

## Glass – Tailgate Window (Wagon) – Renew (42 655 0)

### Proprietary Tools

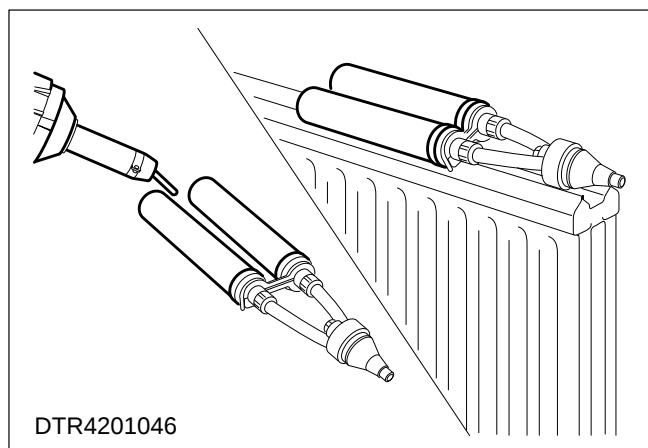
|                                        |
|----------------------------------------|
| Fein cutter blade No. 6 39 03 109 01 8 |
| Fein cutter blade No. 6 39 03 157 01 1 |
| Fein cutter blade No. 6 39 03 163 01 1 |
| Fein cutter blade No. 6 39 03 113 02 2 |

### Equipment

|                         |                  |
|-------------------------|------------------|
| Fein oscillating cutter | FDEP No. 2583391 |
| Hot air gun             | FDEP No. 1561950 |
| Mixer/applicator gun    | FDEP No. 2650730 |



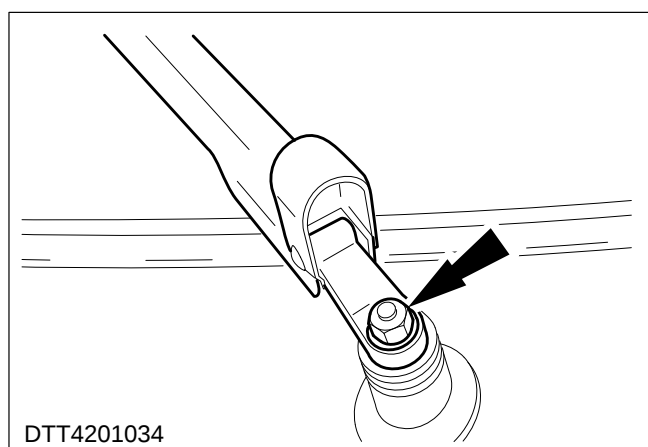
**WARNING:** Always wear gloves and eye protection when working with the glass cutting tool as the cutting operation may produce splinters. Ear defenders should be worn when using the Fein cutter.



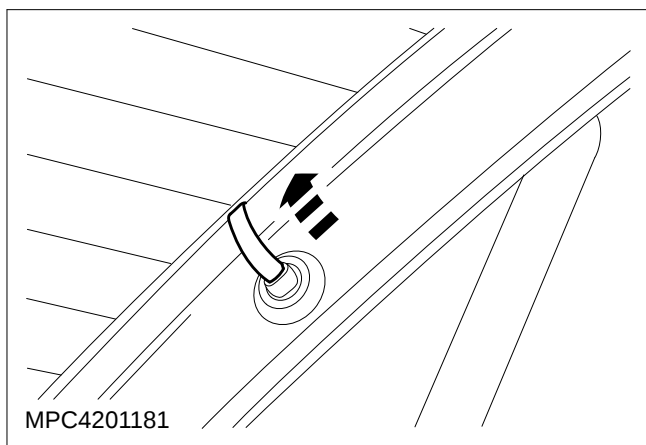
### Remove

**NOTE:** Should the ambient temperature fall below 10°C, heat the cartridges for approximately 15 minutes by placing them on a warm radiator, or by using a heat gun set at approximately 25°C.

