

B: MATERIALS REQUIRED FOR APPLICATION

Description	Remarks
Repair adhesive set ● Cartridge of single liquid urethane adhesive ● Primer for glass and body	Sunstar No. 580 or Essex Chemical Corp's Urethane E Sunstar No. 435-580
Windshield knife or piano wire	For cutting windshield.
Sealant gun	For applying adhesive.
Suction cups	For holding glass.
Putty knife	For finishing adhesion surface and cutting spacer.
Sponge	For applying primer.
Gauze or cloth	For cleaning.
Alcohol or white gasoline	Alcohol or white gasoline For cleaning adhesion surface.
Tape	For preventing damage to painted surface.

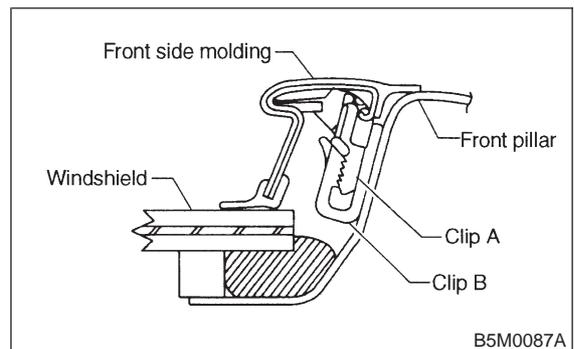
5. Windshield

A: REMOVAL

1. USING WINDSHIELD KNIFE

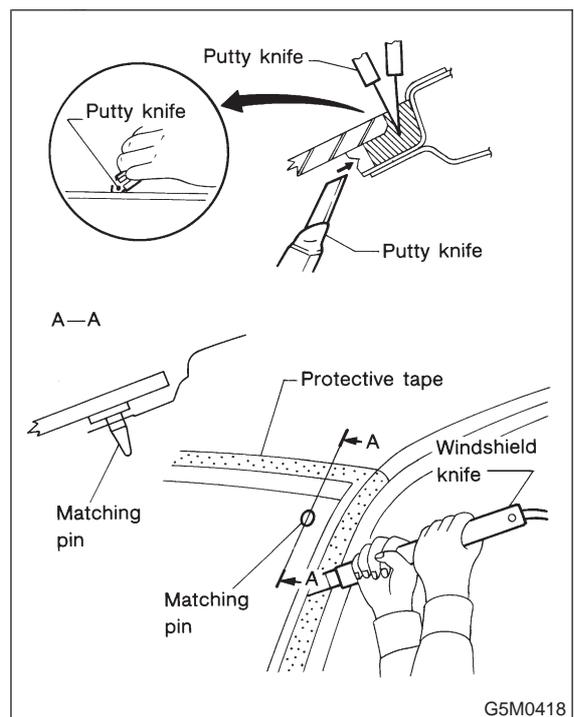
The following procedure for the front windshield can also be applied to other window glass.

- 1) Remove wiper arm and cowl panel.
- 2) Remove front side molding and front molding upper.



3) Remove glass:

- (1) Put protective tape on body to prevent damage.
- (2) Apply soapy water to the surface of the adhesive agent so the knife blade slides smoothly.
- (3) Cut off excess adhesive agent.
- (4) Put windshield knife into layer of adhesive
- (5) Cut adhesive layer with the windshield knife.

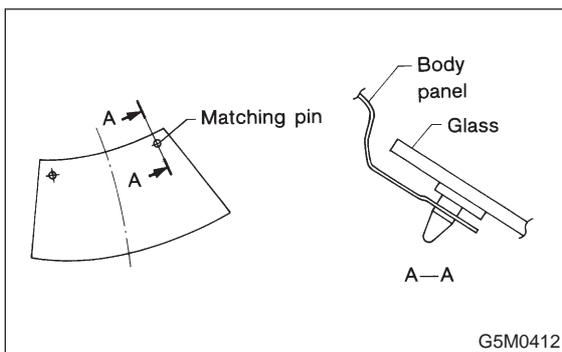


CAUTION:

- Keep knife edge along glass surface and end face.
- When first putting knife into layer of adhesive, select point with wide gap between body and glass.

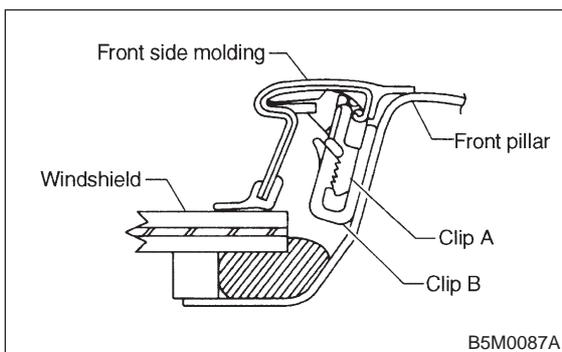
NOTE:

A matching pin is cemented to corners of glass on compartment side.
Use a piano wire when cutting each pin.



