

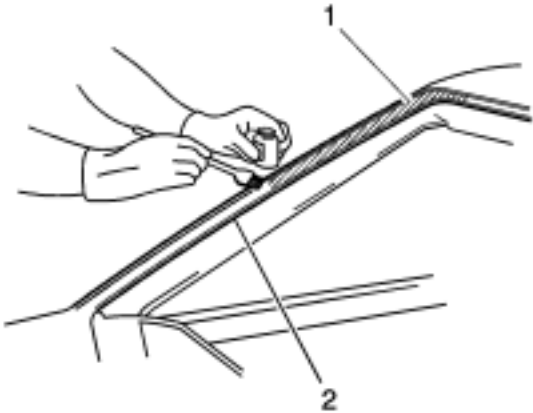
## Adhesive Installation of Liftgate Windows

**Warning:** Refer to [Glass and Sheet Metal Handling Warning](#) .

1. Use a urethane adhesive systems which meet GM Specification GM3651G.
2. Remove all mounds or loose pieces of urethane adhesive from the pinchweld area.
3. If the original window is being reused, remove all but approximately 2 mm (3/64 in) of the existing bead of urethane adhesive from the pinchweld flange by using a clean utility knife or razor blade scraper.
4. Inspect for any of the following problems in order to help prevent future breakage of the window:
  - The flange of the window opening
  - High weld
  - Solder spots
  - Hardened sealer
  - Any other obstruction or irregularity in the pinchweld flange

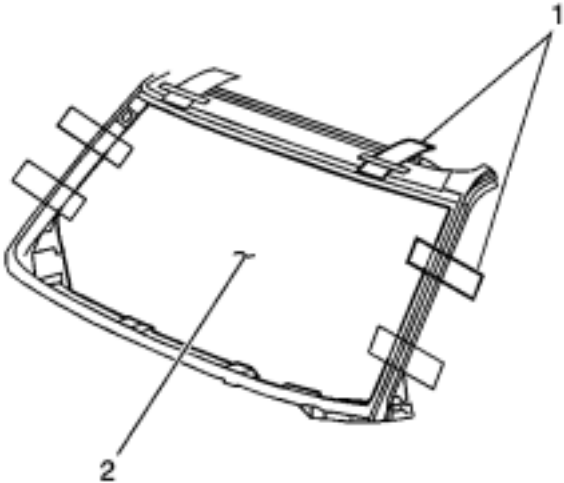
**Note:** If corrosion of the pinch-weld flange is present or if sheet metal repairs or replacements are required, the pinch-weld flange must be refinished in order to restore the bonding area strength. If paint repairs are required, mask the flange bonding area prior to applying the color coat in order to provide a clean primer only surface. Materials such as BASF DE15®, DuPont 2610®, Sherwin-Williams PSE4600 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.
6. Verify all primers and urethane adhesive are within expiration dates.



**Warning:** 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.

7. Apply the primer to the surface of the pinch-weld flange (1).
8. Allow the pinch-weld primer to dry per auto-adhesive instructions by the manufacturer's.
9. With an assistant, dry fit the window (1) to the opening in order to determine the correct position.



10. Use masking tape in order to mark the locations (1) of the window (2) in the opening.
11. Cut the masking tape in the center and remove the window from the opening.