

Glass – Fixed Rear Quarter Window (Wagon) – Remove And Install (42 514 0)

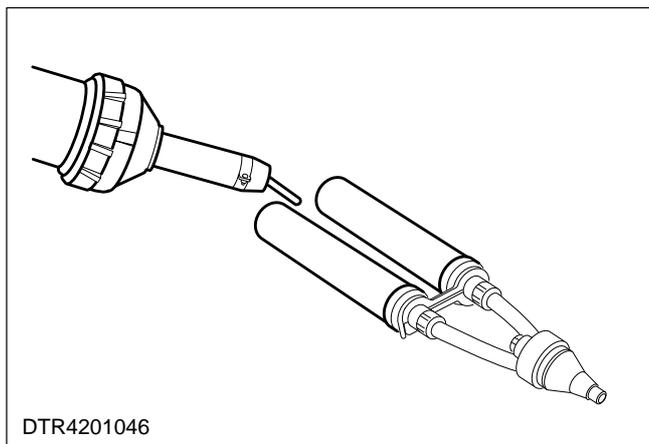
Proprietary Tools

Fein Cutter Blade No. 6 39 03 143 01 3
Fein Cutter Blade No. 6 39 03 113 02 0

Equipment

Fein Oscillating Cutter	FDEP 2583391
Hot Air Gun	FDEP 1561950
Mixing/Applicator Gun	FDEP 2650730

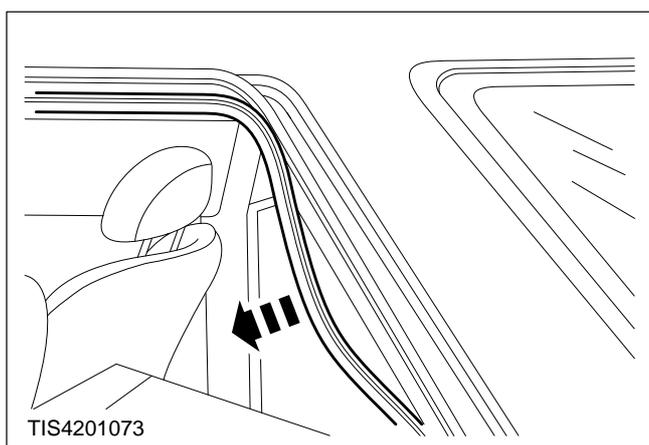
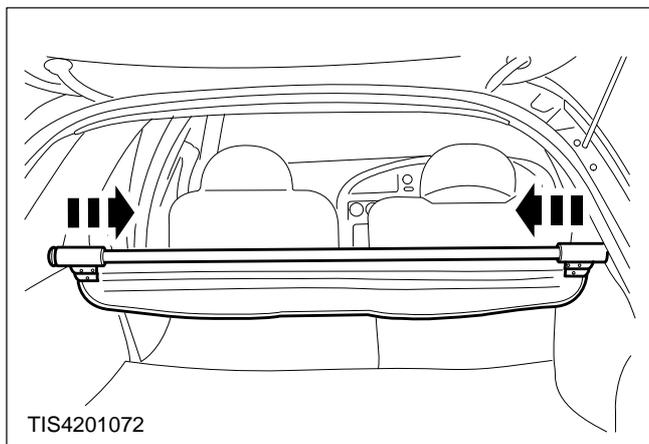
⚠ WARNING: Always wear gloves and eye protection when working with the glass cutting tool as the cutting operation may produce splinters. Ear defenders should be worn when using the Fein cutter.

