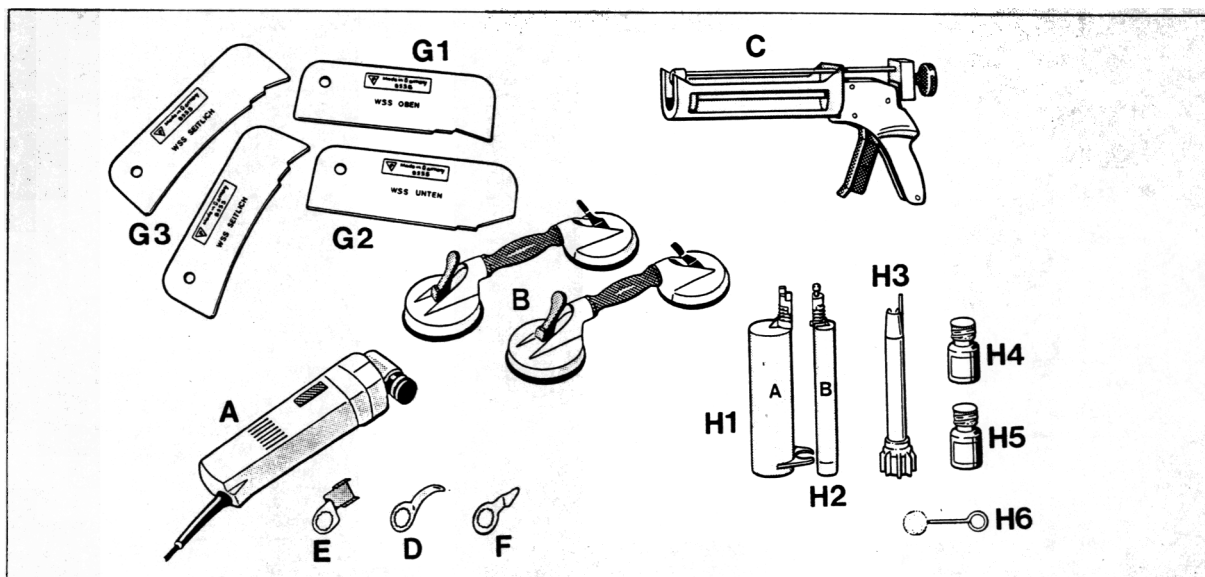


64 12 19 Removing and installing the windshield

The following tools and materials are required for removal and installation of the windshield using two-pack adhesive:



2225 - 64

A	Cutter	VAG 1561	e.g. VW Werk AG
B	Twin-cup suction puller	VAG 1344	Service equipment supply
	Bonding gun 9586	000.721.958.60	Porsche Parts Department
	Cutting knife, curved	6.39.03.164.01.9	e.g. C & E FEIN GmbH & Co.
	Flashing knife	6.39.03.113.02.2	Postfach 172
	Cutting knife, cranked	6.39.03.122.01.1	70013 Stuttgart
	Assembly template 9555	000.721.955.50	
	– G1 Roof template		
	– G2 Drip rail template		
	– G3 A-post template		
H	Adhesive set	000.043.203.42	Porsche Parts Department

Contents of adhesive set:

H 1 = Cartridge component A

H 2 = Cartridge component B

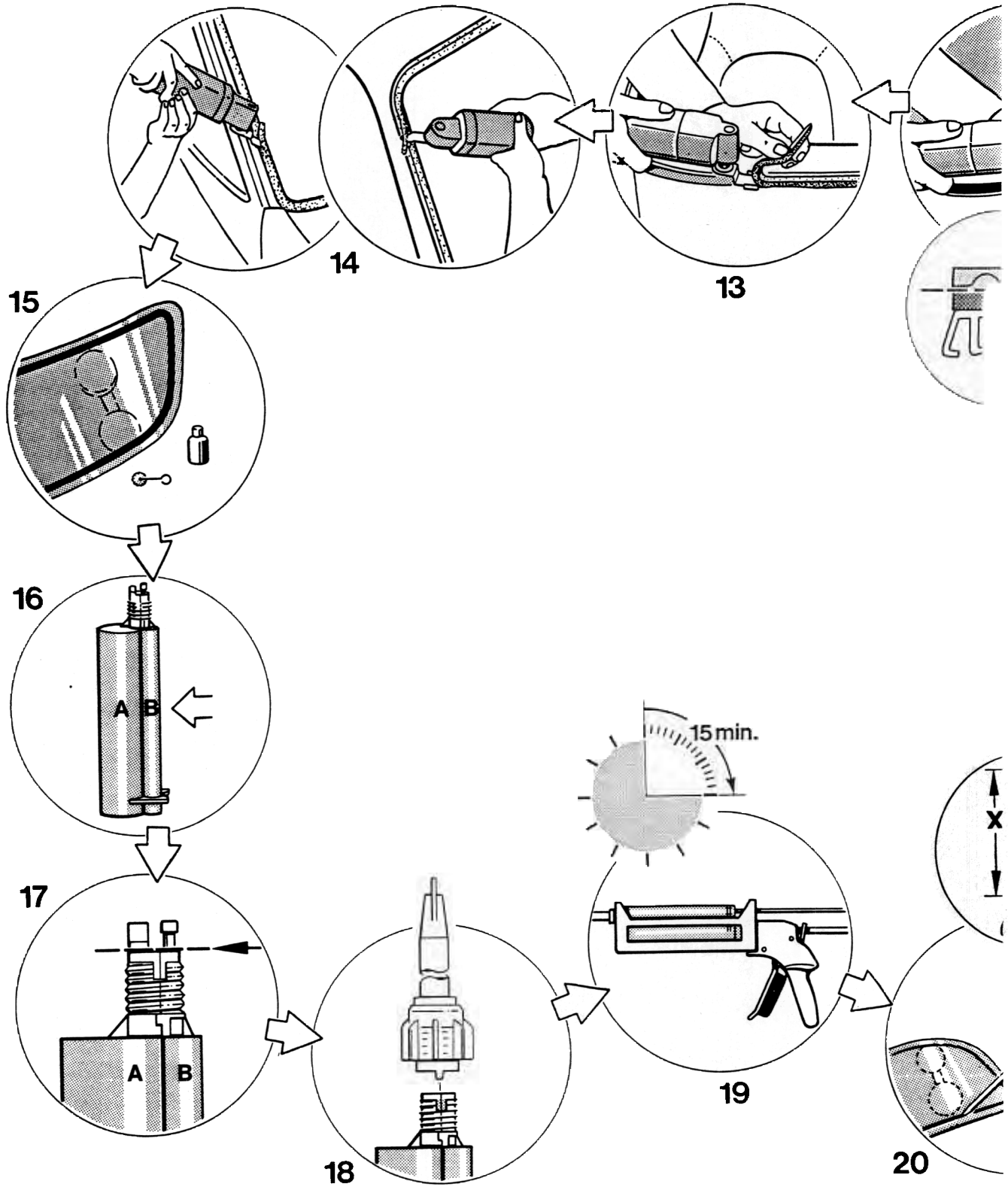
H 3 = Mixing cartridge

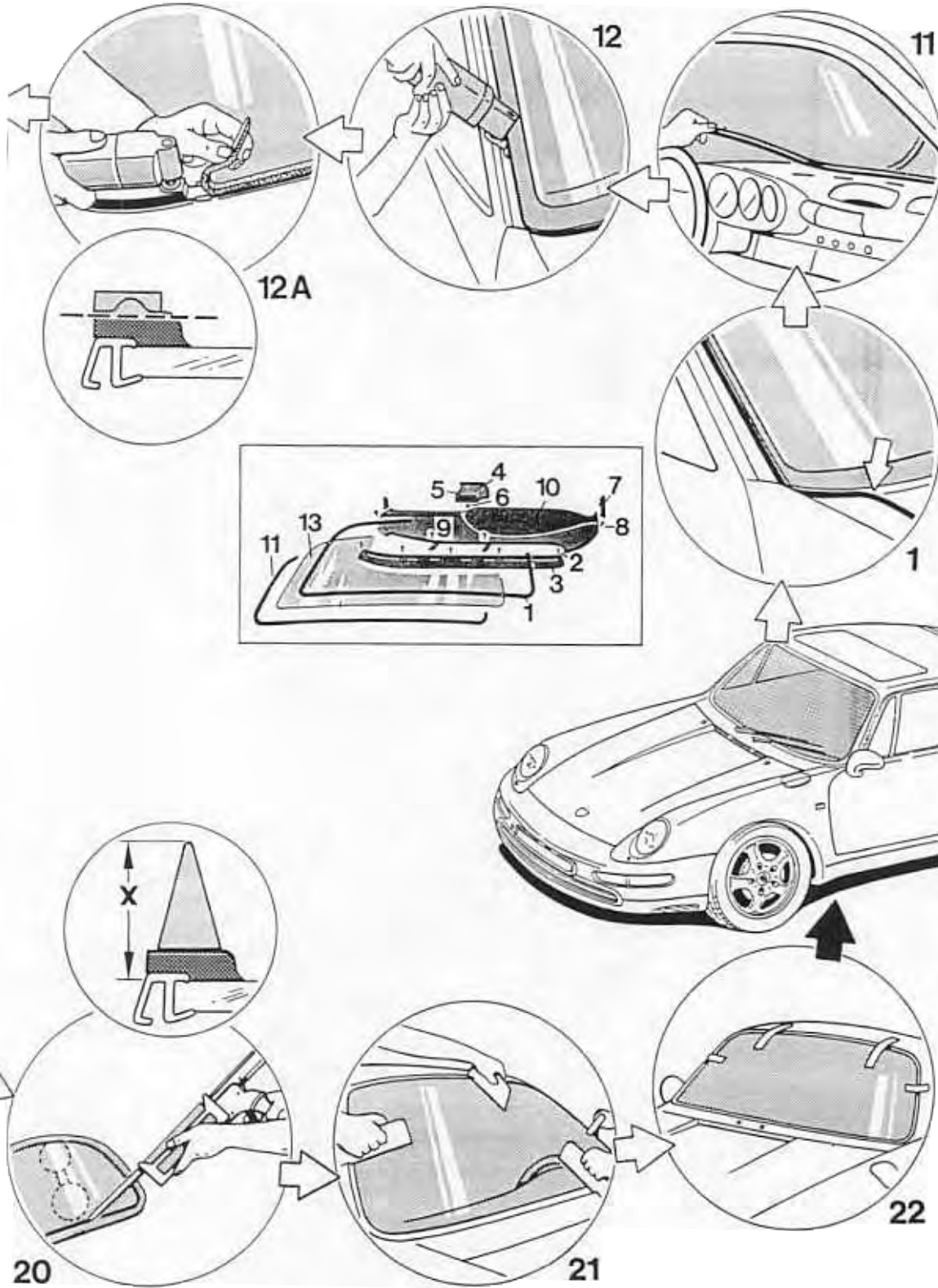
H 4 = Primer

H 5 = Activator (Solvent Cleaner)

H 6 = Cleaning solution

Removing and installing windshield





64 12 19 Removing and installing windshield

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64 12 19 Removing and installing windshield

Note: The removed windshield may be re-used if:

- there are no signs of damage on the windshield,
- the windshield was removed without damage,
- the rim profile for the cover molding is undamaged

Removing windshield

No.	Operation	Procedure
	Remove windshield wipers	Unscrew hexagon head nuts. Lift off spring washers and wipers.
1	Pull off cover molding	Detach and pull off windshield cover molding.
	Open door windows	Caution: The door windows must not be closed until the adhesive has cured completely.
2	Remove demister molding – <i>Countersunk head self-tapping screws</i>	Screw out 5 countersunk head screws and take off demister molding.
3	– <i>Demister molding</i>	
4	Remove center jet – <i>Mounting lugs</i>	Press two mounting lugs down and pull out center nozzle.
5	– <i>Center nozzle</i>	
6	Remove upper part of instrument panel – <i>Hexagon head nut</i>	Unscrew hexagon-head nut from threaded stud of center instrument panel mount on the left of the center nozzle aperture. Pull off 2 cover panels. Screw out two self-tapping screws below the cover panels. Screw 2 self-tapping screws out of upper instrument panel mount. Lift off upper instrument panel section.
7	– <i>Cover panels</i>	
8	– <i>Self-tapping screws</i>	
9	– <i>Self-tapping screws</i>	
10	– <i>Instrument panel upper section</i>	