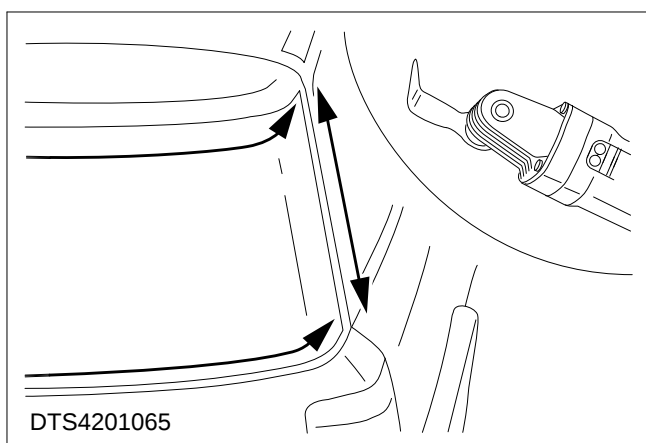
**1. Heat the adhesive if required.**



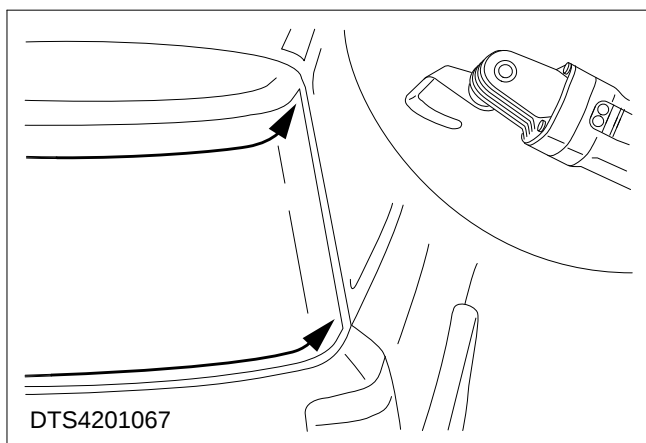
**2. Remove the rear wiper arm assembly (one nut).**



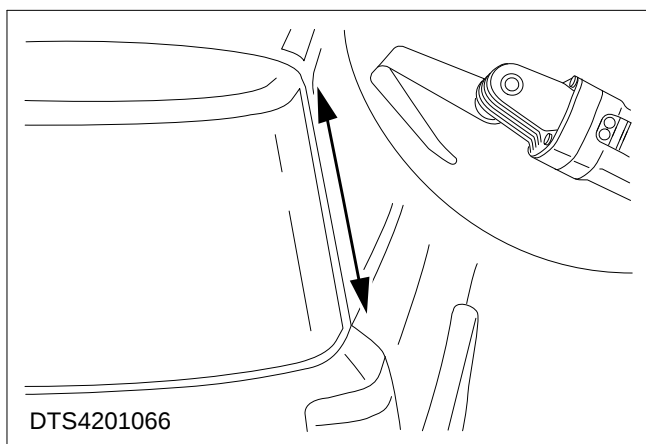
3. Disconnect the heated rear window connectors (one each side).



4. From outside the vehicle cut through the glass encapsulation using the Fein cutter fitted with blade number 6 39 03 109 01 8.

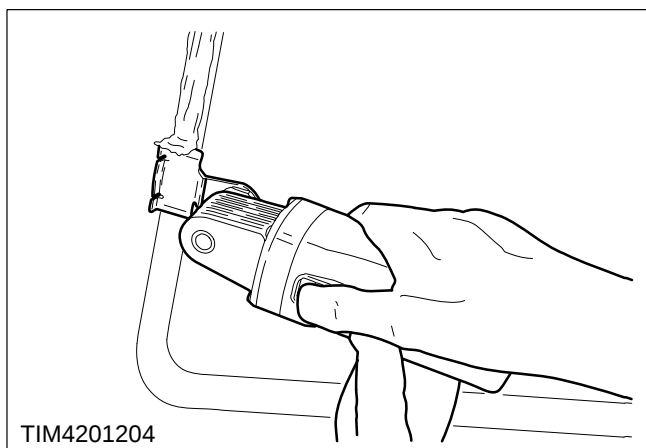


5. From outside the vehicle cut along the top and bottom edges of the tailgate glass using the Fein cutter fitted with blade number 6 39 03 163 01 1.



**NOTE:** When cutting out, the glass should be supported or held by another technician to prevent it from falling.

6. From outside the vehicle cut around the tailgate glass using the Fein cutter fitted with blade number 6 39 03 157 01 1.
7. Remove the tailgate glass.

