

1 General information

Follow general [instructions](#) on window bonding.

[Materials](#) needed for window bonding.

The vehicle can be towed away or driven without a windscreen, rear window and side window.

When carrying out dismantling/installation work and during the hardening time, the vehicle must be standing on its wheels on a level floor.

The windscreen, rear window and side windows are glued to the body. This bonding will increase the torsional rigidity of the vehicle. To obtain perfect bonding, comply with the installation procedure described in the following.

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2 Disassembly

The following dismantling methods are applied, according to the version:

- [Roll Out 2000](#)
- [Oscillating knife](#) (not permissible for vehicles with window bonding on carbon body components)
- Cutting wire with [wire pull handles](#)
- Windscreen removal system "[Spider](#)"

Note:

When cutting out the window glass with wire pull handles, there is a risk of damage to the window glass if the wire is pulled over the window edge.

Unless otherwise described, only use this method when replacing the window glass.

Follow the vehicle-specific repair instructions!

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3 Installation

3.1 Preparation

Place the front or rear window on the universal work table or fix it onto the tool trolley with a suction lifter.

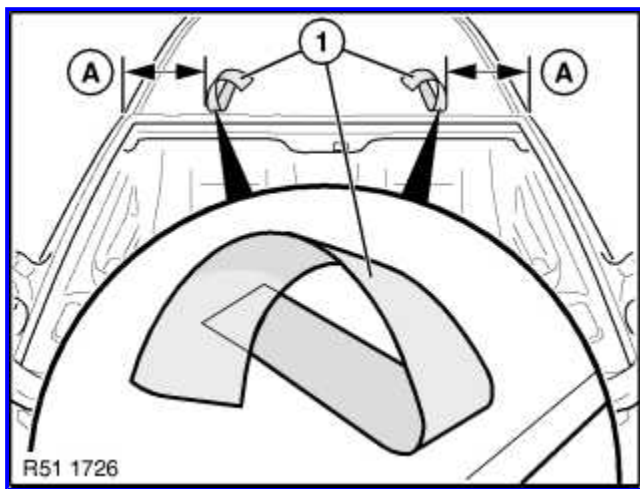
When placing the window glass on the universal work table, attach two suction lifters to the window glass.

According to its size, fix side and door window glass onto the tool trolley using suction lifters or special tool [51 3 220](#) and set down on a suitable support.

Always keep the suction faces of the window glass suction lifters dry and clean.

Note:

If accessibility is restricted, insert the window glass on a trial basis.



Bond two yellow plastic adhesive tapes (1) approx. 400 mm in length to the roof.

(A) = 250 mm

Only the yellow plastic adhesive tape may be used to fix the window glass.

The glass will slip down if other adhesive tapes are used.

Window glass slippage will result in leaks and wind noises.

After completing the paint work, the paint must be fully hardened before the plastic adhesive tapes are applied.

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3.2 Pre-treatment of bonding surfaces

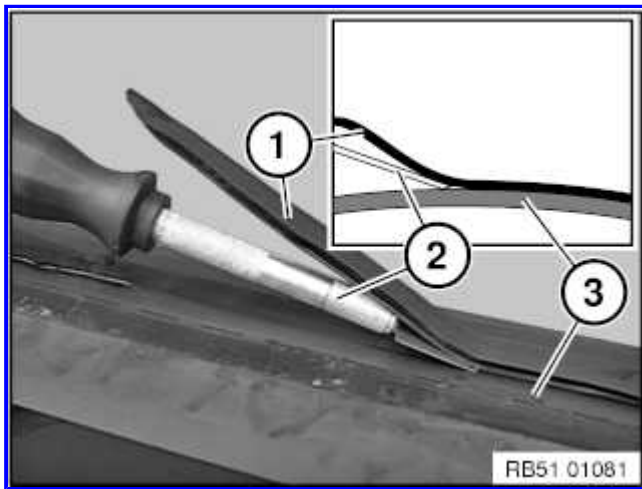
- Clean window glass and body aperture with cleaning agent R2

Attention! Do **not** use Sika remover 208 for cleaning in the adhesive area.

- Observe an air drying time of at least 5 minutes (at least 15 minutes when applied to residual adhesive bead)
- Remove residual adhesive bead from body and window glass (see point 3.3)
- Touch up [paintwork damage](#) to body aperture with BMW multibase filler (except for carbon body components)
- Only for a newly painted body aperture, apply paint activator (blue stick) to paint and then wipe dry with a paper towel
- Observe an air drying time of at least 1 minute (at least 10 minutes when applied to residual adhesive bead)

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3.3 Remove adhesive residue from the body and window glass



Do not remove residual adhesive bead (1) until shortly before bonding.

To remove the residual adhesive bead (1) from the body aperture and when reusing on the window glass (3), use the pinchweld scraper (2).

Position the pinchweld scraper (2) as shown and detach residual adhesive bead (1) to a thickness of approx. 0.5 mm.

