

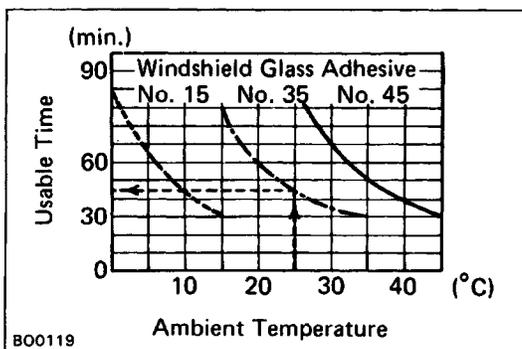
WINDSHIELD (Adhesive Type) PREPARE ITEMS LISTED

Part name and No.	Contents of set	Quantity
Adhesive set 08850-00070 (0 - 150C or 32 - 59°F)	Main agent 500g (17.64 oz.) hardening agent 75g (2.65 oz.) Primer G (for glass) 20g (0.71 oz.)	1 1 1
08850-00080 (15 - 351C or 59 - 951F)	Primer M (for body) 20g (0.71 oz.) Sponge (for applying primer)	1 2
08850-00090 (35 - 450C or 95 - 1131F)	Piano wire 0.6 mm dia. x 1 m (0.024 x 39.37 in.) Cartridge	1 1
Dam kit 04562-30040	Dam Double-stick tape (for sticking on dam)	
	Sealant gun (for applying adhesive) Glass or steel sheet (for mixing adhesive) Putty spatula (for mixing adhesive and correcting adhered parts) Cleaner (for cleaning adhering surface)	

Ambient temperature	Part No.	Part name
0 - 15°C (32 - 59°F)	08850-00070	Windshield glass adhesive set No. 15
15 - 35°C (59 - 95°F)	08850-00080	Windshield glass adhesive set No. 35
35 - 45°C (95 - 113°F)	08850-00090	Windshield glass adhesive set No. 45

1. CHOOSE SUITABLE ADHESIVE SET

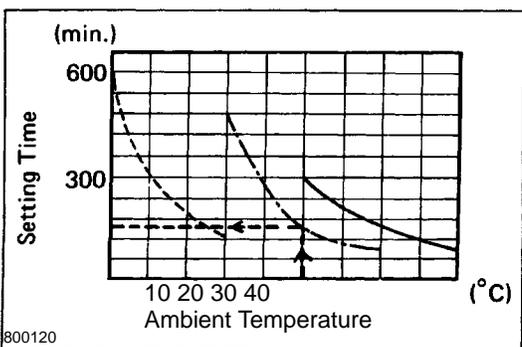
Use an adhesive set suitable for the ambient temperature.



2. CHECK ADHESIVE USABLE TIME

After mixing the main and hardening agents, finish glass installation within the specified time as shown.

Example: For glass installation in ambient temperature of 25°C (77°F), apply adhesive set No.35 within 45 minutes.



