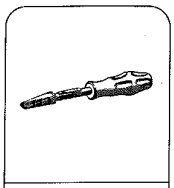
Data

Primer edge on glass: top and laterally 10 mm; below 30 mm wide
Primer edge on body flange: top and laterally across entire width of fold; below 30 mm wide.

Special tools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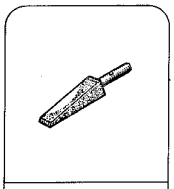
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Conventional tool

Siphon	e.g. Karl Assfalg KG Buchstr. 149 D–7070 Schwäbisch Gmünd Order No. 602-2

Note

The windshield glass is glued to body by means of Butyl tape. During removal and installation of windshield glass the tape is made plastic by heating. This is done best by electrical heating of a copper wire embedded in center of butyl tape. As an energy source, connect a transformer with 12 V output voltage or a well charged 12 V vehicle battery, which is specially used for repair jobs.

The heating time of the Butyl tape is usally approx. 15 minutes. At the end of this period the Butyl tape attains approx. 50 °C within connected range of copper wire. This temperature is adequate for safe removal of glass.

The following factors will influence the heating-up time:

1. Dia. of copper wire; 0.3, 0.4, 0.7 mm (the thicker, the shorter the heating time)
2. Age of Butyl tape (the older, the longer the heating time)
3. Temperature of glass and vehicle body (the colder, the longer the heating time)
4. Condition of glass (glass which is already damaged can be removed after a short heating up time by applying increased force).

Renewal of windshield glass requires use of repair kit for glazing, Part No. 126 670 01 93. The contents of this repair kit have been selected for use with models 107, 126 and 201.
The primer 126 670 00 93 is separately available, if required.

Contents of repair kit:

1 Butyl tape, 4200 mm long, 10 ± 0.7 mm dia.

2 Glass bottle with primer, component part A.

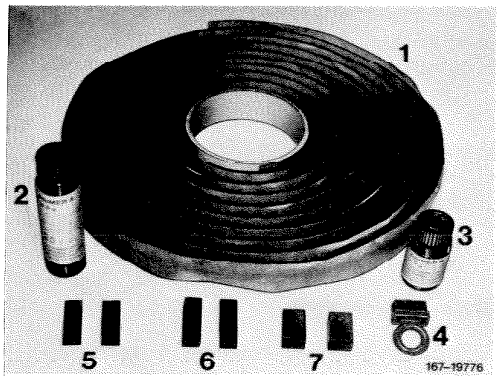
3 Glass bottle with primer, component part B.

4 Application sponge for primer.

5 Spacing pads for windshield (required on model 107 only).
Dimensions: 30 mm x 10 mm x 6 mm.

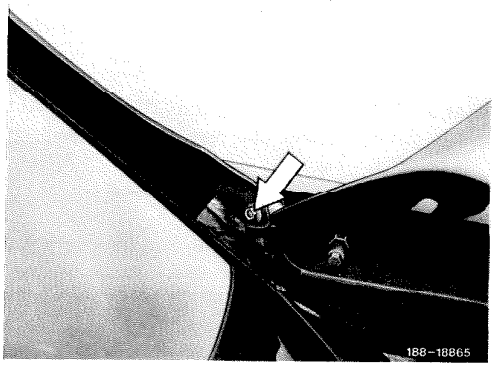
6 Spacing pads for side window glass (required on model 107 only).
Dimensions: 30 mm x 10 mm x 6 mm.

7 Spacing pads for rear window glass (required on model 107 only).
Dimensions: 20 mm x 13 mm x 10 mm.

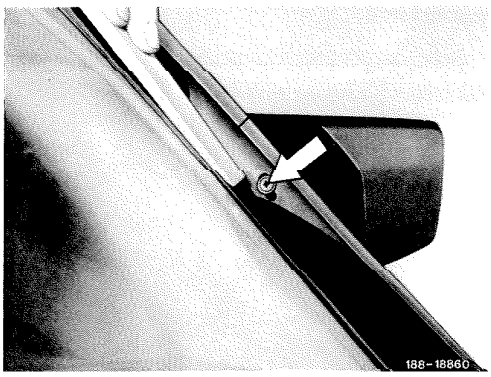


Removal

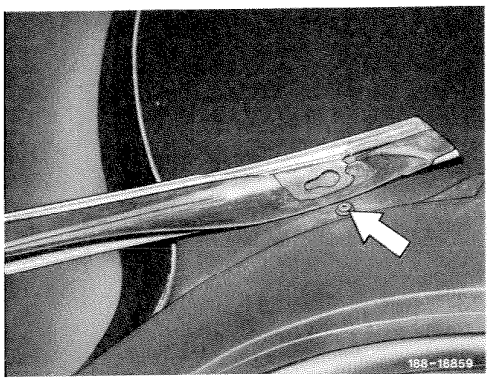
1 Unscrew screw below on lefthand ornamental molding.



