

Adhesive Installation of Stationary Windows (Windshield)

Caution: Refer to [Glass and Sheet Metal Handling Caution](#) in the Preface section.

Important: Remove all but approximately 2 mm (3/64 in) of the existing bead of urethane adhesive from the pinch-weld flange.

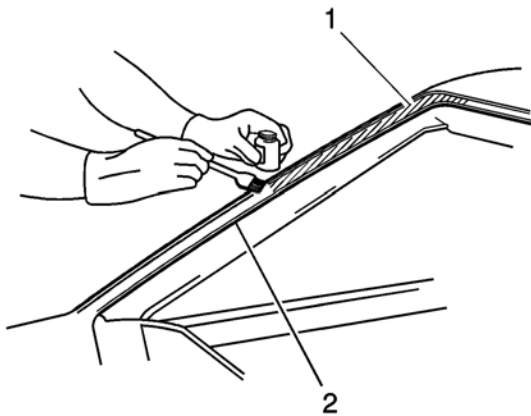
1. Remove all mounds or loose pieces of urethane adhesive from the pinch-weld area.
2. If the original window is being reused, remove all but a thin film of the existing urethane adhesive from the window surface by using a clean utility knife or razor blade scraper.
3. Inspect the following components for the causes of a broken window:
 - The flange of the window opening
 - The window reveal molding
4. Inspect for any of the following problems in order to help prevent future breakage of the window:
 - High weld
 - Solder spots
 - Hardened sealer
 - Any other obstruction or irregularity in the pinch-weld flange

Important: If corrosion of the pinch-weld flange is present or if sheet metal repairs or replacements are required, the pinch-weld flange must be refinished in order to restore the bonding area strength. If paint repairs are required, mask the flange bonding area prior to applying the color coat in order to provide a clean primer only surface. Materials such as BASF DE15®, DuPont 2610®, Sherwin-Williams PSE 4600 and NP70® and Martin-Semour 5120 and 5130® PPG DP90LF SPIES/HECKER 3688/8590 - 3688/5150 - 4070/5090 STANDOX 11158/13320 - 14653/14980 products are approved for this application.

5. After repairing the opening as indicated, perform the following steps:
 - 5.1. Remove all traces of broken glass from the outer cowl panel, seats, floor and defroster ducts.
 - 5.2. Clean around the edge of the inside surface of the window with a 50/50 mixture of isopropyl alcohol and water by volume on a dampened lint free cloth.

Caution: Refer to [Window Retention Caution](#) in the Preface section.

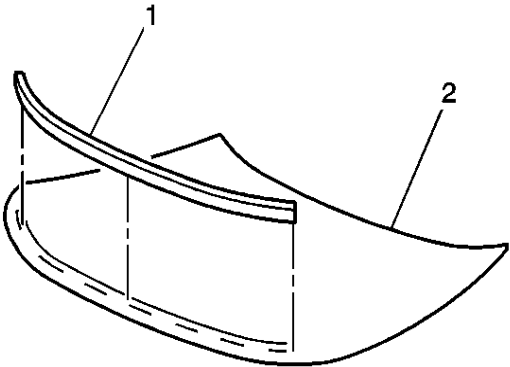
6. Verify all primers and urethane adhesive are within expiration dates.



Caution: Failure to prep the area prior to the application of primer may cause insufficient bonding of urethane adhesive. Insufficient bonding of urethane adhesive may allow unrestrained occupants to be ejected from the vehicle resulting in personal injury.

Important: Do not apply the black #3 primer to the existing bead (1) of the urethane adhesive on the pinch-weld flange. Apply the primer only to nicks, scratches or the primed surfaces.

7. Shake the pinch-weld primer black #3 for at least 1 minute.
8. Use a new dauber in order to apply the primer to the surface of the pinch-weld flange (2).
9. Allow the pinch-weld primer to dry for approximately 10 minutes.



10. Install the new windshield acoustic strip (1) to the windshield (2), if equipped or damaged.

The acoustic strip aids in reducing noise.