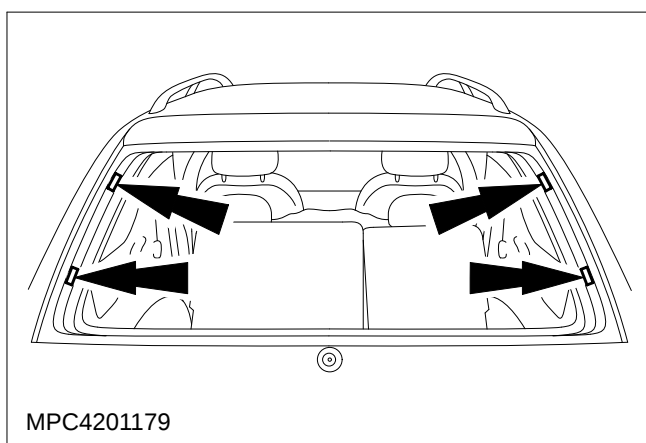


## Renew

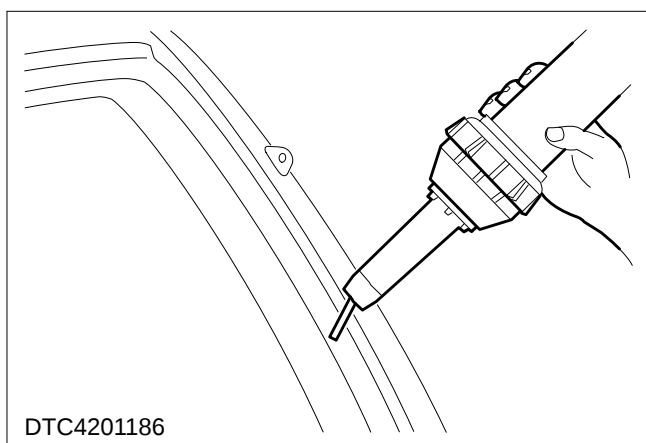
**CAUTION:** Avoid touching the trimmed surface as this will inhibit the new adhesive from bonding.

8. Remove the excess PU adhesive from the aperture using the Fein cutter fitted with blade number 6 39 03 113 02 2.

Carefully trim the remaining PU adhesive from the window aperture to leave approximately 1 mm of trimmed PU adhered to the bodywork.



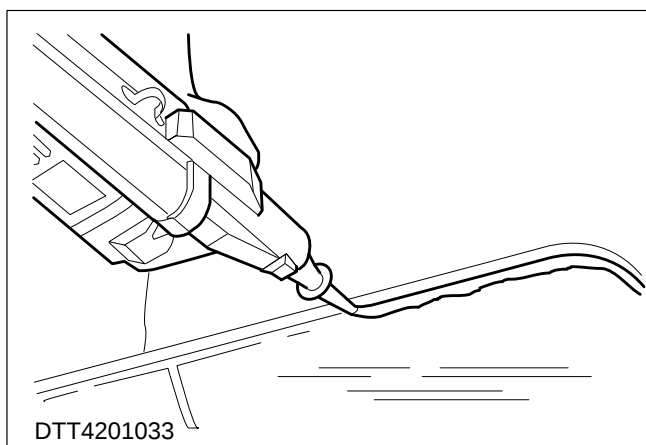
9. Fit four foam spacers to the tailgate aperture.



**WARNING:** To ensure that the PU adhesive cures, it is essential that all bonding surfaces are free of all moisture.

10. Using a heat gun, apply warm air (25 °C) to the window aperture to remove all traces of moisture.

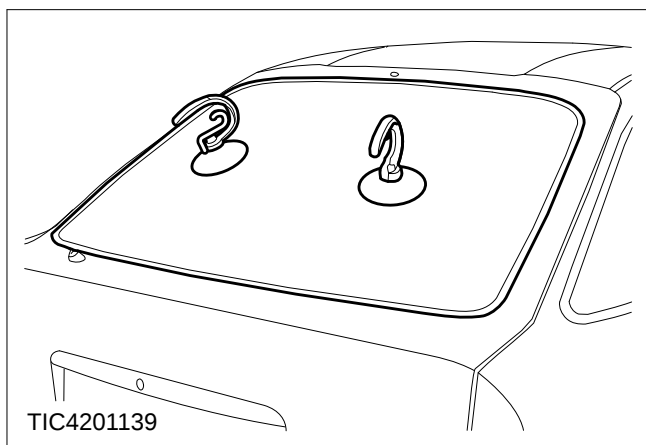
11. Prepare the glass, window aperture and trimmed PU adhesive in accordance with the instructions supplied with the adhesive kit.



**NOTE:** Discard the first 10 cm of PU adhesive as this may have a reduced working time.

**NOTE:** To avoid water leaks, any breakage in the continuous bead should be overlapped by 20 mm.

12. Apply the PU adhesive in a continuous bead of between 8 and 10 mm height to the tailgate flange along the bond line.

**13. Fit the tailgate glass.**

- With the aid of another technician, use suction pads to carefully lift the glass and align it in position over the aperture flange.
- Firmly and evenly press the glass into position.

**14. Refit the remaining components in reverse order.****15. Check for leaks and correct as necessary.**