

Aluminum Repair Procedures

Glass

Note: The products and process for this repair are the same as standard procedure.

Windshield Removal and Installation

1



Glass Removal

Apply interior surface protection. Remove wiper blades and cowl panel. Remove windshield molding. Cut urethane with the appropriate tool. Remove glass.

2



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.

3



Pinchweld Inspection & Preparation

Close-cut the old urethane down to a thickness of 1mm–2mm. Clean with water and a clean cloth. Apply primer to any bare metal scratches if necessary and allow to dry for 5–10 minutes.

4



Clean and Prepare the Glass

Clean glass with glass cleaner and a clean cloth.

5



Apply Primer to the New Windshield

Check the expiration date on the primer. Shake the primer can well. Apply a continuous layer of primer to the new windshield and allow to dry for 5–10 minutes.

6



Apply Urethane & Install Windshield

Check expiration date on urethane. Cut nozzle to desired width and shape. Apply a bead of new urethane to the old urethane on the pinchweld at an application angle of 90-degrees. Paddle all joints/gaps in one direction.

7



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.

8



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.

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Product List

3M™ Precision Masking Tape, 2 in. width, PN 06528



3M™ Single Step Primer, 30mL can, PN 08682



3M™ Urethane Primer Daubers, PN 08688



3M™ Glass Cleaner, 19 oz. aerosol, PN 08888



3M™ Fast Cure Auto Glass Urethane, 450mL Flex Pack, PN 08689; 10.5 fl. oz. cartridge, PN 08690



3M™ Flex Pack Heavy Duty 450mL Applicator Gun, PN 08991



3M™ Specialty Adhesive Remover, 1 qt. can, PN 38984; 15 oz. aerosol, PN 38987



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



Individual Product Instruction and Safety Information

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

For product material safety data sheets see www.3MCollision.com

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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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