


## Windscreen – Remove and Install (42 114 0)

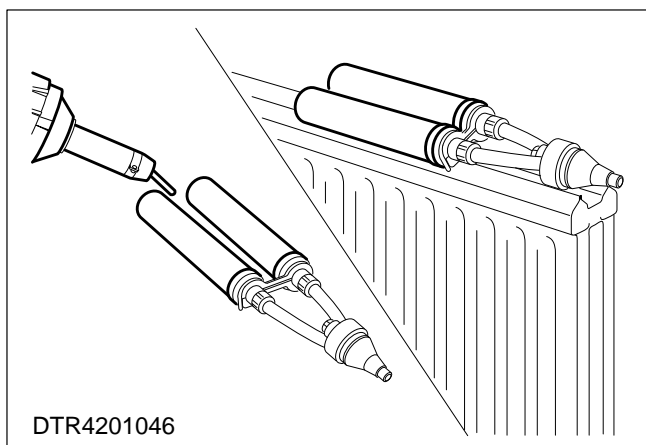
### Proprietary Tools

Fein cutter blade No. 6 39 03 079 01 2
Fein cutter blade No. 6 39 03 076 01 1
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

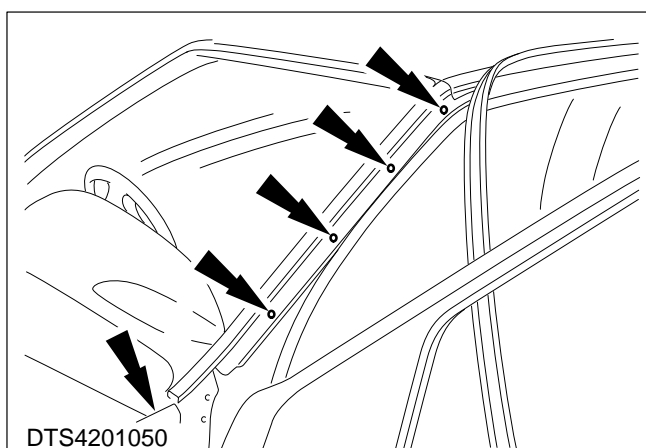
 **WARNING:** Always wear gloves and eye protection when working with the glass cutting tool as the cutting operation may produce splinters. Ear defenders should be worn when using the Fein cutter.



### Remove

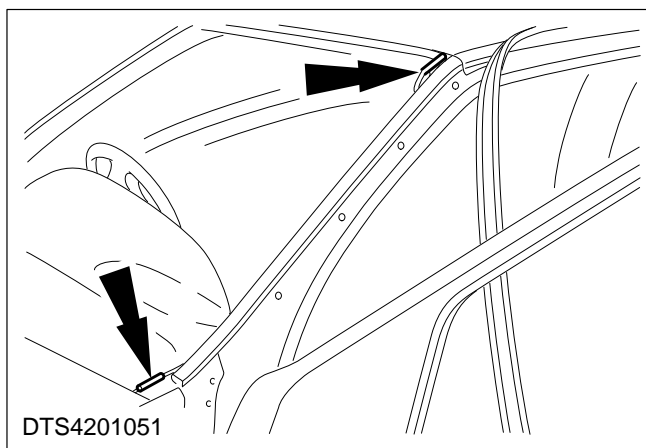
**NOTE:** Should the ambient temperature fall below 10°C, heat the cartridges for approximately 15 minutes by placing them on a warm radiator, or by using a heat gun set at approximately 25°C.

1. Heat the adhesive if required.
2. Remove the cowl top outer (refer to Operation Number 43 230 0).
3. Locally remove the A-pillar weatherstrip (refer to Operation Number 41 375 0).

