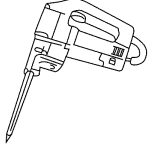



REMOVAL AND INSTALLATION

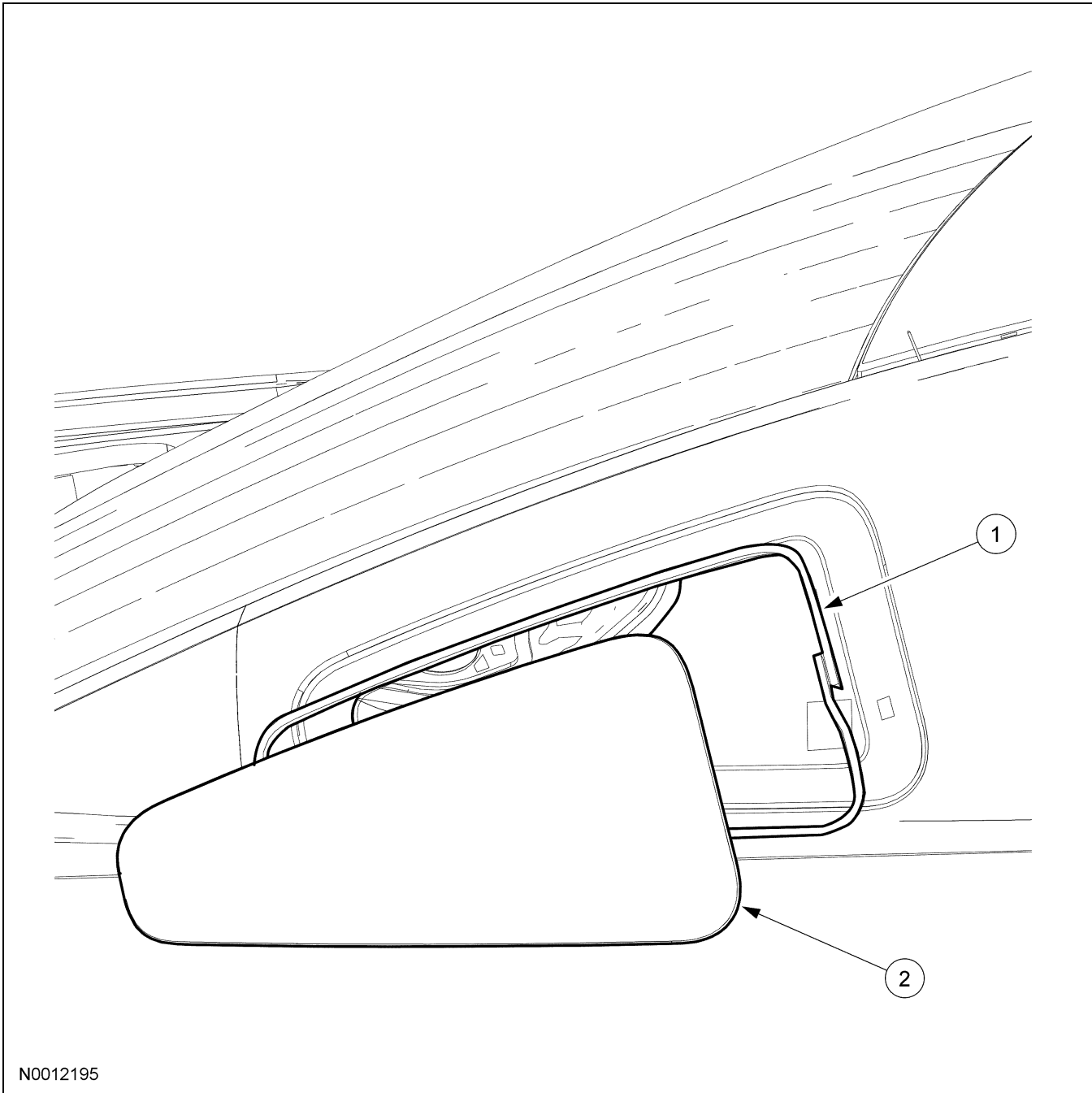
Rear Quarter Window Glass — Coupe

Special Tool(s)

