
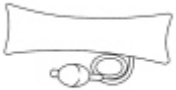


Window Glass — Rear

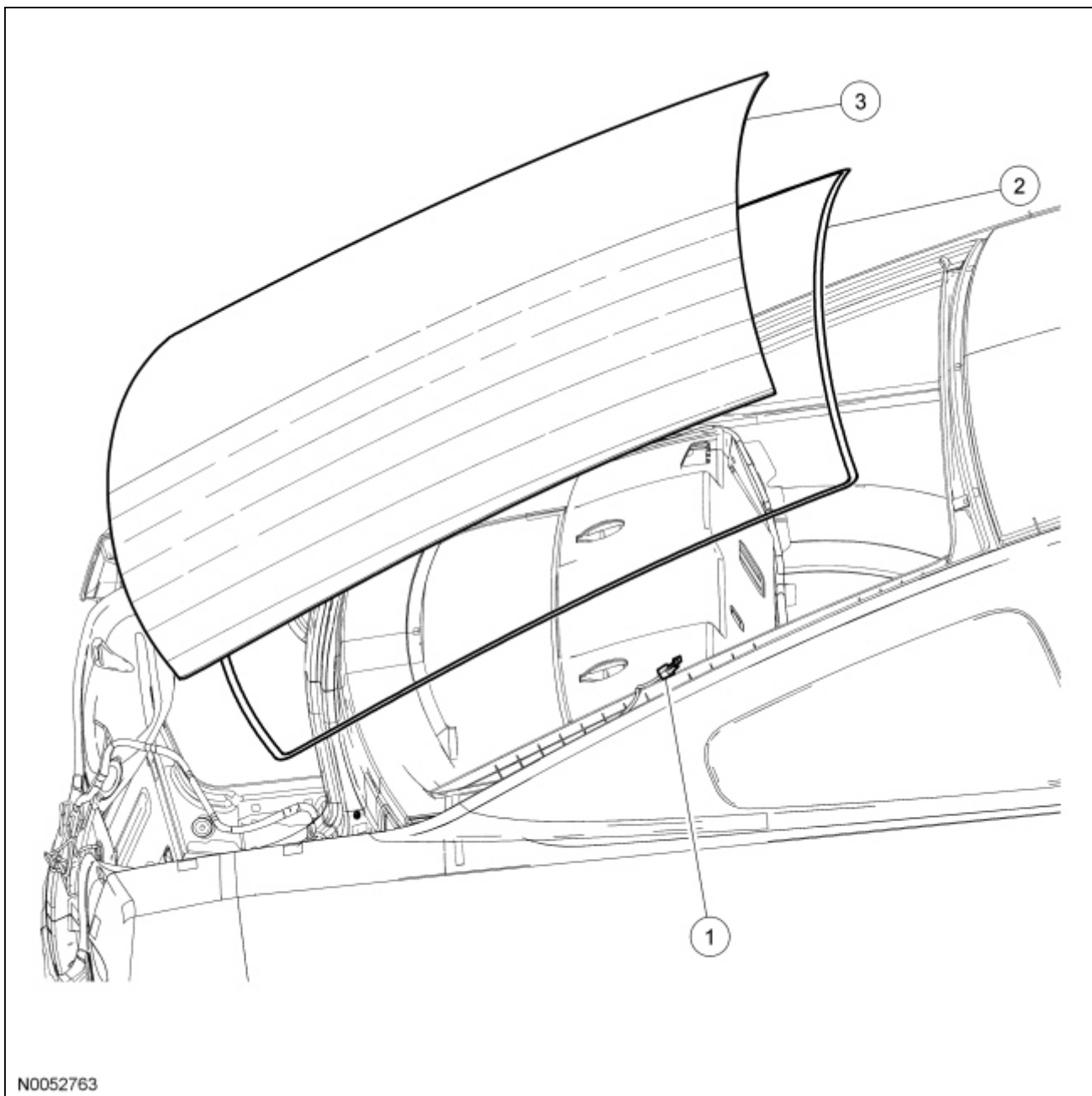
Special Tool(s)

 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

NOTE: The luggage compartment lid is not shown for clarity.



N0052763

Item	Part Number	Description
1	—	Heated rear window electrical connector (part of 14A005)
2	—	Urethane adhesive
3	6342006	Rear window glass


Removal

1. Remove the parcel shelf. For additional information, refer to [Section 501-05](#).
2. Disconnect the 2 heated rear window electrical connectors.
3. Before cutting the urethane adhesive, remove dirt and other foreign material from the rear window glass pinch weld area.
 - Use a clean shop towel or oil-free compressed air.
4. **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.