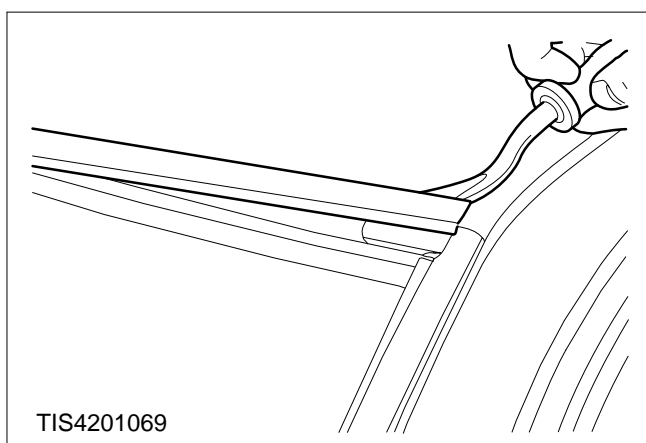


4. Remove the A-pillar glass trims.

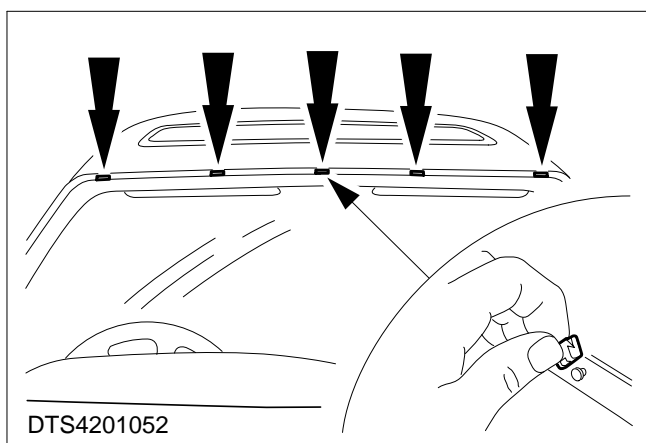
Drill out five rivets on both sides and remove the trims.



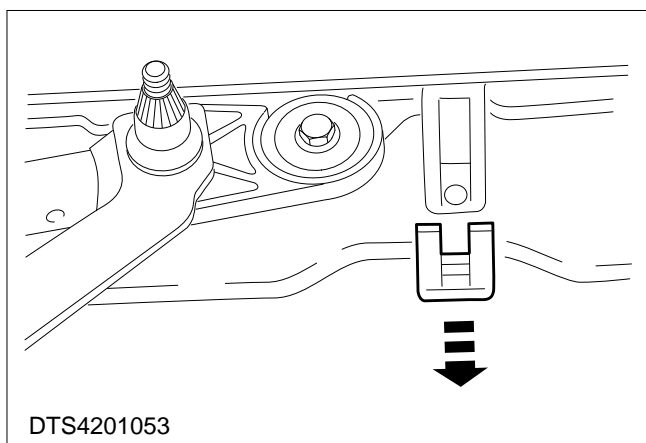
5. Disconnect the four heated windscreen connectors (two each side).



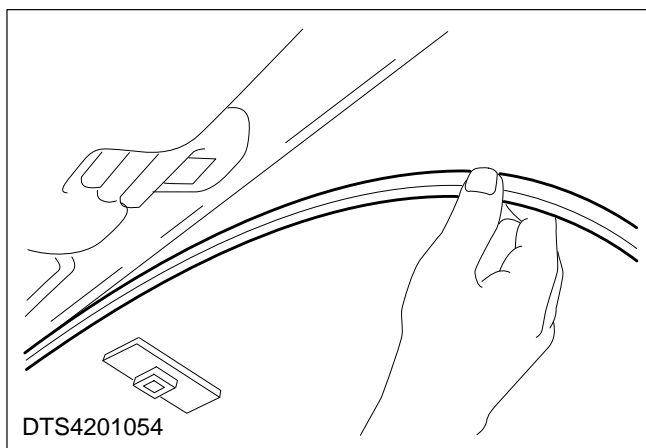
6. Remove the top windscreen weatherstrip.



