

Stationary Auto Glass Removal and Installation		
1		Glass Removal Apply interior surface protection. Remove interior trim pieces and disconnect electronics. Remove molding. Cut urethane with the appropriate tool. Remove glass.
2		Preparing Damaged Pinchweld Remove all of the old urethane from the damaged area only. For the undamaged pinchweld, leave the urethane intact at this time.
3		Additional Surface Protection Take time to add additional surface protection if needed. This will save time and money in the end.
4		Preparation of New Pinchweld Scuff pinchweld area with general purpose scuffing pad and apply two-part epoxy primer. Then, mask off the pinchweld prior to top coating. Check with paint manufacturer for two-part epoxy primer.
5		Dry Set Glass Clean the pinchweld area of all loose pieces of urethane. Dry fit the glass. Use masking tape to mark proper alignment by applying two pieces of tape along the top edge of the glass, perpendicular to the pinchweld. Cut the masking tape and remove the glass.
6		Clean and Prepare Glass Clean the existing glass. Close cut the urethane if it is in good condition to a thickness of 1mm–2mm. Clean with water and a clean cloth. For new glass, clean glass with glass cleaner and a clean cloth.
7		Preparation of Undamaged Pinchweld Close-cut the old urethane down to a thickness of 1mm–2mm. Clean the pinchweld area with water and a clean cloth.
8		Apply Primer to Pinchweld if Necessary Check the expiration date on the primer, and shake the primer well. For the undamaged pinchweld area, apply the primer to any bare metal scratches. For the damaged pinchweld area that has been repaired, apply a continuous layer of primer to the newly abraded and cleaned epoxy primer. Allow 5–10 minutes of dry time for the primer.
9		Apply Urethane and Install Glass Check the expiration date on the urethane. Cut the application nozzle to the desired width and shape and install the flex pack into the applicator gun. Apply urethane to either the close-cut urethane on the undamaged pinchweld area and/or the prepped epoxy primed area of the new pinchweld. Paddle all gaps in the urethane in one direction and install the glass.
10		Tape Removal Remove all tape before delivering the vehicle. For best results remove it in a slow, uniform motion. Remove it in the direction of the painted surface to the windshield, and remove the tape at an angle of approximately 135° to the surface. Tape removal works best if the temperature is above 60°F.
11		Reinstall Moldings and Panels Reinstall moldings and interior panels as needed. Reconnect electronics. Remove excess urethane. Keep vehicle out of service until the urethane builds strength per manufacturer recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List
<p>3M™ White Masking Paper, 12 in. x 750 ft., PN 06538</p> 
<p>3M™ High Performance Welding Drape, PN 05919</p> 
<p>Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659</p> 
<p>3M™ Precision Masking Tape, 2 in. width, PN 06528</p> 
<p>3M™ Glass Cleaner, 19 oz. aerosol, PN 08888</p> 
<p>3M™ Single Step Primer, 30mL can, PN 08682</p> 
<p>3M™ Urethane Primer Daubers, PN 08688</p> 
<p>3M™ Fast Cure Auto Glass Urethane, 450mL Flex Pack, PN 08689; 10.5 fl. oz. cartridge, PN 08690</p> 
<p>3M™ Flex Pack Heavy Duty 450ml Applicator Gun, PN 08991</p> 
<p>3M™ Specialty Adhesive Remover, 1 qt. can, PN 38984; 15 oz. aerosol, PN 38987</p> 

Think About Your Health
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p> 
<p>3M™ Half Facepiece Respirator, PN 07182</p> 
<p>3M™ Virtua™ Protective Eyewear, PN 11326</p> 

Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at 3MCollision.com

For product material safety data sheets see 3MCollision.com

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



3M Automotive Aftermarket Division
3M Center, Building 223-6S-07
St. Paul, MN 55144-1000
U.S.A.

3M, Accuspray, Cubitron, E-A-R, Hookit, Perfect-It, Platinum, PPS, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, SUN GUN, Trizact, Versaflo and Virtua are trademarks of 3M. All other trademarks are property of their respective owners.

Web 3MCollision.com

Please recycle. Printed in U.S.A. © 3M 2019. All rights reserved. Rev 7/19. 60-4402-8018-2