REMOVAL AND INSTALLATION

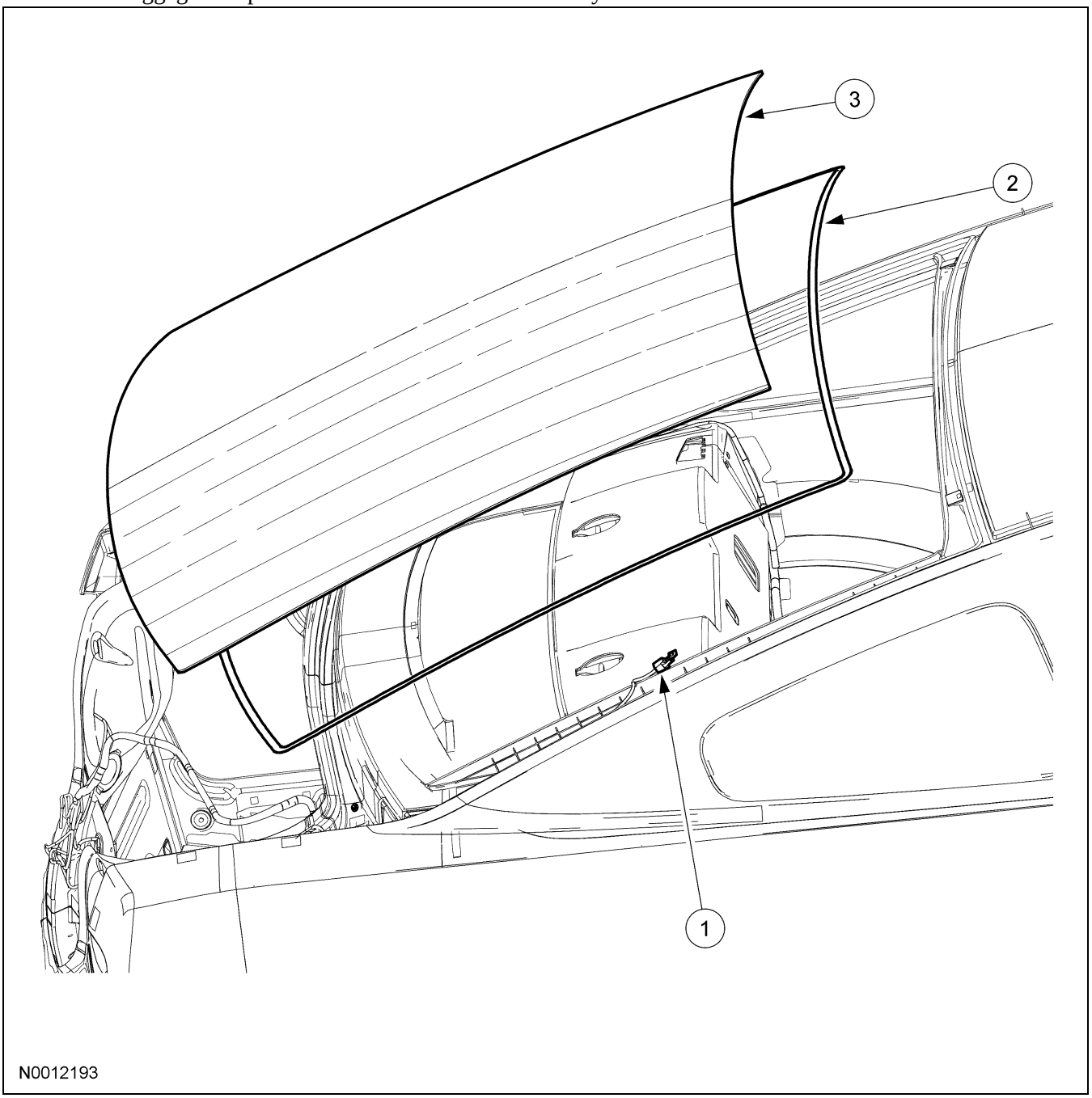
Rear Window Glass

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)

NOTE: The luggage compartment lid is not shown for clarity.



Item	Part Number	Description
1	—	Heated rear window electrical connector (part of 14A005)
2	Essex 400-HV	Urethane adhesive
3	6342006	Rear window glass

Removal

⚠ WARNING: To prevent glass splinters from entering eyes or cutting hands, wear safety glasses and heavy gloves when cutting glass from the vehicle. Failure to follow these instructions may result in personal injury.

