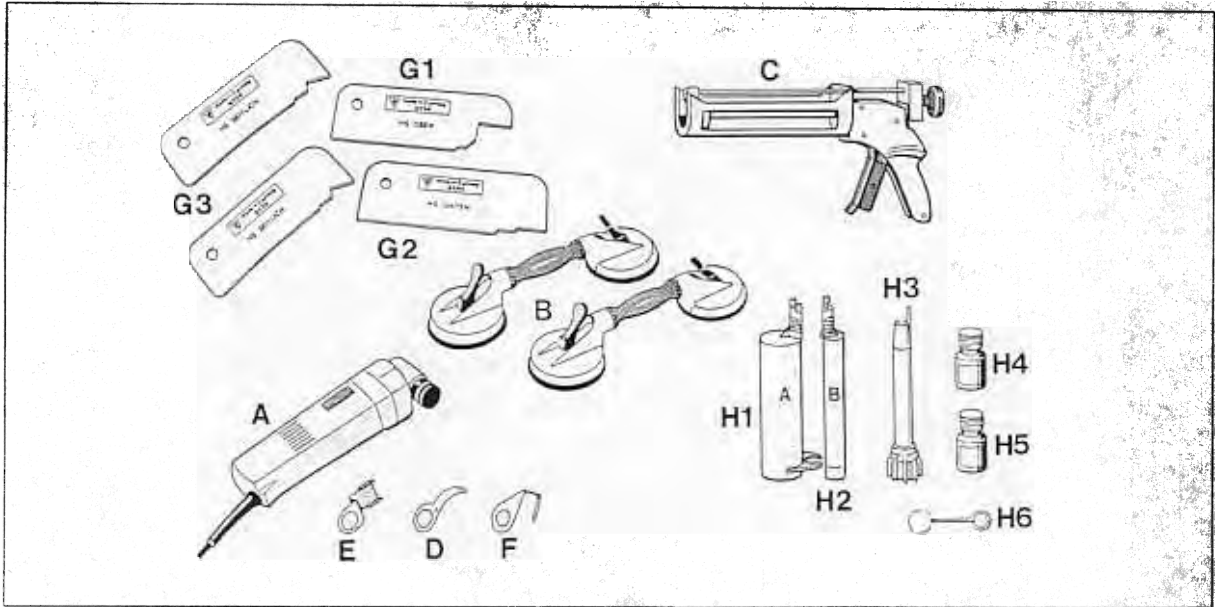


64 86 19 Removing and installing rear window

The following tools and materials are required for removal and installation of the rear window using 2-pack adhesive:



