

51 31 ... Instructions for repairing stone chip damage on laminated safety glass (clear and tinted)

Note:

These repair instructions are intended for qualified skilled workers who work conscientiously and accept full responsibility for their work.

General:

- These instructions are restricted to the repair materials approved by the plant (sourcing reference: BMW Parts Department), the repair method and related tips to simplify the work involved.
- The instructions can only outline the general work procedure.
- The actual work scope must be adapted to the damage pattern.
- The repair work represents an economical and swift solution which can not rule out visual impairment.
- The repair should be offered to the customer on passing through or for used vehicles and on special customer request.
- The conditions detailed below for repairing laminated safety glass conform to the legal regulations in Germany.
- In other countries, the relevant regulations must be observed.

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Important!

- Repair work may only be carried out outside the field of vision.
- Only damage to the outer area of the windscreen may be repaired.
- The inner window pane and the plastic film between inner and outer window panes must not be damaged.
- Repairing should be carried out as soon as possible after occurrence of the damage.
- The penetration of moisture or dirt must not be visible in the damaged spot.
- Impact spot cavities must not exceed a diameter of 5 mm.
- Cracks leading away from the impact spot must not be longer than 50 mm.
- Cracks must not end in the rubber window frame trim or decorative strip.

- Visibility through the repaired surface must be clear, transparent and with minimum distortion.
- Cover engine compartment lid and front side panels with protective covers.
- Note processing instructions!

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Repairing laminated safety glass,

See [repair instructions](#).