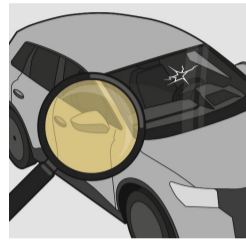


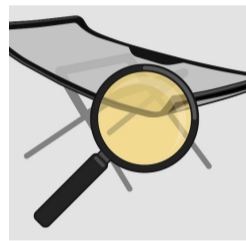
# ALL BLACK PRIMER PROCESS AUTO GLASS REPLACEMENT INSTALLATION GUIDELINE

## 1 INSPECT THE VEHICLE



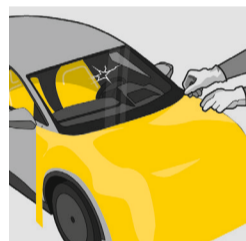
- Check the vehicle carefully before starting.
- Look for scratches, dents, or existing damage in the work area.
- Record findings to avoid later claims.

## 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



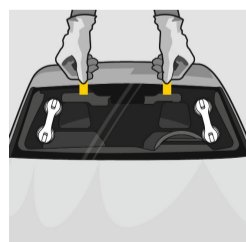
- Check vehicle-specific info before dismantling.
- Carefully remove trim, wipers, mirrors, and cameras.
- Reinstall moldings immediately after glass preparation.

## 5 CUT OUT THE OLD WINDSHIELD



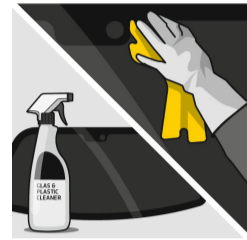
- Always wear protective equipment.
- Use Sika® SmartCut or other approved cutting tools.
- Safely lift and take out the damaged glass.
- Remove leftover debris with a brush or vacuum cleaner.

## 6 DRY FIT THE NEW WINDSHIELD



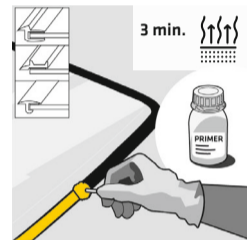
- Place the new glass without adhesive.
- Check fit and alignment.
- Mark reference points for quicker final installation.

## 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



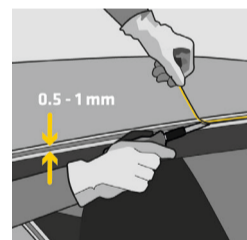
- Apply Sika® Primer-507 using a Sika® Cleaner PCA or dauber.
- Close the primer can tightly and let it flash off for at least 3 minutes.\*

## 9 CLEAN THE ENTIRE PINCHWELD



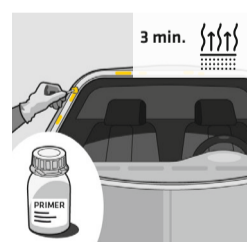
- Remove debris with vacuum cleaner or brush.
- Wipe with lint-free cloth and Sika® Cleaner G+P.
- If needed, use compressed air or Sika® Cleaner PCA for extra cleaning.
- Ensure surface is completely dry and moisture-free.

## 10 PREPARE THE PINCHWELD



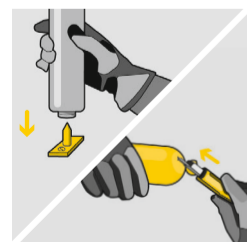
- Trim old polyurethane bead back to 0.5-1 mm.
- Avoid damaging the surface.
- Keep a smooth base for fresh adhesive.

## 11 BARE METAL TREATMENT



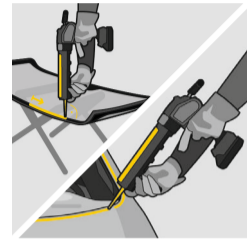
- Cover any small paint damage with Sika® Primer-507.
- Allow at least 3 minutes to flash off.
- For larger paint damage, contact a paint shop or follow OEM specifications.

## 12 ADHESIVE OPENING



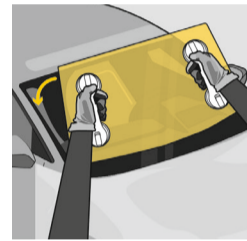
- Cartridge: pierce membrane.
- Unipack: cut approx. 1 cm from the end, opposite side of foil weld.
- PowerCure: load dispenser, no manual opening required.

## 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



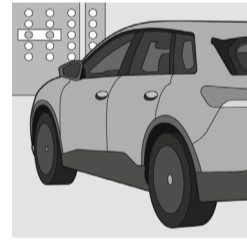
- Position glass within adhesive open time.
  - Once in contact, make only small adjustments.
- Caution:** open time is shorter in high temperatures.

## 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 <sup>a</sup>	●
Pre-applied OEM Primer	●
Fresh Cut Bead <sup>b</sup>	-
Bare Metal Scratch < 5 cm <sup>2</sup>	●
Bare Metal Scratch < 150 cm <sup>2</sup>	●●
Intact OEM Paint	●
Repair Paint (after complete curing of paint) <sup>c</sup>	●
PC / PMMA glass <sup>d</sup>	●
PVC/RIM Encapsulation, Pre-applied Adhesive System <sup>e</sup>	●

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

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

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

<sup>c</sup> Scuff surface

<sup>d</sup> 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

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