 <p>ST1320-A</p>	<p>Interior Auto Glass Cut-Out Knife Kit (electric) 164-R2450 or equivalent</p>
 <p>ST2579-A</p>	<p>Interior Auto Glass Cut-Out Knife Kit (Air Powered) 164-R2451 or equivalent</p>

Material

Item	Specification
Urethane Adhesive Essex 400-HV	WSB-M2G316-B
Urethane Glass Prep Essex U-401	WSB-M5B280-C
Urethane Glass Primer Essex U-402	WSB-M2G314-B
Urethane Metal Primer Essex U-413	WSB-M2G234-C


REMOVAL AND INSTALLATION (Continued)

Item	Part Number	Description
1	Essex 400-HV	Urethane adhesive
2	6329700	Rear quarter glass

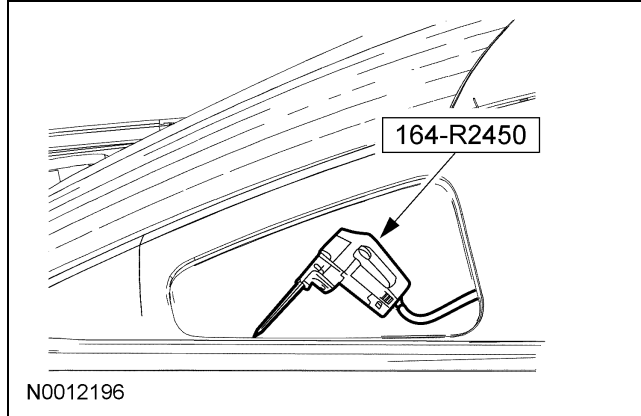
Removal

1. Remove the quarter trim panel and the B-pillar upper trim panel. For additional information, refer to Section 501-05.

REMOVAL AND INSTALLATION (Continued)


2.  **CAUTION:** Care must be taken to avoid scratching the pinch weld.

Using the special tool and working from the inside, cut the urethane seal.

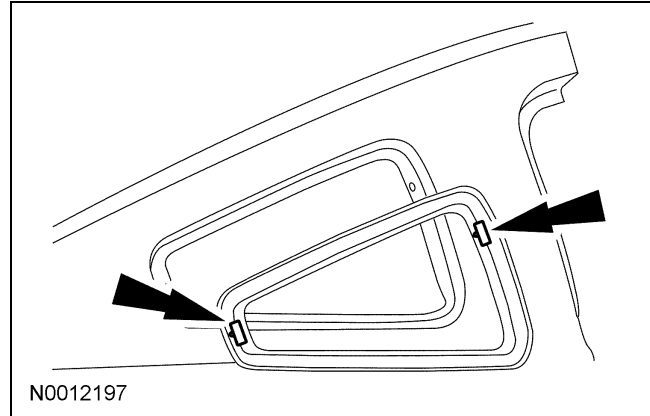



- Remove the quarter window glass.
- Using a soft brush or vacuum, clean the pinch weld.

Installation

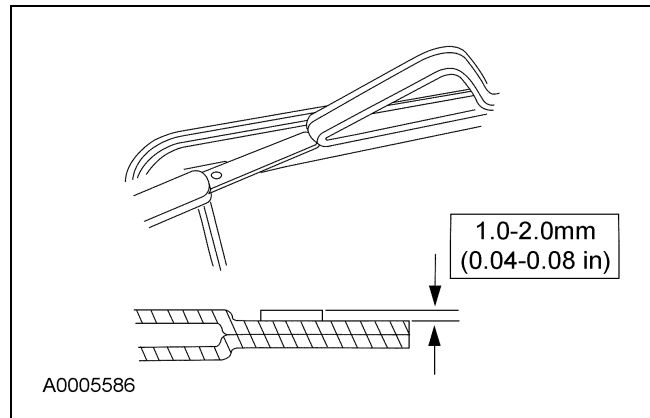
 **CAUTION:** After installing the urethane installed quarter window glass, the vehicle should not be driven until the urethane adhesive has cured. The curing time at temperatures above 13°C (55°F) and relative humidity above 50% is 12-24 hours. Refer to the ESSEX drive away chart for cure times as temperatures and humidity may vary. Inadequate curing of the urethane adhesive may adversely affect the strength of the urethane adhesive bond.

