

51 34 191**Replacing left or right fixed door window
in rear window frame****Special tools required:**

- [51 3 220](#)

**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](#) to dismantle / install bonded window glass

Note:

Removal is carried out with [wire pull handles](#).



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

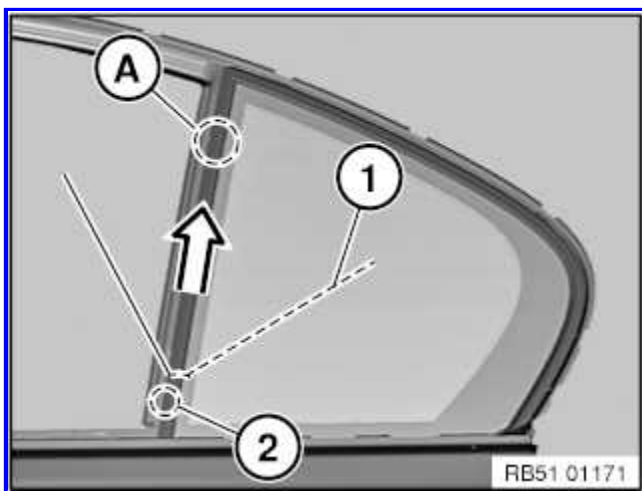
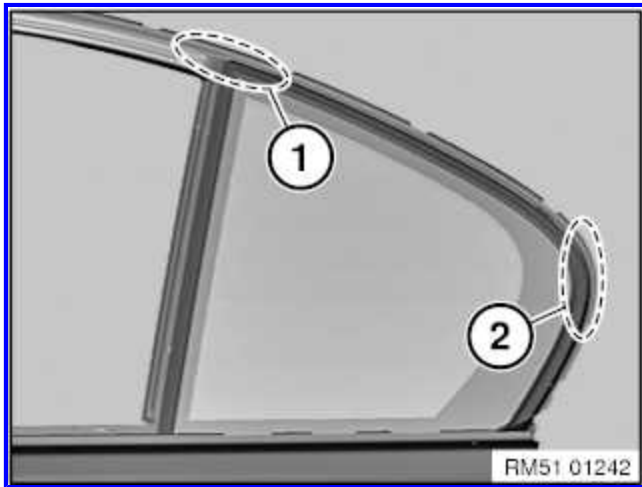
Material	Quantity
Side window	1
Small repair kit	1
Cutting wire	1

**Necessary preliminary tasks:**

- Remove [cover for window guide](#)
- Remove [rubber window seal for door window](#) in area of fixed door window.

To avoid damage, the door must be taped off with yellow plastic adhesive tape in area (1 and 2).

- (1) Outer
- (2) Inside and outside

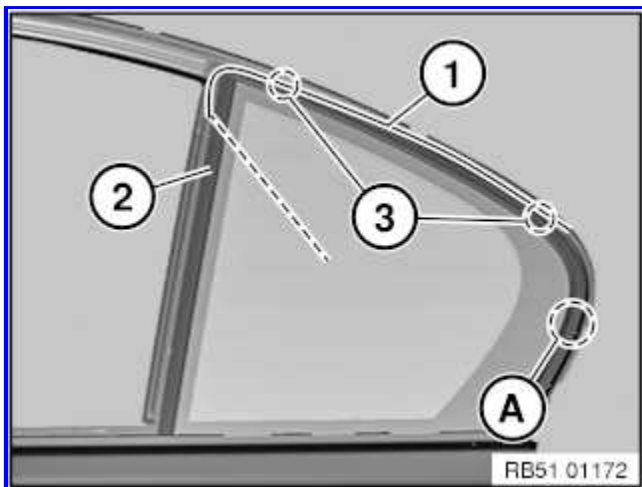


Slide cutting wire (1) through adhesive bead above latch mechanism (2).

Sever adhesive bead in direction of arrow up to area (A), pulling outward.

Note:

Dashed line (1) represents the cutting wire on the inside of the door.



Lay the cutting wire (1) at the top behind the PVC coating (2) and feed it in behind the spacer (3) if possible.

