



23. Ensure all excess urethane adhesive is cleaned from the body before water test.



Note: Do not direct a hard stream of high pressure water to the freshly applied urethane adhesive.

- 24. Use a soft spray of warm water in order to immediately water test the window.
- 25. Inspect the window for leaks.
- 26. If any leaks are found, use a plastic paddle in order to apply extra urethane adhesive at the leak point.
- 27. Retest the window for leaks.

Warning: Insufficient curing of urethane adhesive may allow unrestrained occupants to be ejected from the vehicle resulting in personal injury.

- For the moisture-curing type of urethane adhesive, allow a minimum of 6 hours at 21°C (70°F) or greater and with at least 30 percent relative humidity. Allow at least 24 hours for the complete curing of the urethane adhesive.
- For the chemical-curing type of urethane adhesive, allow a minimum of 1 hour .

Do NOT physically disturb the repair area until after these minimum times have elapsed.

28. Maintain the following conditions in order to properly cure the urethane adhesive:
- Partially lower a door window in order to prevent pressure buildups when closing doors before the urethane adhesive cures.
 - Do not drive the vehicle until the urethane adhesive is cured. Refer to the above curing times.
 - Do not use compressed air in order to dry the urethane adhesive.
29. Complete the window installation.