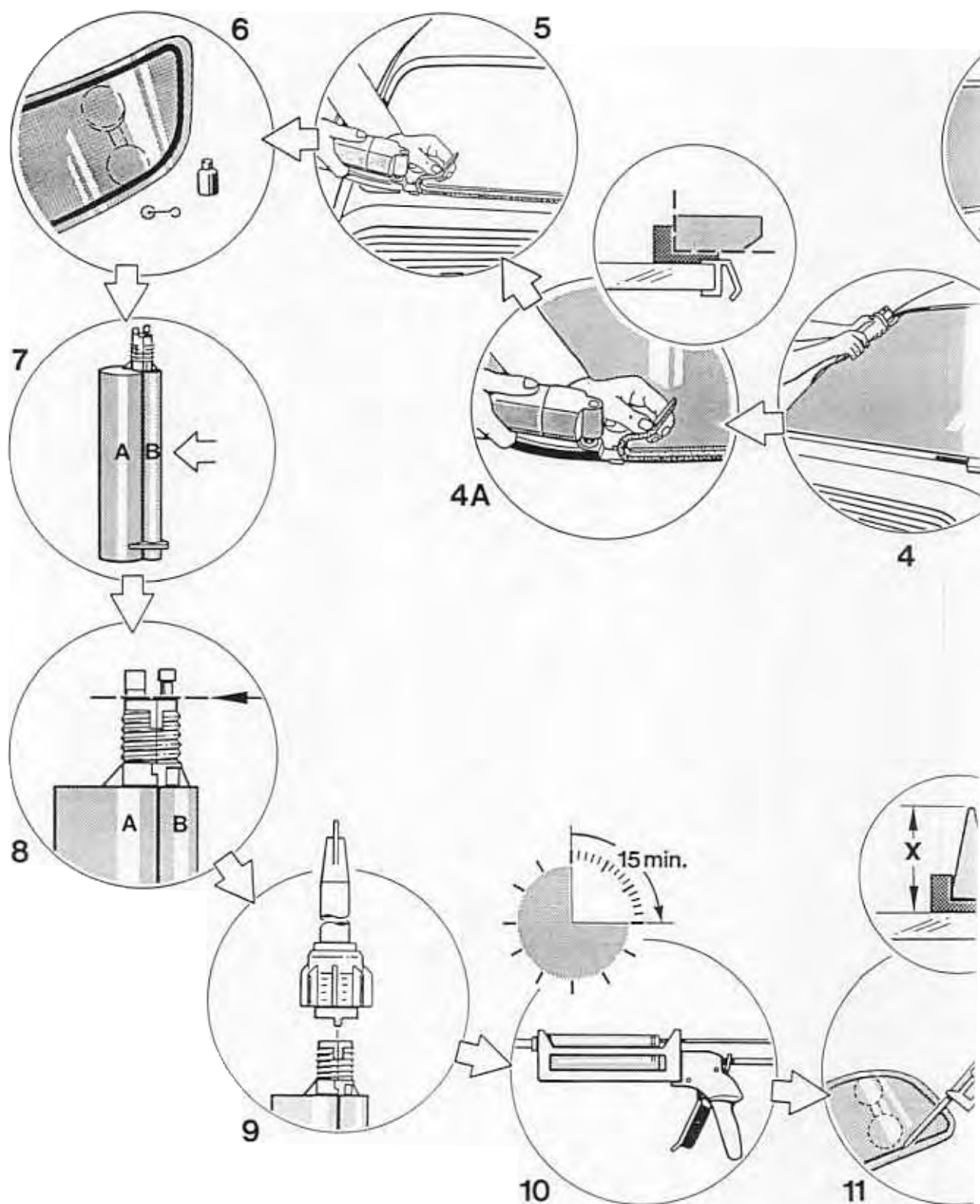
A	Cutter	VAG 1561	e.g. VW Werk AG
B	Twin-cup suction puller	VAG 1344	Service equipment supply
C	Bonding gun 9586	000.721.958.60	Porsche Parts Department
D	Cutting knife, curved	6.39.03.164.01.9	e.g. C & E FEIN GmbH & Co.
E	Flashing knife	6.39.03.113.02.2	Postfach 172
F	Cutting knife, U-shape	6.39.03.118.01.3	70013 Stuttgart 1
G	Installation template 9555 – G1 Roof template – G2 Center section templ. – G3 C-post template	000.721.955.60	Porsche Parts Department
H	Adhesive set	000.043.203.42	