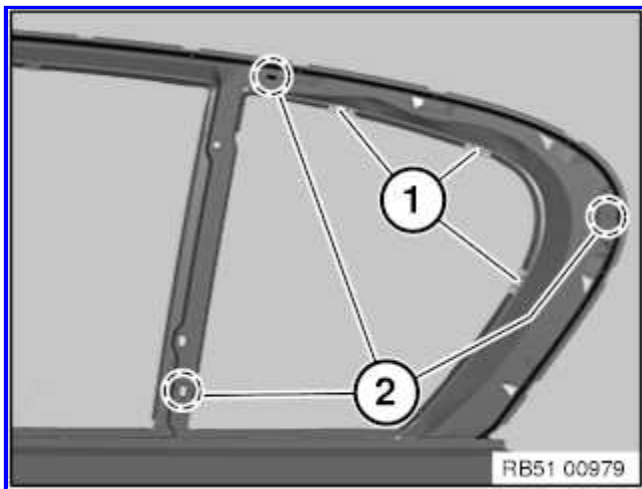
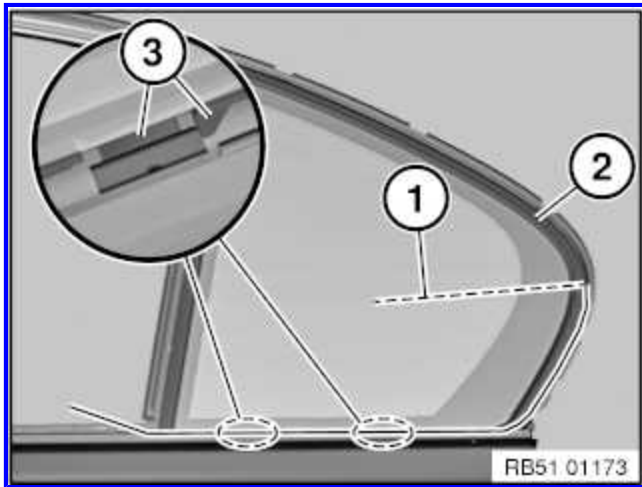
Sever the adhesive bead up to area (A), pulling from the inside only.

Note:

Dashed line (1) represents the cutting wire on the inside of the door.

Lay cutting wire (1) at the bottom behind PVC coating (2) and press underneath spacer (3).