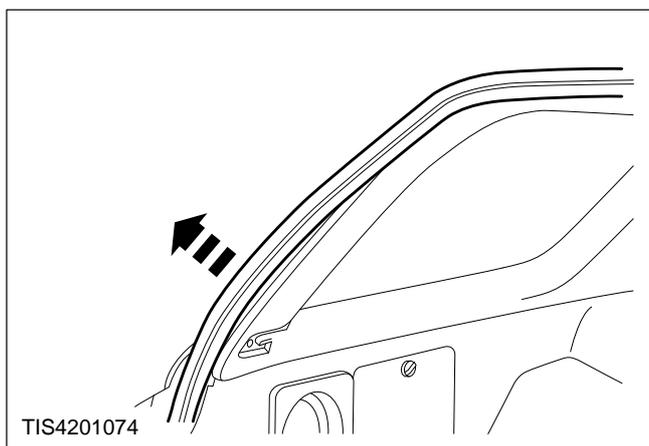


Remove

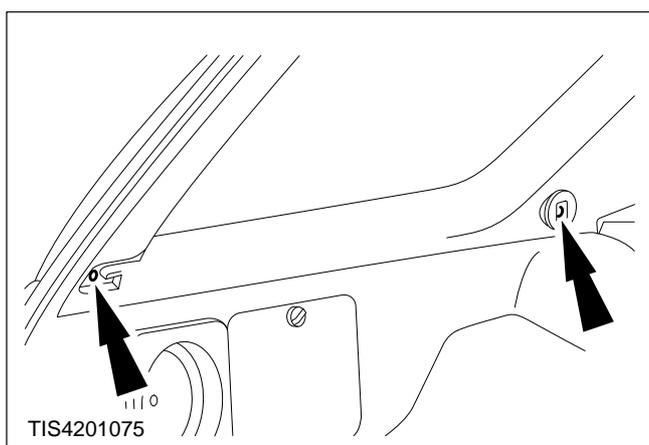
NOTE: Should the ambient temperature fall below 10°C, heat the cartridge for approximately 15 minutes by placing them on a warm radiator, or by using a heat gun set at approximately 25°C.

1. Heat the adhesive if required.
2. Remove the load space cover.
3. Remove the rear seat side bolster (refer to Operation Number 40 135 0).
4. Locally detach the rear door weatherstrip.

