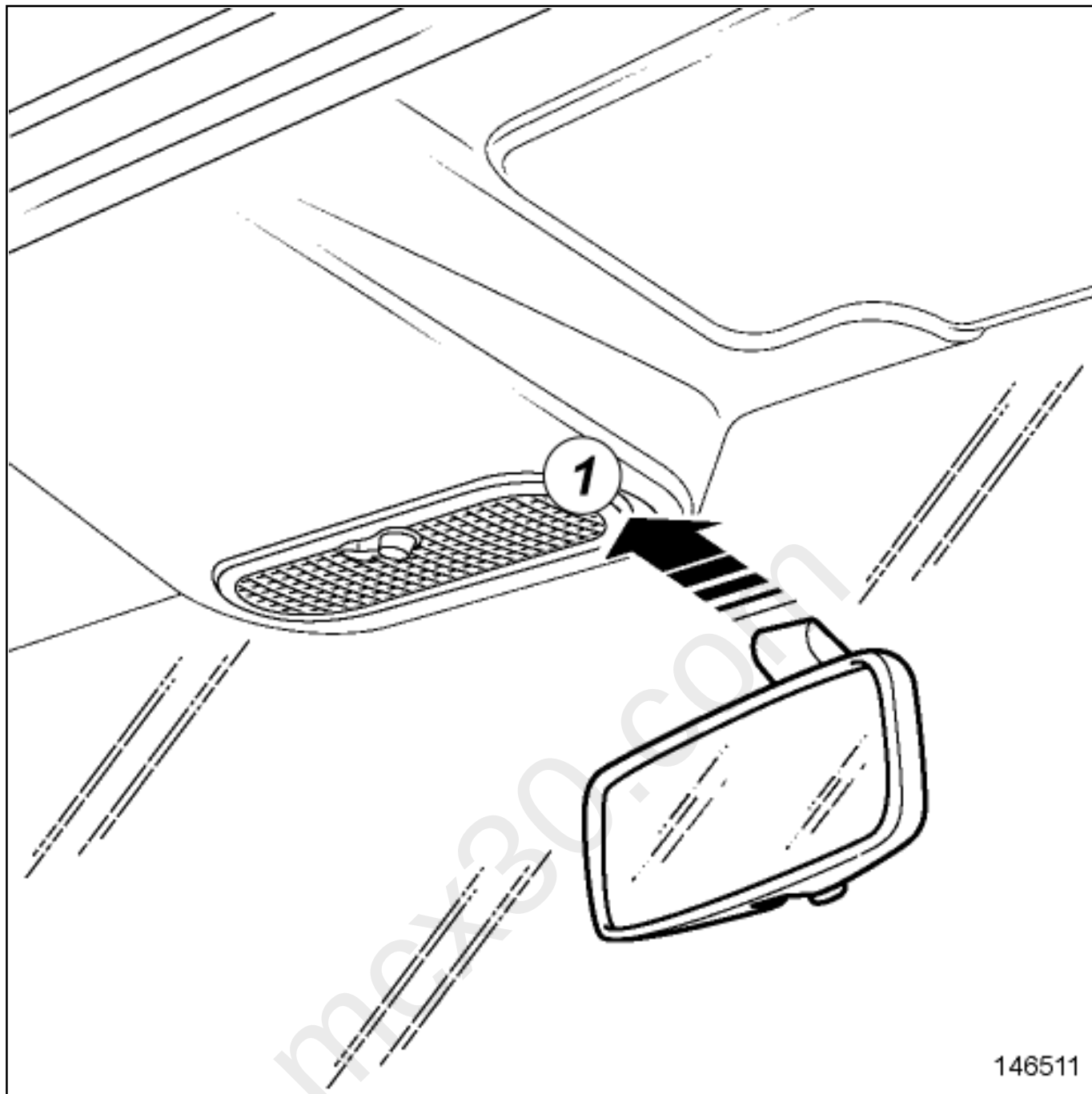
[Windscreen adjusting shim](#)

[rain and light sensor base](#)

