1. Remove all decorative trims
2. Cover the aperture with masking tape
3. Cut out damaged windshield using Sika SmartCut, electrical knife, cutting wire, cold knife etc.
4. Remove damaged windshield
5. Dry fit new windshield
6. Clean the new windshield with Sika® Cleaner G+P
7. Activate the bonding surface of the glass using Sika® Aktivator PRO
8. Trim back the remaining adhesive bead to 1-2 mm
9. Clean the aperture using Sika® Cleaner G+P and activate the remaining bead with Sika® Aktivator PRO
10. Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer’s specification
11. Open the cartridge or the unipack
12. Apply a triangular bead of adhesive either to the glass or the aperture
13. Place the windshield in position within the open time of the adhesive
14. Refit trims and mouldings

**BONDING SURFACE**
- Float Glass and Ceramic coated Glass
- Bare Metal Scratch < 5 cm²
- Bare Metal 5 cm² to 150 cm²
- Intact OEM Paint
- Repair Paint (after complete curing of paint)
- PVC/RIM Encapsulation
- Fresh Cut Bead
- Pre-applied adhesive system
- Polycarbonate
- PMMA

**BLACK PRIMERLESS PROCESS**
- Sika® Primer-207
- Sika® Aktivator PRO

Windshields without ceramic coatings need proper UV protection.

a) Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® Cleaner PCA
b) Scuff surface
c) Coating must be removed prior to use, scuff surface
d) Alternatively Sika® Aktivator-309 P can be used