

51 31 011**Replace windscreen****Special tools required:**

- [51 0 010](#)

**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

Note:

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

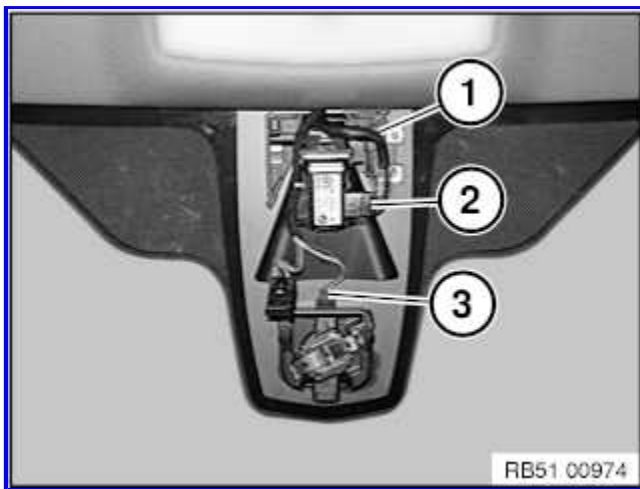


The following new parts / consumables are required (sourcing reference BMW Parts Department).

Material	Quantity
Windscreen	1
Cover, windscreen	1
Spacer buffer 5x5x20 mm	5
Small repair kit	1
Sika Activator 205 (for windscreen cover)	1
Wire from Roll Out 2000	9 m
Expanding foam tape	1

Necessary preliminary tasks:

- Remove [cover for cowl panel](#)
- Remove [inside mirror](#)
- Remove [trim panel for roof pillar](#) (A-pillar) left/right



Depending on version:

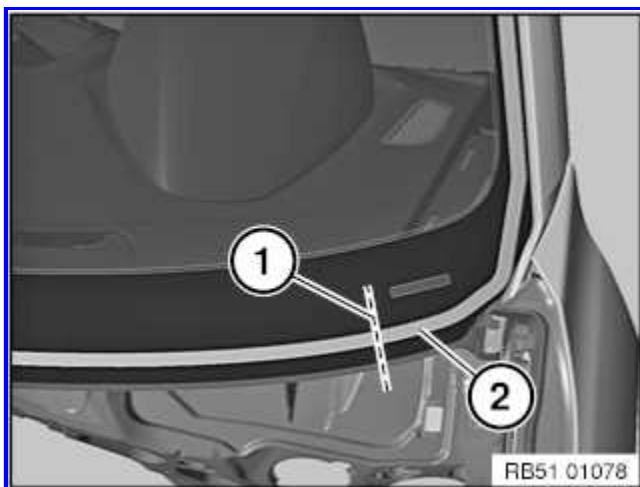
Unplug plug connections (1 to 3).

Remove the [rain/light/solar and condensation sensor](#) and immediately install on a new windscreen.

Remove [camera](#).

Note:

Cables torn from the windscreen must not be soldered back in place. The windscreen must be replaced



Important!

Tape off body in area of piercing point with fabric adhesive tape.

Push wire from [Roll Out 2000](#) along line (1) through adhesive bead (2).

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

Lift out windscreen with [suction cup](#).

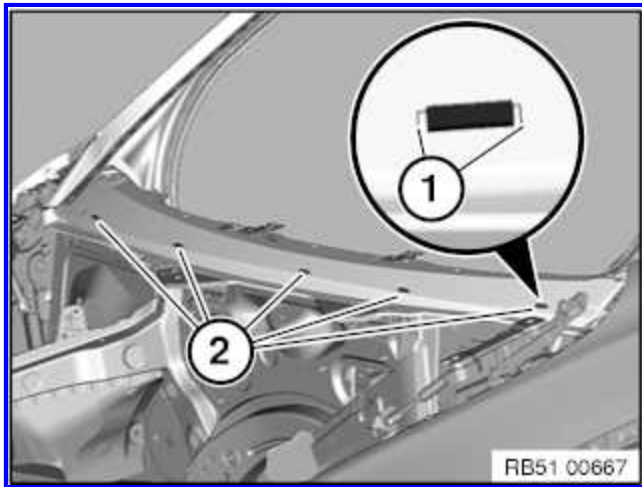
Fitting spacer buffers (spacers):

Important!