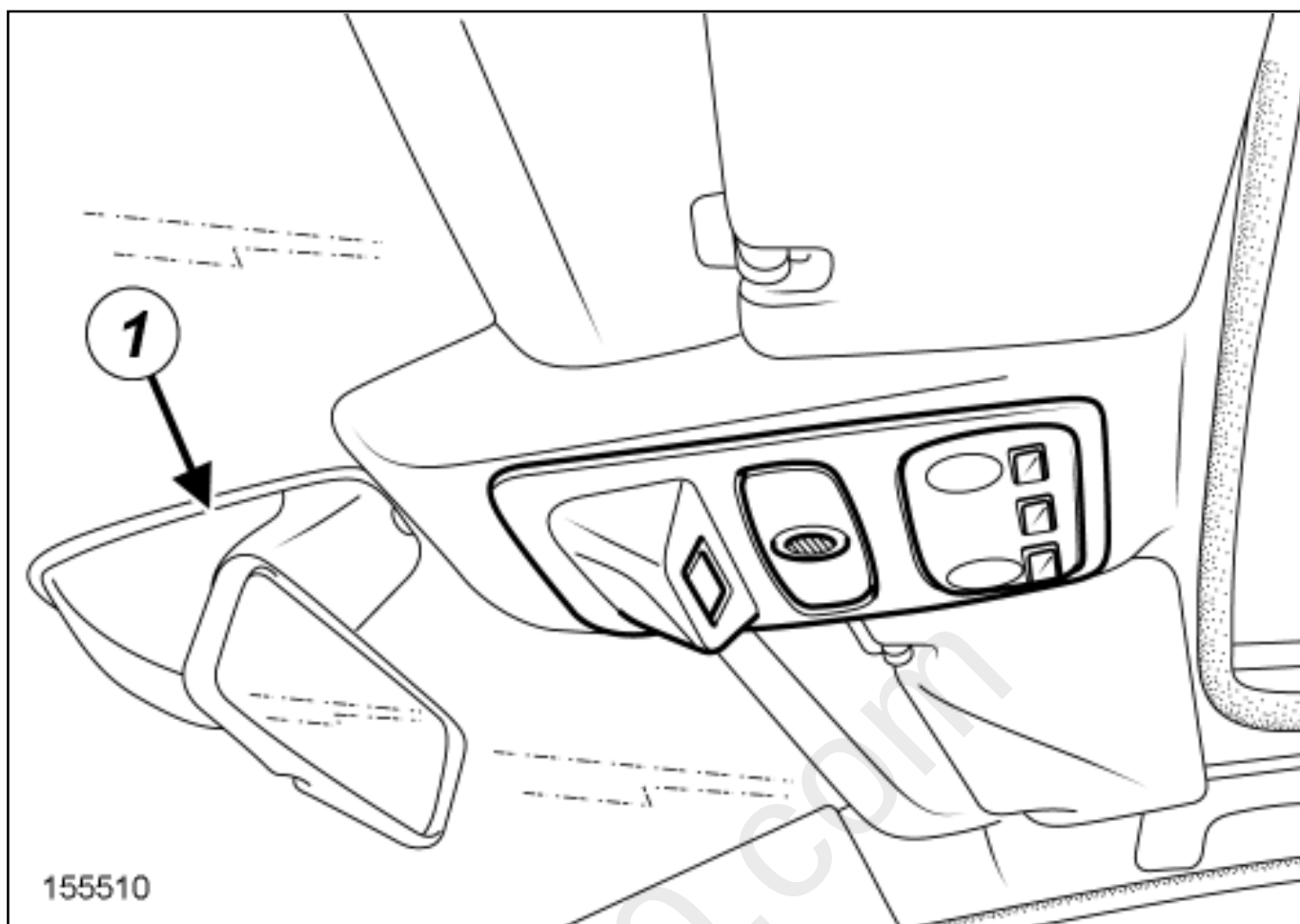
## REMOVAL

### 1. REMOVAL PREPARATION OPERATION

- ☐ Open the bonnet.



146511



Remove:

- 
- the interior rear-view mirror(1) ,
- the windscreen pillar trims [Interior body side trim assembly: Exploded view](#) ,
- the courtesy light [Interior lighting: List and location of components](#) .

Remove:

- 
- the windscreen wiper arms [Wiping and washing: List and location of components](#) ,
- the scuttle panel grille [Scuttle panel grille: Removal - Refitting](#) ,

the scoop under the scuttle panel grille.

Protect the windscreen surround and the headlining with masking tape.

Fit the tool Universal protector ([Car. 1847](#)) on the dashboard.

## 2. REMOVAL OPERATION



### CAUTION

When cutting the cement bead, take care not to cut the wiring harness.



Note:

When cutting the cement bead, protect the engine compartment with a protective bodywork cover.

Cut the cement bead [Window bonding tool: Use](#) and [Window detachment: Description](#) .

Remove the windscreen (this operation requires two people).



Note:

When removing the windscreen, lift the lower part first, then the upper.

## REFITTING

### 1. REFITTING PREPARATION OPERATION



parts always to be replaced: Windscreen adjusting shim .



Fit the new shims and retaining thrust bearings.



For preparation and bonding Products for preparing and bonding windows: Description .

