
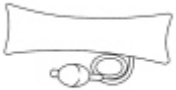


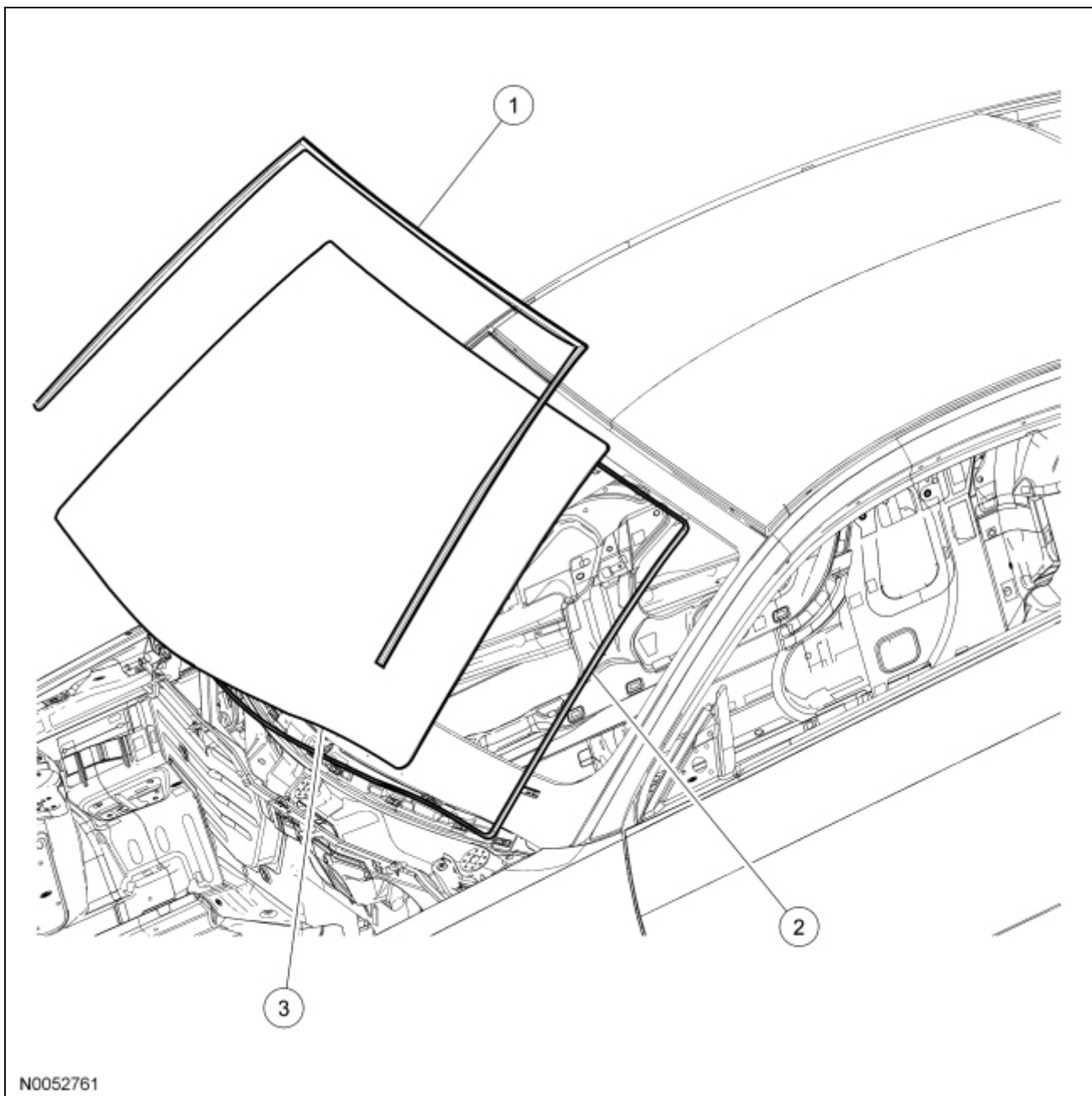
Windshield Glass

Special Tool(s)

 ST1320-A	Deluxe Windshield Removal Tool 164-R2450 or equivalent
 ST2218-B	The Pumper 164-R2459 or equivalent

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



N0052761

Item	Part Number	Description
1	7603110	Windshield glass moulding (may be serviced separately and is included with new windshield glass assembly)
2	—	Urethane adhesive
3	6303100	Windshield glass assembly (new assembly includes windshield glass moulding)

Removal

NOTICE: For vehicles equipped with a roof glass panel, cut the windshield urethane adhesive from the inside of the vehicle to prevent damage to the front glass roof applique.

All vehicles

1. Remove the cowl vent screen. For additional information, refer to [Section 501-02](#).
2. Remove the interior rear view mirror. For additional information, refer to [Section 501-09](#).