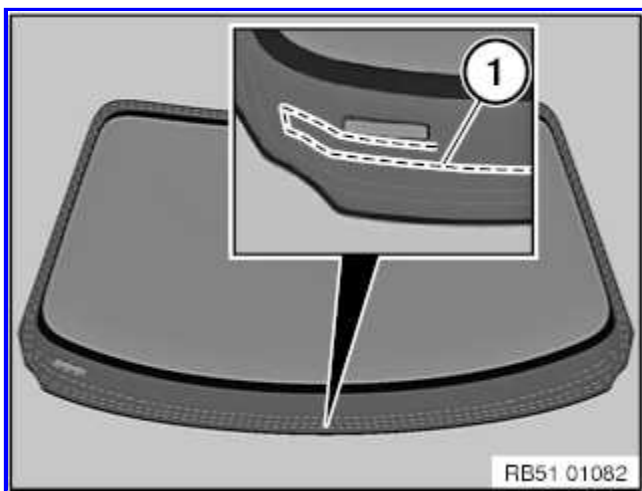
Spacer buffers are installed to avoid windscreen breakage and wind noises.

Completely remove old spacer buffers (2).

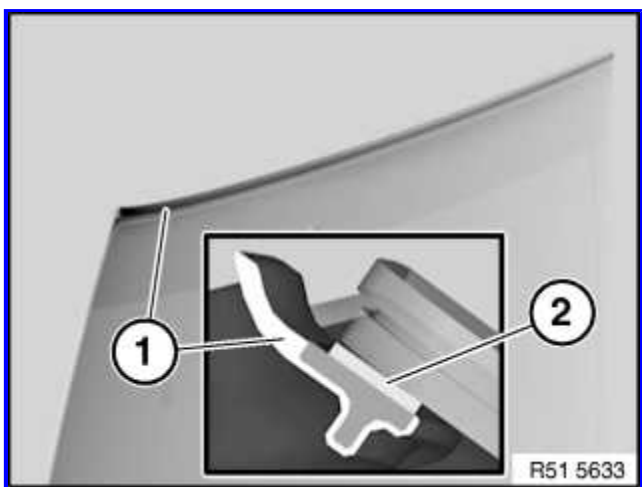
Position the new spacer buffers (2) in the centre of the



embossed marks (1) and bond.