Note:



To bond the windscreen using a Bi-component, this allows to return the vehicle 2 hours after bonding.

## 2. REFITTING OPERATION



Close the bonnet.



Bond the windscreen Window bonding: Description .

Note:



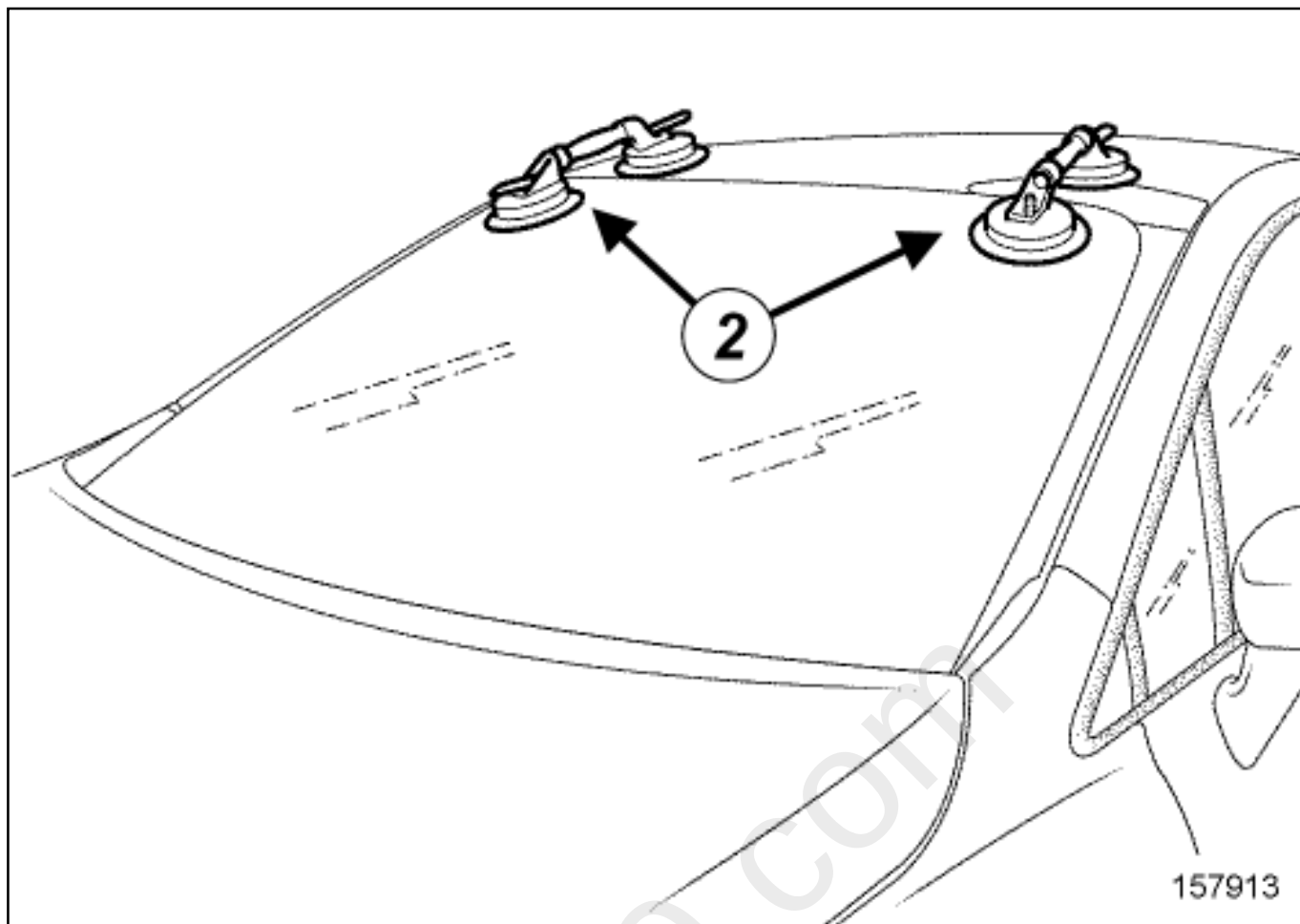
This operation requires two operators.



Position the windscreen in the upper part and lower part.



Check the position of the shims and retaining thrust bearings at the bottom and side of the windscreen.



Respect the following clearances and flush fitting [Vehicle panel gaps: Adjustment value](#) :

- "windscreen - roof panel" ,

- "windscreen - windscreen pillar" .

Position on each upper part of the windscreen a suction cup(2) to hold the windscreen in position while the cement is drying.

Manually pinch the windscreen aperture lower cross member towards the windscreen on the whole width.

Proceed in the reverse order to removal.