Coupe

3. Remove the A-pillar trim panels. For additional information, refer to [Section 501-05](#).
4. Remove the overhead console.
5. Remove the LH and RH sun visors.
6. Lower the front portion of the headliner and block with a suitable material.

Convertible

7. Remove the LH and RH A-pillar trim panels and the header trim panel. For additional information, refer to [Section 501-05](#).


All vehicles

8. Before cutting the urethane adhesive, remove dirt and other foreign material from the windshield pinch weld area.
 - Use a clean shop towel or oil-free compressed air.

9. **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.

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

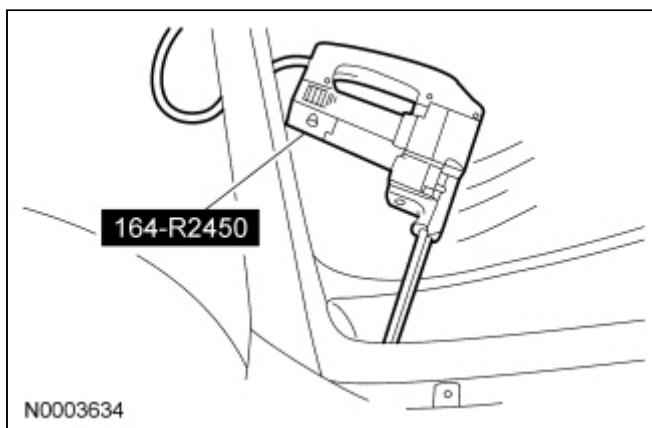
 **WARNING:** Wear protective gloves when handling components or parts that have pointed or sharp edges. Failure to follow this instruction may result in serious personal injury.

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

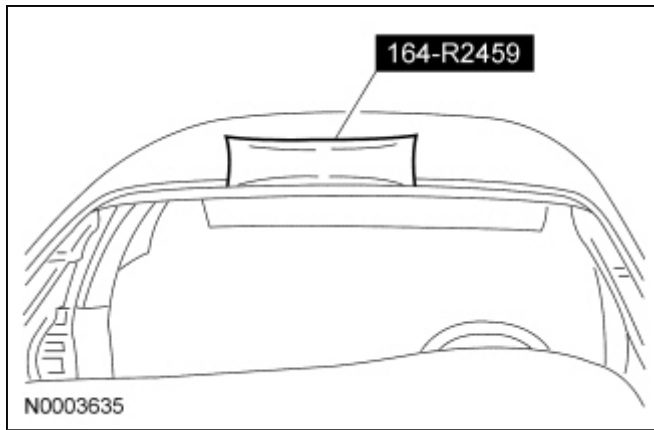
NOTE: Insert the blade into the Deluxe Windshield Removal Tool so that the flat side is against the glass. This will leave the entire urethane adhesive bead on the pinch weld and allow a dry fit of the replacement windshield glass.

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

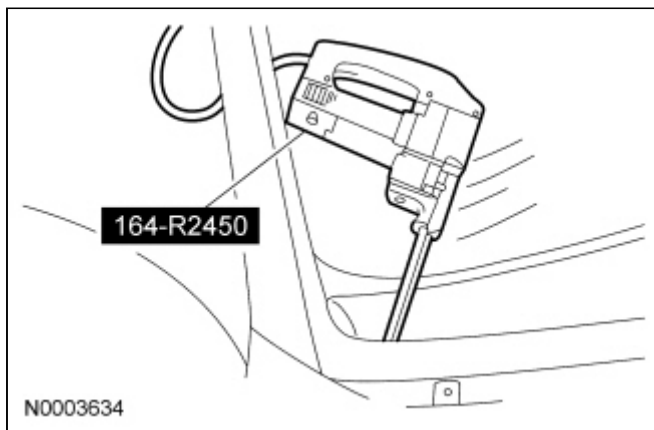
Insert the Deluxe Windshield Removal Tool at the upper center of the windshield glass and work toward the bottom corners.



