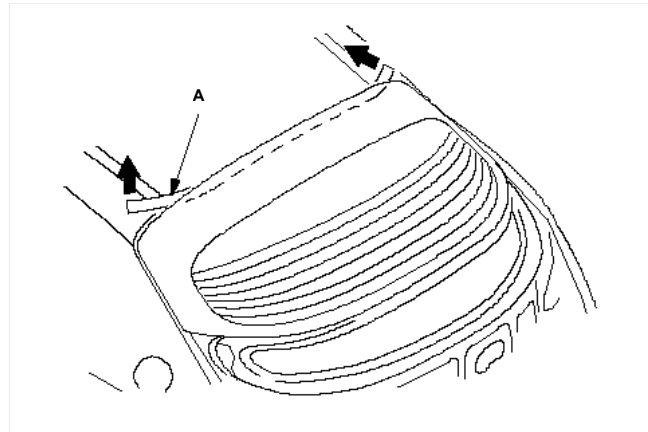


Rear Window Replacement

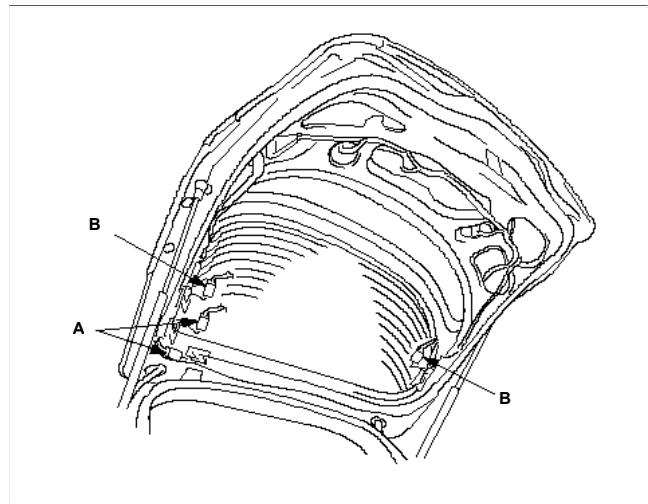
NOTE:

- Put on gloves to protect your hands.
- Wear eye protection when removing the glass with piano wire.
- Use seat covers to avoid damaging any surfaces.
- Do not damage the rear window defogger grid lines and terminals.
- Use glass adhesive set P/N 08C73-X0230N.

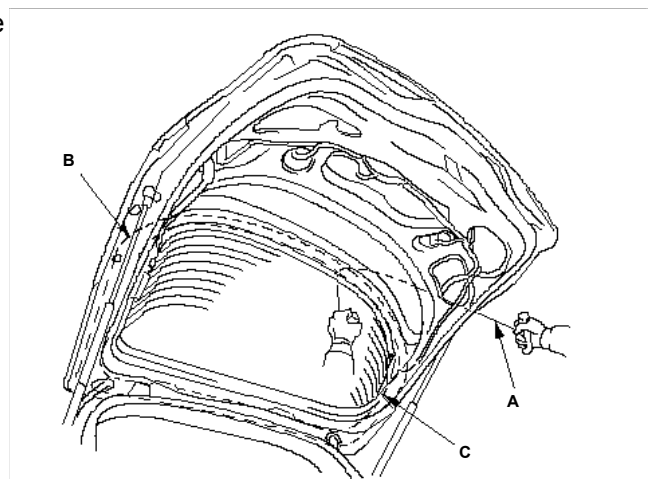
1. [Remove the extra window.](#)
2. Remove the upper seal (A) from the edge of the rear window. If necessary, cut the upper seal with a utility knife.



3. Disconnect the window antenna connectors (A) and rear window defogger connectors (B).
4. If the old rear window is to be reinstalled, make alignment marks across the glass and body with a grease pencil.
5. Apply protective tape along the inside and outside edges of the tailgate. Using an awl, make a hole through the adhesive from inside the vehicle at the corner portion of the rear window. Push the piano wire through the hole, and wrap each end around a piece of wood.