No.	Operation	Procedure
	Pull off window antenna connector	Pull connector of window antenna off the antenna amplifier.
11	Pull off cover section	Separate cover section of windshield from spotweld flange of body and pull off cover section.
12	Cut out windshield	Insert curved knife (D) into cutter (A). Set vibration regulator to stage 5. Cut through bonding between windshield and body along the entire windshield. Take out windshield.
12A	Remove adhesive from windshield	Fit scraper (E) to cutter (A) and use scraper to remove adhesive traces from precoated adhesive strip of windshield. Remove adhesive traces in such a way that adhesive strip remains as intact as possible.
13	Remove adhesive from body	Insert flashing knife (E) into cutter (A) and use cutter to remove adhesive from body only to the extent that the remaining adhesive covers the whole area in a uniform manner.
14	Remove excess adhesive	Only if adhesive has squeezed out on the sides: Fit cranked knife (F) to cutter (A) and carefully cut off adhesive that has squeezed out along the sides so that the remaining adhesive covers the whole area in a uniform manner. Caution: Take care not to damage the paintwork!
	Clean windshield aperture of body	Clean windshield aperture in body carefully with cleaning solution (H5). Caution: Make sure no cleaning solution residue remains on the bodywork.

	Apply primer to damaged areas of bodywork	Use primer (K4) to coat damaged paintwork areas in non-visible section of windshield aperture.
15	Activate bonding section of windshield	Apply activator (H5) to bonding section of pre-coated windshield. Caution: Allow a flash-off time of at least 10 minutes!
	Insert cover section	Fit cover section of windshield from inside (passenger compartment) to spotweld flange on body.
16	Clip cartridges with components A and B together	Clip the component B cartridge to the component A cartridge
17	Open assembled cartridge	Cut the closures of the two cartridges off level using a knife
18	Install mixing tube	Push mixing tube (H3) onto the groove on the assembled cartridge and screw it into place using the unit nut.
19	Place cartridge in bonding gun	Place the assembled cartridge with mixing tube in the bonding gun.

Caution: Open time is 15 minutes!

Open time is the time available for application of the adhesive and for installing the windshield into the aperture of the body.

Installing the windshield

No.	Operation	Procedure
20	Apply adhesive to the windshield	Apply a trapezoidal bead of 2-pack adhesive to the bonding section of the windshield using the bonding gun. Dimension "x" = approx. 16 mm When applying the adhesive, be sure to apply the adhesive in an overlapping manner
	Note:	2 persons are required to insert and to adjust the windshield!
	Insert windshield into bodywork	Insert windshield into window aperture of body in such a manner that the gaps between the windshield and the A-posts are parallel and that the gap between the windshield and the cowl is 4 mm . Caution: Do not press windshield into position yet!
21	Adjust windshield using templates	Press windshield into windshield aperture of body using the roof (G1), cowl (G2) and B-post (G3) templates. Caution: Due to the consistency of the adhesive, a windshield pressed in too deeply cannot be repositioned anymore!
22	Locate windshield	Use two spacer blocks (e.g. wooden or plastic strip) – 4 mm thick – in the body cowl area to prevent the windshield from slipping down. Locate windshield in the roof and B-post areas with a strip of adhesive tape. Note: The locating and securing aids may be removed after approx. 1 hour.

No.	Operation	Procedure
	Clean visible areas	Remove adhesive that has squeezed out immediately and clean the visible areas affected using cleaning solution (K5).
	Connect windshield antenna connector to antenna amplifier	
	Refit upper instrument panel section	Instrument panel mount: 2 upper self-tapping screws, one self-tapping screw on right and left-hand each, 1 hexagon head nut in center. Place right and left-hand cover panels into position.
	Fit demister molding	Fit demister molding with 5 countersunk-head self-tapping screws.

