

Glass – Rear Window – Remove and Install (42 614 0)

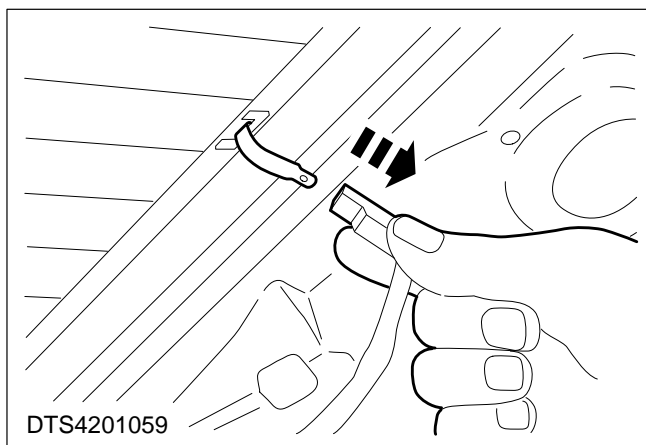
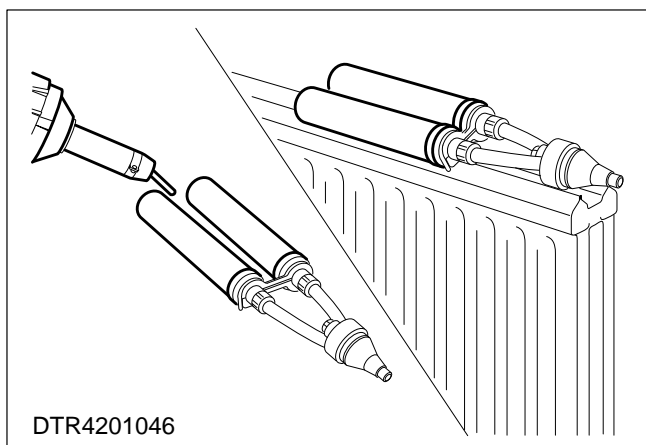
Proprietary Tools

Fein cutter blade No. 6 39 03 123 01 5
Fein cutter blade No. 6 39 03 143 01 3
Fein cutter blade No. 6 39 03 113 02 2

Equipment

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

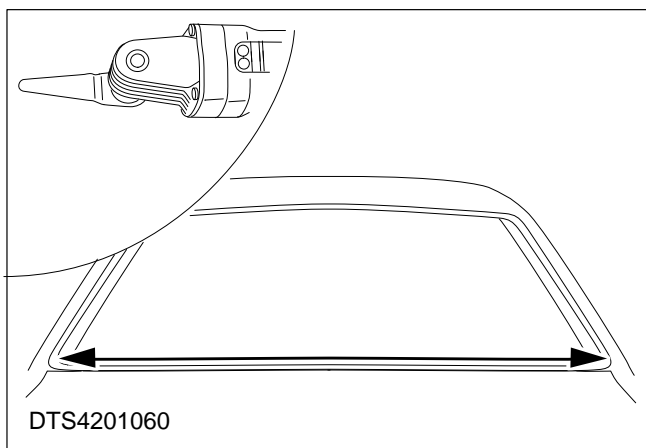
⚠ WARNING: Always wear gloves and eye protection when working with the glass cutting tool as the cutting operation may produce splinters. Ear defenders should be worn when using the Fein cutter.



Remove

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

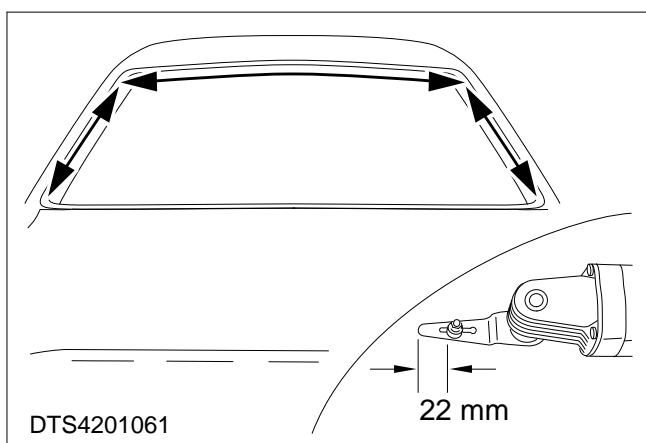
1. Heat the adhesive if required.
2. Disconnect the two heated screen connectors.
3. Remove the rear parcel shelf loudspeakers (refer to Operation Number 38 279 0).
4. Remove the rear parcel shelf (refer to Operation Number 43 688 0).
5. Remove the C-pillar trims (refer to Operation Number 43 618 0).
6. Remove the rear lamp assembly (refer to Operation Number 32 305 0).
7. Locally remove the headlining (refer to Operation Number 43 612 0).