1. Disconnect the 2 heated rear window electrical connectors.

REMOVAL AND INSTALLATION (Continued)

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

   NOTE: Lubricate the existing urethane adhesive with water to aid the tool while cutting.

   Using an appropriate tool (with the luggage compartment lid open approximately 45°), starting at the bottom outboard corner of the rear window glass, cut the urethane adhesive from the glass.

3. Remove the rear window glass.

4. Using a soft brush or vacuum, clean the pinch weld.

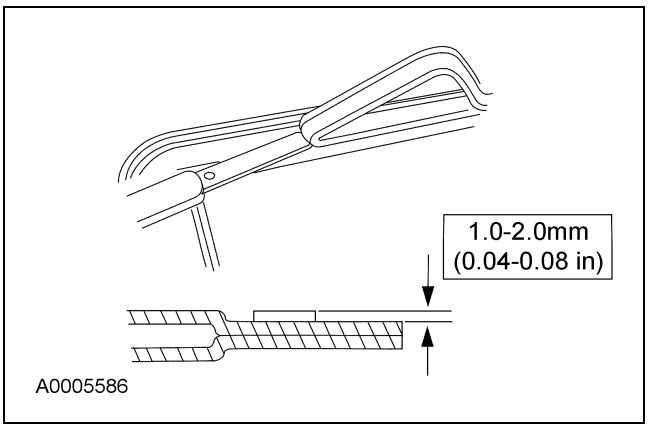
Installation

CAUTION: After installing the urethane installed rear 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.

1. Dry-fit the rear window glass by centering it side-to-side and by adjusting the setting blocks (if equipped) to get the correct position of the part top-to-bottom. 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.



3. **NOTE:** Make sure to not apply primer that will be visible after the rear window glass is installed and do not apply primer to the wall of the 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.

4. If reinstalling the original rear window glass, remove the urethane adhesive from the rear window glass.

5. If installing a new rear window glass, clean the inside of the glass surface with an alcohol-free cleaner to make sure the ceramic-coated area is clean.

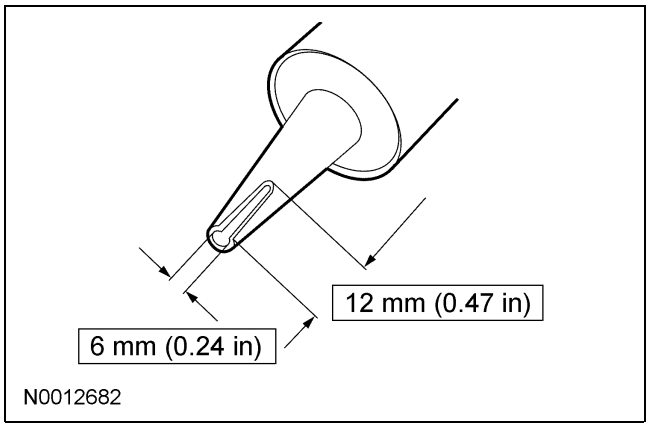
6. **CAUTION: Wipe off the urethane glass prep immediately after each application because it flash dries. Apply deliberate strokes, making sure not to overlap the applied area.**

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

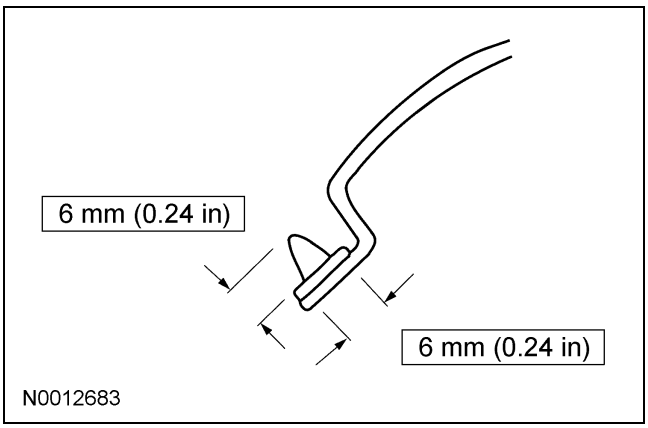
7. If installing a new rear window glass, apply urethane glass primer to the same area referred to in the previous step. Allow 5 minutes to dry.

REMOVAL AND INSTALLATION (Continued)

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 rear window glass from being pushed out by air pressure when the door is closed.**

    Using the alignment marks install the rear window glass.

11. After the glass is set, check for water leaks and add urethane adhesive where needed.

12. Connect the 2 heated rear window electrical connectors.