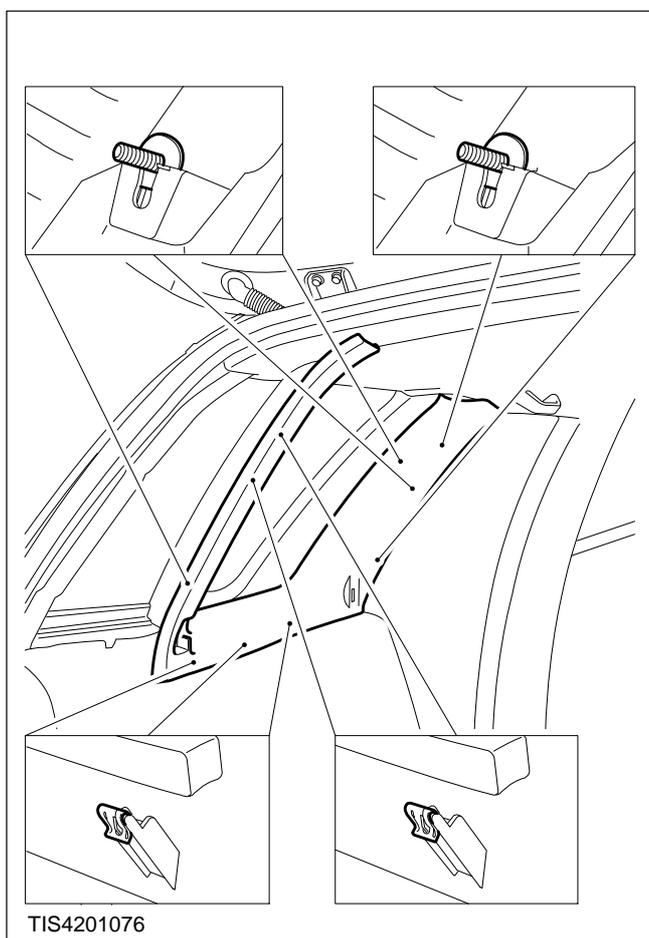




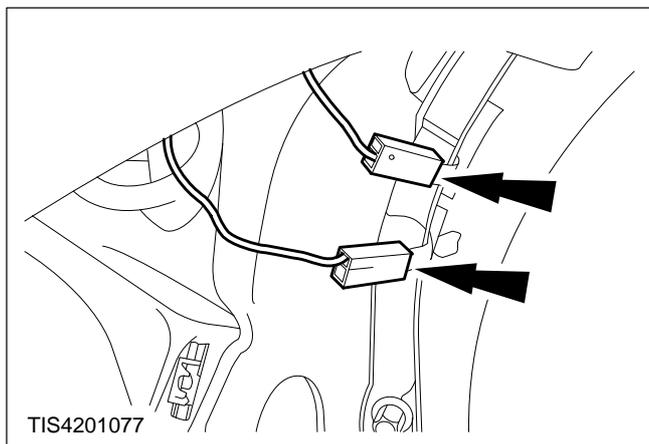
5. **Locally detach the tailgate opening weatherstrip.**



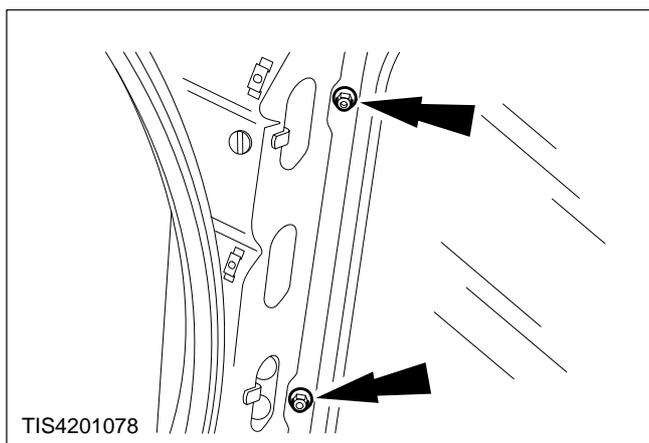
6. **Remove the load space trim panel screws.**



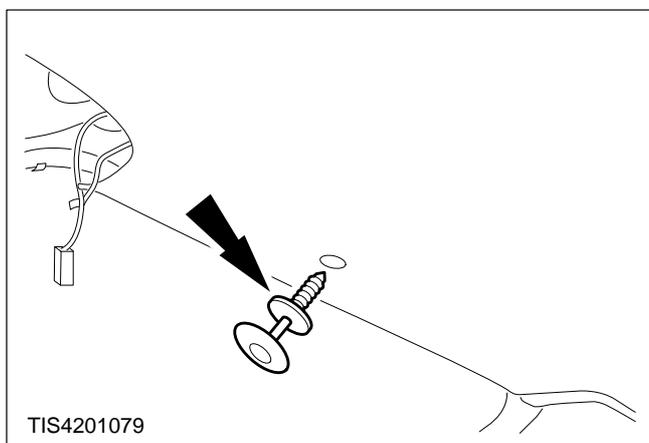
7. **Detach the load space trim panel.**