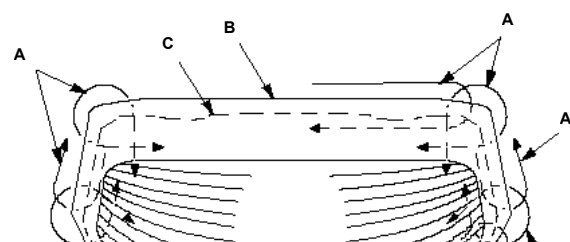


6. With a helper on the outside, pull the piano wire (A) back and forth in a sawing motion. Hold the piano wire as close to the rear window (B) as possible to prevent damage to the tailgate, and carefully cut through the adhesive (C) around the entire rear window.
7. Carefully remove the rear window.
8. With a putty knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire rear window opening flange:
 - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
 - Remove the fasteners from the tailgate.



Cutting positions

9. Clean the tailgate bonding surface with a sponge dampened in alcohol. After cleaning, keep oil, grease and water from getting on the surface.
10. If the old rear window is to be reinstalled, use a putty knife to scrape off all of the old adhesive, the fasteners and the rubber dams from the

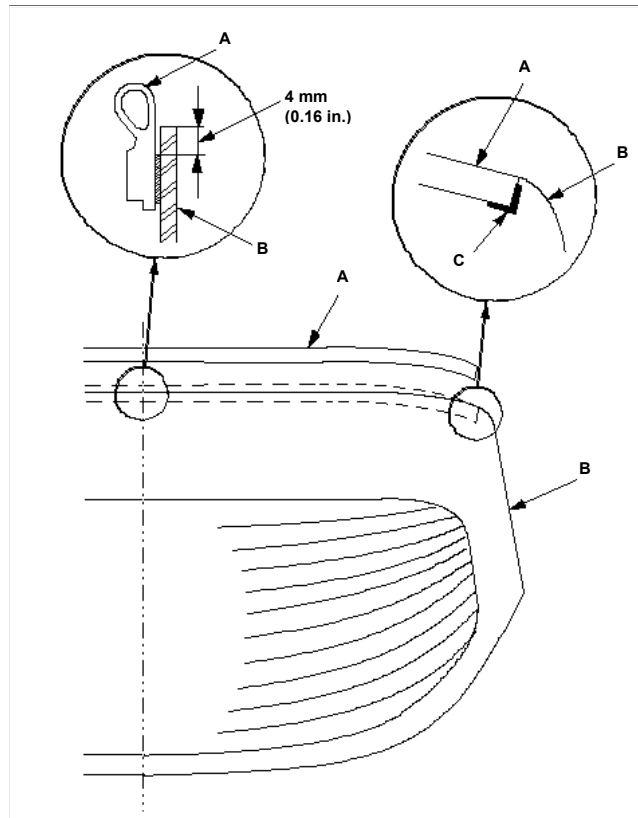


rear window. Clean the inside face and the edge of the rear window with alcohol where new adhesive is to be applied. Make sure the bonding surface is kept free of water, oil and grease.



11. Attach the upper seal (A) with adhesive tape along the upper edge of the rear window (B):
- Before installing the upper seal, apply primer to the area where its adhesive tape will be stuck in inside face of the rear window.
 - Be sure the upper seal with the alignment marks (C) on the upper edge of the rear window.

Adhesive Thickness 0.4 mm (0.02 in.) tape:



12. Attach the rubber dams A, B (A, B) with adhesive tape A, rubber dam C (C) with adhesive tape B, rubber dam D (D) with adhesive tape C, clip (E) with adhesive tape D, and fasteners (F) with adhesive tape E to the inside face of the rear window (G) as shown:

- Before installing the rubber dams, clip and fasteners, apply primer to the area where its adhesive tapes will be stuck in inside face of the rear window.
- Be sure the rubber dams, clip and fasteners with the alignment marks (H) on the upper edge of the rear window.
- Be careful not to touch the rear window where adhesive will be applied.