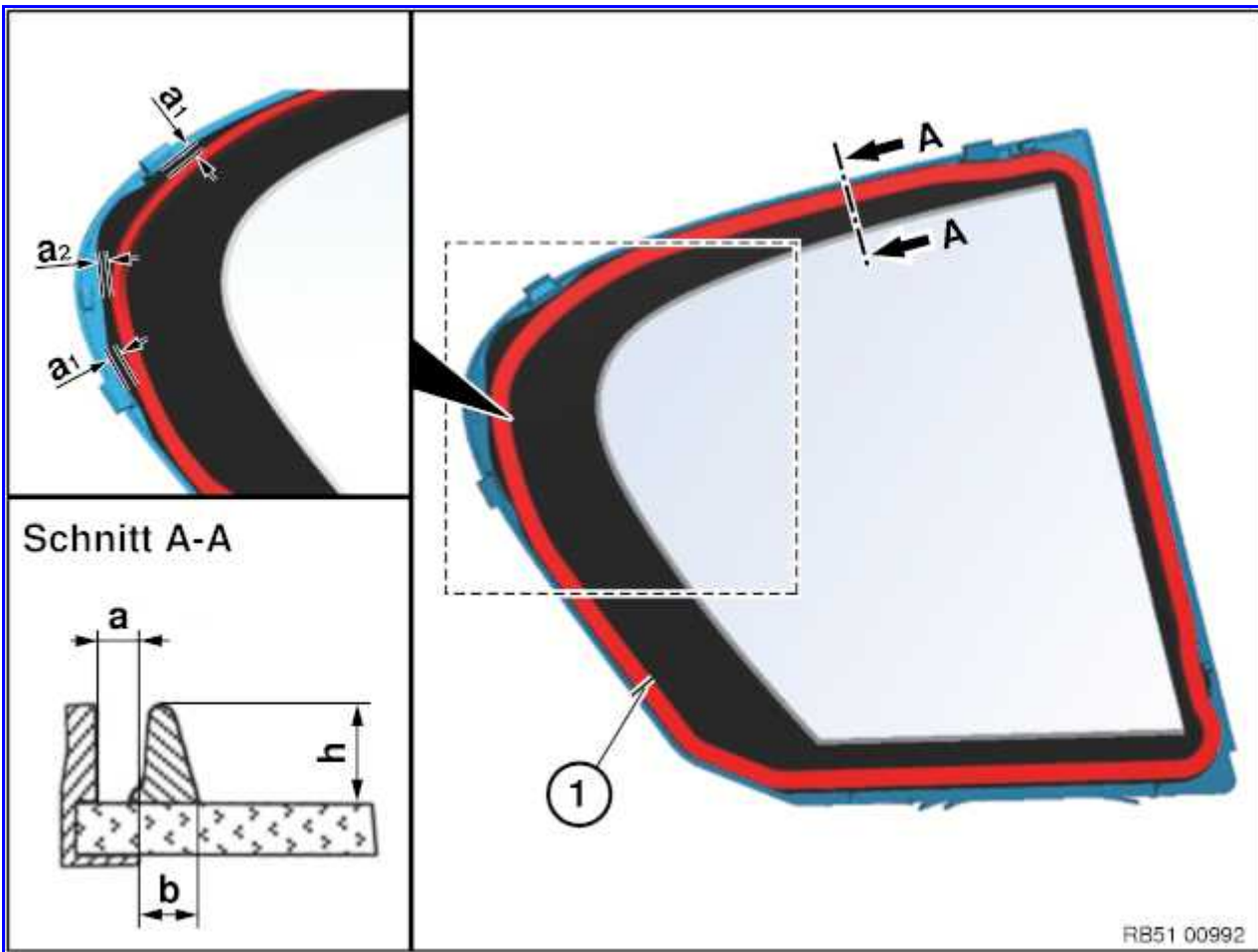
Sever remaining adhesive bead and remove door window.



Replace faulty clamps (1).

Remove remnants frame in the areas (2).

Overview for taping of door window ()



Position (1) corresponds to bead joint.

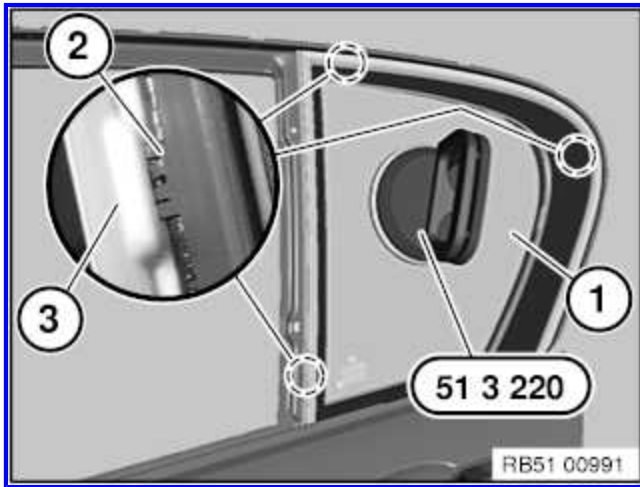
Cut	A - A
a [mm] = Position adhesive bead	1 +1 / along frame contour
b [mm] = Width adhesive bead	8 ±1
h [mm] = Height adhesive bead	15 ±2

Important!

In the marked area, the adhesive bead does **not** follow the contour of the frame.

	F20	F30/F35/F80
a_1	6 +1 mm	2 +1 mm
a_2	8 +1 mm	4 +1 mm

Carefully insert door window (1) with special tool [51 3 220](#) at bottom first, align sideways and insert latch mechanisms (2) in mountings (3).



Assemble the door immediately after installation of the door window.