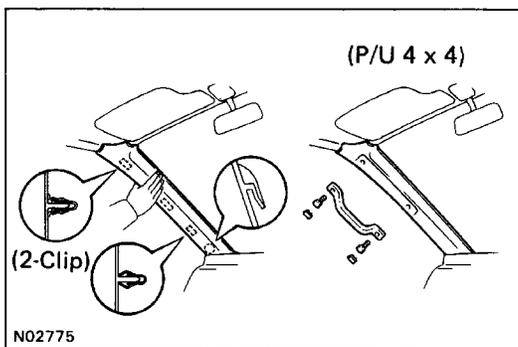
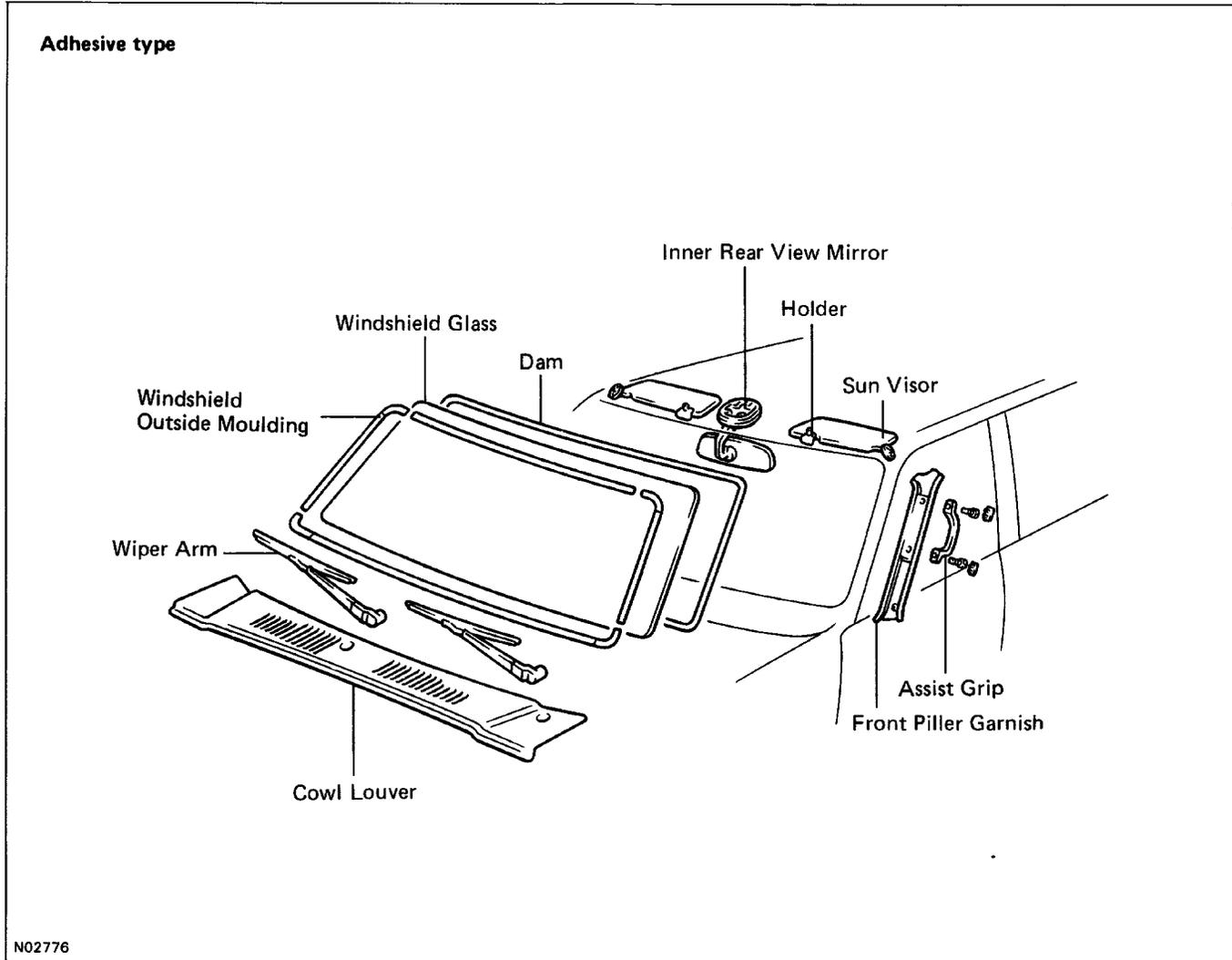
3. CHECK ADHESIVE SETTING TIME

First, mix the main and hardening agents. Then, perform a leak test only after the setting time has elapsed.

Example: The setting time for adhesive set No.35 with an ambient temperature of 25°C (77°F) is 2.5 hours.

NOTICE: Do not drive the vehicle until at least double the setting time has elapsed.

COMPONENTS

**REMOVAL OF WINDSHIELD****1. REMOVE FOLLOWING PARTS:**

- Inner rear view mirror
- Sun visors and holders
- Wiper arms
- Cowl louver
- Front pillar garnishes
- Assist grip