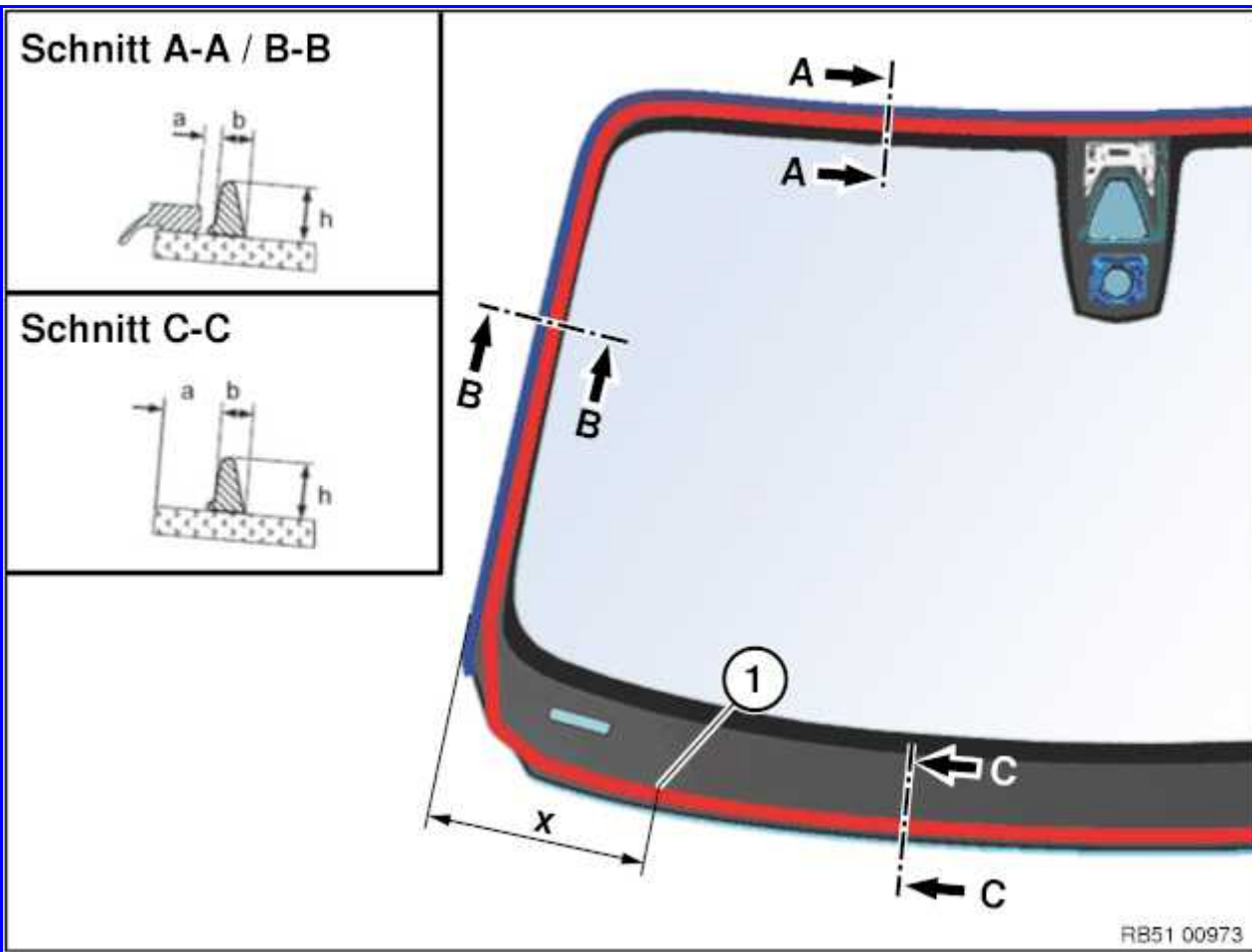


Observe [notes](#) on component-bonding with adhesive tape!
Stick expanding foam tape onto the marked area (1) on the windscreen.



Install the [cover / rubber frame](#) (1) for the windscreen.
Pre-treat adhesive area with Sika-Aktivator205.

Overview of windscreen bonding:



Cut	A - A / B - B	C - C
a [mm] = Position adhesive bead	1 +1	18 +1
b [mm] = Width adhesive bead	8 ±2	8 ±2
h [mm] = Height adhesive bead	12 -2	12 -2

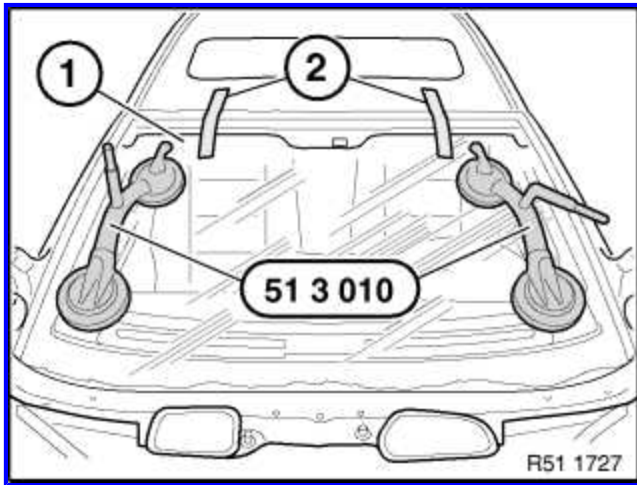
Note:
 A tolerance band is printed on the ceramic (two dashed lines) that marks the position of the adhesive bead.
 Place the adhesive bead in the outer area of the tolerance band.

x = approx. 300 mm (bead joint distance (1) to windscreen outer edge)

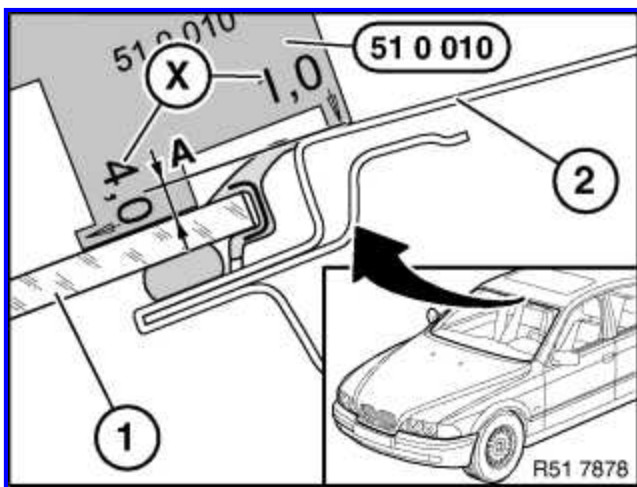
Prepare the body and windscreen.

Perform the following steps carefully on the windscreen (1) using suction cup (51 3 010):

- feed in on the bottom of the lower front side wall
- Position at top
- Align sides evenly



- press upwards until sealing rests evenly on roof and apply pressure
- secure in terms of height in this position at top with two yellow plastic adhesive tapes (2)



Preload on top of windscreen to prevent wind noise:

Windscreen (1) must be lower than roof outer skin (2). This is the only way to prevent wind noises.

Position special tool [51 0 010](#) in middle of vehicle depending on dimension (A) and check underprotrusion of windscreen (1).

Windscreen underprotrusion (A):

A = 2.8 ± 1 mm

X = Measurement stages 1... 4 mm