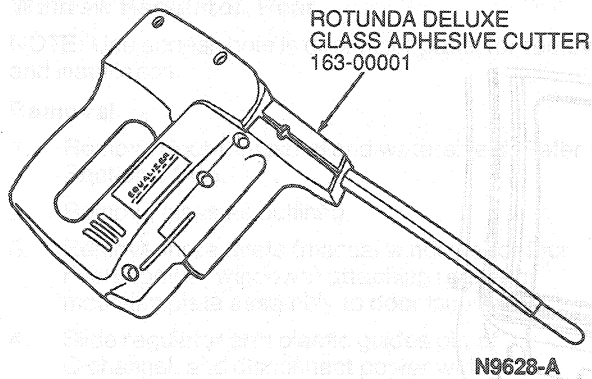
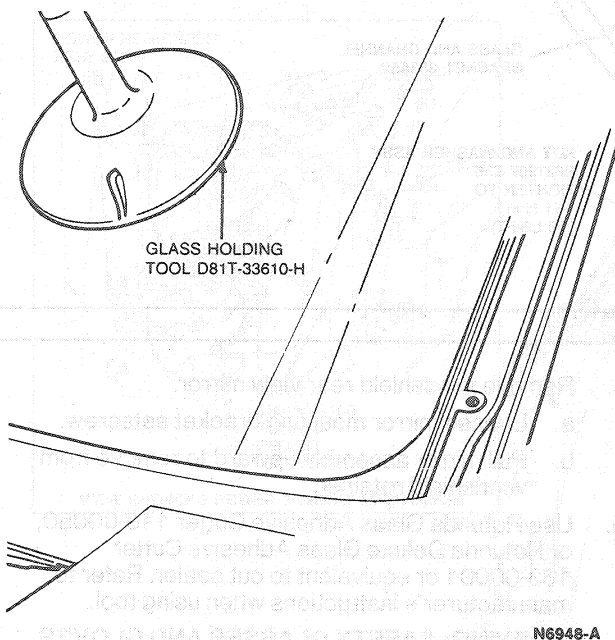


REMOVAL AND INSTALLATION (Continued)



6. Remove windshield / rear window and moulding assemblies from the vehicle using Glass Holding Tool D81T-33610-H or equivalent.



7. Remove any excess urethane, using care not to smear the urethane on component parts, crash pad and vinyl roof.
- NOTE: If the urethane has cured all the way through, it will not be necessary to remove the urethane which remains on the sheet metal.
8. Check flange sealing area for damaged sheet metal or foreign objects which may have caused, or may cause, glass breakage. Service metal, if necessary.

Installation

NOTE: Trim urethane left on the flange with a utility knife or razor blade until surface is smooth and free of cuts. If the urethane has cured it is not necessary to remove all the urethane which remains on the flange. However, at no point should the existing urethane material exceed 1.2mm (0.05 inch).

1. Using a clean brush, apply urethane metal primer WSB-M2G234-A or equivalent to any sheet metal that has been exposed along windshield / rear window opening flange. Apply Vinyl Foam Tape C6AZ-19627-A (ESB-M3G77-A) or equivalent along cowl and 100mm (4 inches) up the lower A-pillars.

NOTE: A minimum of 30 minutes is required for primer surface to dry.

2. Place windshield / rear window on a low stable work surface, inside up.
3. Clean windshield / rear window and install rear view mirror mounting bracket. Refer to Section 01-09.
- NOTE: Wipe off immediately after application because it flash dries.
4. Using a lint-free cloth, wipe inside surface of glass around periphery in from edge with Urethane Glass Wipe WSB-M5B280-C as follows:
- Windshield—21.0mm (0.80 inch) along top and sides, 70.0mm (2.75 inch) along bottom.
 - Rear Window—21.0mm (0.80 inch) along top and sides, 30.0mm (1.20 inch) along bottom.

5. Install windshield / rear window moulding.
6. Properly align windshield / rear window glass to body.
- Place windshield / rear window glass on to the lower glass stops. Center it top and bottom, side-to-side. Adjust the lower glass stops if necessary.
 - Using masking tape or crayon, make alignment marks at points on four sides of both glass and window opening.
7. Remove windshield / rear window glass and moulding assemblies from vehicle and place it back on work table.
8. Thoroughly shake and stir urethane glass primer WSB-M2G314-C or equivalent to ensure uniform pigment mixing.
9. Using a clean brush, apply primer to inside glass edge 21mm (0.8 inch) wide along top and sides and 70mm (2.75 inch) wide along bottom windshield, and 30mm (1.20 inch) wide along bottom rear window.

NOTE: Apply a double bead of urethane along the cowl top and the bottom of windshield opening.

10. Apply an even bead of urethane WSB-M2G316-C around entire sheet metal flange using an air pressure cartridge gun. (Air line pressure should be around 40 psi.) The bead should be triangular in shape, 14mm (0.55 inch) high, and 8.0mm (0.33 inch) at base.

CAUTION: Allow all glass parts installed with urethane 24 hours to cure.