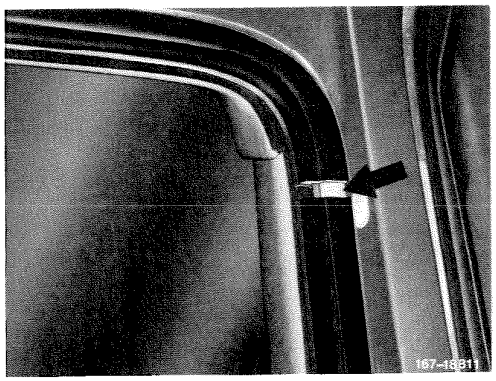
2 Push rubber lip on lefthand ornamental molding aside and unscrew the four screws underneath.



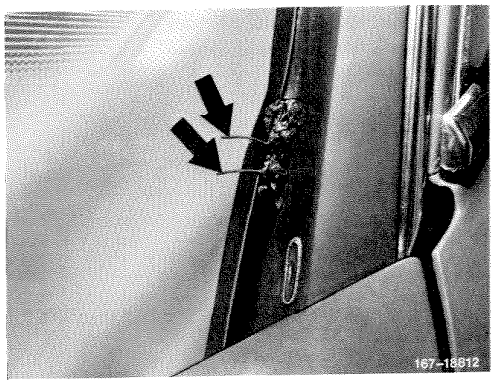
3 Pull ornamental molding on front wall pillar left forward and disconnect at roof paneling.



4 Pull-off ornamental frame on windshield at lefthand front wall pillar.



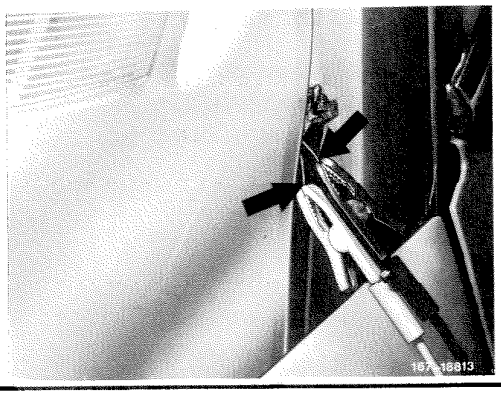
5 Expose copper wire in adhesive cord and make bright at ends with emery paper.



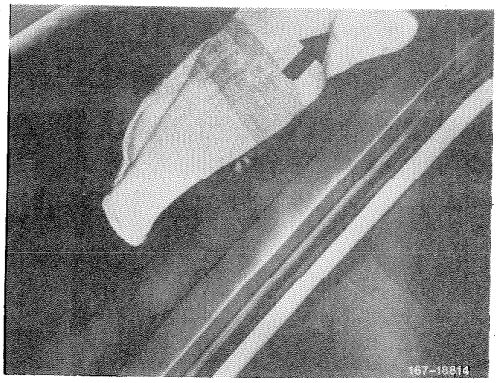
6 Connect copper wire to vehicle battery (12 V) (connection should produce a spark, only then will the current be picked up), heat copper wire for approx. 15 min. if wire dia is 0.3 mm.

7 Remove air inlet cover (83–140).

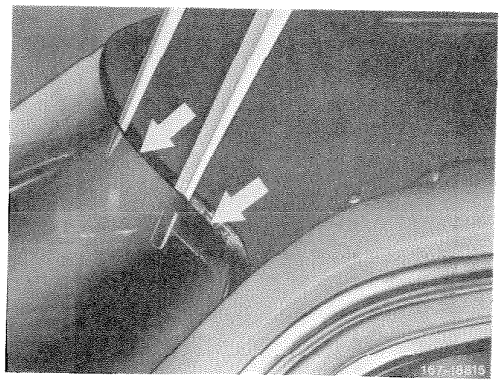
8 Completely remove ornamental frame on windshield (67–120).



9 Push glass outwards in upper range.



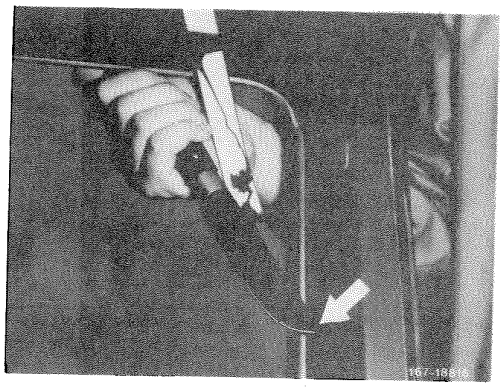
10 Insert assembly wedges into resulting gap between glass and body.



11 Carefully cut adhesive cord all around with an industrial knife, while inserting additional assembly wedges at cut spots to prevent successive glueing-down.

12 Remove windshield glass.

13 Disconnect vehicle battery.



Installation

14 Cut off remains of adhesive cord with angular blade down to a few tenths millimeters from body flange and from glass, do not damage paintwork and glass.