⚠ WARNING: Always wear gloves and eye protection when working with the glass cutting tool as splinters may occur from the edge of the window during cutting. Ear defenders should be worn when using the Fein cutter.

8. From inside the vehicle, cut along the lower section of the rear window.

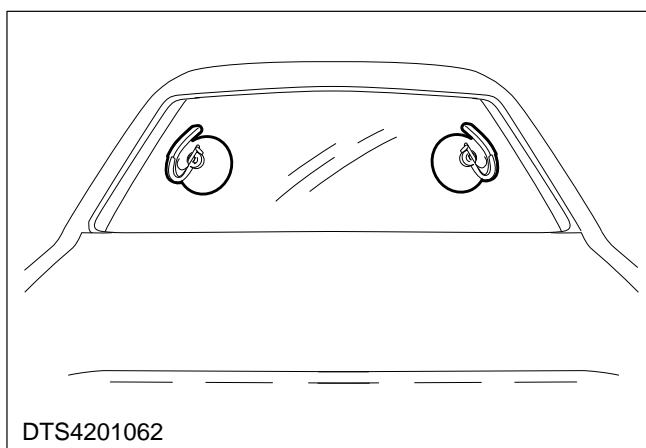
Fit blade number 63903123015 to cut the lower section of the rear window.



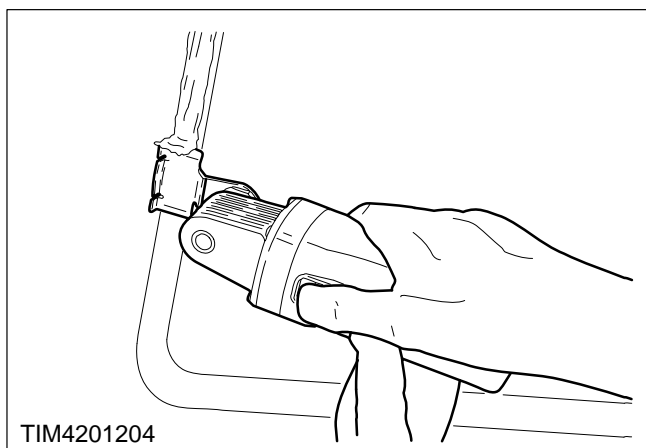
NOTE: If the original glass is to be refitted, care must be taken to keep the cutter low when cutting in the area of the heated rear window connectors.

9. From inside the vehicle cut along the remaining edges of the rear window.

Fit blade number 63903143013 set to 22 mm to cut the remaining sections of the rear window.



10. With the aid of another technician, using suction pads, remove the rear window.



Install

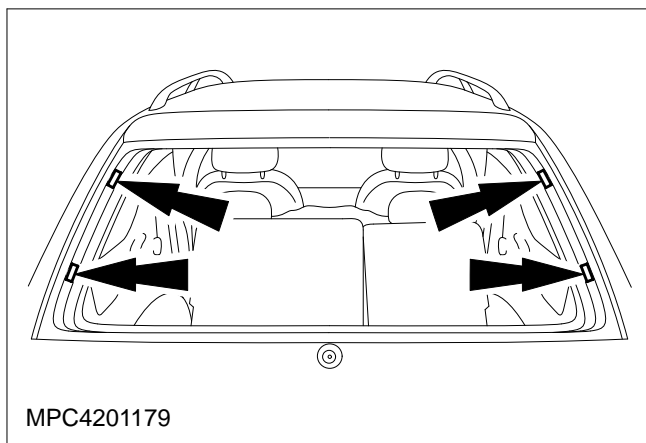
⚠ CAUTION: Avoid touching the trimmed surface as this will inhibit the new adhesive from bonding.

