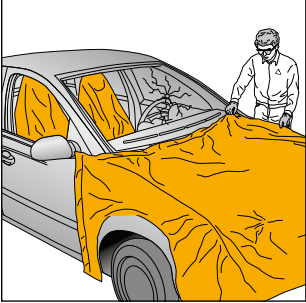


PRIMER-LESS TO GLASS (P2G) PROCESS

AUTO GLASS REPLACEMENT


INSTALLATION GUIDELINE

1



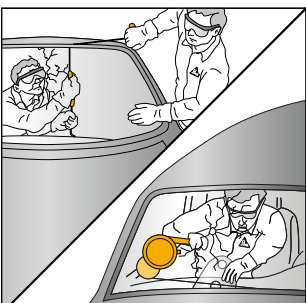
- Wear personal protective equipment
- Cover parts to be protected
- Use seat covers

2



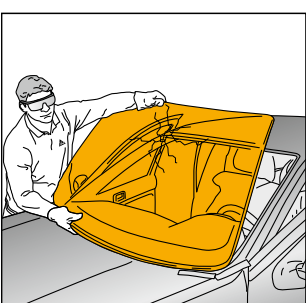
- Carefully remove all trims and accessories
- Carefully remove ADAS related sensors and cameras

3




- Cut out damaged windshield using Sika® SmartCut, electrical knife, cutting wire, cold knife etc.
- Remove dirt with a vacuum cleaner or brush

4



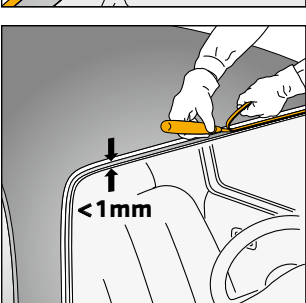
- Remove the damaged windshield

5




- Remove debris with a vacuum cleaner or brush
- Clean the entire pinch weld with Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains

6




- Trim back the remaining PUR bead and try to cause as little damage as possible
- The remaining PUR must be under 1 mm before it is safe to apply fresh adhesive

7



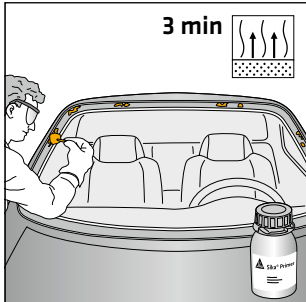
- Dry fit the windshield
- To ensure a quick and precise installation of the windshield once the adhesive is applied, add fitting marks

8



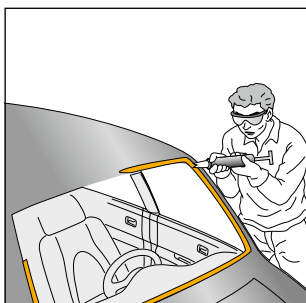
- Clean the windshield with Sika® Cleaner G+P and check for contamination
- Optional: If contaminated, scrub the bonding surface with Sika® Cleaner PCA
- Wipe the window dry with a paper towel

9



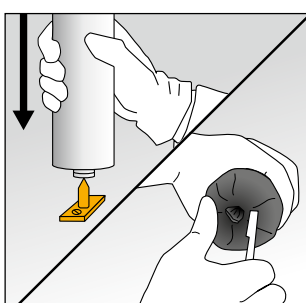
- Cover any minor damage to paint work using Sika® Primer-207
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes
- In case of larger areas, contact a paint shop or refer to the car manufacturer's specification

10



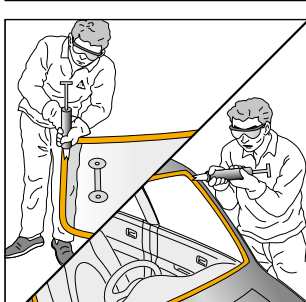
- Optional: Apply a small amount of adhesive onto the damaged area
- Spread it down to a thin coat covering the entire intact area
- Ensure that the adhesive coat overlaps onto the intact paint

11



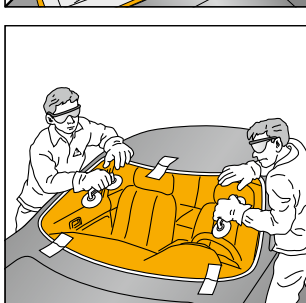
- Cartridge: open by piercing the membrane
- Unipack: open by simply slicing the end of the unipack approx. 1 cm between the clip and the shoulder. Avoid the foil weld
- PowerCure: charge the Dispenser, no need to open manually

12




- Prepare a "V" notched nozzle that has the same height as the pinch weld mounting surface and the roof of the car
- Apply a triangular bead of adhesive either to the glass or the pinch weld
- It is important that the adhesive matches both the cleaned surface on the glass and the fresh cut bead of urethane

13



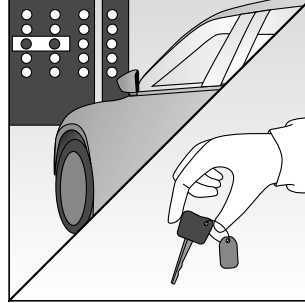
- Place the windshield in position within the open time of the adhesive
- Caution: the open time may be significantly shorter at elevated temperature

14




- Remount trim and moldings so that they fit properly, secure all cowls under the bonnet and affix wipers
- Ensure that all dismantled parts are installed correctly
- Refit and rear-view mirror and check if all ADAS related sensors and cameras work correctly

15



- Conduct and record ADAS recalibration according OEM specification
- Record all batch numbers on job card to insure full traceability
- Complete paperwork and hand back keys to customer after the minimum safe drive away time is achieved



BONDING SURFACE	SURFACE PREPARATION STEPS
Float Glass and Ceramic coated Glass ^a	●
Bare Metal Scratch < 5 cm ²	● / ▲ Optional
Bare Metal Scratch < 150 cm ²	●● / ▲ Optional
Intact OEM Paint	●
Repair Paint (after complete curing of paint) ^b	●
PVC/RIM Encapsulation, Pre-applied Adhesive System ^b	●
Fresh Cut Bead	- / ● Optional
Pre-applied OEM Primer	●

● Sika® Cleaner G+P

● Sika® Primer-207

▲ Apply a thin layer of windscreen adhesive to the affected area by slightly overlapping the intact paint

^a Windshield must be clean of dirt and dust. Potential contamination must be removed by wet scrubbing with Sika® Cleaner PCA

^b Scuff surface

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheets prior to any use.

www.sika.com/aftermarket

BUILDING TRUST

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