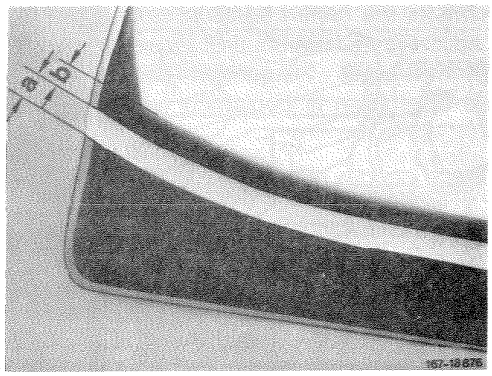
Note: The residual glueing material need not be removed.

15 Check body flange for paint damage, if any, and touch up, if required (pay attention to drying time).

16 Mix primer from repair kit. For this purpose, pour contents of small bottle with component B into large bottle with component A and shake energetically.

17 Clean glueing surfaces on body and glass, from which the adhesive material has been completely removed by mistake, or glueing surfaces on spare parts, with benzine and rub dry. Then apply primer from repair pack with a brush. Let primer air-dry for at least 5 minutes.

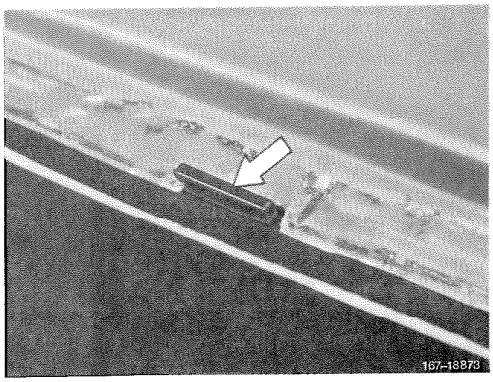
18 On a new glass pane, mark glueing surface in lower range with a felt pencil (glueing surface runs in parallel with screen printing on windshield glass).



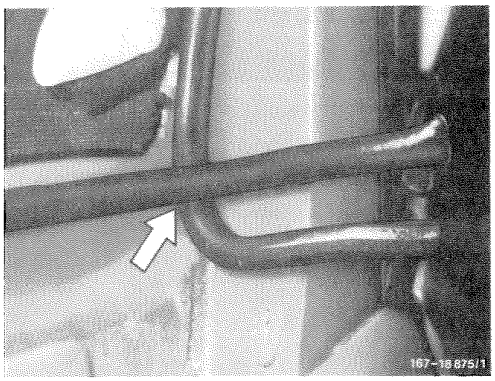
Dimensions:

a 30 mm (glueing surface)
b 30 mm (distance)

19 Check whether spacer at top left and right is in body flange.

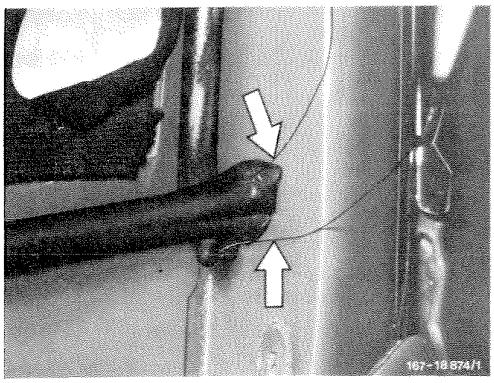


20 Position adhesive cord (butyl tape) from repair kit in center of body flange. Start at front wall pillar bottom left.

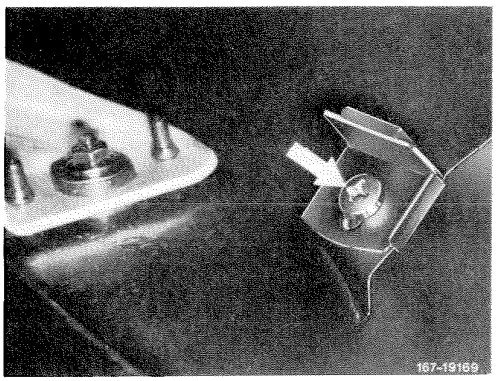


21 Expose copper wire at ends of adhesive cord an grind to a bright finish.

22 Center windshield glass and place on adhesive cord.



Note: Windshield should rest on rubber support of angle bracket. If required, loosen screw (arrow) and displace supporting bracket.



23 Connect vehicle battery (12 V) at both wire ends and heat Butyl tape. Push-in glass uniformly and mount ornamental frame. (Depth of impression is determined by respective fit of ornamental frame).

24 Disconnect vehicle battery.

25 Place wire ends of Butyl tape in-between glass and front wall pillar (do not cut off).

26 For further installation proceed vice versa.

Note: The glued assembly requires no drying time. The rain test can be made at end of assembly jobs. Leaks, if any, can be sealed with MB universal sealing compound, part no. 003 989 01 71 (tube) or 002 989 98 71 (cartridge).