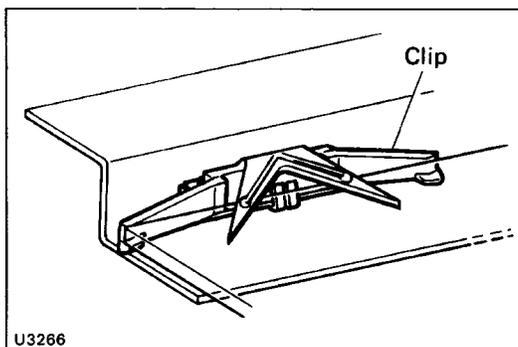
2. REMOVE WINDSHIELD MOULDING

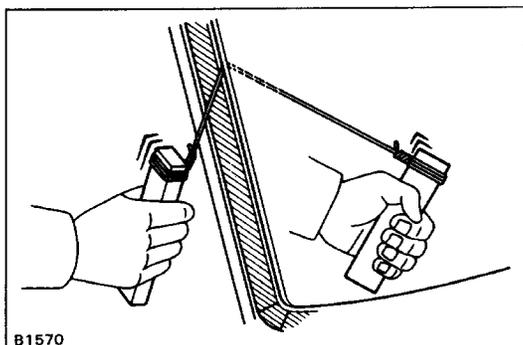
(See page [BO-13](#))

3. REMOVE CLIPS

Be careful not to damage the side moulding clips, when removing them from around the glass.

HINT: It is not necessary to remove the fasteners but any damaged fasteners should be replaced.





B1570

4. REMOVE WINDSHIELD GLASS

- (a) Push piano wire through from the interior.
- (b) Tie both wire ends to the wooden blocks or like objects.

HINT: Apply adhesive tape to the outer surface to keep the surface from being scratched.

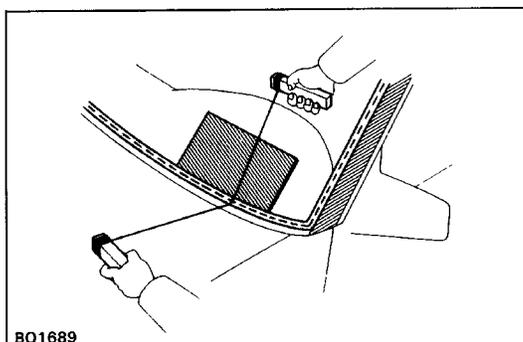
NOTICE: When separating, take care not to damage the paint and interior and exterior ornaments.

To prevent scratching the safety pad when removing the windshield, place a plastic sheet between the piano wire and safety pad.

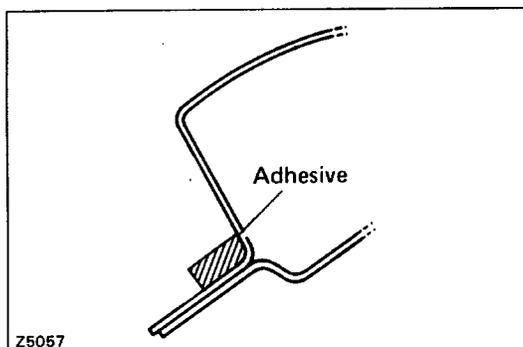
Cut the adhesive by pulling the piano wire around it.

- (d) Remove the glass.

NOTICE: Leave as much of the adhesive layer on the body as possible when cutting off the glass.



BO1689



Z5057

PREPARATION FOR INSTALLATION

1. CLEAN AND SHAPE CONTACT SURFACE OF BODY

- (a) Remove any dam remaining on the body.
- (b) Cut away any rough areas with a knife.

HINT: Leave as much of the adhesive layer on the body as possible.

- (c) Clean the cutting surface of the adhesive with a piece of cloth saturated in cleaner.

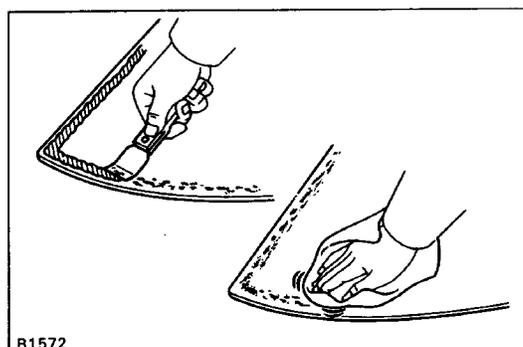
HINT: Even if all the adhesive has been removed, clean the body.