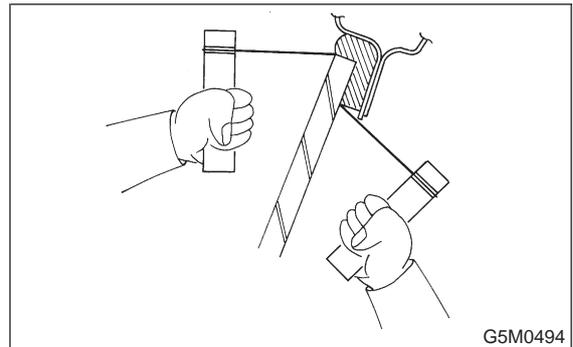
2. USING PIANO WIRE

- 1) Remove wiper arm and cowl panel.
- 2) Remove front side molding and front molding upper.



- 3) Remove glass:
 - (1) Put protective tape on body to prevent damage.
 - (2) Using drill or putty knife, make through-hole (one place) in adhesive agent.

- (3) Pass piano wire through the hole from inside the compartment, and connect both ends of wire securely to wooden blocks.



- (4) Cut adhesive layer with the wire by pulling it back and forth.

CAUTION:

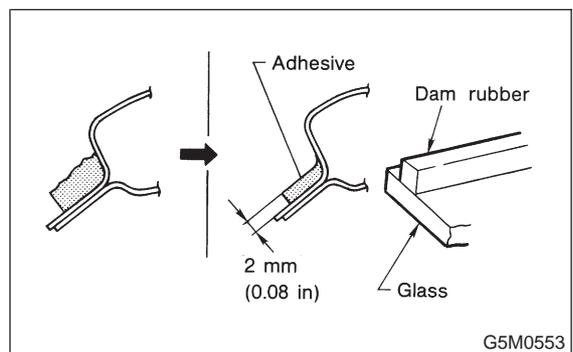
When making through-hole into adhesive layer and cutting the adhesive, be careful not to damage interior and exterior parts.

B: INSTALLATION

- 1) After cutting layer of adhesive, remove dam rubber remaining on body.
- 2) Finishing adhesion surface on body side: Using a cutter knife etc., cut layer of adhesive sticking firmly to body, and finish it to a smooth surface of about 2 mm (0.08 in) in thickness.

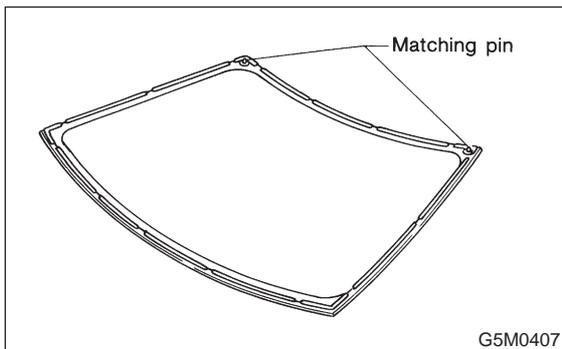
CAUTION:

Take extra care not to cause damage to body paint.



- 3) Cleaning body surface:
 - (1) Thoroughly remove chips, dirt and dust from body surface.
 - (2) Clean body wall surface and upper surface of layer of adhesive with a solvent such as alcohol or white gasoline.
- 4) Positioning glass:
 - (1) Mount glass on body.
 - (2) Adjust position of glass so that gap between body and glass is uniform on all sides.

- (3) Put matching pin on body and glass in several places.

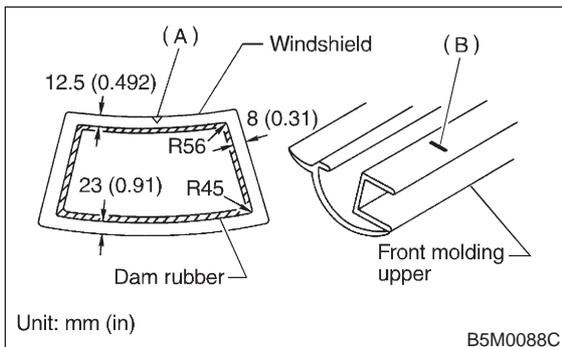


5) Cleaning glass:

- (1) Dismount glass from body
(2) Clean surface of glass to be adhered with alcohol or white gasoline.

6) Stick dam rubber and install front molding upper:

While aligning ceramic print notch (A) on windshield upper portion with mark (B) in center of upper front molding, install upper front molding on windshield.



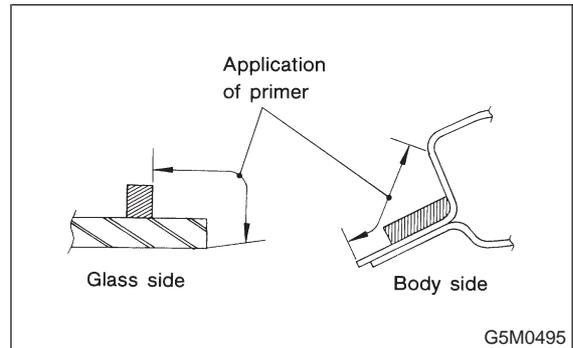
7) Application of primer:

- (1) Using a sponge, apply primer to part of glass to be adhered.