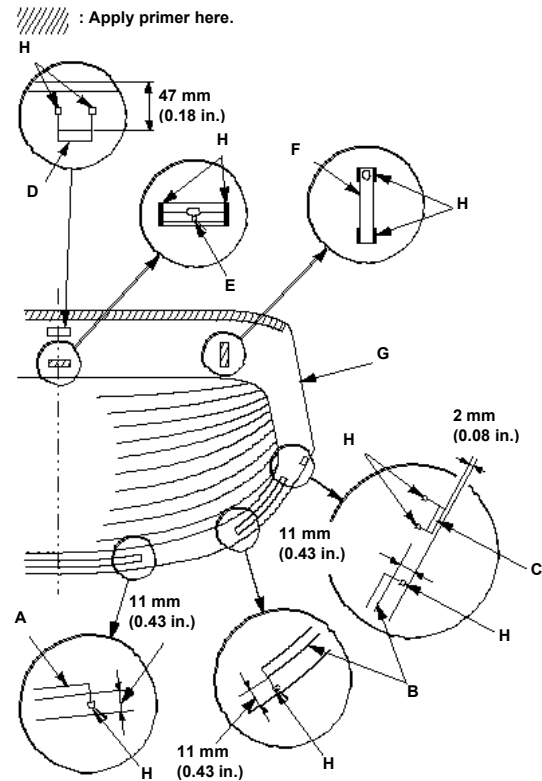
Adhesive tape A: Thickness 0.16 mm (0.006 in.)
Width 5 mm (0.2 in.)

Adhesive tape B: Thickness 0.16 mm (0.006 in.)
Width 3 mm (0.12 in.)

Adhesive tape C: Thickness 0.6 mm (0.24 in.)
Width 7.5 mm (0.29 in.)

Adhesive tape D: Thickness 0.4 mm (0.02 in.)
Width 10 mm (0.4 in.)

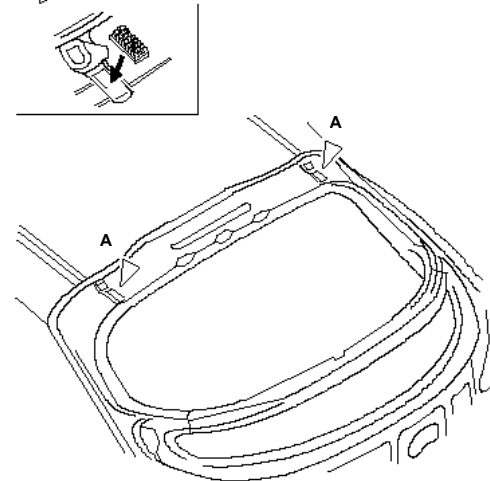
Adhesive tape E: Thickness 0.6 mm (0.024 in.)



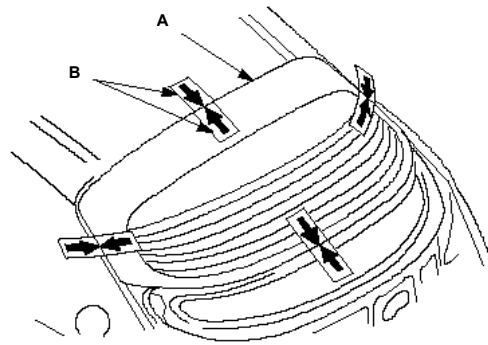
13. Attach the fasteners (A) to the tailgate as shown.

Fastener Locations

A ▷ : Fastener, 2



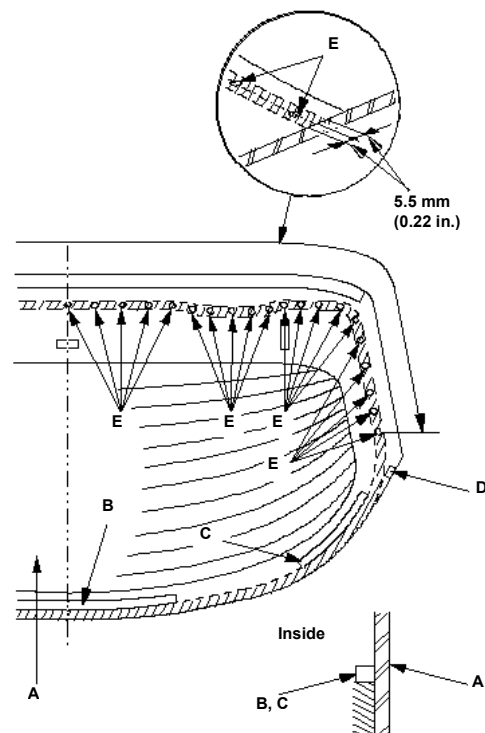
14. Set the rear window (A) in the opening, and center it. Make alignment marks (B) across the rear window and body with a grease pencil at the four points shown. Be careful no to touch the rear window where adhesive will be applied.
15. Remove the rear window.



