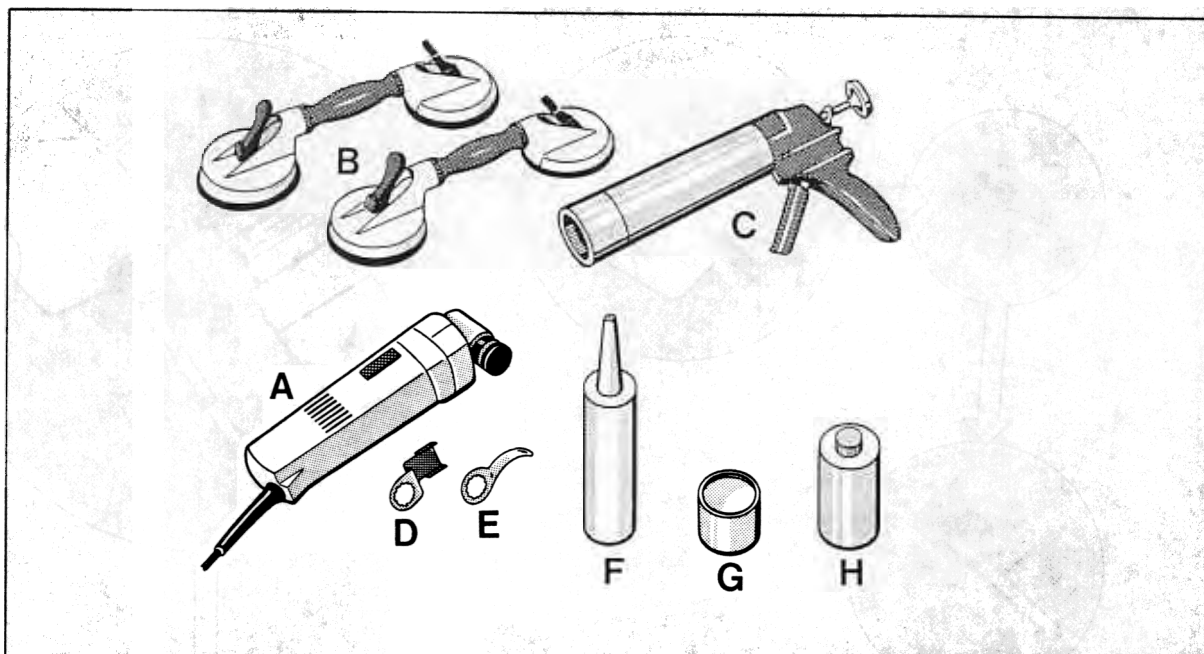


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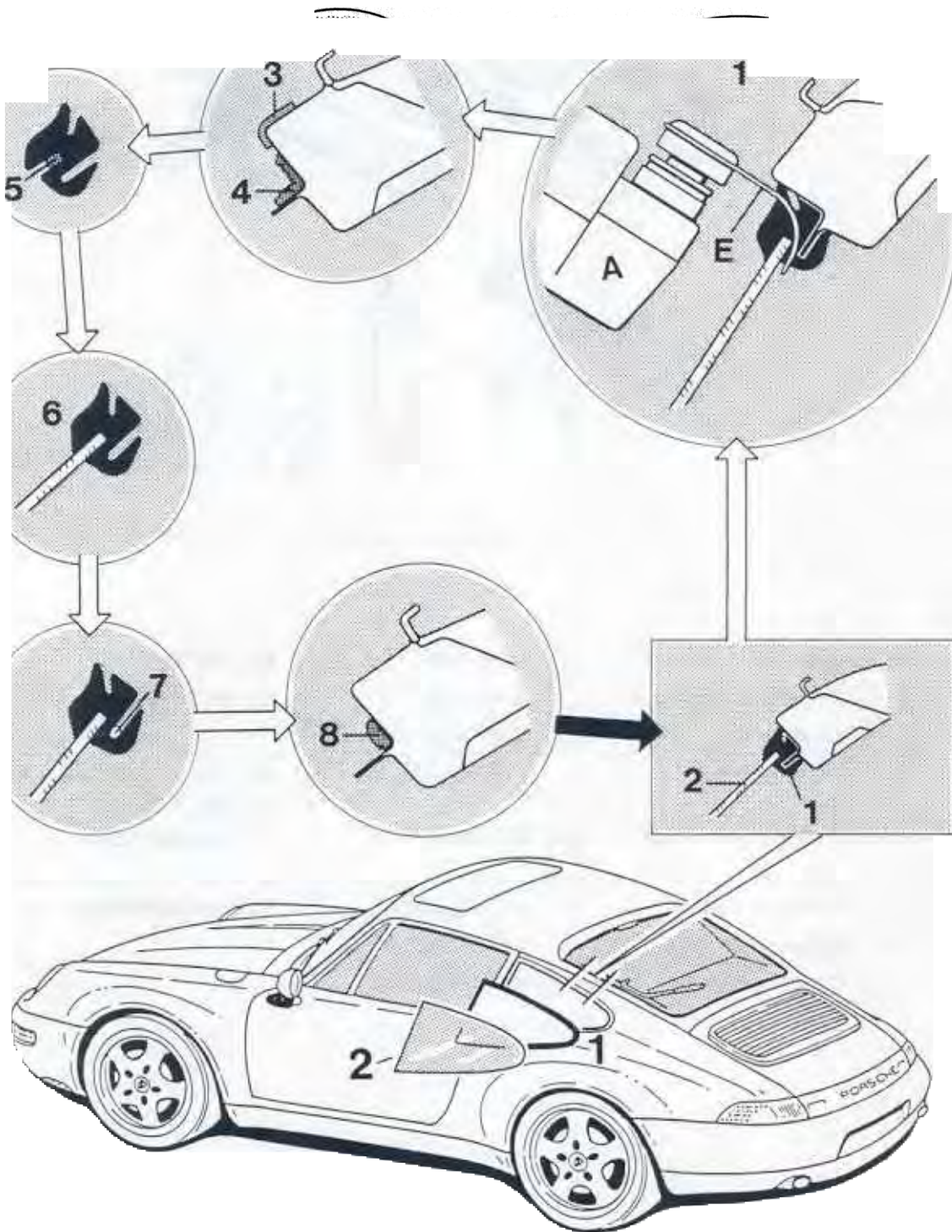
The following tools and materials are required for the removal and installation of the side window:



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A	Cutter	VAG 1561	z.B. VW Werk AG
B	Twin-cup suction puller	VAG 1344	KD-Gerätevertrieb
C	Bonding gun	VAG 1628	
D	Flashing knife	6.39.03.113.02.2	e.g. C & E FEIN GmbH & Co. Postfach 172
E	Cutting knife curved	6.39.03.103.01.7	D-70013 Stuttgart 1
F	Adhesive sealant	999.915.400.40	Porsche-Teiledienst
G	Body primer	999.915.487.40	
H	Cleaning solution	999.915.487.40	

Removing and installing side window



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No.	Operation	Procedure
1	Cut through rubber seal	Fit curved cutting knife (D) to cutter (A). Push cutting knife into sealing rubber, set vibration regulator to stage 6 and cut through rubber seal along its full circumference between side window and and body.
	Lift out side window	
	Pull sealing rubber residues off the body panel	
2	Attach adhesive tape to bodywork	Mask off body in visible area of window aperture to protect the paintwork.
3	Remove adhesive sealant from bodywork	Fit flashing knife (E) to cutter (A) and cut adhesive sealant from the bodywork only to the extent that the remaining adhesive covers the entire area.
	Clean window aperture of bodywork	Thoroughly clean window aperture of body with cleaning solution (H). Caution: Make sure no cleaning solution residue remains on the body.
	Apply primer to damaged areas of bodywork	Apply body primer (G) to damaged topcoat in non-visible areas of window aperture.
	Remove adhesive sealant from side window	Remove adhesive sealant carefully from side window using a fixed knife. Adhesive residues covering the area in a uniform manner may remain on the window.

No.	Operation	Procedure
	Clean side window	Thoroughly wipe off side window with some cleaning solution (H). Caution: Make sure no cleaning solution residue remains on the side window.
	Clean rubber seal	Clean window channel of rubber seal with some cleaning solution (H) Caution: Make sure no cleaning solution residue remains in the window channel of the rubber seal.
4	Apply adhesive sealant to channel of rubber seal	Place cartridge containing adhesive sealant (F) into bonding gun (C) and bond window channel of rubber seal along its entire circumference. Caution: The side window must be refitted to the vehicle no later than 4 hours after applying the adhesive.
5	Place rubber seal to side window	
6	Place assembly cord into rubber seal	
7	Apply adhesive sealant to body	Using the bonding gun (C), apply adhesive sealant (F) in a continuous bead to the circumference of the window aperture in the body
	Place side window into body	Place prepared side window into body aperture, align and press into place. Working from the passenger compartment, pull rubber seal over the spotweld flange of the body by pulling out the assembly cord.
	Clean visible areas	Adhesive sealant that has squeezed out must be removed immediately and the visible areas affected must be cleaned with cleaning solution (H).