

# Removal and Installation of Side Window on Coupe Top 67.1

Revision: Revised and repair kit changed.

## Special Tool

Handle for cutting wire with tommy

107 589 00 59 00

## Conventional Tools

Processing gun, manually or compressed-air-operated

## Note

For removal and installation of glued glass (panes), order **Repair Kit** for glueing (bonding) **107 586 00 67** from Spare Parts Department Sindelfingen.

## Removal

- 1 Remove ornamental frame on side window (68.1–570).
- 2 Remove reveal molding top and bottom on side window (68.1–420 or 425).
- 3 Cover coupe top in range of side window with adhesive tape to avoid damaging paintwork.
- 4 Cut approx. 600 mm (half length) of steel wire (2) from repair kit.
- 5 Stick one end of steel wire (2) from inside through glueing cord (1) by means of pliers.

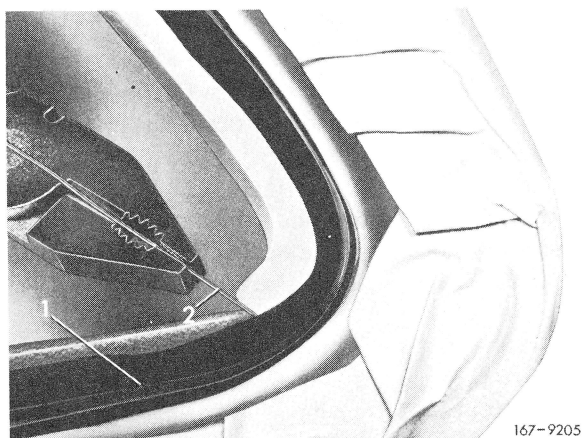


Fig. 1

1 Glueing cord

2 Steel wire

**Note:** If required, steel wire of approx. 0.5 mm dia. may be used instead of steel wire from repair kit. (E.g., welding wire from shielded arc welder).

- 6 Attach steel wire (2) inside to handle (14).
- 7 Attach tommy (15) to other end of steel wire (2).
- 8 Tension wire (2) inside with handle (14) (Fig. 2).

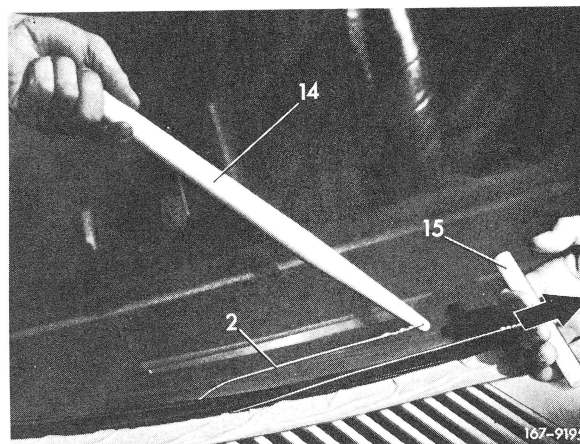


Fig. 2

(Shown on windshield panel)

2 Steel wire

15 Tommy

14 Handle

- 9 Let a helper pull on tommy (15) and cut glueing cord (1). Guide wire (2) in such a manner that edge of glass is not damaged. If required, press steel wire (2) at cutting edge against channel by means of a wedge.

# 67.1 Removal and Installation of Side Window on Coupe Top

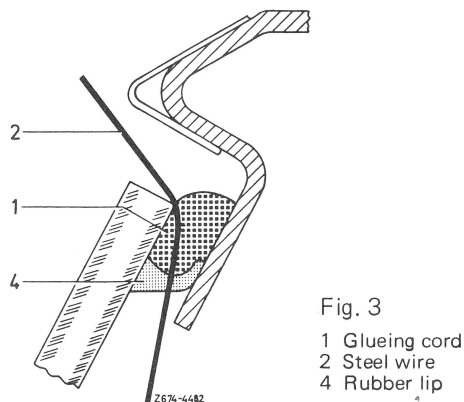


Fig. 3

- 1 Glueing cord
- 2 Steel wire
- 4 Rubber lip

10 Remove side window.

## Installation

11 Clean channel on body mechanically with a wooden or plastic wedge.

**Note:** Do not use solvents for cleaning channel, since this would impair the quality of the new bond.

12 Coat channel with cleaner (8) from repair kit.

13 Insert all reveal moldings.

14 Cover reveal moldings inside with adhesive tape to avoid contamination by glue.

15 Glue rubber lip (4) from repair kit against reveal moldings on channel.

16 When the removed side window is used again, remove residual glue completely by mechanical means and by means of test gasoline.

17 Apply cleaner (8) from repair kit by means of enclosed paper cloth (10) to outer edge of side window and permit to react for approx. 1 minute.