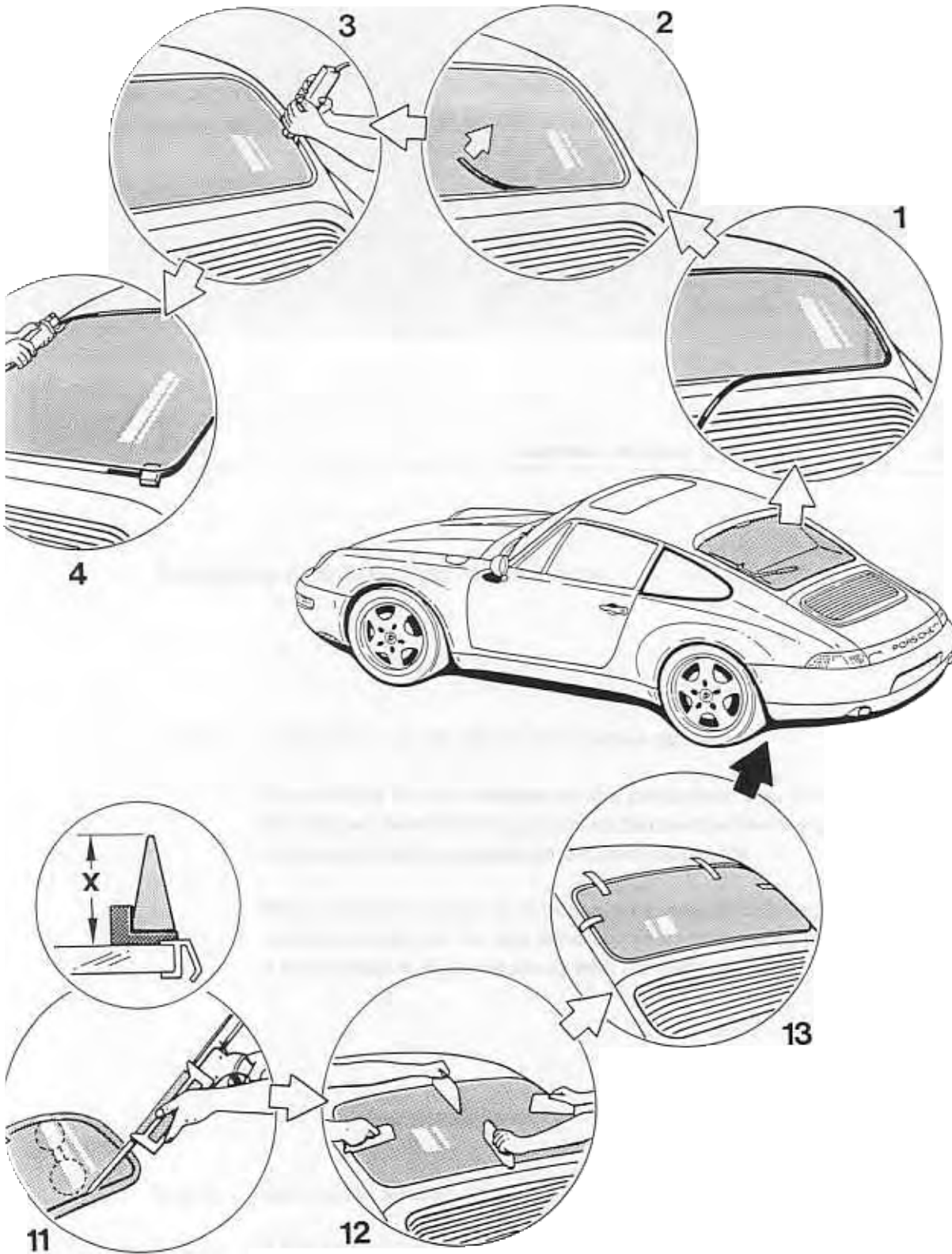
Contents of adhesive set:

H 1 = Cartridge component A
H 2 = Cartridge component B
H 3 = Mixing cartridge

H 4 = Primer
H 5 = Activator (Solvent Cleaner)
H 6 = Cleaning solution

Removing and installing rear window





Removing and installing rear window

Note: The removed rear window may be re-used if:

- there are no signs of damage on the rear window,
- the rear window was removed without damage,
- the rim profile for the cover molding is undamaged.

Removing rear window

No.	Operation	Procedure
	Remove rear window wiper	Flip up cover cap, unscrew hexagon head screw, lift off spring washer and upper wiper arm. Pull off cover grommet, unscrew hexagon head nut, lift off spring washer and lower wiper arm.
1	Pull off cover molding	Detach and pull off rear window cover molding.
	Attach adhesive tape to body	Mask off upper roof section of rear window aperture with masking tape to protect the paintwork.
	Open door windows	Caution: The door windows must not be closed until the adhesive has cured completely.
	Remove rear wall trim	Fold rear seat backs forward. Unscrew 4 self-tapping screws from rear wall trim and push rear wall trim upwards out of its support.
	Pull off rear window heater connector	Pull connector of rear window heater off the rear window.