5.  **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.**

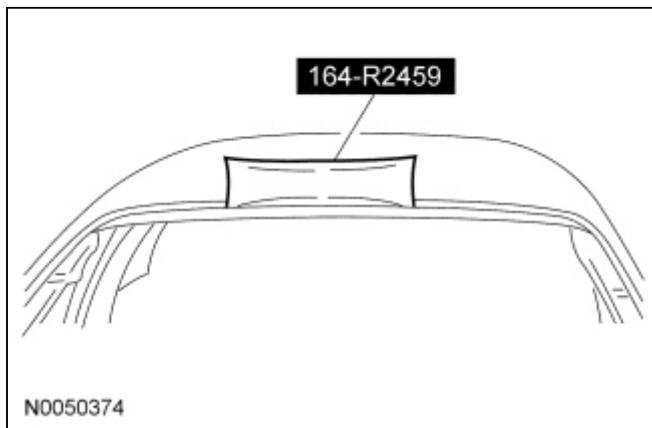
NOTICE: To avoid rust formation, use extreme care not to scratch the paint or primer, or otherwise damage the pinch weld during glass removal.

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 rear window glass.


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

Using the Deluxe Windshield Removal Tool (with the luggage compartment lid open approximately 45 degrees), cut the urethane adhesive from the glass starting at the bottom outboard corner of the rear window glass.

6. Using The Pumper, distance the rear window glass from the body to cut the remaining urethane adhesive and remove the rear window glass. Place the rear window glass on a stable work surface.

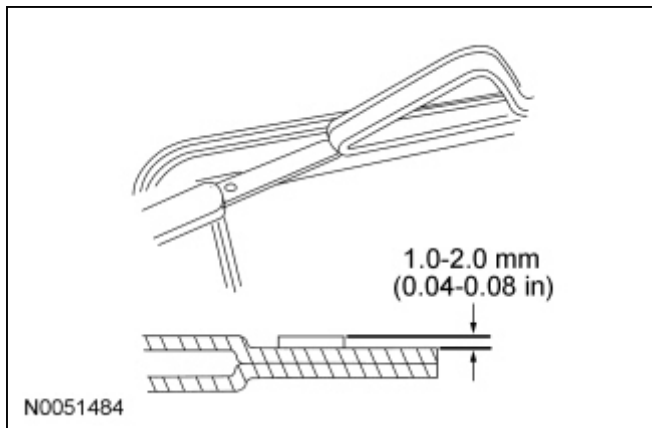


Installation

1. Dry-fit the rear window glass on the existing urethane adhesive bead on the pinch weld.
 - Position the rear window glass on the pinch weld.
 - Center the rear window glass in the opening.
 - Adjust the rear window 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 rear window glass and the body.
2. After the dry-fit alignment, remove the rear window 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.

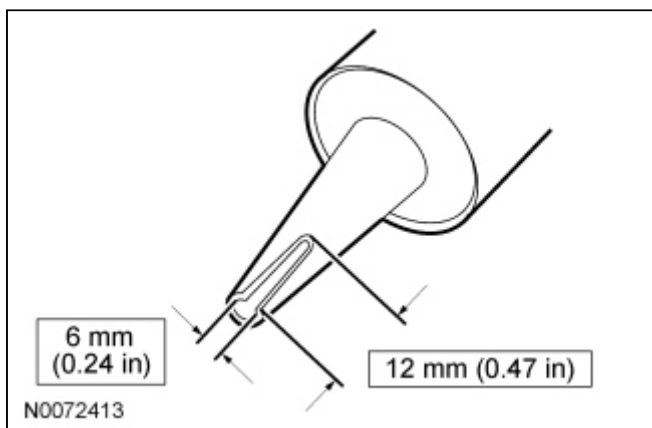
Using an appropriate tool, trim the urethane adhesive leaving a 1-2 mm (0.04-0.08 in) base of original equipment urethane adhesive on the pinch weld.



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 rear window glass removal.
5. If reinstalling the original rear window glass, remove the urethane adhesive from the rear window glass leaving a thin layer to bond with the new urethane bead.
6. If installing a new rear window 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 rear window glass, apply glass primer according to manufacturer's instructions. Allow at least 6 minutes to dry.

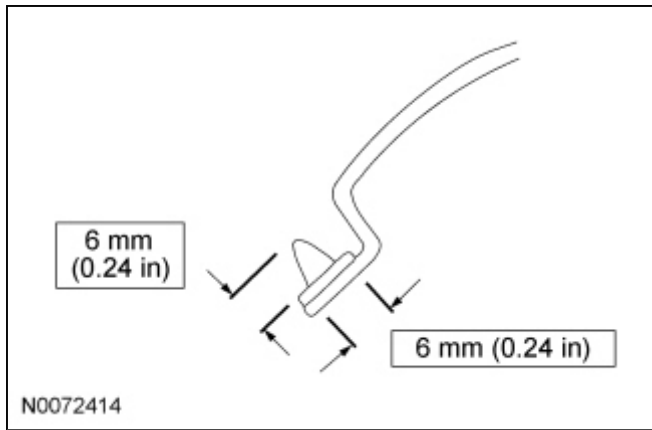
8. Cut the urethane adhesive applicator tip to specification. This will produce a triangular bead during application.




9. **NOTE:** The rear 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 top of 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.



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 rear window glass on the pinch weld.

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 rear window glass seal for air or water leaks through the urethane adhesive bead and add urethane adhesive as necessary.
 12. Connect the 2 heated rear window electrical connectors.
 13. Install the quarter trim panels and parcel shelf. For additional information, refer to [Section 501-05](#).
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