

**51 31 200****Removing and installing/replacing rear window****Important!**

The following notes form the basis for these repair instructions and must be adhered to at all times:

- [Notes on window bonding](#)
- [General procedure](#) for dismantling/installing bonded window glass

When reusing the rear window:

Avoid damaging lines for heated rear window / -aerial.

*Note:*

Removal is performed with [Roll Out 2000](#).



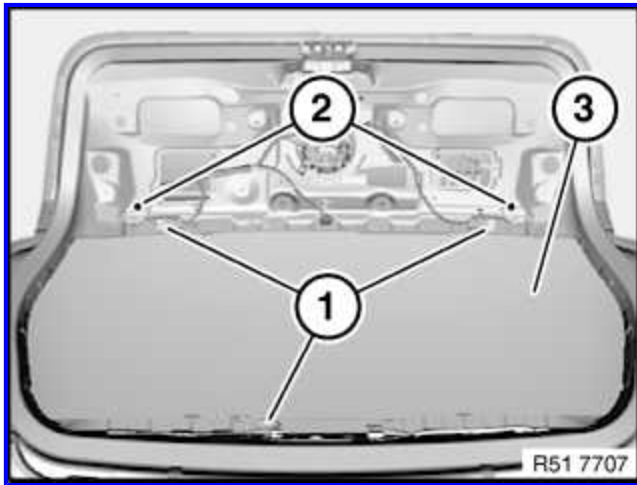
The following new parts / consumables are required (sourcing reference BMW Parts Department).

| Material                       | Quantity |
|--------------------------------|----------|
| Rear window (with replacement) | 1        |
| Spacer buffer 5x5x20 mm        | 7        |
| Small repair kit               | 1        |
| Wire from Roll Out 2000        | 7 m      |

**Necessary preliminary work:**

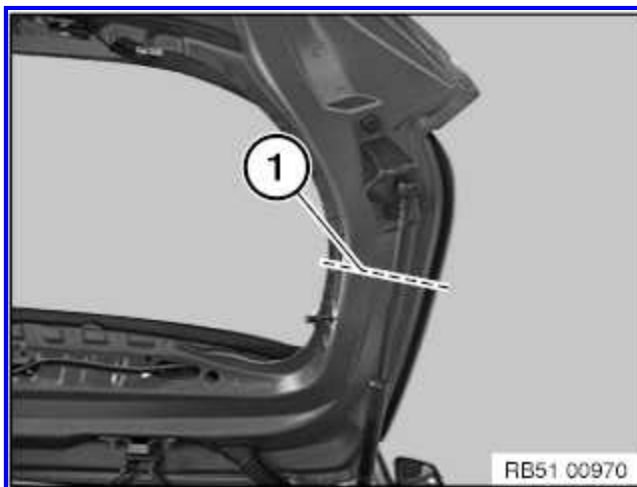
- Remove [trim for rear lid](#)
- Remove [wiper arm](#)

Disconnect plug connection (1).



Release screws (2) and remove earth cable.

Secure electric cable with adhesive tape to rear window (3).



### Important!

Tape off body in area of piercing point with fabric adhesive tape (risk of damage).

Push wire from [Roll Out 2000](#) at line (1) through adhesive bead.

For details on how to proceed, refer to: [Window removal with Roll Out 2000](#).

Because of the window geometry and adhesive strength, make sure that the cutting wire is always at an acute angle to the adhesive bead.

If necessary, reposition the suction cup several times that is used as the deflection point.



### Fitting spacer buffers (spacers):

#### Important!

Spacer buffers are installed to avoid rear window breakage.