No.	Operation	Procedure
2	Pull off cover section	Pull cover section of rear window off the body spotweld flange.
3	Cut rear window out of center section and C-post areas	Fit curved knife (D) to cutter (A). Set vibration regulator to stage 5. Cut through bonding between body and rear window in the center section and C-post areas.
	Lift up rear window in center section	Lift up rear window in center section / C-post areas by approx. 3 cm and support window, e.g. with wooden blocks.
4	Cut out rear window in roof area	Fit U-shaped knife (F) to cutter (A). Set vibration counter to stage 6. Cut through bond between body and rear window in roof section. Lift out rear window.
4A	Remove adhesive from rear window	Fit scraper (E) to cutter (A) and use scraper to remove adhesive traces from precoated adhesive strip of rear window. Remove adhesive traces in such a way that adhesive strip remains as intact as possible.
5	Remove adhesive from body	Fit flashing knife (E) to cutter (A) and remove adhesive only to the extent that the remaining adhesive covers the whole area in a uniform manner.
	Clean window aperture of body	Clean window aperture of body thoroughly using cleaning solution (H5) . Caution: Make sure no cleaning solution residue remains on the body.
	Apply primer to damaged areas of bodywork	Apply primer (H4) to to damaged of paintwork areas in non-visible section of window aperture.

No.	Operation	Procedure
6	Activate bonding section of rear window	Apply activator to bonding section of pre-coated rear window (H5). Caution: Allow a flash-off time of at least 10 minutes!
	Place cover section into position	Attach cover section of rear window from inside (passenger compartment) to the body spotweld flange.
7	Clip cartridges with components A and B together	Clip the component B cartridge to the component A cartridge
8	Open assembled cartridge	Cut the closures of the two cartridges off level using a knife
9	Install mixing tube	Push mixing tube (H3) onto the groove on the assembled cartridge and screw it into place using the unit nut.
10	Place cartridge in bonding gun	Place the assembled cartridge with mixing tube in the bonding gun.

Caution: Open time is 15 minutes!

Open time is the time available for application of the adhesive and for installing the windshield into the aperture of the body.

Installing the rear window

No.	Operation	Procedure
	Apply adhesive to the rear window	Apply a trapezoidal bead of 2-pack adhesive to the rear window using the bonding gun. Dimension "X" = approx. 18 mm When applying the adhesive, make sure it is applied in an overlapping manner.
	Note:	2 persons are required to insert and adjust the rear window!
	Insert rear window into body	Install rear window into window aperture of body in such a manner that the gap between the rear window and the C-post is parallel and that a gap of 6 mm remains between the rear window and the body center section. Caution: Do not press rear window into place yet!
22	Adjust rear window with templates	Press rear window into body window aperture according to contours of roof (G1), center section (G2) and C-post (G3) templates. Caution: Due to the consistency of the adhesive, the position of the rear window cannot be corrected if it has been pressed in too deeply!
23	Locate rear window	Use 2 spacer blocks (e.g. wooden or plastic strips) – 6 mm thick – in the center body area to prevent the rear window from shifting down. Apply adhesive tape to locate rear window in roof and C-post areas. Note: The locating and protecting aids may be removed after approx. 1 hour.

No.	Operation	Procedure
	Clean visible areas	Remove adhesive that has squeezed out immediately and clean the visible areas affected using cleaning solution (K5).
	Refit connector of rear window heater	Refit connector for rear window heater and route wire according to windshield contours.
	Fit rear wall trim	Push rear wall trim into support from above and screw into place with 4 self-tapping screws. The self-tapping screws must be fitted with washers to protect the cloth.