8. Disconnect the glass electrical connectors.

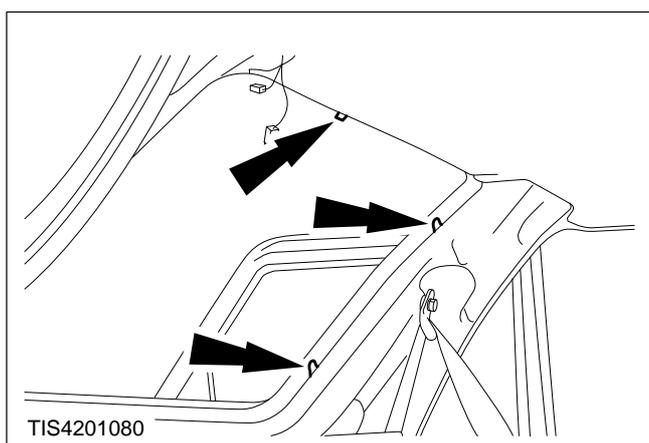


9. Remove the two window fixing nuts.

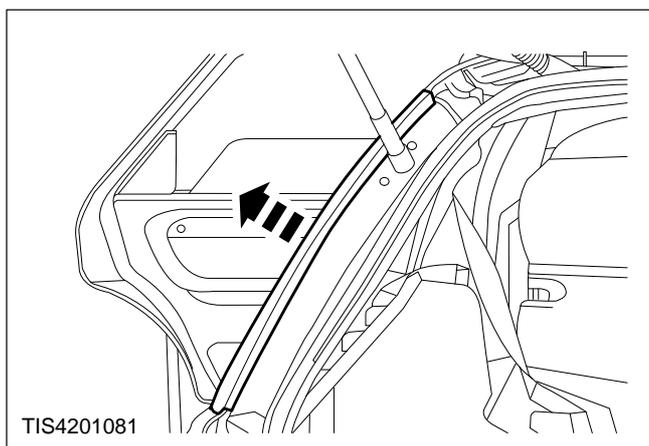


⚠ CAUTION: Do not fold the headlining back as this will crease the headlining.

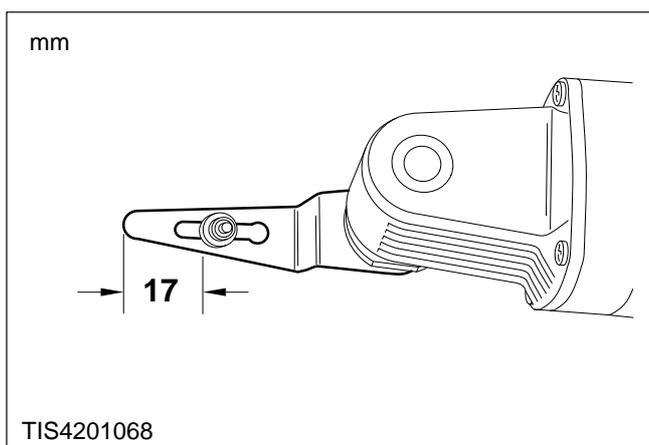
10. Locally detach the headlining.



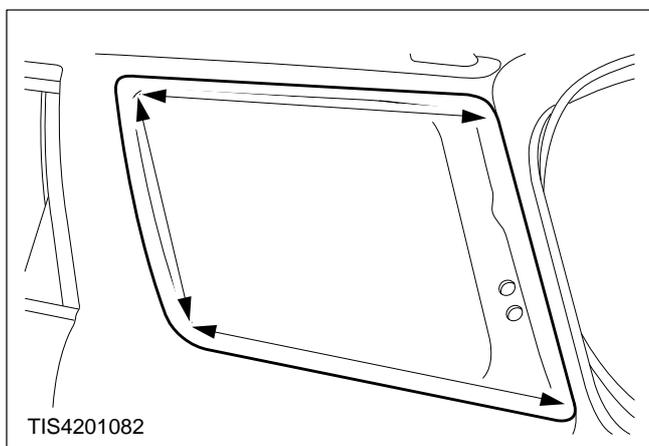
11. Fold back the glass locating fixings.



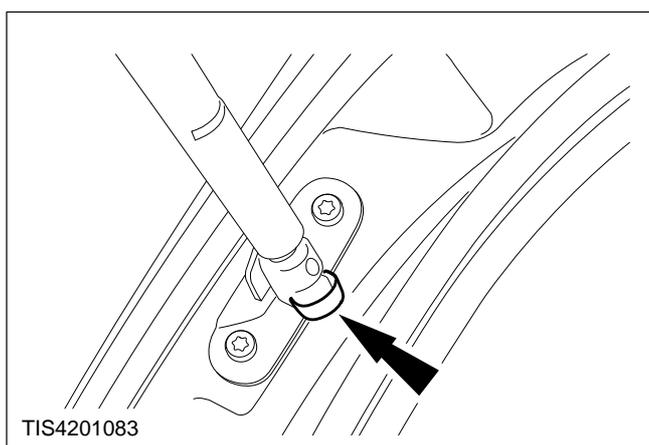
12. Remove the tailgate opening trim.



