

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.

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Product List	
3M™ White Masking Paper, 12 in. x 750 ft., PN 06538	
3M™ High Performance Welding Drape, PN 05919	
Scotch-Brite™ General Purpose Hand Pad, PN 07447	
3M™ Precision Masking Tape, 2 in. width, PN 06528	
3M™ Glass Cleaner, 19 oz. aerosol, PN 08888	
3M™ Single Step Primer, 30mL can, PN 08682	
3M™ Urethane Primer Daubers, PN 08688	
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	