Caution

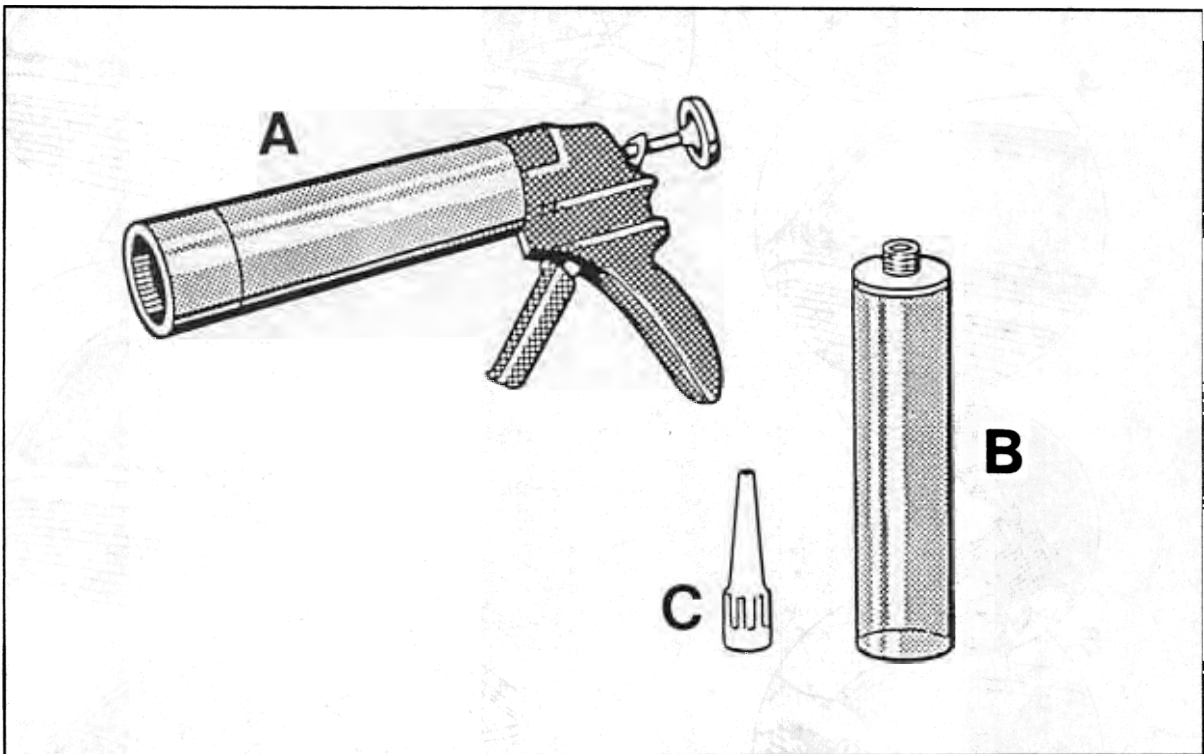
The bonding does not immediately reach its full strength. In order to ensure sufficient bonding strength, the following boundary conditions must be met:

Curing time	3 hours
Temperature	min. 10° C
Fixing time	approx. 1 hour

Do not operate the vehicle before the curing time has elapsed!

64 86 51 Sealing the rear window**Insulating the gap between rear window and body**

The following tools and materials are needed for insulating the gap between the rear window and the body.