13. Fit blade number 6 39 03 143 01 3 set to 17 mm to cut out the glass.

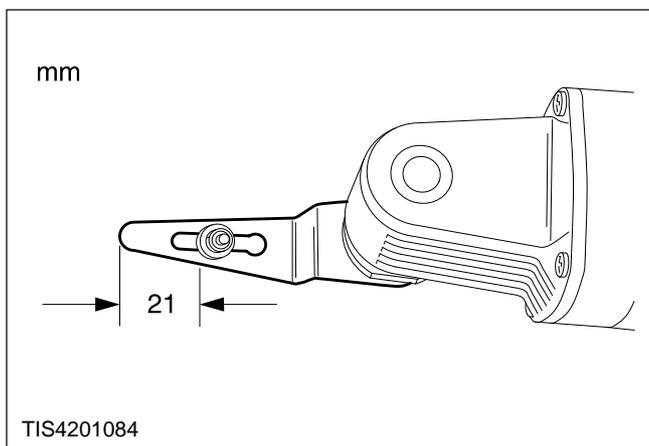


14. Cut out the glass from inside the vehicle.

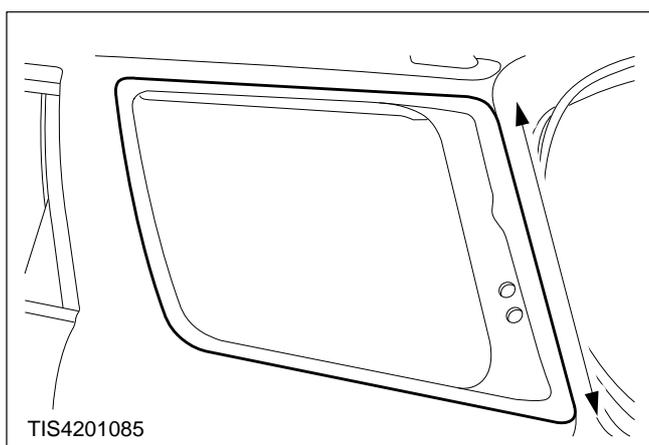


⚠ WARNING: It is vital that the tailgate is securely supported in the fully open position before attempting to disconnect either of the support struts.

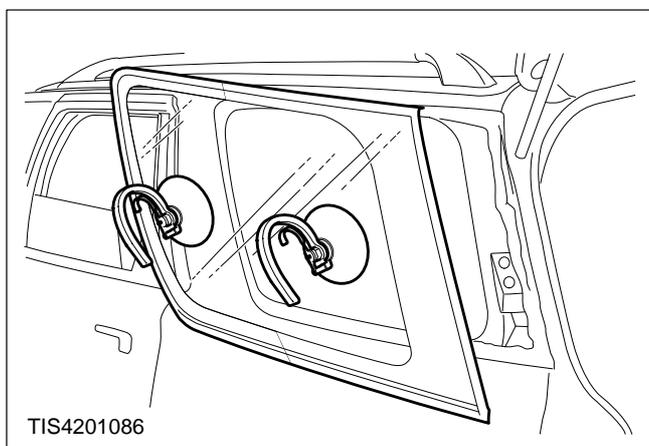
15. Detach the tailgate support strut.