7. Remove the five weatherstrip retaining clips.

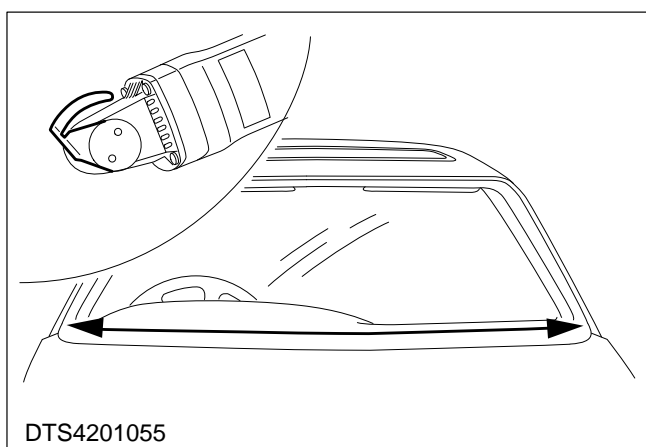


8. Remove the windscreen support block.
9. Remove the A-pillar trims (refer to Operation Number 43 616 0).



**10. Remove the headlining rubber.**

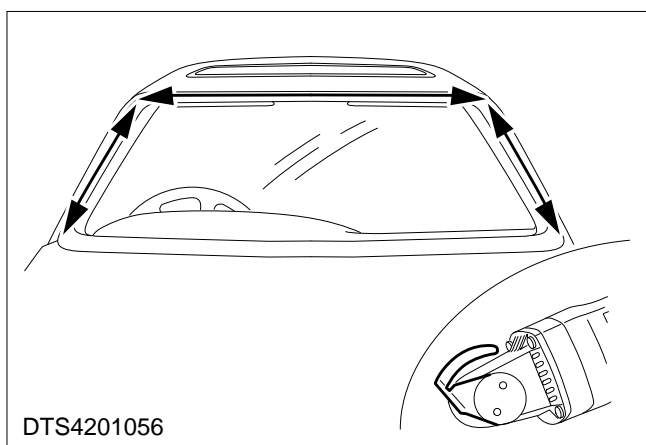
**11. Open the hood.**



**NOTE:** If the same screen is to be refitted, care must be taken to keep the cutter low when cutting in the area of the heated windscreen connectors.

**12. Cut along the lower section of the windscreen.**

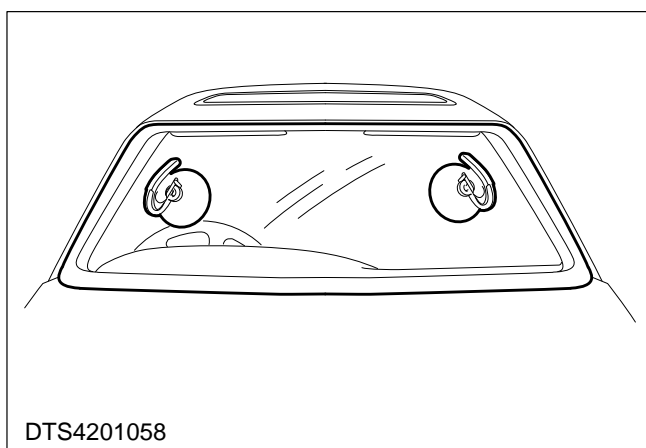
Fit blade number 63903079012 to cut the lower section of the windscreen.



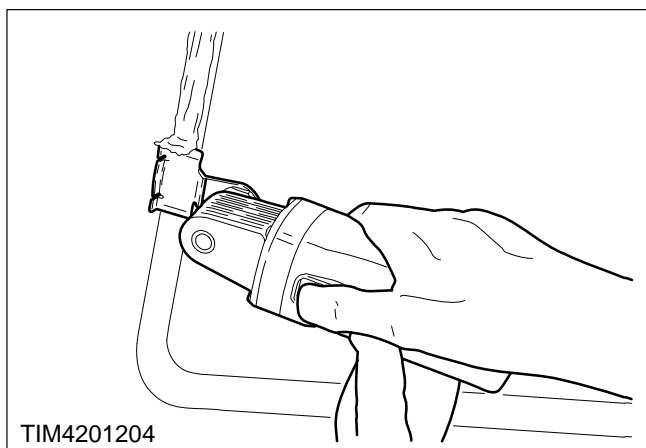
**NOTE:** If the same screen is to be refitted, care must be taken to keep the cutter low when cutting in the area of the heated windscreen connectors.

**13. Cut out the remaining windscreen edges.**

Fit blade number 63903076016 to cut the remaining sections of the windscreen.