2. IF NECESSARY, REPLACE FASTENERS

(See page [BO-14](#))

3. CLEAN REMOVED GLASS BEFORE INSTALLATION

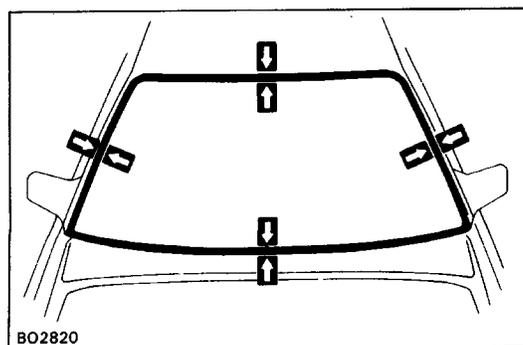
- (a) Using a scraper, remove the adhesive sticking to the glass.
- (b) Using the cleaner, clean the glass.



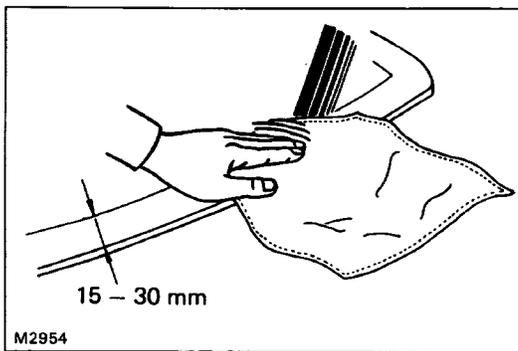
B1572

4. POSITION GLASS

- (a) Place the glass in correct position.
- (b) Check that all contacting parts of the glass rim are perfectly even, and do not make contact with the fasteners.
- (c) Mark reference marks between the glass and body.
- (d) Remove the glass.



BO2820

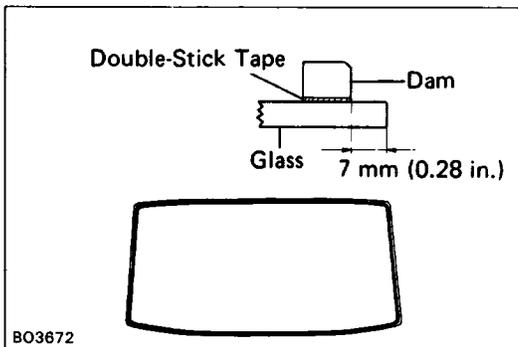


INSTALLATION OF WINDSHIELD

(See pages [BO-13](#) and 18)

1. CLEAN CONTACT SURFACE OF GLASS

Using cleaner, clean the contact surface 15 – 30 mm (0.59 – 1.18) wide around the entire glass rim.



2. INSTALL DAM

(a) Apply double-stick tape at a point as shown.

(b) Place the dam on the double-stick tape.

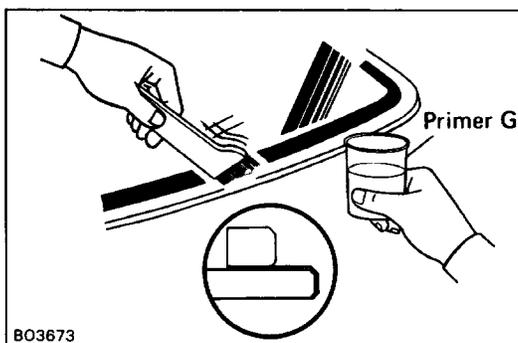
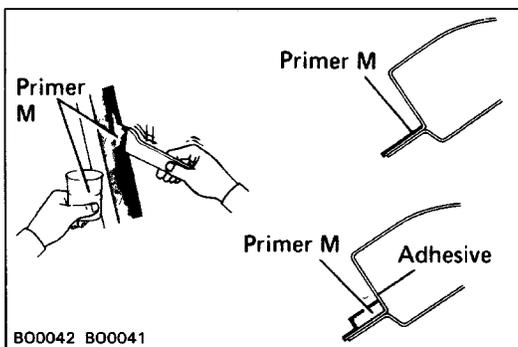
NOTICE: Do not touch the glass face after cleaning it.

3. COAT CONTACT SURFACE OF BODY WITH PRIMER "M"

Using a brush, coat the contact surface on the body with Primer M.