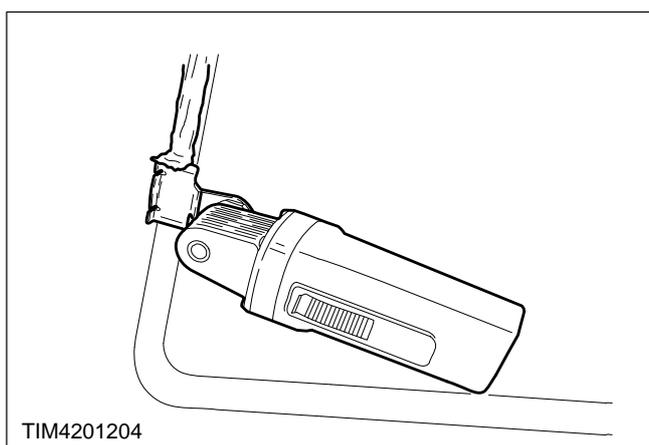
16. Fit blade number 6 39 03 143 01 3 set to 21 mm to cut out the glass.



17. Cut out the glass from outside the vehicle.



18. Remove the glass.



Install

⚠ CAUTION: Avoid touching the trimmed surface as this will inhibit the new adhesive from bonding.

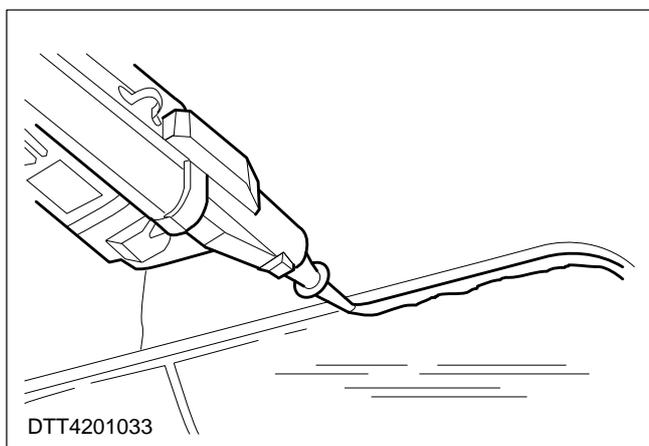
19. Remove the excess PU adhesive from the opening. Leave approximately 1 mm of trimmed PU adhered to the body work.

20. If the original glass is to be refitted, remove the excess PU adhesive from the glass as described in the previous step.

⚠ CAUTION: To ensure that the PU adhesive cures, it is essential that the bonding surfaces are free of moisture.

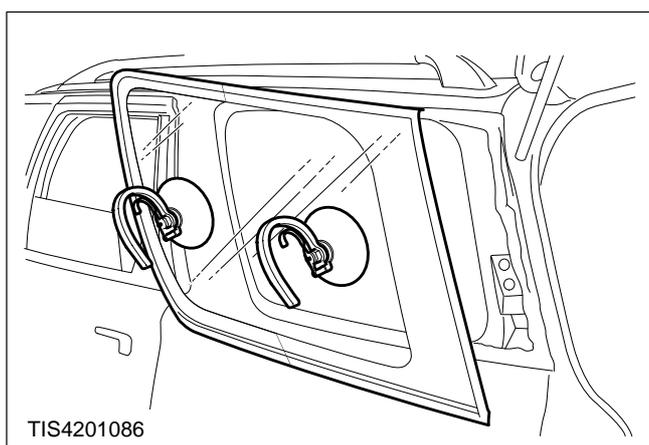
21. Using a heat gun, apply warm air (25 °C) to the window opening and glass bond line to remove all traces of moisture.

22. Prepare the rear quarter window and window opening in accordance with the instructions supplied with the adhesive kit.



NOTE: Discard the first 100 mm of PU adhesive as this may have a reduced working time. To avoid water leaks, any breakage in the continuous bead should be overlapped by 20 mm.

23. Apply the PU adhesive in a continuous bead between 8 and 10 mm in height to the glass along the bond line.



24. Fit the window with the aid of another technician, using suction pads to carefully lift the glass and align it in position over the window opening.

- Firmly and evenly press into position.

25. Should the ambient temperature fall below 10 °C use a heat gun at a distance of approximately 50 mm from the opening and apply warm air (25 °C) continuously for 15 minutes (inside the vehicle).

26. Refit the remaining components in reverse order.