

13. Windshield Glass

A: REMOVAL

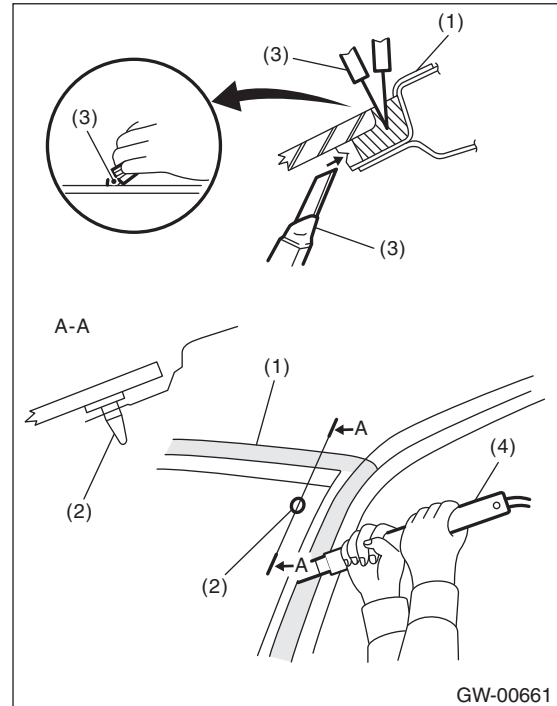
1. WHEN USING WINDSHIELD GLASS KNIFE

- 1) Remove the front pillar trim of the passenger's side, and disconnect the wiper deicer connector. (Model with wiper deicer)
- 2) Remove the cowl panel. <Ref. to EI-37, REMOVAL, Cowl Panel.>
- 3) Remove the glass molding.
- 4) Tape the body side of the circumference of windshield glass for protection.
- 5) Apply sufficient amount of soapy water to the adhesive part.
- 6) Using a razor blade, cut a notch so that the windshield glass knife will be easier to insert.
- 7) Insert the windshield glass knife into the adhesive part.

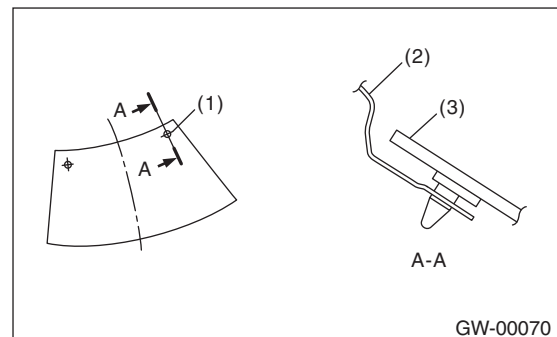
- 8) While holding the knife edge and windshield glass edge at a right angle, move the windshield glass knife in parallel to the windshield glass edge along the surface and edge of windshield glass to cut the adhesive part.

NOTE:

- Do not twist the windshield glass knife.
- Cutting of adhesive part shall be started with wider gap between windshield glass and body.
- The locating pins are bonded to the corners of glass. Use piano wire to disconnect the pins.



- (1) Tape for protection
- (2) Locating pin
- (3) Cutter knife
- (4) Windshield glass knife



- (1) Locating pin
- (2) Body panel
- (3) Windshield glass

Windshield Glass

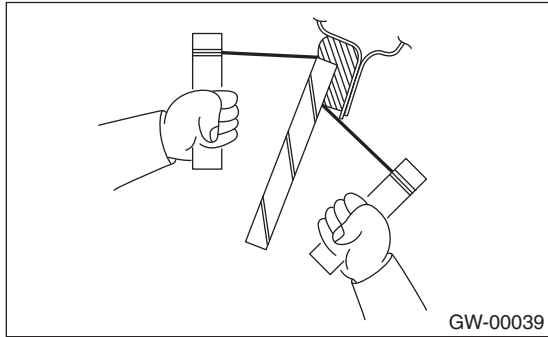
GLASS/WINDOWS/MIRRORS

2. WHEN USING PIANO WIRE

CAUTION:

- Do not tightly pull the piano wire against the windshield glass edge.
- Apply protective tape, etc., and be careful not to damage interior and exterior parts.
- Do not cross piano wires. Otherwise they may be cut.