Attention!

Carbon body components are not to have scratches with a depth greater than 0.2 mm.

Note, comply with life module check!

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3.4 Installation of spacer (spacer buffer/dual-lock tapes)

Remove all remnants of existing spacers completely before sticking on new spacers.

The exact position of the spacers must be retained (see vehicle-specific repair instructions).

Incorrectly fitted spacers will result in:

- Window glass breakage due to tension
- Leakage (if the spacer is in the adhesive area)
- Wind noises

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3.5 Add-on part

Depending on the version, attach sealing, expanding foam tape, rain sensor, etc.

Observe [Overview of additional work with rain sensor](#) when working with versions including the rain sensor!

Follow the vehicle-specific repair instructions!

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3.6 Pre-treatment of new window glass

- Apply a thin coat of glass activator (yellow stick); a final wipe is not necessary.
- Observe an air drying time of at least 2 minutes

The glass activator is used for adhesion between glass or ceramic glass and the adhesive. Therefore, a thin, homogeneous and continuous line of glass activator must be applied. If the window glass is to be reused with a cut-back adhesive bead, glass activator is not needed.

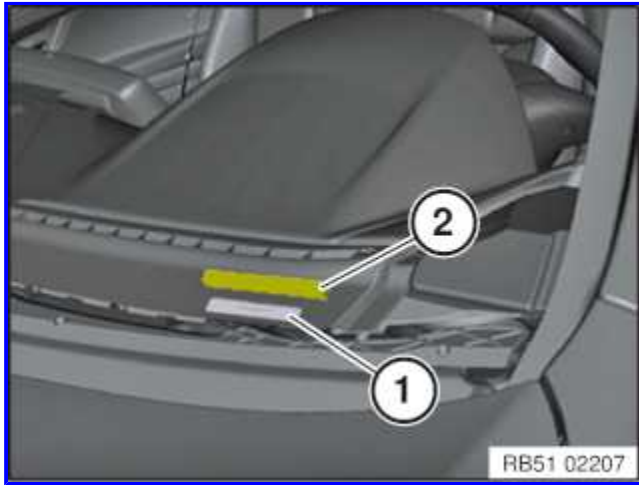
It must be guaranteed that a 1 to 2 mm wide line of glass activator is located on the ceramic glass next to the squeezed adhesive bead.

The adhesive bead may become up to 15 mm wide in compressed condition. The width of the glass activator is therefore normally a minimum of 17 mm for windscreens and rear windows and a minimum of 9 mm for side windows.

The glass activator may not be applied in the field of view or the point grid. Fresh glass activator in the field of view must immediately be wiped off with cleaning agent R2 because hardened glass activator will leave a haze behind.

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3.7 Version with inspection glass for vehicle identification number in windscreen



Foam tape (2) must be installed to protect the vehicle identification number (1) against tampering. If applicable, install foam tape TNR 07 14 7 222 909.

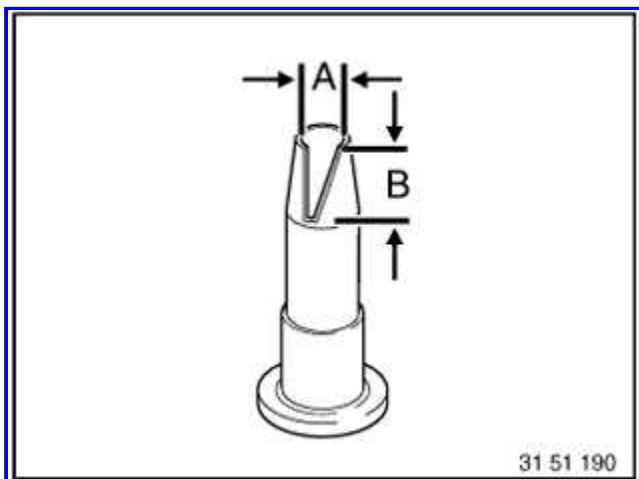
Close off the inspection glass on the windscreen (bottom left) with Sika bonding base VP 206.

Except for:

- All US/GB models
- All models with a black dashboard cover, which means that the vehicle colour cannot be seen through the inspection glass

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3.8 Nozzle preparation



When not using standard nozzle C, prepare plastic nozzle(s) for shaping the adhesive bead.

Follow the vehicle-specific repair instructions!

Black ceramic glass impermeable to UV light is located on the peripheral zone of the inside edge of the window to protect the adhesive bead.

Ceramic glass must not be damaged.

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3.9 Apply adhesive

Adhesive is applied to the window glass with a cartridge gun.

Glue cartridge must be vertical to window glass.

The almost vertical part of the adhesive bead must be facing the outer window glass edge.

On window glass with guidelines, the adhesive bead must be applied centrally between the guidelines.

On window glass without guidelines, the position of the adhesive bead is specified in the vehicle-specific repair instructions.

Coat bead joint.

