

51 31 021

Removing and installing/replacing windscreen rubber surround

Special tools required:

- [2 232 316](#)



Necessary preliminary tasks:

- Remove [windscreen](#)



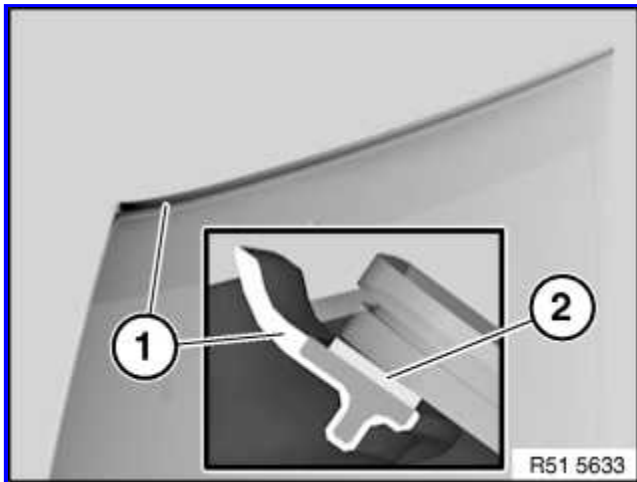
Important!

The glass activator for pre-treating the area of the windscreen adhesive trace must not encroach upon the adhesive area for the rubber frame.

The bonding result of the rubber frame is otherwise compromised.

The rubber frame must therefore be installed prior to applying the glass activator.

Following [instructions](#) for bonding components with double-sided adhesive tape.



Pull off rubber frame (1).

Remove remnants of adhesive tape (2).

Clean bonding surface.

Air drying time: ≥ 1 minute

Important!

Adhesive area must be dry and free from dust and grease.

Once it has been cleaned, do not touch the adhesive area with bare hands.

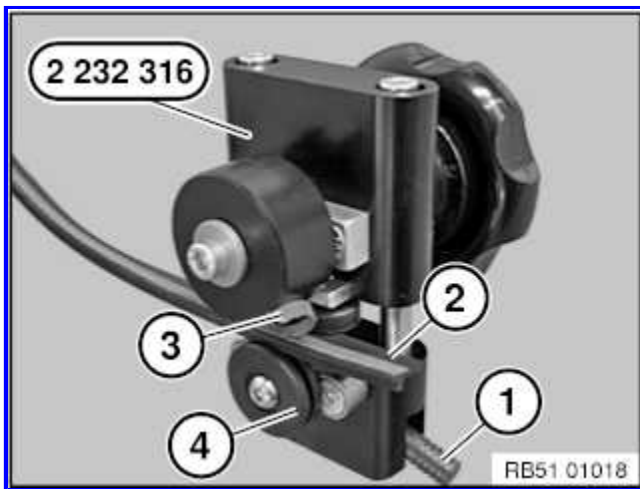


Installation note:

Pre-treat adhesive area with Sika-Aktivator205.

Air drying time: ≥ 1 minute

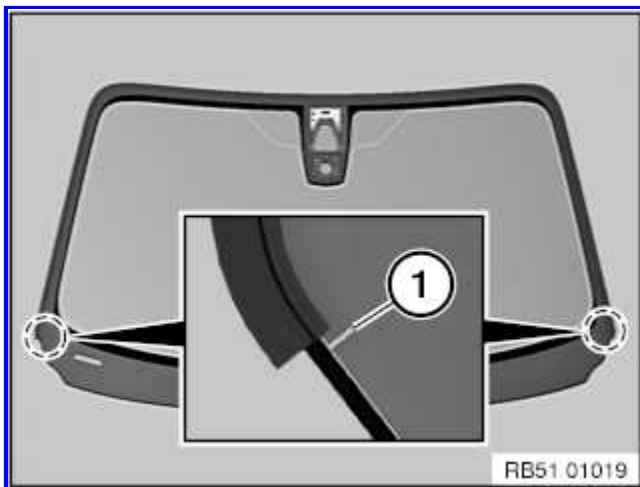
Sika Activator 205 must not get onto adhesive area of adhesive bead.



