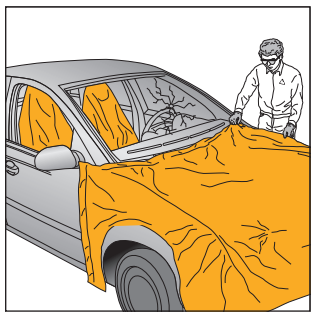
BLACK PRIMERLESS
AUTO GLASS REPLACEMENT INSTALLATION GUIDELINE

1



- Wear personal protective equipment
- Cover parts to be protected
- Use seat covers

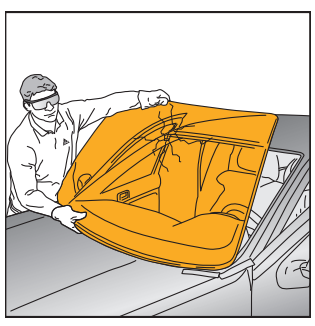
2

- Carefully remove all trims and accessories
- Carefully remove ADAS related sensors and cameras

3

- Cut out damaged windshield using Sika® SmartCut, electrical knife, cutting wire, cold knife etc.
- Remove dirt with a vacuum cleaner or brush

4



- Remove the damaged windshield

5

- Remove debris with a vacuum cleaner or brush
- Clean the entire aperture with Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains

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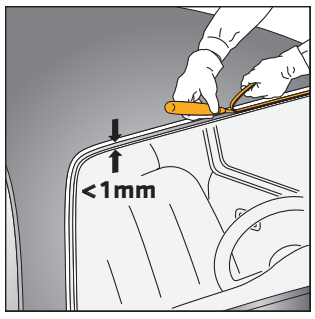

- Trim back the remaining PUR bead and try to cause as little damage as possible
- The remaining PUR must be under 1 mm before it is safe to apply fresh adhesive

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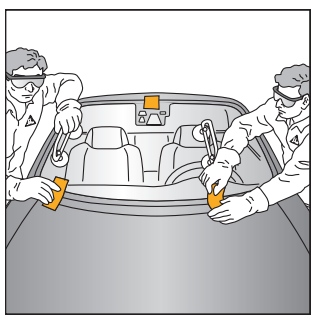


- Dry fit the windshield
- To ensure a quick and precise installation of the windshield once the adhesive is applied, add fitting marks

8

- Clean the windshield with Sika® Cleaner G+P and check for contamination
- If contaminated, scrub the bonding surface with Sika® Cleaner PCA
- Wipe the window dry with a paper towel

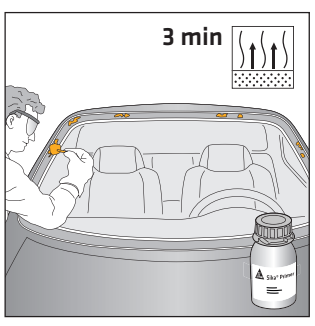
9

- Wet a lint free tissue with Sika® Aktivator PRO
- Wipe the bonding surface of the glass
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes

10

- Wet a lint free tissue with Sika® Aktivator PRO
- Wipe the fresh cut bead of urethane
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes

11



- Cover any minor damage to paint work using Sika® Primer-207 or Sika® Primer-507
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes
- In case of larger areas, contact a paint shop or refer to the car manufacturer's specification

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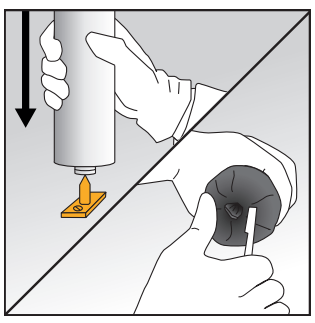

- Cartridge: open by piercing the membrane
- Unipack: open by simply slicing the end of the unipack approx. 1 cm between the clip and the shoulder. Avoid the foil weld
- PowerCure: charge the Dispenser, no need to open manually

13

- Prepare a "V" noched nozzle that has the same height as the pinchweld mounting surface and the roof of the car
- Apply a triangular bead of adhesive either to the glass or the aperture.
- It is important that the adhesive matches both the primed surface on the glass and the fresh cut bead of urethane

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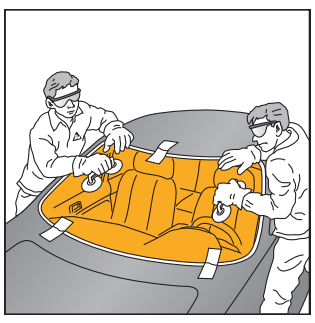

- Place the windshield in position within the open time of the adhesive
- Caution: the open time may be significantly shorter at elevated temperature

15

- Remount trim and moldings so that they fit properly, secure all cowlings under the bonnet and affix wipers
- Ensure that all dismantled parts are installed correctly
- Refit and rear-view mirror and check if all ADAS related sensors and cameras work correctly

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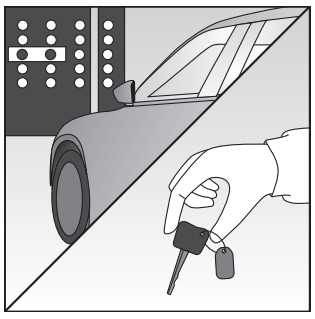

- Conduct and record ADAS recalibration according OEM specification
- Record all batch numbers on job card to insure full traceability
- Complete paperwork and hand back keys to customer after the minimum safe drive away time is achieved

BONDING SURFACE	SURFACE PREPARATION STEPS
Float Glass and Ceramic coated Glass[a]	●
Bare Metal Scratch < 5 cm²	● ●
Bare Metal Scratch < 150 cm²	● ● ●
Intact OEM Paint	● ●
Repair Paint (after complete curing of paint)[b]	● ●
PVC/RIM Encapsulation, Pre-applied Adhesive System[b]	● ●
Fresh Cut Bead	●
Pre-applied OEM Primer	●
PC / PMMA glass[c]	● ●

● = Sika® Aktivator PRO (Sika® Aktivator-100 may be used as an alternative, respecting a 10 minute flash off time)

● = Sika® Primer-207 or Sika® Primer-507

a) Windshield must be clean of dirt and dust. Potential contamination must be removed by wet scrubbing with Sika® Cleaner PCA
b) Scuff surface
c) Anti Scratch Coating must be removed prior to use, scuff surface, (only for temporary glazing, UV-protection required)

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheets prior to any use.

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