

WORK INSTRUCTIONS WINDSCREEN REPLACEMENT



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REMOVAL



- 1 Remove the trim, seals and wipers in accordance with the vehicle manufacturer's instructions. Cut out the damaged windscreen using a cutting wire or a special knife. Use vacuum lifters to remove the defective windscreen.



- 2 Before cleaning the new windscreen, we recommend testing its fit and inspecting it for defects. Now insert the spacers, if necessary, and use tape to mark the correct positions of the windscreen.

BODY WORK



- 6 It is important to thoroughly clean the body flange with **DINITROL 582**, for example, before the remaining bead on the body flange is trimmed. Do not apply **DINITROL 582** or windscreen cleaning agent to the newly trimmed remaining bead. Let the flange briefly air dry after cleaning it.



- 7 Use a degreased blade to trim the remaining adhesive bead to a height of approx. 1-2 mm and keep it clean. The clean, trimmed bead is the best possible adhesive base. Please note: Do not treat the cut surface with adhesion cleaner or a similar material (alcohol). In case of longer open time (> 4 hours), the trimmed bead must be cleaned with **DINITROL 582**. It is essential to comply with flash-off time of 10-15 minutes. For even longer open times of more than 12 hours, the trimmed bead must be cleaned with **DINITROL 582** and activated with **DINITROL 540**.



- 8 Paint damage on the flange can be touched up with **DINITROL 538** Plus one-step primer. Before touching up, shake the bottle for approx. 1 minute until the steel ball is audible or shake the primer tube (without steel ball) for approx. 1 minute as well (see Figure 5).
Please note: Air dry for min. 5 minutes

CLEANING



- 3 Clean the windscreen with a certified windscreen cleaning agent such as **DINITROL 7250**, or a similar, proven windscreen cleaning agent without ammoniac.



- 4 Thoroughly clean the surface to be bonded (ceramic edge) of the new windscreen using **DINITROL 582** to remove stubborn contamination on glass surfaces and the ceramic coating. After cleaning, air dry for 5 minutes.



INSTALLATION



- 9 Apply windscreen adhesive as a triangular shaped bead either to the windscreen, the body flange, or the newly trimmed remaining bead.
Please note: The triangular nozzle must be trimmed in accordance with the vehicle manufacturer's instructions.



- 10 Insert the new windscreen within the adhesive's open time and use the tape to position it. Now install the associated components such as the trim, etc.

PREPARATION FOR TREATMENT



- 5 Before use, shake the **DINITROL 538** Plus one-step primer (bottle) for approx. 1 minute until the steel ball is audible. The aluminium tube does not contain a steel ball, but the tube must also be shaken well before use. Now use a dauber or the tube to evenly apply one layer of primer to the clean bonding surface.

Please note: Air dry for min. 5 minutes



Here you can find our application video.

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