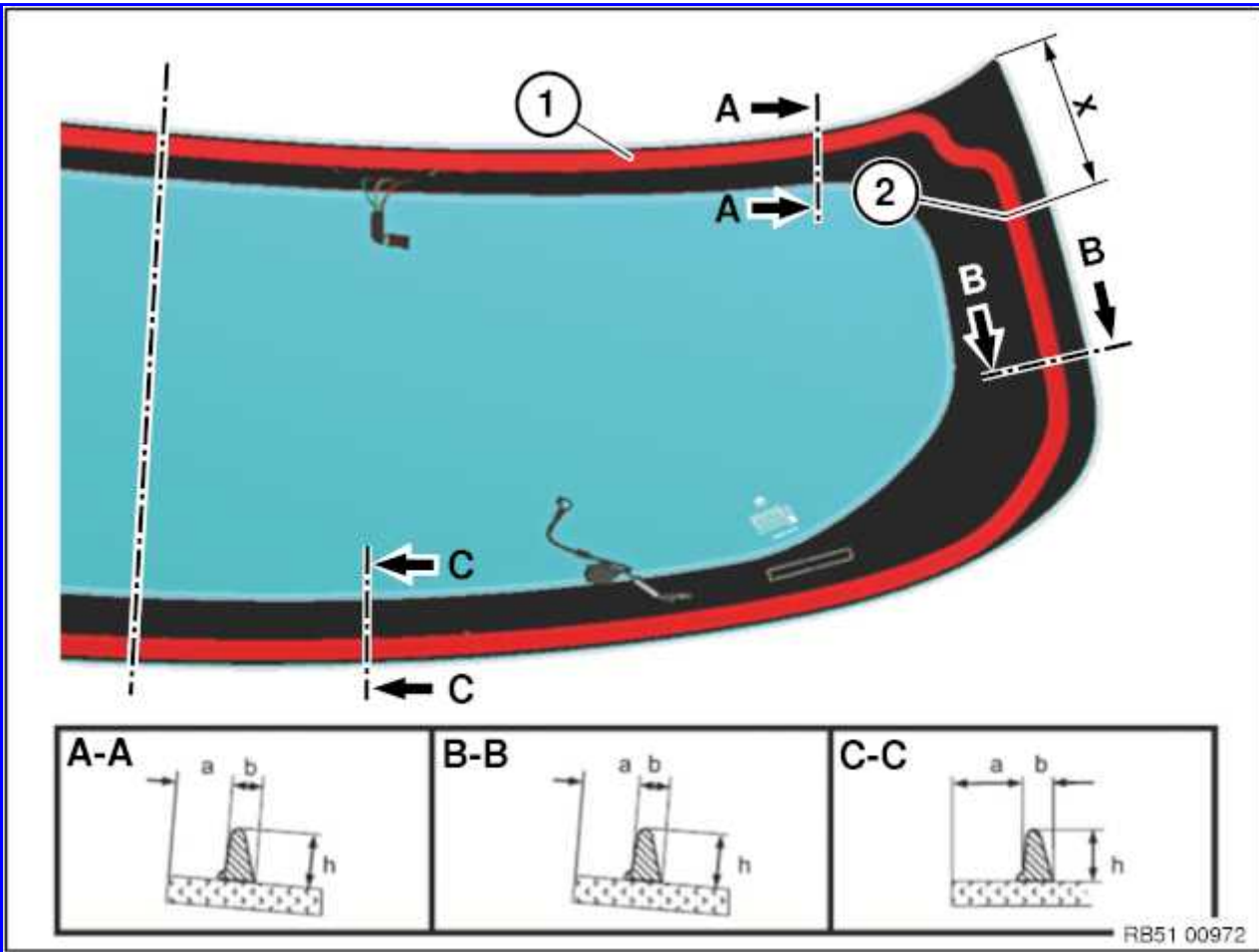
Completely remove old spacer buffers (1 and 2).

Stick new spacer buffers (1) centrally onto moulding.

Bond new spacer buffers (2) within the tabs.

Spacer buffers (2) must not extend over sheet metal edge.

### Overview of rear window bonding:



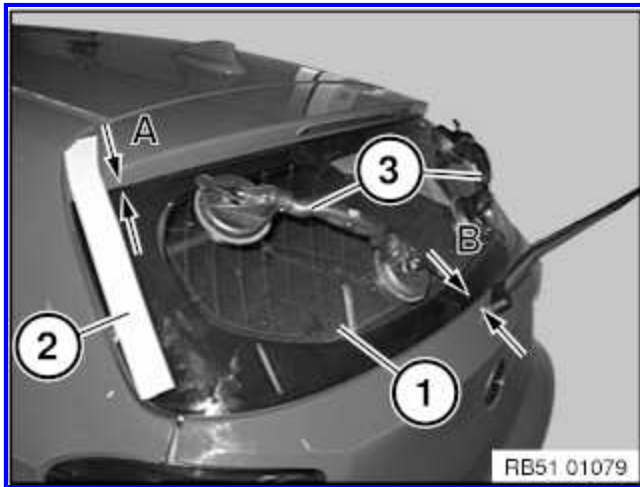
| Cut                                    | A - A | B - B | C - C |
|----------------------------------------|-------|-------|-------|
| <b>a</b> [mm] = Position adhesive bead | 6 +2  | 25 +2 | 5 ±2  |
| <b>b</b> [mm] = Width adhesive bead    | 8 ±2  | 8 ±2  | 8 ±2  |
| <b>h</b> [mm] = Height adhesive bead   | 12 -2 | 12 -2 | 12 -2 |

**Note:**  
 A tolerance band is printed on the ceramic (two dashed lines) that marks the position of the adhesive bead. Adhesive bead (1) must be applied centred on tolerance band.

Prepare the body and rear window.  
 x = approx. 250 mm (bead joint distance (1) to rear window outer edge)

**Note:**  
 Adhesive area for plastic adhesive tapes (2) must be free from grease and dust.

Perform the following steps carefully on the rear window (1) using the siphon (3):



- Position at distance (A) at the top
- Align sides evenly
- Place at distance (B) at bottom and press in
- If necessary, adjust gap dimension (A and B)
- Secure in terms of height in this position at top with yellow plastic adhesive tapes (2)

A =  $2.5 \pm 1$  mm

B =  $3.5 \pm 1.4$  mm