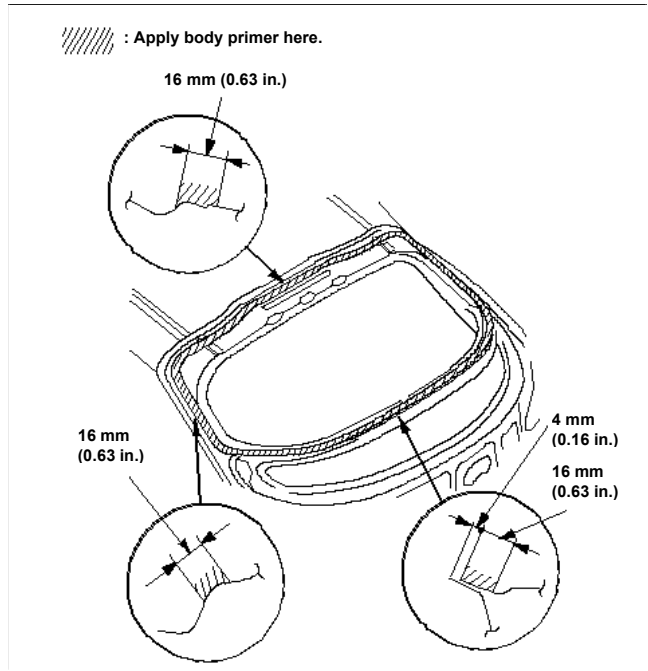
16. With a sponge, apply a light coat of glass primer around the edge of the rear window (A) between the rubber dams (B, C, D) as shown, then lightly wipe it off with gauze or cheesecloth:

- With the printed dots (E) on the rear window as a guide, apply the glass primer to the upper and both side portions of the rear window.
- Do not apply body primer to the rear window, and do not get tailgate and glass primer sponges mixed up.
- Never touch the primed surfaces with your hands. If you do, the adhesive may not bond to the rear window properly, causing a leak after the rear window is installed.
- Keep water, dust, and abrasive materials away from the primed surface.

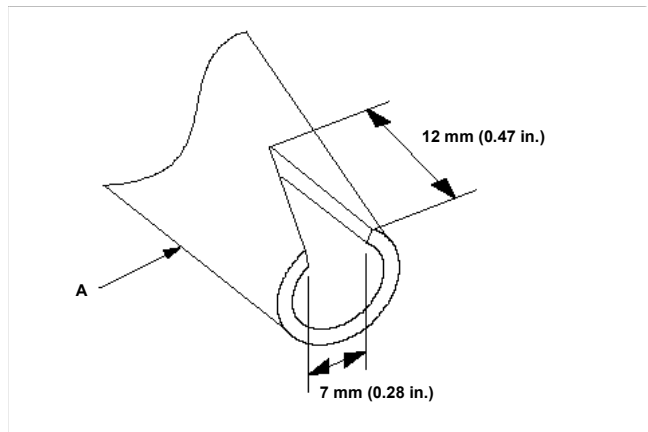
//// : Apply glass primer here.



17. With a sponge, apply a light coat of body primer to the original adhesive remaining around the rear window opening flange. Let the body primer dry for at least 10 minutes:
- Do not apply glass primer to the body, and be careful not to mix up glass and body primer sponges.
 - Never touch the primed surfaces with your hands.



18. Before filling a cartridge, cut a "V" in the end of the nozzle (A) as shown.



19. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) on the rear window (B) around the edge of the upper seal (C), and rubber dams (D, E, F), as shown. Apply the adhesive within 30 minutes after applying the glass primer. Make a slightly thicker bead at each corner.
20. Use suction cups to hold the rear window over the opening, align it with the alignment marks you made in [Step 14](#), and set it down on the adhesive. Lightly push on the rear window until its edges are fully seated on the adhesive all the way around. Do not open or close the doors until the adhesive is dry.
21. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the rear window, use a soft shop towel dampened with alcohol: Let the adhesive dry for at least 1 hour, then spray water over the rear window and check for leaks. Mark the leaking areas, let the rear window dry, then seal with sealant. Let the vehicle stand for at least 4 hours.
22. [Install the extra window.](#)
23. Let the adhesive dry for at least 1 hour, then spray water over the roof glass and check for leaks. Mark leaking areas, and let the roof glass dry, then seal with sealant:
 - Let the vehicle stand for at least 4 hours after toplight roof glass installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
 - Keep the toplight roof glass dry for the first hour after installation.
24. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

 - Slam the doors with all the windows rolled up.
 - Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).