**14. With the aid of another technician, using suction pads, remove the windscreen.**



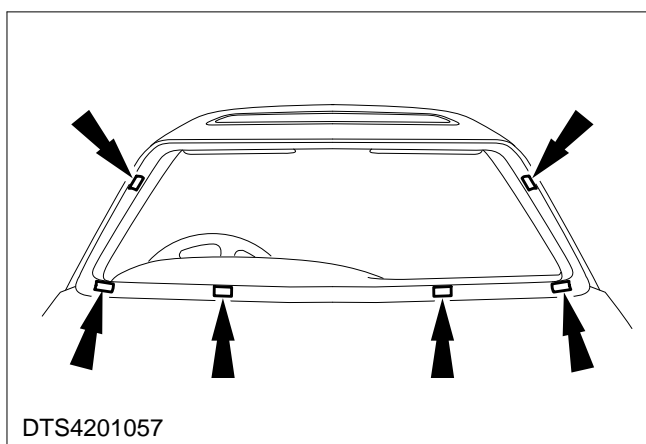
## Install

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

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

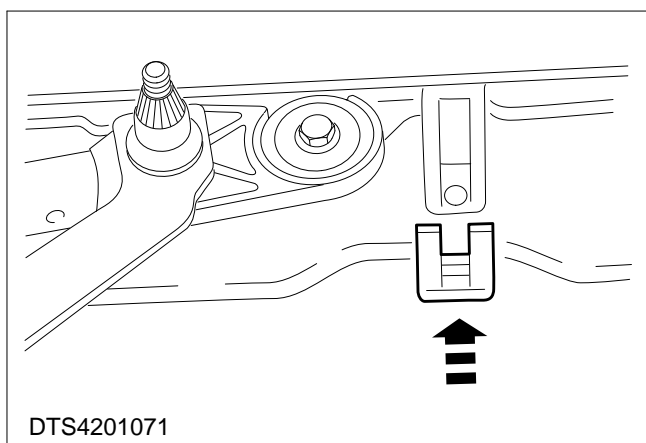
Carefully trim the remaining PU adhesive from the window aperture to leave approximately 1 mm of trimmed PU adhered to the bodywork.

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

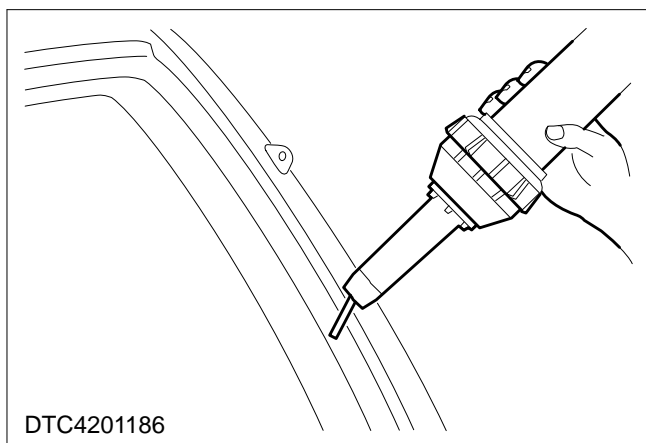


- 17. Fit six spacer blocks.**

- 18. Refit the headlining rubber.**



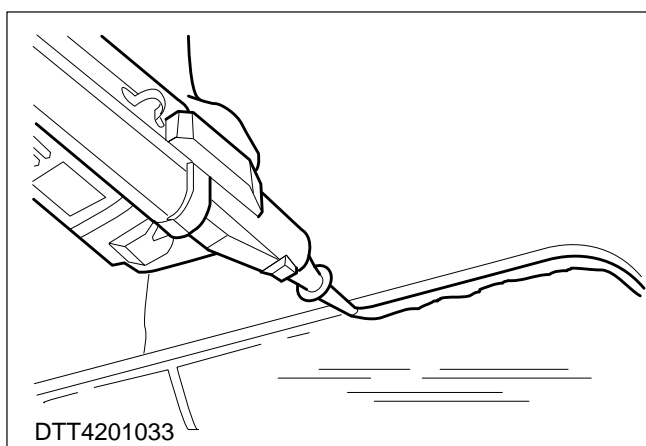
- 19. Replace the windscreen support block.**



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

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

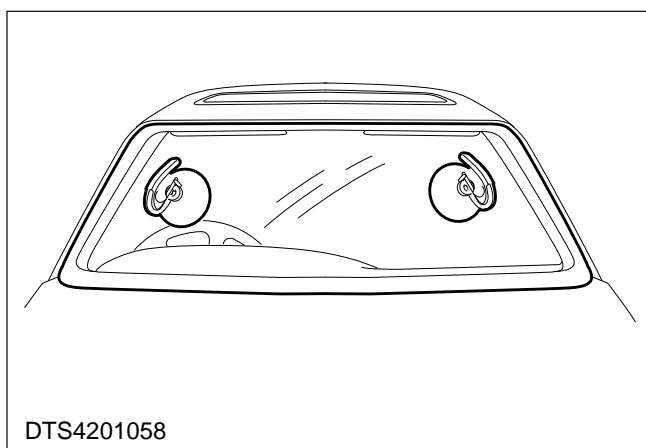
**21. Prepare the glass, window aperture and trimmed PU adhesive in accordance with the instructions supplied with the adhesive kit.**



**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.

**22. Apply the PU adhesive in a continuous bead of between 8 and 10 mm height to the windscreen flange along the bond line.**



**23. Fit the windscreen.**

- 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.

**24. Refit the remaining components in reverse order.**

**25. Check for leaks and correct as necessary.**