NOTICE:

- Let the Primer coating dry for 10 minutes or more. Make sure that the installation of the glass is finished within 2 hours.
- Use care not to leave any part of the contact surface uncoated or excessively coated, as Primer M and G serve to boost the adhesive power of the adhesive to the glass or body.
- Do not keep any of the opened Primer M and G for later use.



4. COAT CONTACT SURFACE OF GLASS WITH PRIMER "G"

(a) Using a brush or sponge, coat the edge of the glass and the contact surface with Primer G.

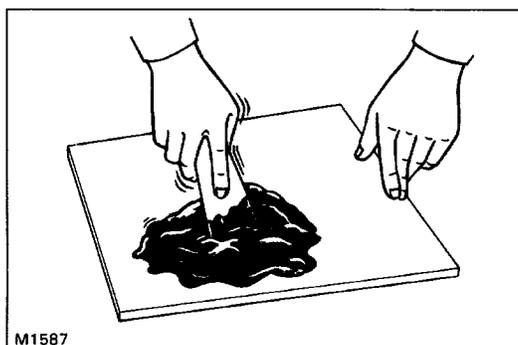
(b) Before the Primer dries, wipe it off with a clean cloth to avoid too thick a coat.

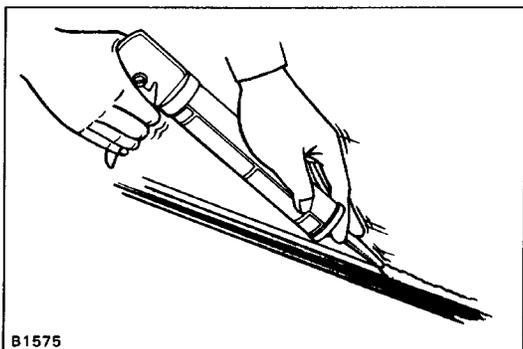
NOTICE: Be sure that installation of the glass is finished within 70 minutes.

5. MIX ADHESIVE COATING

NOTICE:

- Be sure that installation of the glass is finished within usable time. (See step 2 on page [BO-17](#))
 - The mixture should be made in 5 minutes or less.
- (a) Thoroughly clean the glass plate and putty spatula with cleaner.
- (b) Thoroughly mix 500 g (17.64 oz.) of the main agent and 75 g (2.65 oz.) of the hardening agent on a glass plate or like object with a putty spatula.





B1575

6. APPLY ADHESIVE

- Cut off the tip of the cartridge nozzle to make a hole 5 mm (0.20 in.) in diameter. Fill the cartridge with adhesive.
- Load the cartridge into the sealer gun.
- Coat the glass with adhesive on all contact surfaces along the ridge.

Adhesive height:

If adhesive remains on the body

3.5 – 5.0 mm (0.138 – 0.197 in.)

If no adhesive remains on the body

8 – 10 mm (0.31 – 0.39 in.)

7. INSTALL GLASS

- Position the glass so that the reference marks are lined up, and press in gently along the rim.
- Using a spatula, apply adhesive on the glass rim.
- Use a spatula to remove any excess or protruding adhesive.
- Fasten glass securely until the adhesive sets.

8. INSPECT FOR LEAKS AND REPAIR

- Perform a leak test after the hardening time has elapsed.
- Seal any leaks with auto glass sealer.
Part No. 08833-00030 or equivalent

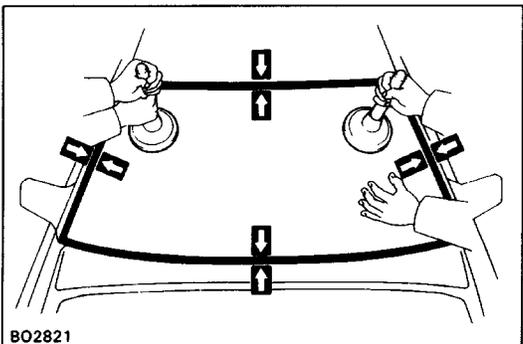
9. INSTALL CLIPS AND WINDSHIELD MOULDING

(See page [BO-13](#))

10. INSTALL FOLLOWING PARTS:

(See page [BO-18](#))

- Inner rear view mirror
- Sun visors and holders
- Front pillar garnishes
- Cowl louver
- Wiper arms



B02821