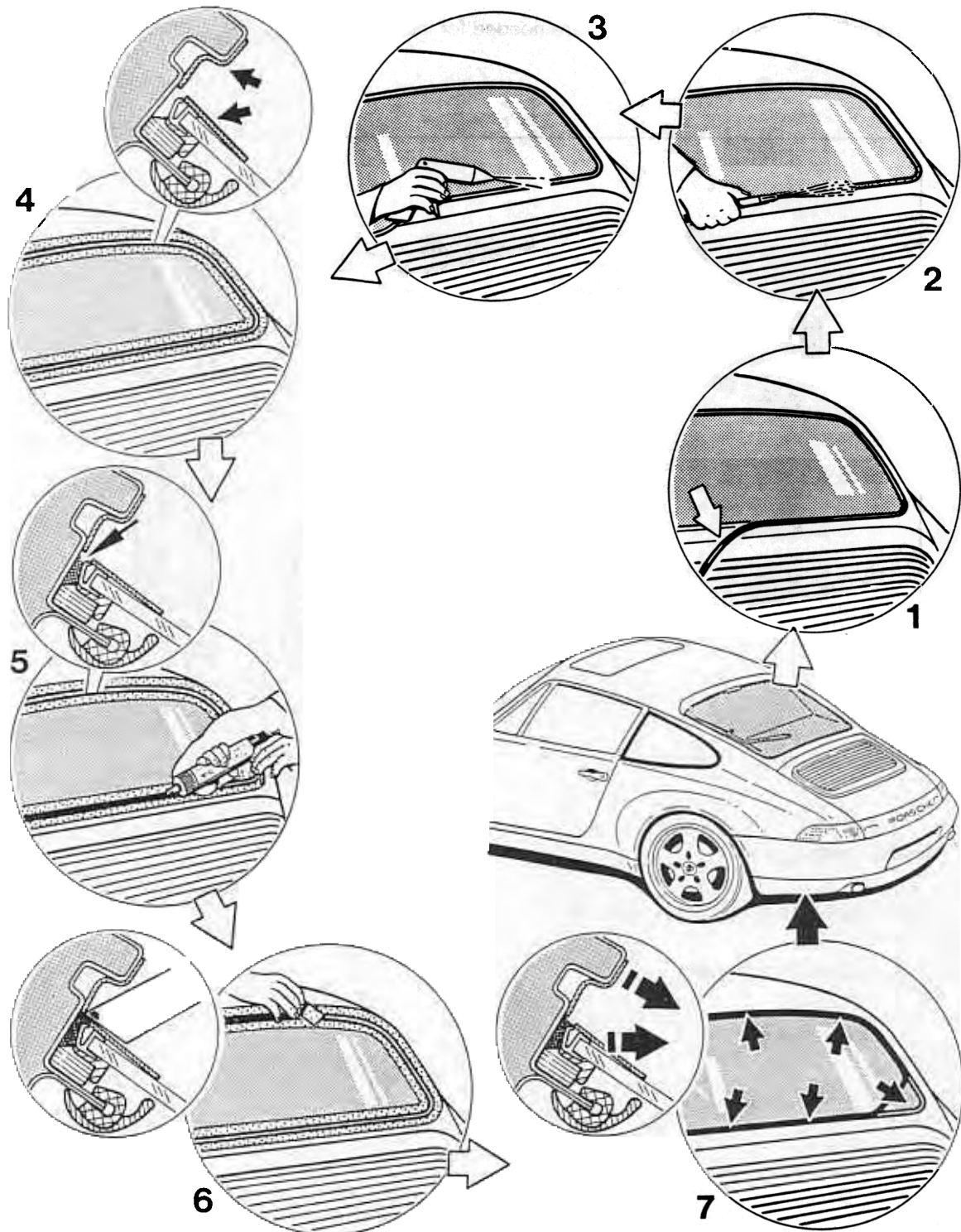


A = bonding gun

B = cartridge of insulation material

C = application nozzle

Insulating the gap between rear window and body



Insulating the gap between rear window and body

No.	Operation	Instructions
	Remove cover strip.	Loosen and remove cover strip of rear window.
2	Clean gap between rear window and body.	Wash out the gap between rear window and body with water all round the rear window.
3	Dry gap between rear window and body.	Dry the gap between rear window and body using compressed air all around the rear window.
4	Mask off rear window and body.	Apply masking tape around the rear window, making sure that the mounting section for the cover strip is covered. Apply masking tape all round the body opening for the rear window up to the edge of the gap.
5	Apply insulating material.	Screw application nozzle (C) onto insulating material cartridge (B). Insert cartridge with nozzle into bonding gun (A). Fill the gap between the rear window (mounting section) and the body completely with insulating material.
6	Remove excess insulating material.	Strip excess insulating material above the gap between rear window and body off smoothly using a piece of cardboard.
7	Remove masking tape and instal cover strip.	Remove masking tape from rear window and body. Press rear window cover strip into mounting section.