11. Using The Pumper, distance the windshield from the body.




12. Insert the Deluxe Windshield Removal Tool into the bottom of the urethane adhesive and cut from corner to corner.



13. Carefully remove the windshield glass from the vehicle and place on a stable work surface.

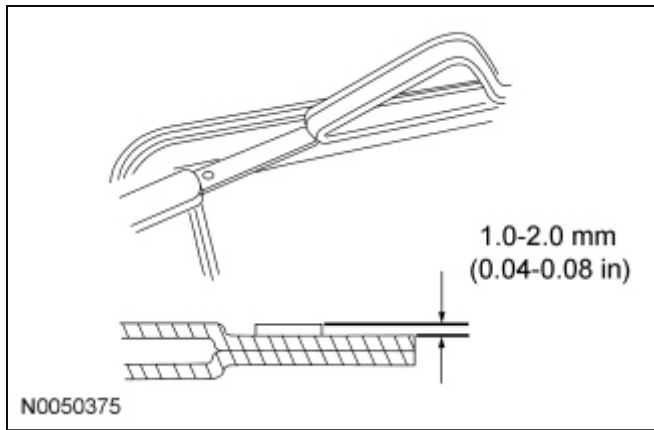
Installation

All vehicles

1. Dry-fit the windshield glass on the existing urethane adhesive bead on the pinch weld.
 - Position the windshield glass on the pinch weld.
 - Center the windshield glass in the opening.
 - Adjust the windshield glass stop blocks (if equipped) as needed for best fit.
 - Make alignment marks with tape or non-staining grease pencil (preferably at the glass stop blocks) on the windshield glass and the body.
2. After the dry-fit alignment, remove the windshield glass and moulding assembly from the windshield 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.

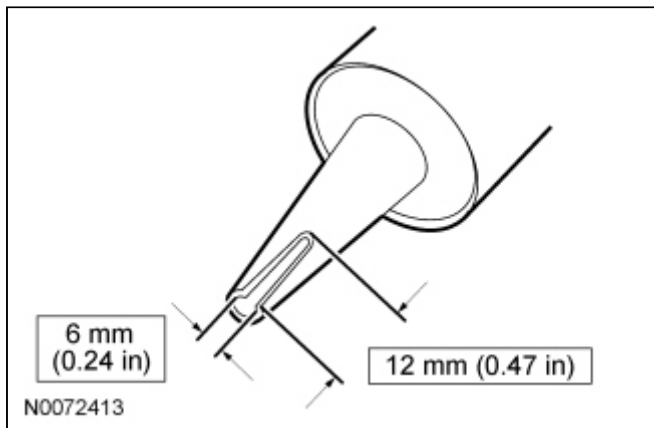
Using an appropriate tool, trim the urethane adhesive leaving a 1-2 mm (0.04-0.08 in) base of original equipment urethane adhesive on the pinch weld.



4. 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 windshield removal.
5. If reinstalling the same windshield glass, remove the remaining urethane adhesive from the glass leaving a thin layer to bond with the new urethane adhesive bead.
6. If installing a new windshield glass, clean the inside of the glass surface with glass cleaner.
 - Make sure to thoroughly clean the surface of the blackened border area where the urethane adhesive will be applied.
7. **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 windshield glass, apply glass primer according to manufacturer's instructions. Allow at least 6 minutes to dry.

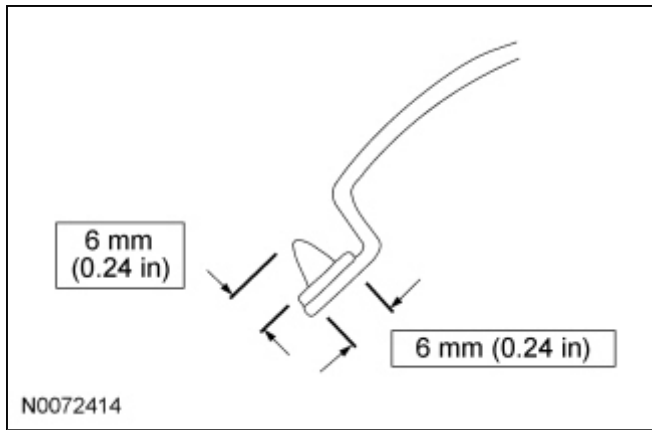
8. Cut the urethane adhesive applicator tip to specification. This will produce a triangular bead during application.




9. **NOTE:** The windshield 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 top of the existing trimmed urethane adhesive bead on the pinch weld, starting and ending at the bottom of the windshield near the center, making sure there are no gaps in the bead.



10.  **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 windshield 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 windshield glass on the pinch weld.

- For vehicles equipped with a glass roof, using a plastic windshield setting tool (or equivalent), carefully tuck the top of the windshield moulding beneath the leading edge of the front glass roof applique.

11. **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 windshield glass seal for air or water leaks through the urethane adhesive bead and add urethane adhesive as necessary.

12. Install the interior rear view mirror. For additional information, refer to [Section 501-09](#).
13. Install the cowl vent screen. For additional information, refer to [Section 501-02](#).

Convertible

14. Install the header trim panel and the LH and RH A-pillar trim panels. For additional information, refer to [Section 501-05](#).

Coupe

15. Position the front portion of the headliner.
16. Install the LH and RH sun visors.
17. Install the overhead console.
18. Install the LH and RH A-pillar trim panels. For additional information, refer to [Section 501-05](#).

All vehicles

19. Install and adjust the wiper blade and pivot arms as necessary. For additional information, refer to [Section 501-16](#).
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