

**REMOVAL AND INSTALLATION (Continued)**

- Remove urethane from flange as close to sheet metal as possible, using a razor blade or utility knife.

**Installation**

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

- Using a clean brush, apply Urethane Metal (Body) Primer WSB-M2G234-C or equivalent to any sheet metal that has been exposed along the window opening flange.
- Using a lint-free cloth, wipe the 10mm (3/8 inch) wide glass track on inside surface of window module with Urethane Glass Cleaner WSB-M5B280-C or equivalent.

**NOTE:** Wipe off cleaner immediately after application, before it flash dries.

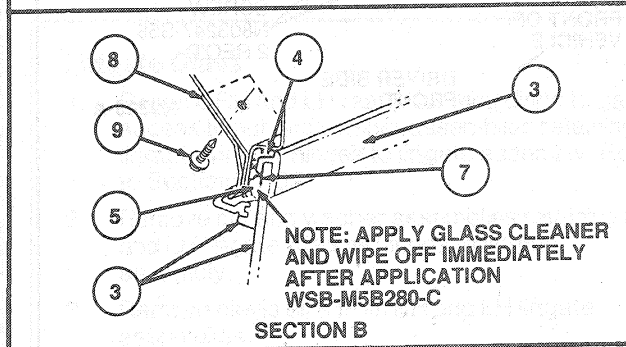
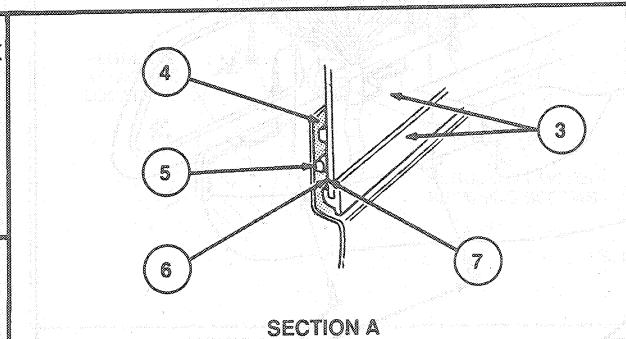
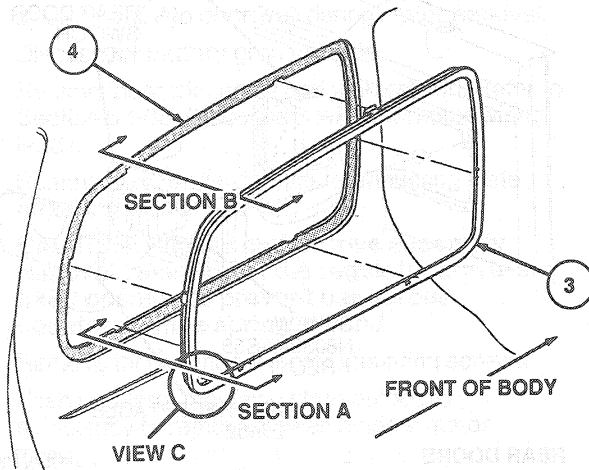
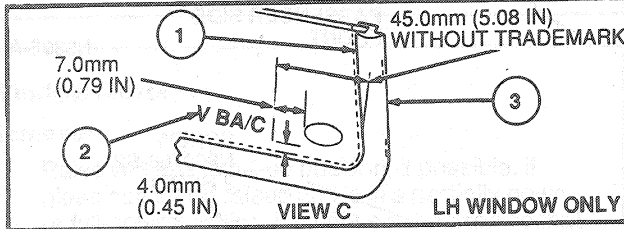
- Using a clean brush, apply Urethane Glass Primer WSB-M2G314-B or equivalent to the 10mm (3/8 inch) wide glass track on inside surface of the window module. Allow five minutes dry time for the primer.

**NOTE:** Thoroughly shake and stir Urethane Glass Primer WSB-M2G314-B to ensure uniform pigment mixing.

- Apply a bead of high viscosity Urethane Adhesive WSB-M2G316-B in the track of the pinch weld. The bead of adhesive should be triangular with a 8mm (0.32 inch) base and a 14mm (0.55 inch) height (bead size large enough for proper sealing with no objectionable expulsion).

**CAUTION:** Allow all glass parts installed with urethane ample time to cure.

- Position glass and moulding to flange and press retaining tabs into flange to engage.
- Install spring retainers.
- Install interior quarter trim panel. Refer to Section 01-05.



N6571-D

Item	Part Number	Description
1	—	Ceramic Dot Pattern
2	303K04	Decal
3	29700	Window Assy
4	WSB-M2G234-C	Urethane Body Primer (Black)

(Continued)

Item	Part Number	Description
5	WSB-M2G316-B	Urethane High Viscosity
6	WSB-M5B280-C	Glass Cleaner Urethane
7	WSB-M2G314-B	Glass Primer Urethane (Black)
8	30140	Retainer
9	82413-S55X	Screw