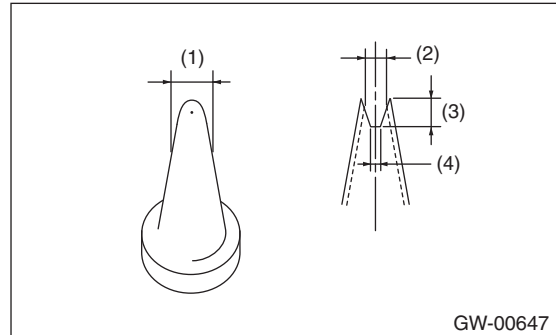
- 1) Remove the front pillar trim of the passenger's side, and disconnect the wiper deicer connector. (Model with wiper deicer)
- 2) Remove the cowl panel. <Ref. to EI-37, REMOVAL, Cowl Panel.>
- 3) Remove the glass molding.
- 4) Tape the body side of the circumference of windshield glass for protection.
- 5) Using a drill or razor blade, make a hole in the adhesive part.
- 6) Pass the piano wire through the hole, and attach both the wire ends securely to pieces of wood.



- 7) Pull the wire ends alternately to cut off the adhesive part.

B: INSTALLATION

- 1) Process the cartridge nozzle tip as shown in the figure, and set the adhesive in the sealant gun.

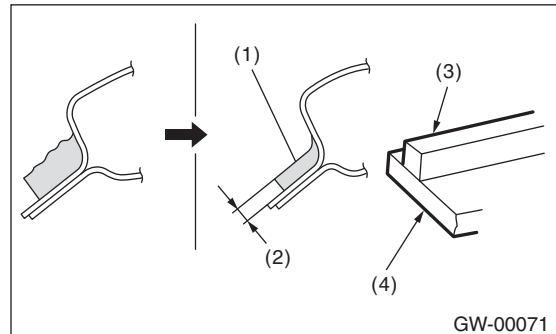


- (1) 10 mm (0.39 in)
- (2) 8 mm (0.31 in)
- (3) 9 mm (0.35 in)
- (4) 2 mm (0.08 in)

- 2) Clean the external circumference of windshield glass with alcohol or white gasoline.
- 3) Remove the adhesive layer on the body using cutter knife to obtain smooth face of 2 mm (0.08 in) thick.

CAUTION:

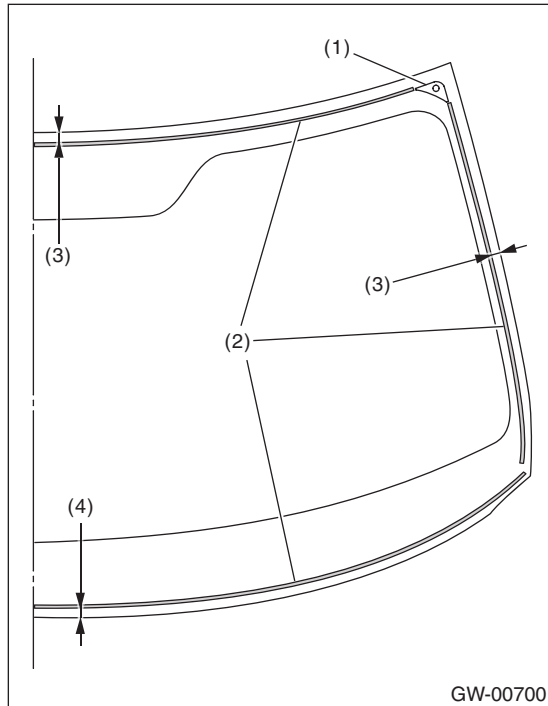
Be careful not to damage the body and paint surface.



- (1) Adhesive
- (2) 2 mm (0.08 in)
- (3) Dam rubber
- (4) Glass

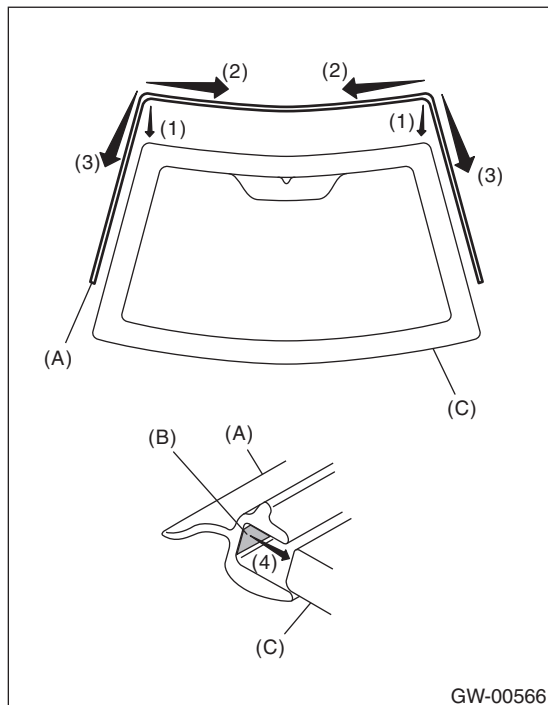
- 4) Clean the body with alcohol or white gasoline to eliminate cutting powder, dust and dirt completely from body.

