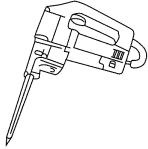
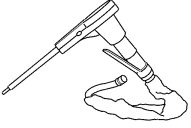


REMOVAL AND INSTALLATION

Window Glass — Rear Quarter, Coupe

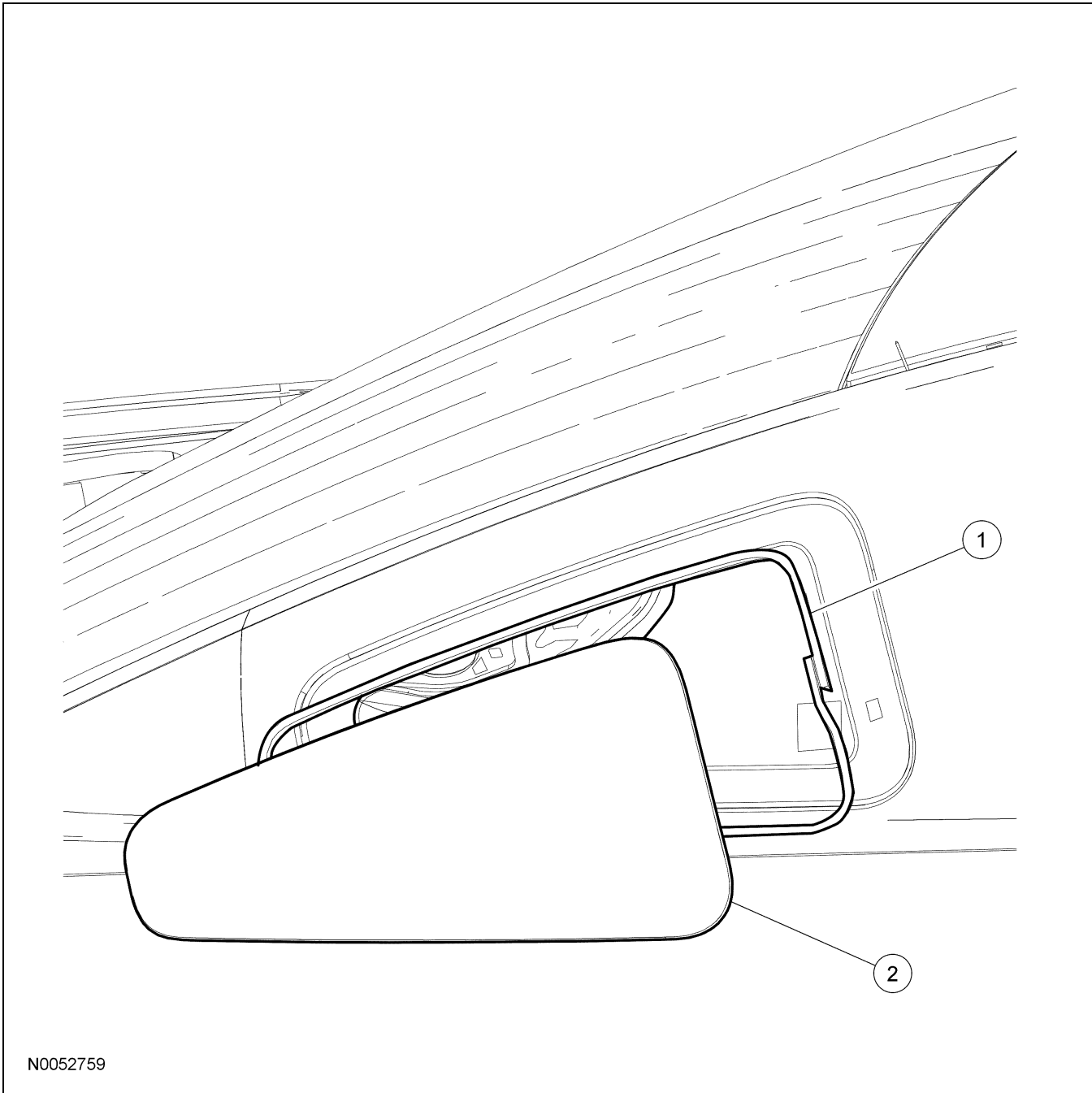
Special Tool(s)