18 Coat glueing surface on side window with primer (9) (use second paper cloth or primer brush).

19 Cut-off stop on nozzle (6).

20 Punch through aluminum diaphragm in cartridge threads with a screw driver and screw nozzle (6) on cartridge (7).

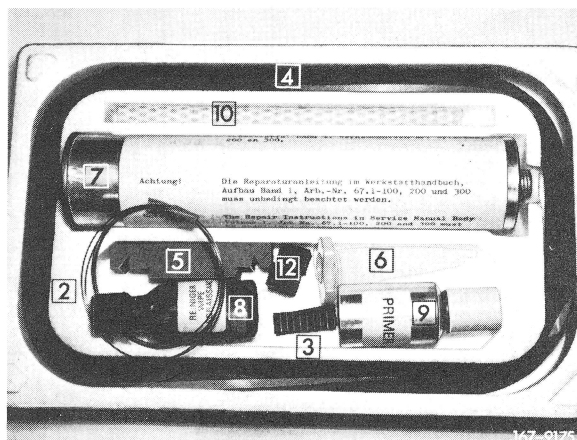


Fig. 5

Repair kit 107 586 00 67

- |                  |                                 |
|------------------|---------------------------------|
| 2 Steel wire     | 7 Cartridge                     |
| 3 Spacer 4 mm    | 8 Cleaner                       |
| 4 Rubber lip     | 9 Primer                        |
| 5 Auxiliary tool | 10 Paper cloths                 |
| 6 Nozzle         | 12 Spacer for rear window 10 mm |

21 Remove bottom from cartridge (7), pour chemicals into cavity behind and insert cartridge (7) into processing gun (11).

**Note:** We recommend using a compressed-air-operated processing gun, since this tool can also be used to process older cartridges, if the glue can still be pressed out.

22 Guide nozzle along rubber lip (4) while uniformly squeezing out glue, until channel is covered with a glue bead at least 5 mm high.

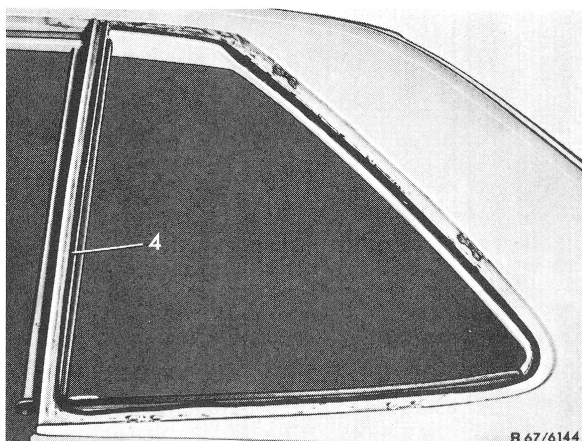


Fig. 4

4 Rubber lip

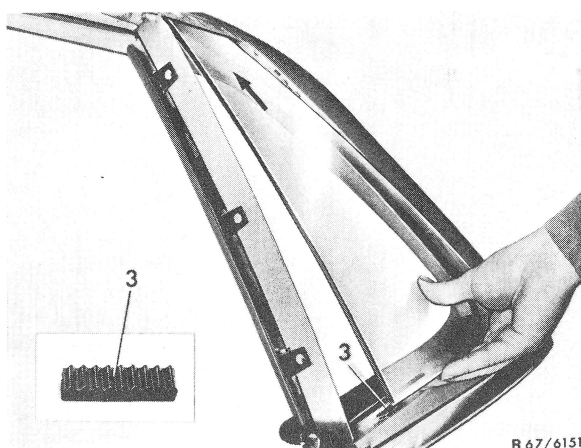


Fig. 6

3 Spacer 4 mm

**23** Place two spacers (3) (4 mm high) from repair kit on the two lower clips, as shown in Fig. 6 and 7.

**24** Insert side window at an angle in upward direction, align and place carefully against glue bead on channel in such a manner that glass rests on spacers (Fig. 6 and 7).

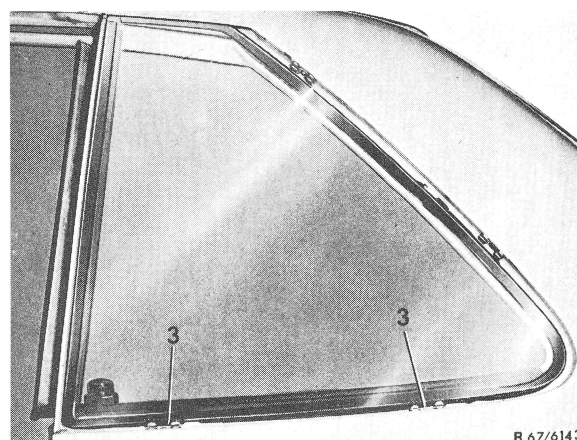


Fig. 7

3 Spacer 4 mm

**25** Press side window all around uniformly by hand against channel until glue emerges visibly on sides.

**26** Clean side window of glue residue, if any.

**Caution!** During subsequent cleaning of side window, make sure that glass is not pushed outwards, since the glue will take approx. 4 hours to cure.