

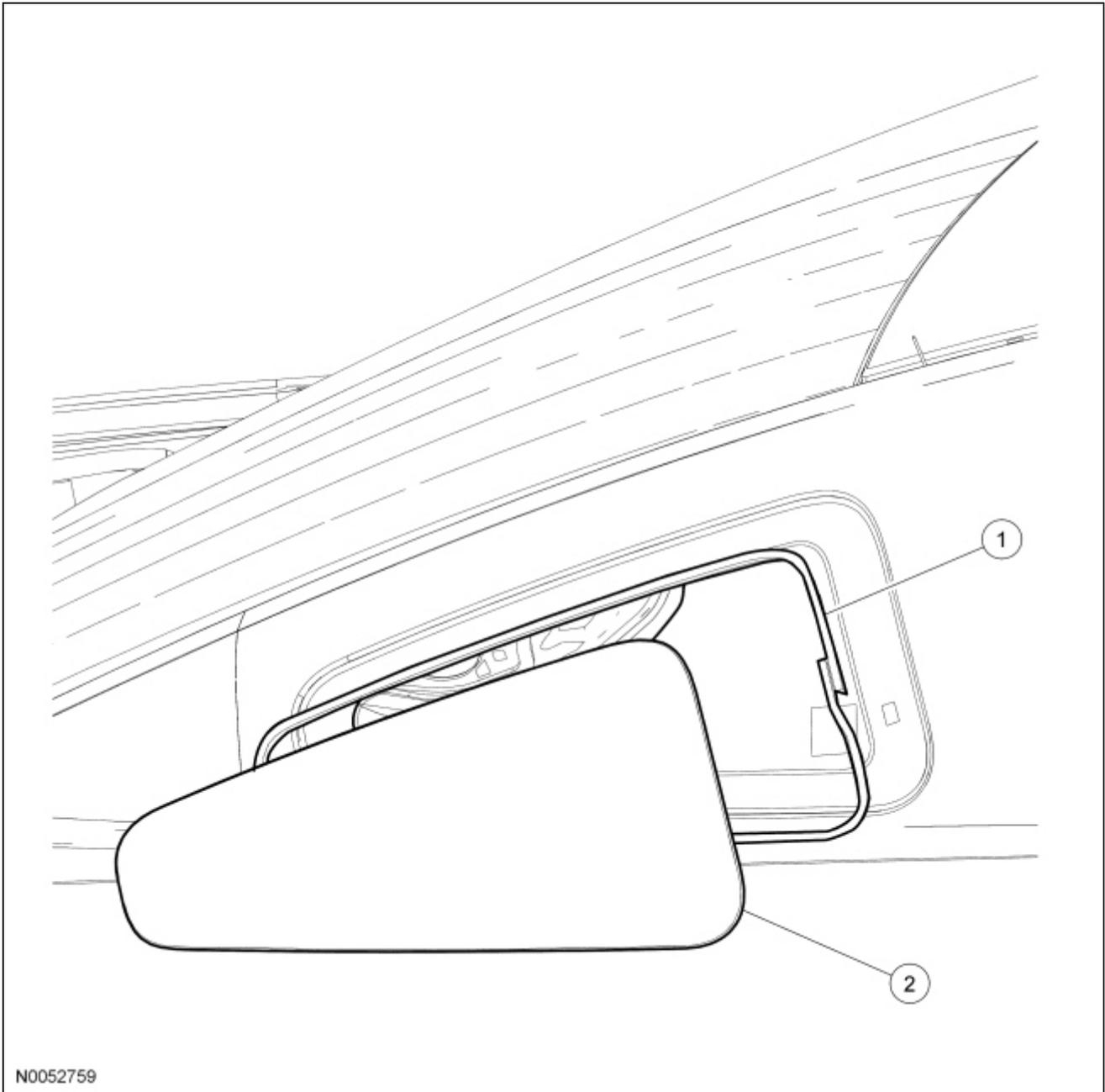
Window Glass — Rear Quarter, Coupe

Special Tool(s)

 ST1320-A	Deluxe Windshield Removal Tool 164-R2450 or equivalent
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Material

Item	Specification
Dow Urethane Adhesive Betaseal™ Express	—
Dow Urethane One Step Glass Primer Betaprime™ 5500 / 5500A / 5500SA	—
Sika Urethane Adhesive Sika Tack ASAP	—
Sika Urethane Metal and Glass Primer Sika 206 G+P	—
Ultra-Clear Spray Glass Cleaner ZC-23	ESR-M14P5- A



N0052759

Item	Part Number	Description
1	—	Urethane adhesive
2	6329710 RH/ 632971 LH	Quarter window glass

Removal

NOTE: If the quarter window glass is being removed to repair a dust/water leak, remove and reinstall the existing quarter window glass.