Caution

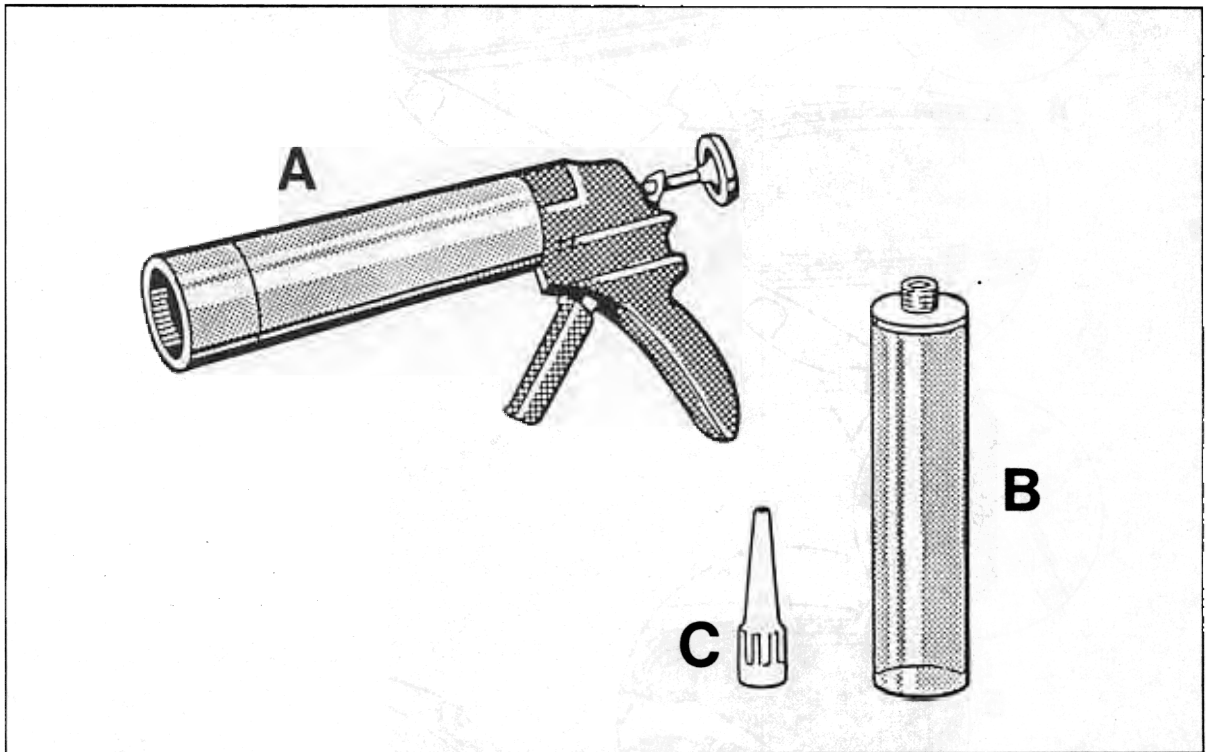
The bonding does not immediately reach its full strength. In order to ensure sufficient bonding strength, the following boundary conditions must be adhered to:

Curing time	3 hours
Temperature	min. 10° C
Fixing time	approx. 1 hour

Do not operate the vehicle before the curing time has elapsed!

64 12 51 Sealing the windshield**Insulating the gap between windshield and body**

The following tools and materials are needed for insulating the gap between the windshield and the body.