- (2) Apply primer to part of body to be adhered.

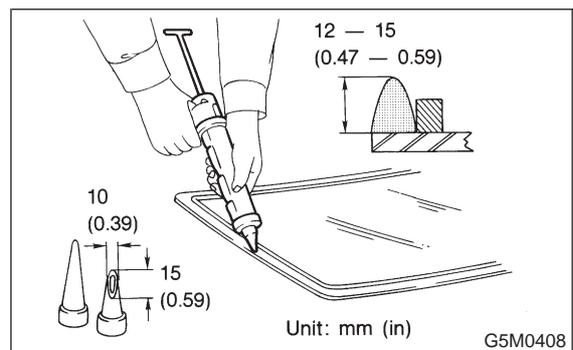
CAUTION:

- Primer is hard to wipe off of body paint, instrument panel, inner trim, etc. So put masking around these areas for protection.
- After application, let 1st primer dry spontaneously for about 10 minutes.
- Do not touch primer-coated surface under any circumstances.



8) Application of adhesive:

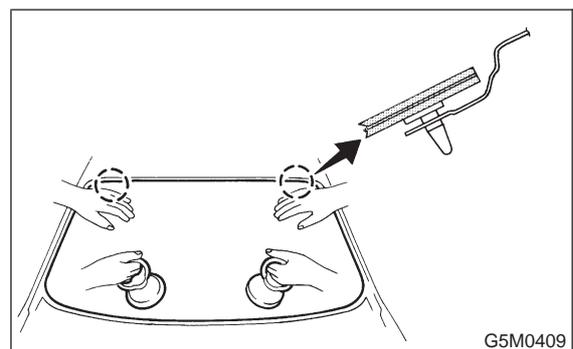
- (1) Cut nozzle tip of cartridge as shown in figure.



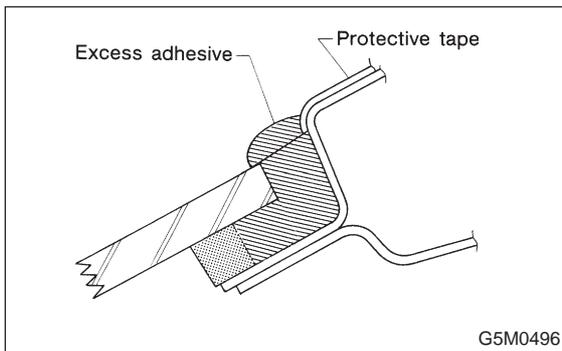
- (2) Open cartridge and put it into a gun with nozzle attached.
(3) Apply adhesive uniformly to all sides of adhesion surface while operating gun along glass end face.

9) Installation of glass:

- (1) Hold glass with rubber suction cups.
(2) Mount glass on body with matching pin aligned.



- (3) Stick them fast by pressing all sides lightly.
10) Installation of molding:
(1) Remove adhesive overflowing from outside of glass until it becomes level with outer height of glass. Then, add adhesive to portions that need it, and clean with alcohol or white gasoline.



- (2) Install front side molding.

CAUTION:

Do not open and close door after moldings have been installed. When opening and closing door for unavoidable reason, lower door glass and gently move door.

- 11) Water leakage test:
Test for water leakage about one hour after installation.

CAUTION:

- Move vehicle very gently.
- Do not squirt strong hose stream on vehicle.

- 12) Spontaneous drying:
After completing all operations, leave vehicle alone for 24 hours.

CAUTION:

When delivering vehicle to user, tell him that vehicle should not be subjected to heavy shocks for at least three days.

- 13) Install cowl panel and wiper arm.

6. Rear Window Glass

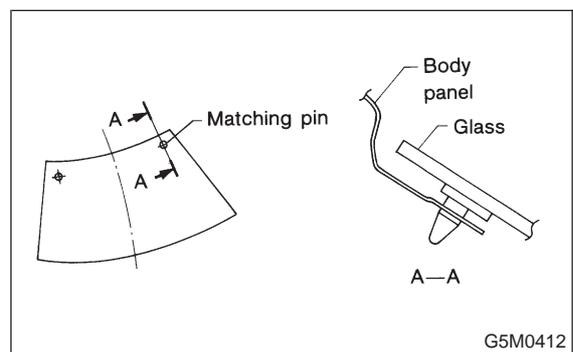
A: REMOVAL

1. SEDAN

- 1) Disconnect connector from rear defogger terminal.
- 2) Remove glass in the same manner as in windshield.

NOTE:

A matching pin is cemented to the corners of glass on compartment side. Use a piano wire when cutting each pin.



2. WAGON

NOTE:

It is impossible to remove the molding from the glass.
If molding is broken, replace rear glass.

- 1) Remove rear wiper and rear gate trim.
- 2) Disconnect connector from rear defogger terminal.
- 3) Remove glass in the same manner as in windshield.

CAUTION:

In case of using a piano wire, when re-installing the old rear window glass, be careful not to damage molding.

NOTE:

A matching pin is cemented to corners of glass on compartment side. Use a piano wire when cutting each pin.