1. Remove the quarter window trim panel. For additional information, refer to [Section 501-05](#).
2. Before cutting the urethane adhesive, remove dirt and other foreign material from the quarter window glass pinch weld area.
 - Use a clean shop towel or oil-free compressed air.
3. **NOTE:** Refer to manufacturer's instructions before using the Deluxe Windshield Removal Tool.

Lubricate the urethane adhesive with water to aid the Deluxe Windshield Removal Tool when cutting the urethane adhesive.

4.  **WARNING: Always wear eye protection when servicing a vehicle. Failure to follow this instruction may result in serious personal injury.**

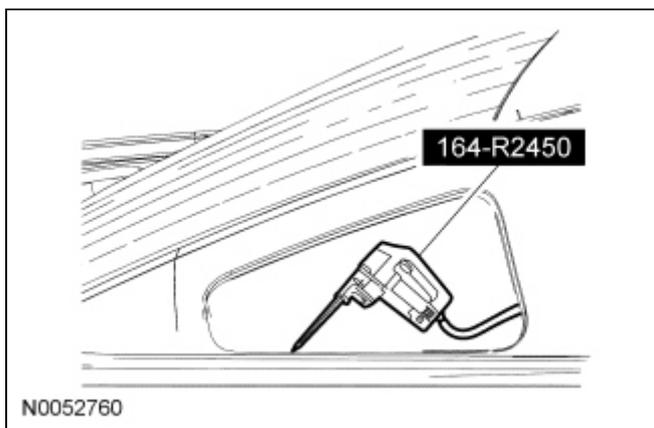
 **WARNING: Wear protective gloves when handling components or parts that have pointed or sharp edges. Failure to follow this instruction may result in serious personal injury.**

NOTICE: To avoid rust formation, use extreme care not to scratch the paint or primer or otherwise damage the pinch weld during glass removal.

NOTE: Insert the blade into the Deluxe Windshield Removal Tool so that the flat side is against the glass. This will leave the entire urethane adhesive bead on the pinch weld and allow a dry fit of the replacement quarter window glass.

NOTE: Support the quarter window glass as necessary to prevent the glass from dropping while cutting the urethane adhesive.

Using the Deluxe Windshield Removal Tool, cut at the upper center of the quarter glass and work toward the bottom corners. Then cut through the remaining urethane adhesive along the bottom of the quarter window glass.



5. Remove the quarter window glass.

Installation

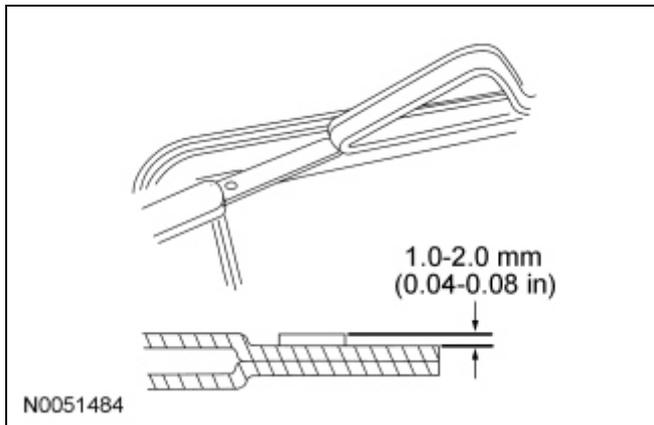
1. Dry-fit the quarter window glass on the existing urethane bead on the pinch weld.
 - Position the quarter window glass on the pinch weld.
 - Center the quarter window glass in the opening for best fit.
 - Make alignment marks with tape or non-staining grease pencil on the quarter window glass and the body.

2. After the dry-fit alignment, remove the quarter window glass from the opening and place on a stable work surface with the interior side of the glass facing up.