Effect of differing adhesive quantities:

Too little adhesive:	Too much adhesive:
- Window glass rests too low in body aperture - Insufficient squeezing of adhesive bead (leaking)	- Window glass rests too high in body aperture - Wind noise may occur - Strains/tensions may occur (window glass breakage) - Dirt contamination of add-on parts by emerging adhesive - Adhesive on uninsulated strainer pressure lines of aerial(s) (interference of reception)

Note on bonding of windscreen:

The adhesive amount specified in the vehicle-specific repair instructions is sufficient if the specified adhesive bead size is maintained.

If too much adhesive is applied due to application-related variations (manual application), the specified adhesive amount may not be sufficient. To avoid interrupting adhesive application for longer than the permitted period, have another glue cartridge ready.

Important!

Once the adhesive bead has been applied, the window glass must be installed within 7 minutes (depending on air humidity, temperature).

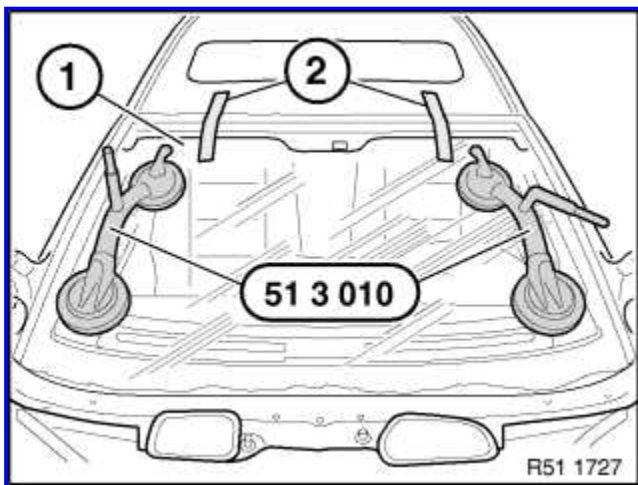
After 7 minutes the adhesive bead forms a skin which can no longer guarantee a perfect bond.

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3.10 Mounting the window glass

To prevent a pressure build-up in the passenger compartment when the doors are closed:

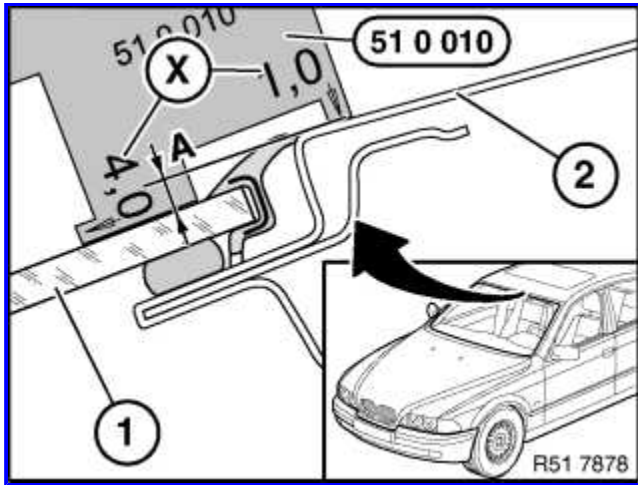
- Open a side window



Mount window glass (1) with [suction lifter](#) (51 3 010).

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3.11 Adjusting the window glass



To avoid wind noise, the front and rear windows (1) must be lower than the roof outer skin (2).

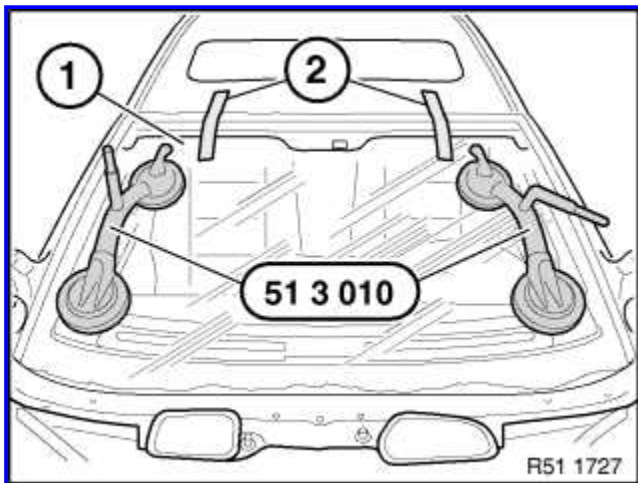
Check ride height of the windscreen or rear window using special tool [51 0 010](#).

Dimension (A) of window glass offset, refer to vehicle-specific repair instructions.

X = measurement stages 1 ... 4 mm

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3.12 Fixing the window glass



Fix the window glass with yellow plastic adhesive tapes (2).

Immediately remove dirt contamination with adhesive residue using Sika remover 208. Do not press out the window glass again.

Hardened adhesive can only be removed mechanically.

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3.13 Label

Depending on version, apply [label](#).

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