- 11. Remove the excess PU adhesive from the aperture using the Fein cutter fitted with blade number 6 39 03 113 02 2.**

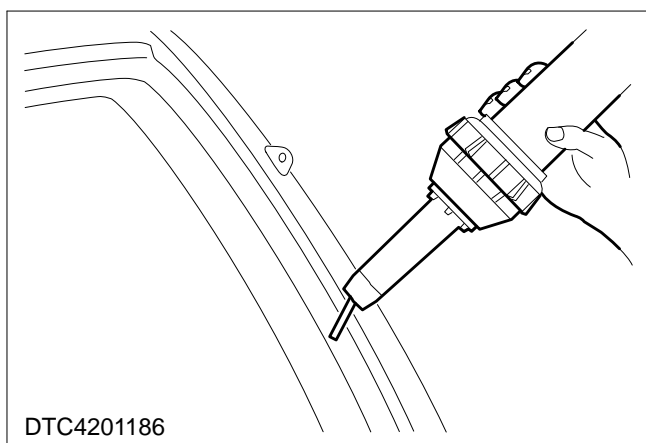
Carefully trim the remaining PU adhesive from the window aperture to leave approximately 1 mm of trimmed PU adhered to the bodywork.

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

- 13. Fit the window weatherstrip.**



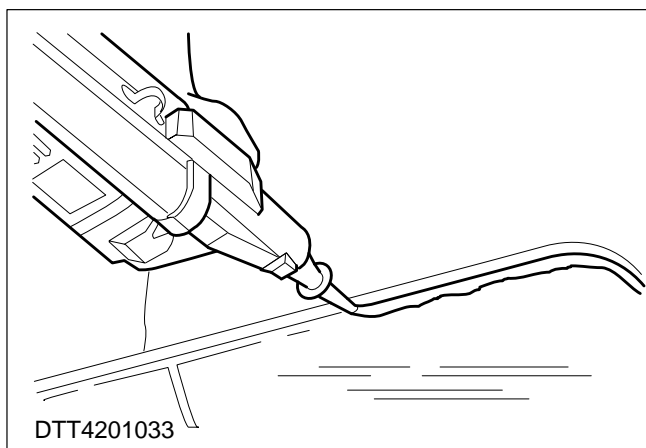
- 14. Fit four foam spacers to the rear window aperture.**



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

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

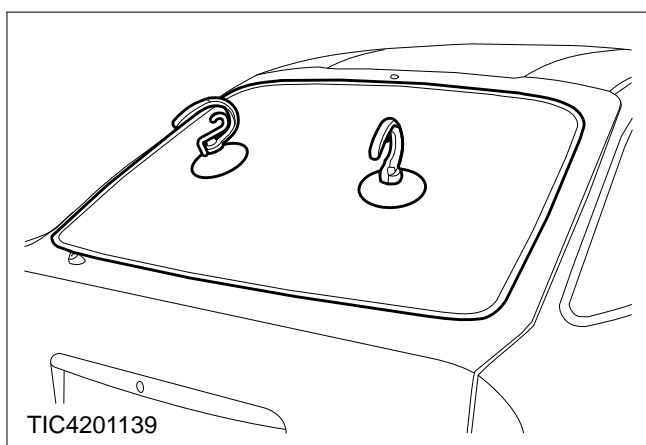
- 16. Prepare the glass, window aperture and trimmed PU adhesive in accordance with the instructions supplied with the adhesive kit.**



NOTE: Discard the first 10 cm of PU adhesive as this may have a reduced working time.

NOTE: To avoid water leaks, any breakage in the continuous bead should be overlapped by 20 mm.

17. Apply the PU adhesive in a continuous bead of between 8 and 10 mm height to the rear window flange along the bond line.



18. Fit the rear window glass.

- With the aid of another technician, use suction pads to carefully lift the glass and align it in position over the aperture flange.
- Firmly and evenly press the glass into position.

19. Refit the remaining components in reverse order.

20. Check for leaks and correct as necessary.