5) Install the dam rubber.



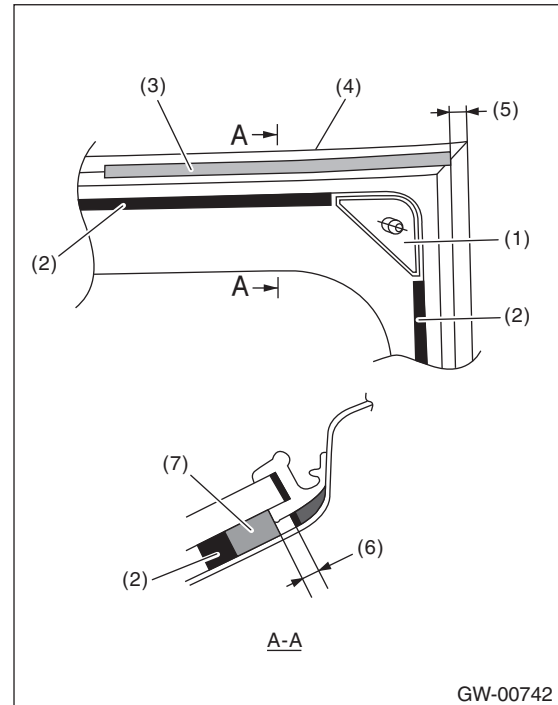
- (1) Locating pin
- (2) Dam rubber
- (3) 11 mm (0.433 in)
- (4) 13.5 mm (0.531 in)

6) Attach the molding to the glass.



- (1) Align the molding (A) to the upper ends of the windshield glass (C).
- (2) Attach the molding from the upper corners towards the center.
- (3) Attach the molding from the upper corners downward.
- (4) Firmly apply the double sided tape (B) of the molding evenly to the end face of the glass.

7) Apply the sticker to the molding



- (1) Locating pin
- (2) Dam rubber
- (3) Seal
- (4) Molding
- (5) 10 mm (0.39 in)
- (6) 1.5 mm (0.06 in)
- (7) Adhesive

NOTE:

Apply so that the sticker does not overlap out to the adhesive side (6).

Windshield Glass

GLASS/WINDOWS/MIRRORS

8) Using a sponge, apply primer to the glass side and body side adhesive surfaces.

Glass primer:

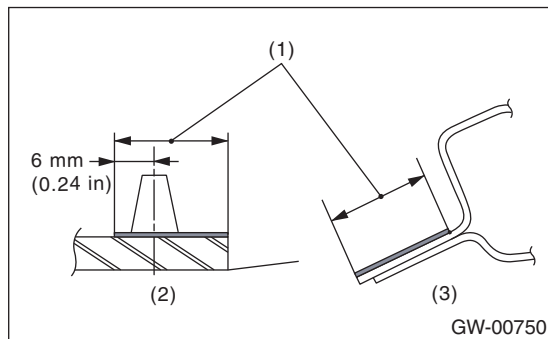
**Dow Automotive
ESSEX U-401, U-402 or equivalent**

Painted surface primer:

**Dow Automotive
ESSEX U-413 or equivalent**

NOTE:

- Primer once attached to the painted surface of the body and internal trim is hard to wipe off. Mask the circumference of such area.
- Let primer dry for about ten minutes before installing the glass.
- Do not touch the surface coated with primer.

