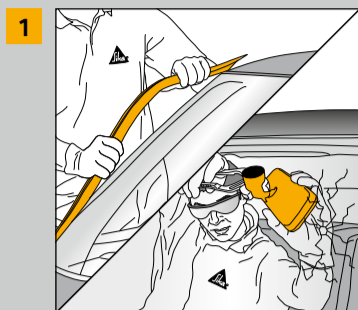


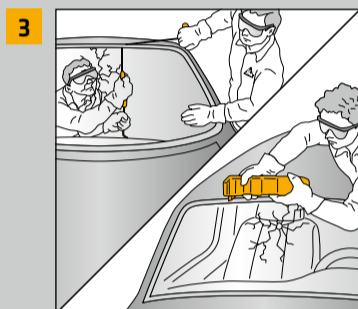
# ALL BLACK PROCESS AUTO GLASS REPLACEMENT



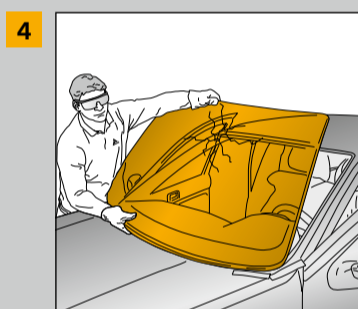
- Remove all decorative trims



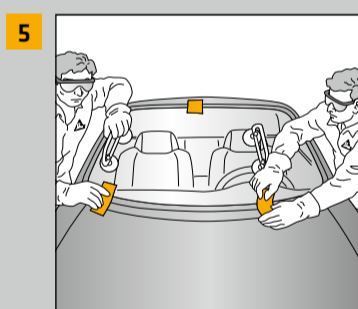
- Cover the aperture with masking tape



- Cut out damaged windshield using Sika SmartCut, electrical knife, cutting wire, cold knife etc.



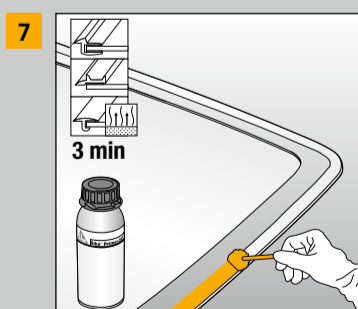
- Remove damaged windshield



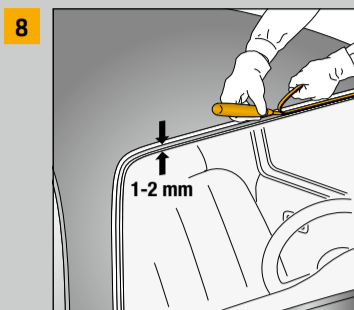
- Dry fit new windshield



- Clean the new windshield with Sika® Cleaner G+P



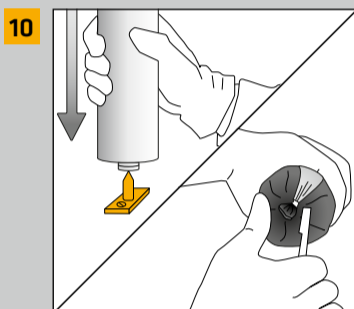
- Prime the bonding surface of the glass using Sika® Primer-207



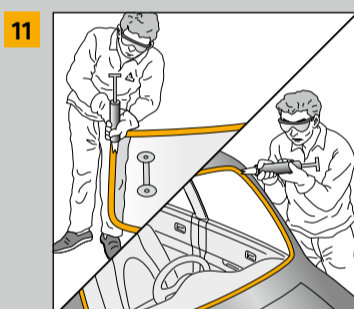
- Trim back the remaining adhesive bead to 1-2 mm



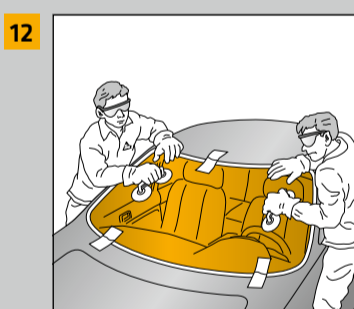
- Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification



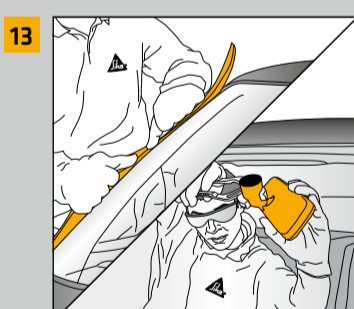
- Open the cartridge or the unipack



- Apply a triangular bead of adhesive either to the glass or the aperture



- Place the windshield in position within the open time of the adhesive



- Refit trims and mouldings



## BONDING SURFACE

Float Glass and Ceramic coated Glass <sup>a</sup>	●
Bare Metal Scratch < 5 cm <sup>2</sup>	●
Bare Metal 5 cm <sup>2</sup> to 150 cm <sup>2</sup>	●●
Intact OEM Paint <sup>d</sup>	●
Repair Paint (after complete curing of paint) <sup>b, d</sup>	●
PVC/RIM Encapsulation <sup>b</sup>	●
Fresh Cut Bead <sup>d</sup>	Optional / ●
Pre-applied adhesive system <sup>b</sup>	Optional / ●
Polycarbonate <sup>c</sup>	●
PMMA <sup>c</sup>	●

● = Sika® Primer-207

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

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

[www.sika.com/aftermarket](http://www.sika.com/aftermarket)

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