Reposition lever (1) and open special tool [2 232 316](#).

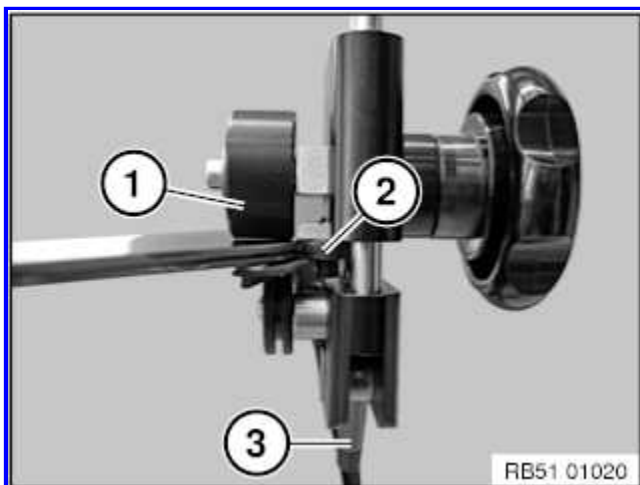
Pull off protective film (3) in stages from adhesive tape.

Insert rubber frame (2) in guide pulley (4).



Installation note:

The start and end points of the rubber point are marked on the windscreen with marks (1).



Place special tool with contact rollers (1 and 2) up against window edge.

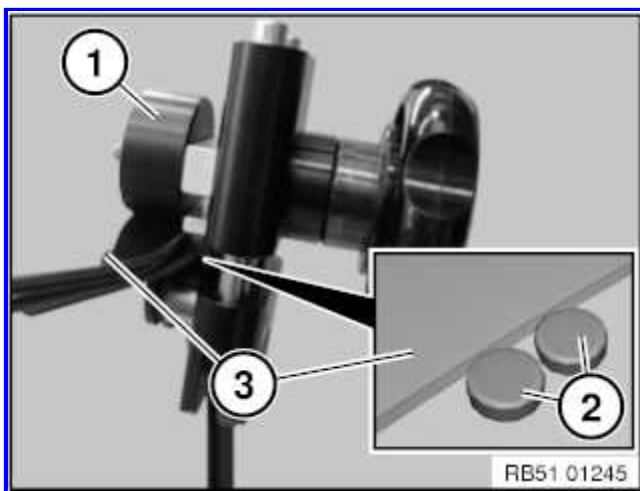
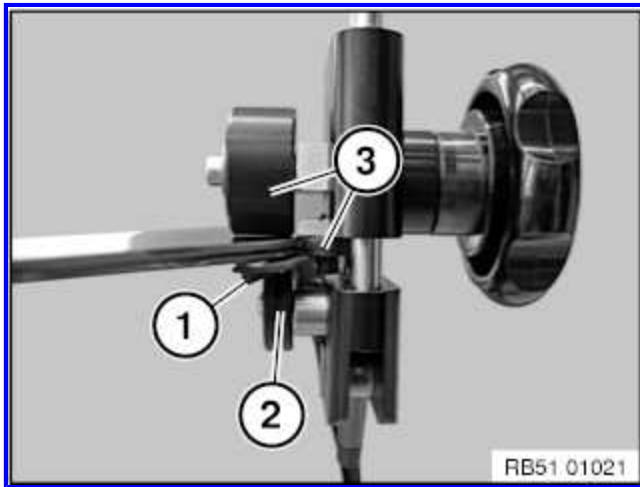
Align the rubber frame on the outer window edge.

Reposition lever (3) and close special tool.

Make rubber frame (1) is correctly seated in guide pulleys (2).

Continue to pull off protective film in stages from adhesive tape.

Run special tool with hand wheel over entire window edge.



Guide pulleys (1 and 2) must always be correctly placed at windscreen (3) and are not to be twisted.

- Guide pulley (1) from top on windscreen (3)
- Side guide pulleys (2) at outer edge of windscreen (3)