 <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
DOW AUTOMOTIVE 2-HOUR CURE	
Dow Urethane Adhesive Betaseal® Express	—
Dow Urethane One Step Glass Primer Betaprime® 5500 / 5500A / 5500SA	—
SIKA 2-HOUR CURE	
Sika Urethane Adhesive Sika Tack ASAP	—
Sika Urethane Metal and Glass Primer Sika 206 G+P	—
Ultra-Clear Spray Glass Cleaner ZC-23	ESR-M14P5-A

REMOVAL AND INSTALLATION (Continued)




Item	Part Number	Description
1	—	Urethane adhesive
2	6329710 RH/ 632971 LH	Quarter window glass

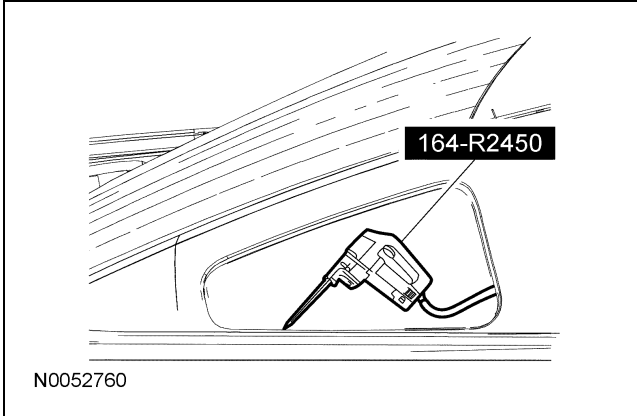
Removal

1. Remove the quarter window 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.



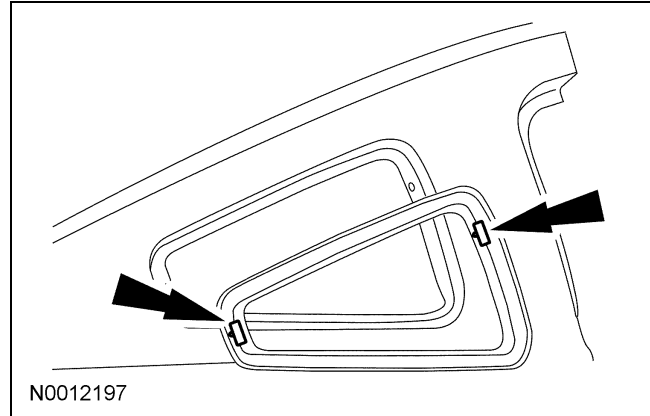
3. Remove the quarter window glass.
4. Using a soft brush or vacuum, clean the pinch weld.

Installation

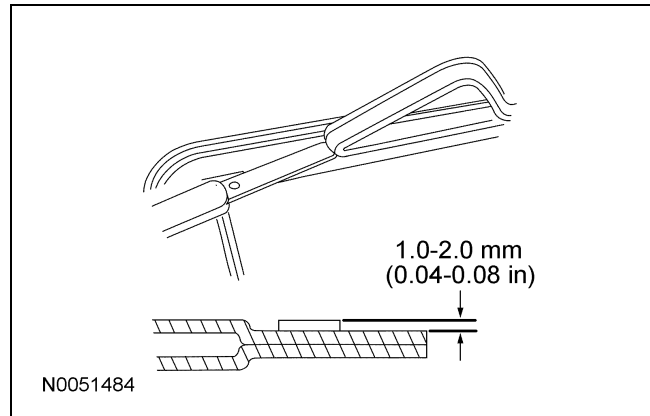
1.  **CAUTION:** When installing urethane-installed glass parts, the vehicle must not be driven until the urethane has cured. Adequate cure time is specified on the drive away chart for each urethane product as the temperatures and humidity vary. Inadequate or incorrect curing can adversely affect the retention of the quarter window glass.

