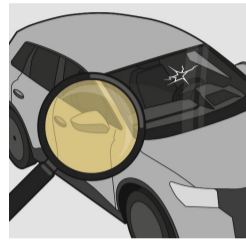


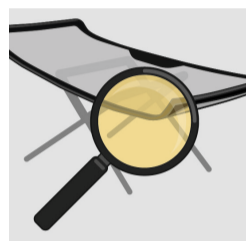
CLEAR AKTIVATOR PROCESS AUTO GLASS REPLACEMENT INSTALLATION GUIDELINE

1 INSPECT THE VEHICLE



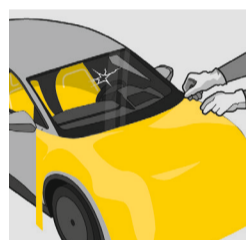
- Check the vehicle carefully before starting.
- Look for scratches, dents, or existing damage in the work area.
- Record findings to avoid later claims.

2 ALWAYS START WITH THE GLASS



- Inspect the glass before installation.
- Clean it thoroughly.
- Confirm quality and that it fits the specific vehicle.

3 PROTECT VULNERABLE AREAS OF THE VEHICLE



- Use fender, hood, and seat covers.
- Tape edges of painted surfaces to prevent scratches.
- Never place tools on paint, dashboards, or seats.

4 REMOVE TRIM, WIPERS, CAMERAS, REAR VIEW MIRRORS



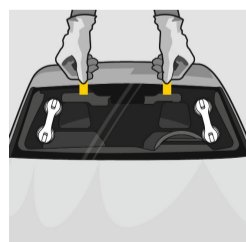
- Check vehicle-specific info before dismantling.
- Carefully remove trim, wipers, mirrors, and cameras.
- Reinstall moldings immediately after glass preparation.

5 CUT OUT THE OLD WINDSHIELD



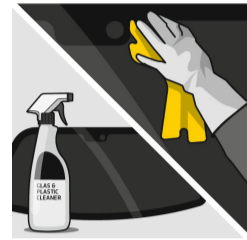
- Always wear protective equipment.
- Use Sika® SmartCut or other approved cutting tools.
- Safely lift and take out the damaged glass.
- Remove leftover debris with a brush or vacuum cleaner.

6 DRY FIT THE NEW WINDSHIELD



- Place the new glass without adhesive.
- Check fit and alignment.
- Mark reference points for quicker final installation.

7 CLEAN THE NEW WINDSHIELD



- Clean the windshield using Sika® Cleaner G+P to remove contaminants such as silicone, dust, oils, or dirt.
- If contamination is still visible, apply Sika® Cleaner G+P and scrub the bonding surface with Sika® Cleaner PCA.
- Ensure the bonding area is clean and dry before proceeding to the next step.

8 PREPARE THE NEW WINDSHIELD



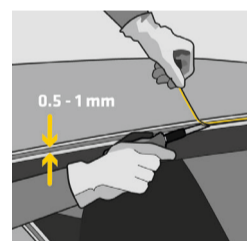
- Wet a lint free tissue with Sika® Aktivator-317
- Wipe the bonding surface of the glass in one direction
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes*

9 CLEAN THE ENTIRE PINCHWELD



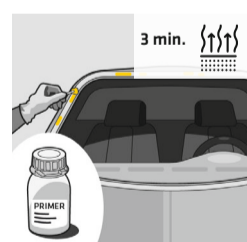
- Remove debris with vacuum cleaner or brush.
- Wipe with lint-free cloth and Sika® Cleaner G+P.
- If needed, use compressed air or Sika® Cleaner PCA for extra cleaning.
- Ensure surface is completely dry and moisture-free.

10 PREPARE THE PINCHWELD



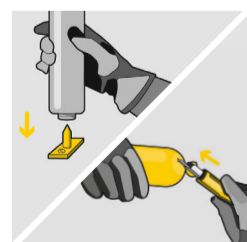
- Trim old polyurethane bead back to 0.5-1 mm.
- Avoid damaging the surface.
- Keep a smooth base for fresh adhesive.

11 BARE METAL TREATMENT



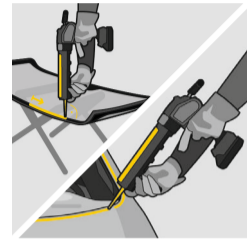
- Cover any small paint damage with Sika® Primer-507.
- Allow at least 3 minutes to flash off.
- For larger paint damage, contact a paint shop or follow OEM specifications.

12 ADHESIVE OPENING



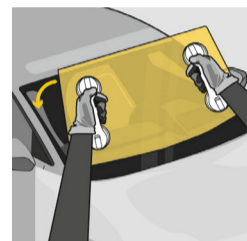
- Cartridge: pierce membrane.
- Unipack: cut approx. 1 cm from the end, opposite side of foil weld.
- PowerCure: load dispenser, no manual opening required.

13 ADHESIVE APPLICATION



- Prepare a "V"-cut nozzle matching pinchweld and roof height.
- Apply a triangular bead of adhesive to glass or pinchweld.
- Ensure adhesive contacts both primed glass and fresh cut bead.

14 INSTALL THE NEW WINDSHIELD



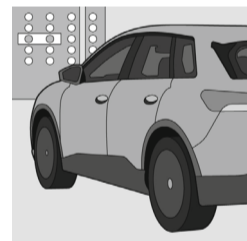
- Position glass within adhesive open time.
 - Once in contact, make only small adjustments.
- Caution:** open time is shorter in high temperatures.

15 REPLACE TRIM, WIPER, CAMERAS, SENSORS AND REAR VIEW MIRRORS



- Reinstall trim, moldings, and covers securely.
- Reattach wipers, cameras, and rear view mirrors.
- Ensure everything fits correctly.
- Verify ADAS sensors and cameras function properly.

16 RECALIBRATE



- Vehicle manufacturers require recalibration after replacement.
- Perform and record ADAS recalibration according to OEM specification.

17 CLEAN AND INSPECT



- Record adhesive and primer batch number for traceability.
- Clean the glass and surrounding area.
- Inspect work carefully to ensure correct installation.

18 RETURN TO VEHICLE OWNER



- Advise owner when it is safe to drive the vehicle.
- Base advice on MDAT of adhesive and current environmental conditions.



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

- Sika® Aktivator-317
- Sika® Primer-507 (Sika® Primer-207 can be used as an alternative)

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

^b If the bead was trimmed down more than 8 hours, or more than 2 hours in direct sunlight, it must be primed.

^c Scuff surface

^d Anti Scratch Coating must be removed prior to use, scuff surface, (only for temporary glazing, UV-protection required)

* Flash off time: 10 min. below -5°C

Note: Sika® Aktivator-317 is NEVER to be applied with a brush or a dauber

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