3.  **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).**

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

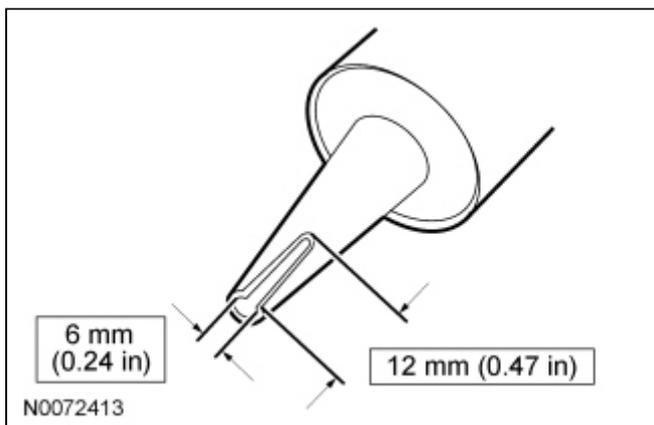
Using an appropriate tool, trim the urethane adhesive leaving a 1-2 mm (0.04-0.08 in) base of original equipment urethane adhesive on the pinch weld.



4. If reinstalling the original quarter window glass, remove the urethane adhesive from the quarter window glass.
5. Using a clean shop towel, brush or oil-free compressed air, clean the pinch weld area. Remove any foreign material or water that may have entered during quarter window removal.
6. If reinstalling the same quarter window glass, remove the remaining urethane adhesive from the glass leaving a thin layer to bond with the new urethane adhesive bead.
7. If installing a new quarter window glass, clean the inside of the glass surface with glass cleaner to make sure the ceramic-coated area is clean.
8. **NOTE:** Be sure to use the same brand and cure-rate products for the urethane adhesive and glass primer. Do not mix different brands of urethane adhesive and glass primer. For additional information, refer to the Material Chart in this procedure.

If installing a new quarter window glass, apply glass primer according to manufacturer's instructions. Allow at least 6 minutes to dry.

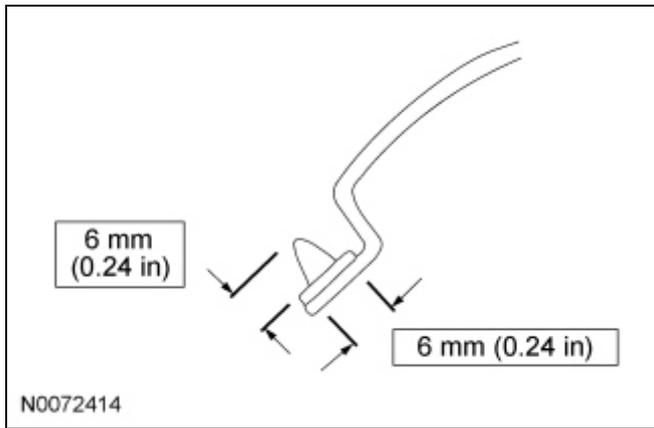
9. Cut the urethane adhesive applicator tip to specification. This will produce a triangular bead during application.



10. **NOTE:** The quarter window glass must be positioned within 10 minutes of applying the urethane adhesive.

NOTE: Use either a high-ratio, electric or battery-operated caulk gun that applies the urethane adhesive with less effort and a continuous bead.

Apply urethane adhesive on to top the existing trimmed urethane adhesive bead on the pinch weld, starting and ending at the bottom of the quarter window glass near the center, making sure there are no gaps in the bead.



11.  **WARNING:** Do not drive vehicle until the urethane adhesive seal has cured. Follow urethane adhesive manufacturer's curing directions. Inadequate or incorrect curing of the urethane adhesive seal will adversely affect glass retention. Failure to follow these instructions may result in serious injury to vehicle occupant(s).

NOTICE: Before positioning the quarter window glass, open vehicle windows to prevent the air pressure of closing doors from affecting the urethane adhesive bond.

Using the alignment marks made previously, position the quarter window glass on the pinch weld.

12. **NOTE:** The urethane adhesive must cure for a minimum of one hour before testing for air or water leaks.

After the urethane adhesive has cured, check the quarter window glass seal for air or water leaks through the urethane adhesive bead and add urethane adhesive as necessary.

13. Install the quarter window trim panel. For additional information, refer to [Section 501-05](#).
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