NOTE: For additional material guidelines, refer to the manufacturer's installation information.

2. 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.



3. Remove the quarter window glass.
4. **NOTE:** Avoid scratching the pinch weld. For minor scratches or exposed metal on the pinch weld see manufacturer's recommendations. Trim the urethane with an appropriate tool leaving a 1 mm to 2 mm base of Original Equipment urethane on the pinch weld.



5. If reinstalling the original quarter window glass, remove the urethane adhesive from the quarter window glass.
6. If installing a new quarter window glass, clean the inside of the glass surface with glass cleaner to make sure the ceramic-coated area is clean.

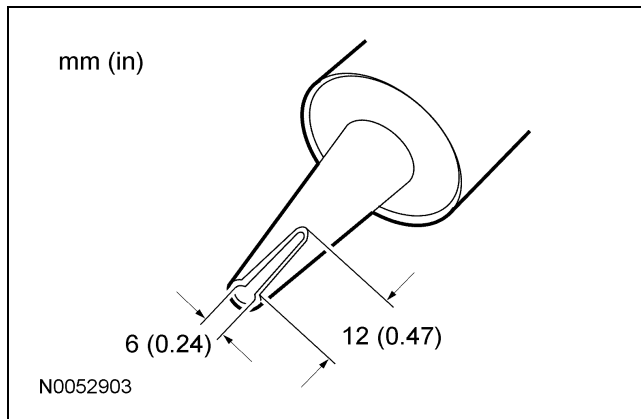
REMOVAL AND INSTALLATION (Continued)

7. **⚠ CAUTION:** Be sure to use the same brand and cure-rate products for the adhesive and primer. Do not mix different brands of urethane and primer. Refer to the Material Chart in this procedure.

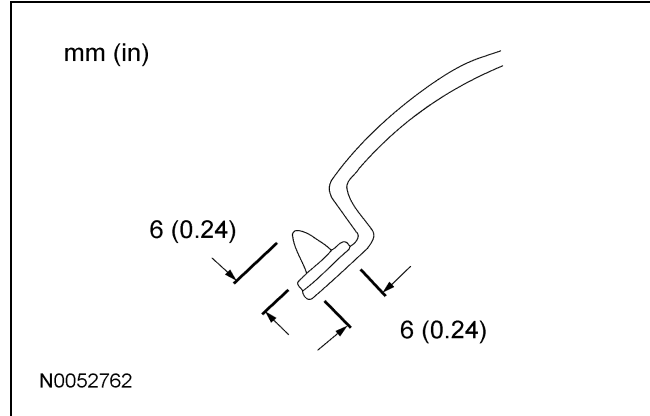
NOTE: Sika uses the same black primer for the glass and pinch weld area.

If installing a new quarter window glass, apply urethane glass primer according to manufacturer's instructions. Allow at least 6 minutes to dry.

8. Cut the applicator tip to specification.



9. **NOTE:** Use either a high-ratio, electric or battery-operated caulk gun that applies the urethane adhesive with less effort and a continuous bead.
- Apply a bead of urethane adhesive to the pinch weld. Make sure that all gaps in the urethane adhesive are smoothed into one continuous bead, starting at the bottom of the quarter window glass near the center.



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. **⚠ CAUTION:** When installing urethane-installed glass parts, the vehicle must not be driven until the urethane has cured. Adequate cure time is specified on the drive away chart for each urethane product as the temperature and humidity vary. Inadequate or incorrect curing can adversely affect the retention of the quarter window glass.

After the urethane has cured, check the quarter window glass seal for air or water leaks through the urethane adhesive bead and add urethane adhesive as necessary.

12. Install the quarter window trim panel. For additional information, refer to Section 501-05.