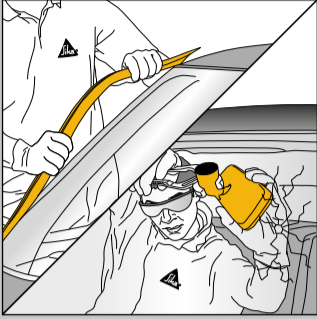


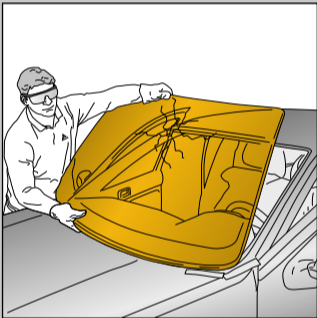
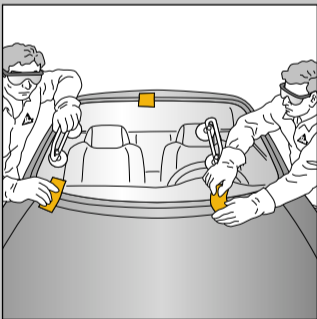
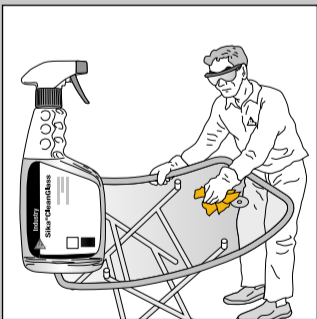
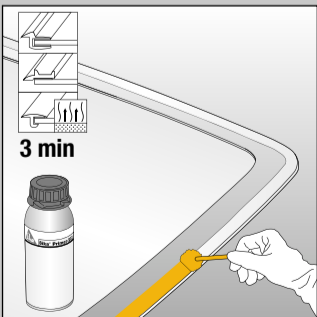
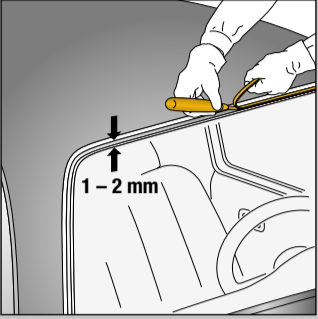
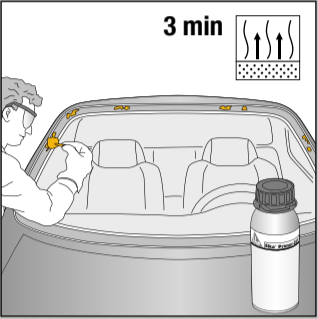
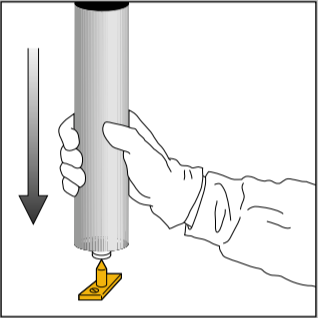





# ALL BLACK PROCESS AUTO GLASS REPLACEMENT

- 1 
  - Remove all decorative trims
- 2 
  - Cover the aperture with masking tape
- 3 
  - Cut out damaged windshield using an electrical knife, cutting wire, cold knife etc.
- 4 
  - Remove damaged windshield
- 5 
  - Dry fit new windshield
- 6 
  - Clean the new windshield with Sika® Cleaner G+P
- 7 
  - Prime the bonding surface of the glass using Sika® Primer-207
- 8 
  - Trim back the remaining adhesive bead to 1 - 2 mm
- 9 
  - Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification
- 10 
  - Open the cartridge or the unipack
- 11 
  - Apply a triangular bead of adhesive either to the glass or the aperture
- 12 
  - Place the windshield in position within the open time of the adhesive
- 13 
  - Refit trims and mouldings



BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5 cm <sup>2</sup>	●
Bare Metal 5 cm <sup>2</sup> to 150 cm <sup>2</sup>	●●
Intact OEM Paint	●
Repair Paint (after complete curing of paint)	●
PVC/RIM Encapsulation	●
Fresh Cut Bead	Optional / ●
Pre-applied adhesive system	Optional / ●
Polycarbonate**	●
PMMA**	●

● = Sika® Primer-207

\* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

\*\* Coating must be removed prior to use, only for temporary glazing, UV-protection required.

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

[www.sika.com/aftermarket](http://www.sika.com/aftermarket)

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