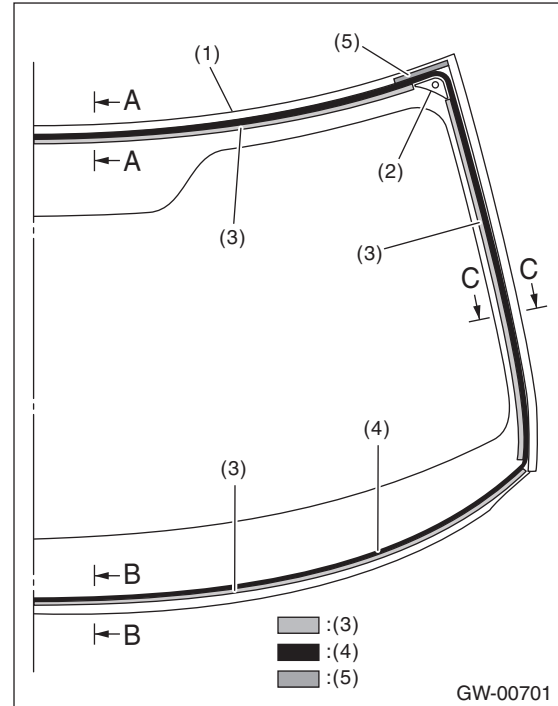


- (1) Application of primer
- (2) Glass side
- (3) Body side

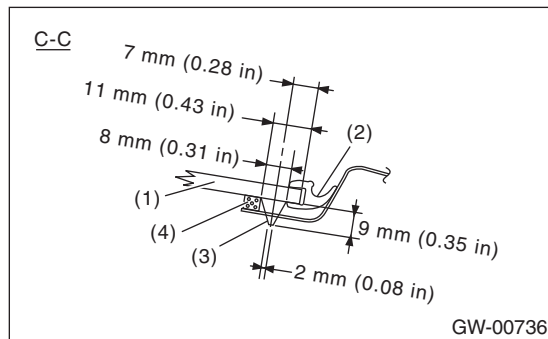
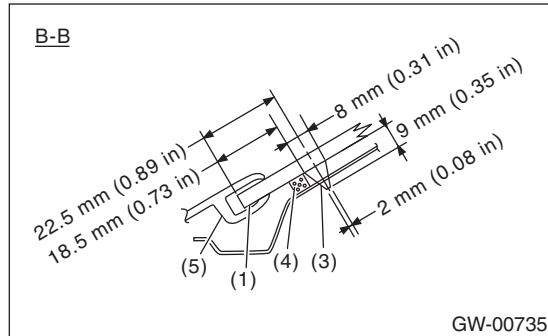
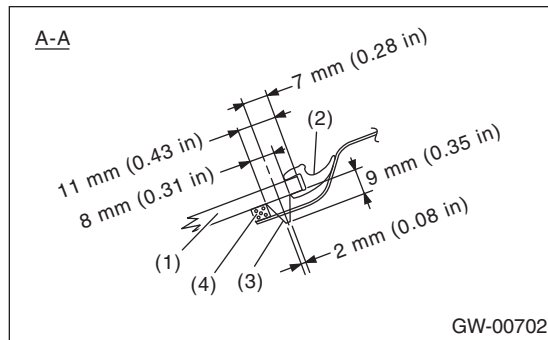
9) Apply adhesive to the glass end surface as shown in the figure.

Adhesive:

**Dow Automotive
ESSEX U-400HV or equivalent**



- (1) Molding
- (2) Locating pin
- (3) Dam rubber
- (4) Adhesive
- (5) Seal



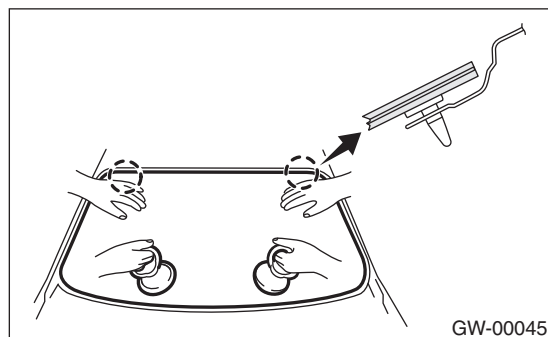
A-A Upper end area

B-B Lower end area

C-C Side area

- (1) Glass
- (2) Molding
- (3) Adhesive
- (4) Dam rubber
- (5) Cowl panel

10) Using suction rubber cups, fit the locator pins into the body side, and attach the windshield glass.



- 11) Lightly press the windshield glass for tight fit.
- 12) Make flush the adhesive surface juttred out using spatula.
- 13) Connect the wiper deicer connector. (Model with wiper deicer)
- 14) After completion of all work, allow the vehicle to stand for about 24 hours.

NOTE:

- When door is opened/closed after glass is bonded, always lower the door glass first, and then open/close it carefully.
- Move the vehicle slowly.
- For minimum drying time and vehicle standing time before driving after bonding, follow instructions or instruction manual from the adhesive manufacturer.
- 15) After curing of adhesive, pour the water on external surface of vehicle to check that there are no water leaks.

NOTE:

When a vehicle is returned to the user, tell him or her that the vehicle should not be subjected to heavy impact for at least three days.

16) Install the cowl panel. <Ref. to EI-37, INSTALLATION, Cowl Panel.>