- Dry-fit the quarter window glass by centering it using the locating pins. Make alignment marks with tape or non-staining grease pencil on both the glass and the vehicle body.




2.  **CAUTION:** Care must be taken to avoid scratching the pinch weld.

Trim the remaining urethane adhesive on the pinch weld using only the full-cut method. In this method, most of the existing urethane is removed leaving a level bead around the entire pinch weld.



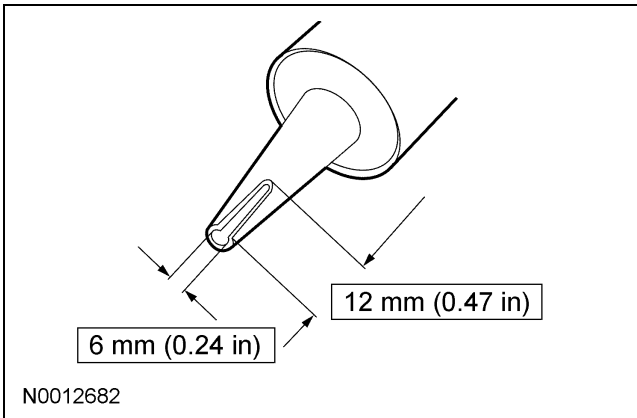
- Using a wool applicator, apply the urethane metal primer to any exposed metal on the pinch weld. Allow 6 to 10 minutes to dry.
- If reinstalling the original quarter window glass, remove the urethane adhesive from the quarter window glass.
- If installing a new quarter window glass, clean the inside of the glass surface with an alcohol-free cleaner to make sure the ceramic-coated area is clean.

REMOVAL AND INSTALLATION (Continued)

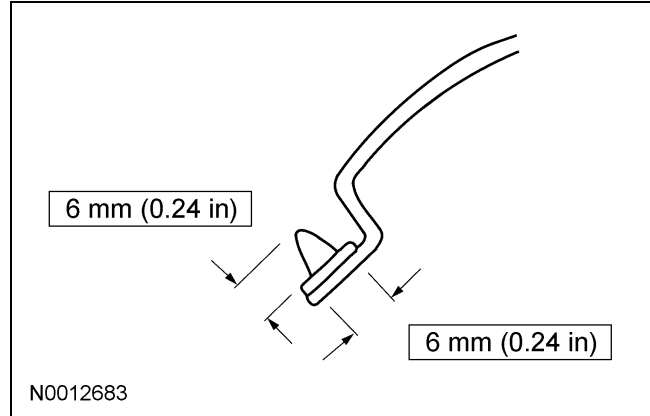
6.  **CAUTION:** Wipe off the urethane glass prep immediately after each application because it flash dries. Apply deliberate strokes, making sure not to overlap the applied area.


If installing a new quarter window glass, apply urethane glass prep twice around the class surface to be prepped.

7. If installing a new quarter window glass, apply urethane glass primer to the same area referred to in the previous step. Allow 5 minutes to dry.
8. Cut the applicator tip to specification.



9. Apply a bead of urethane adhesive to the pinch weld.



10.  **CAUTION:** Open a window to prevent the quarter window glass from being pushed out by air pressure when the door is closed.

Using the locator pins on the glass, install the quarter window glass by aligning the locator pins to the body locator holes.

11. After the glass is set, check for water leaks and add urethane adhesive where needed.
12. Install the quarter trim panel and the B-pillar upper trim panel. For additional information, refer to Section 501-05