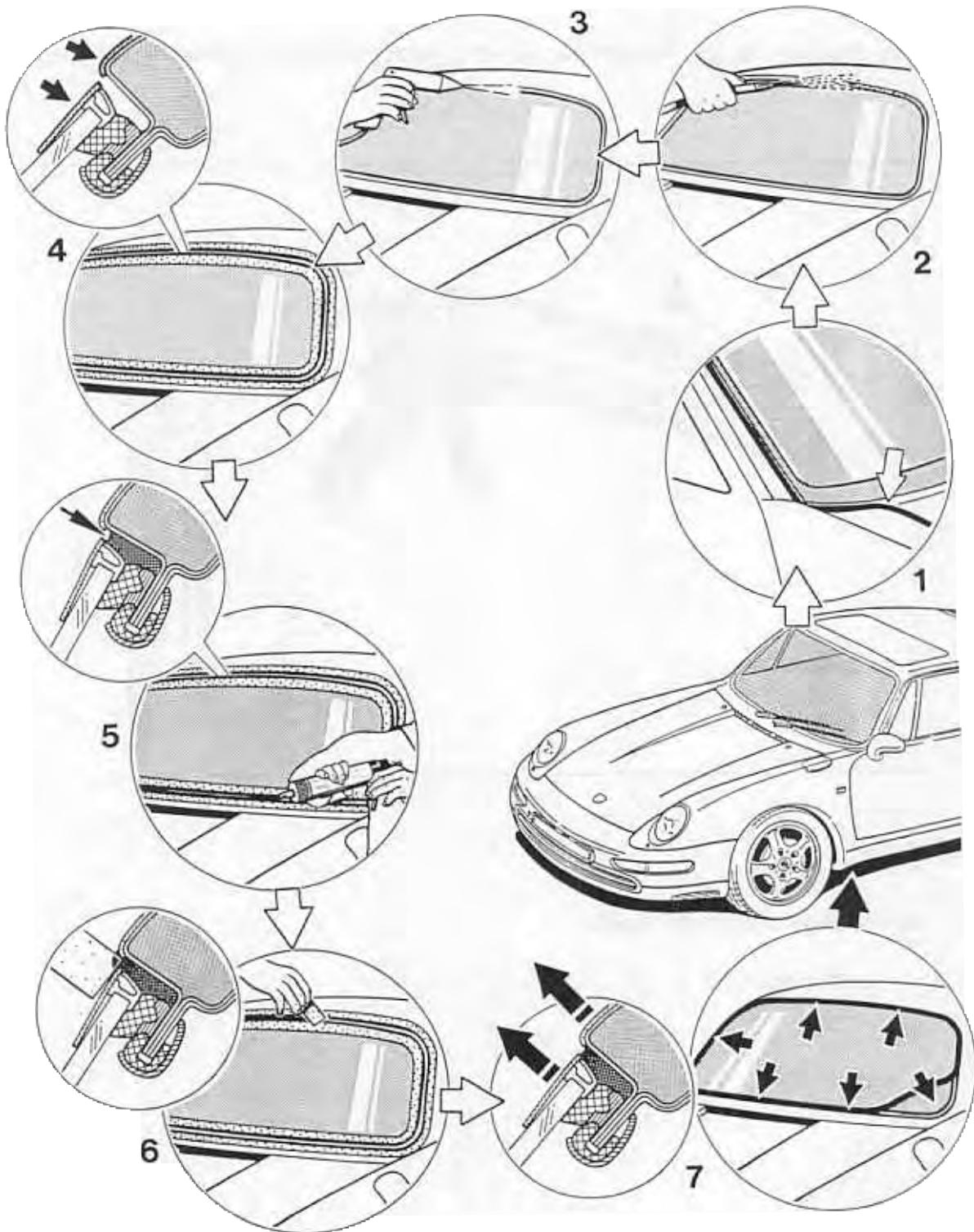


A = bonding gun

B = cartridge of insulation material

C = application nozzle

Insulating the gap between windshield and body



Insulating the gap between windshield and body

No.	Operation	Instructions
1	Remove cover strip.	Loosen and remove cover strip of windshield.
2	Clean gap between windshield and body.	Wash out the gap between windshield and body with water all round the windshield.
3	Dry gap between windshield and body.	Dry the gap between windshield and body using compressed air all around the windshield.
4	Mask off windshield and body.	Apply masking tape around the windshield, making sure that the mounting section for the cover strip is covered. Apply masking tape all round the body opening for the windshield up to the edge of the gap.
5	Apply insulating material.	Screw application nozzle (C) onto insulating material cartridge (B). Insert cartridge with nozzle into bonding gun (A). Fill the gap between the windshield (mounting section) and the body completely with insulating material.
6	Remove excess insulating material.	Strip excess insulating material above the gap between windshield and body off smoothly using a piece of cardboard.
7	Remove masking tape and instal cover strip.	Remove masking tape from windshield and body. Press windshield cover strip into mounting section.