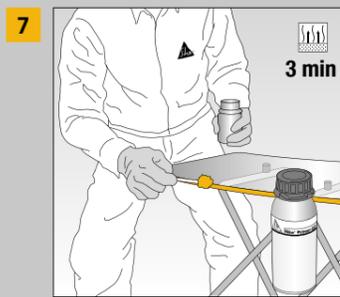


# ALL BLACK PROCESS BUS AND COACH GLASS REPLACEMENT



1 ■ Remove all decorative trims



7 ■ In case of laminated safety glass, apply a protecting layer of Sika® Primer-207 onto the edge of the glass and let it dry for a minimum of 3 minutes



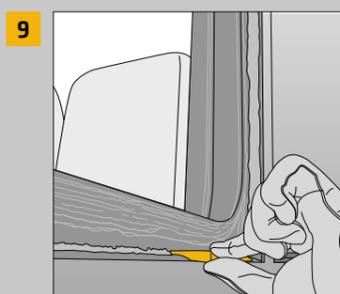
2 ■ Cut out damaged windshield using electrical knife, cutting wire, cold knife, etc.



8 ■ Using a brush apply a thin continuous coat of Sika® Primer-207 on the damaged area and let it dry for a minimum of 3 minutes



3 ■ Trim back remaining adhesive bead to 1-2 mm



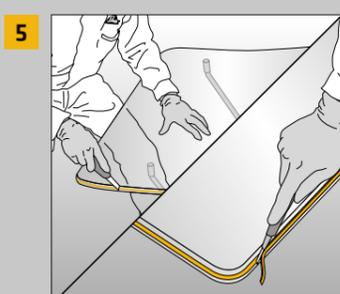
9 ■ Position suitable spacers on the lower edge of the frame to support the glass weight during adhesive curing



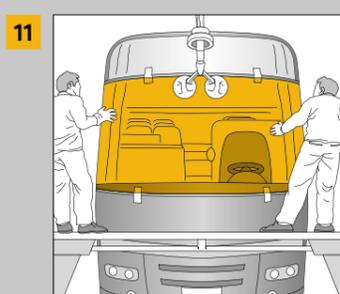
4 ■ If the installation requires a backfilling it is advisable to mask the edge of the flange adjacent to the backfilling with suitable masking tape during this phase



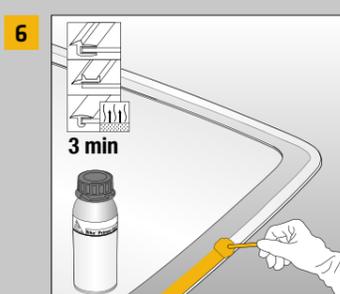
10 ■ Using a triangular nozzle apply the adhesive on the glass or on the body



5 ■ In case of laminated safety glass cut back the protruding layer of PVB foil



11 ■ Place windshield in position within open time of adhesive



6 ■ Prime bonding surface with Sika® Primer-207. Let it dry for a minimum of 3 minutes



BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5cm <sup>2</sup>	●
Bare Metal 5 cm <sup>2</sup> to 150cm <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.

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