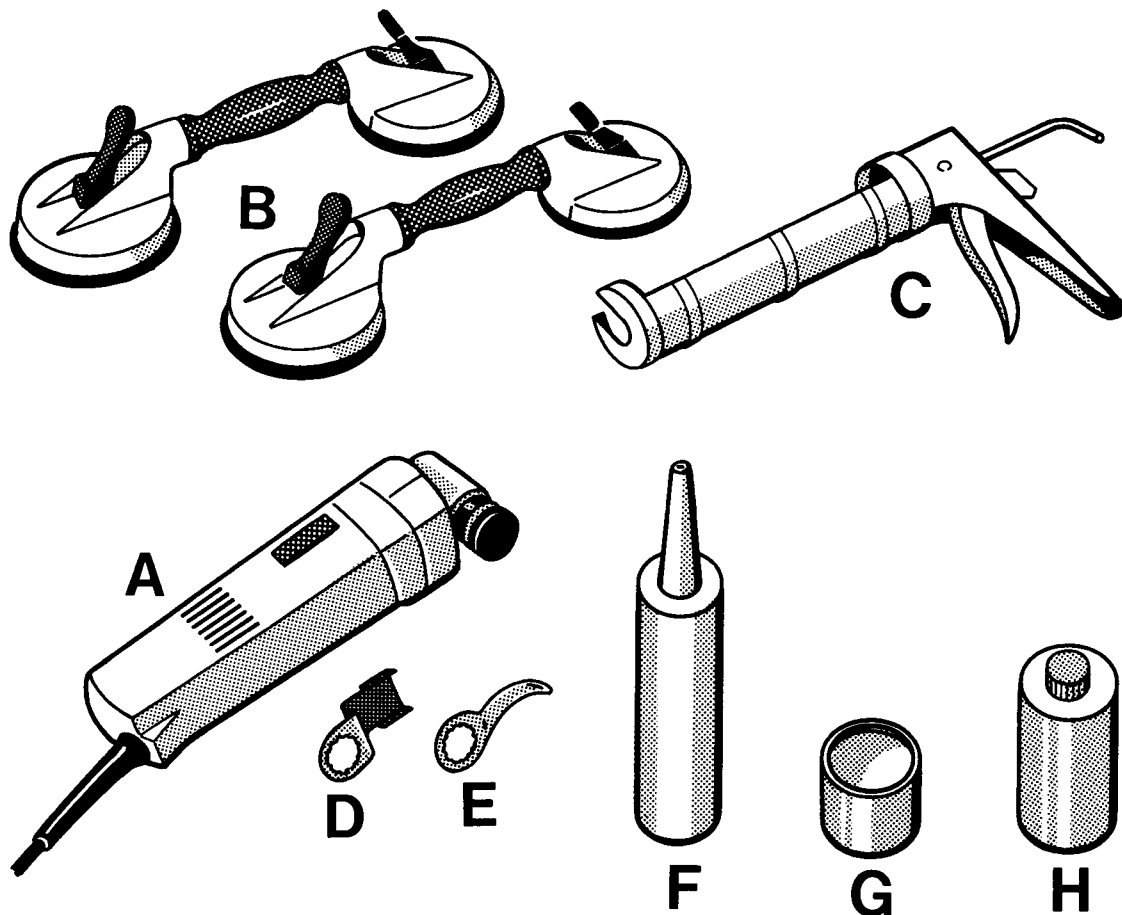


Removing and installing windows

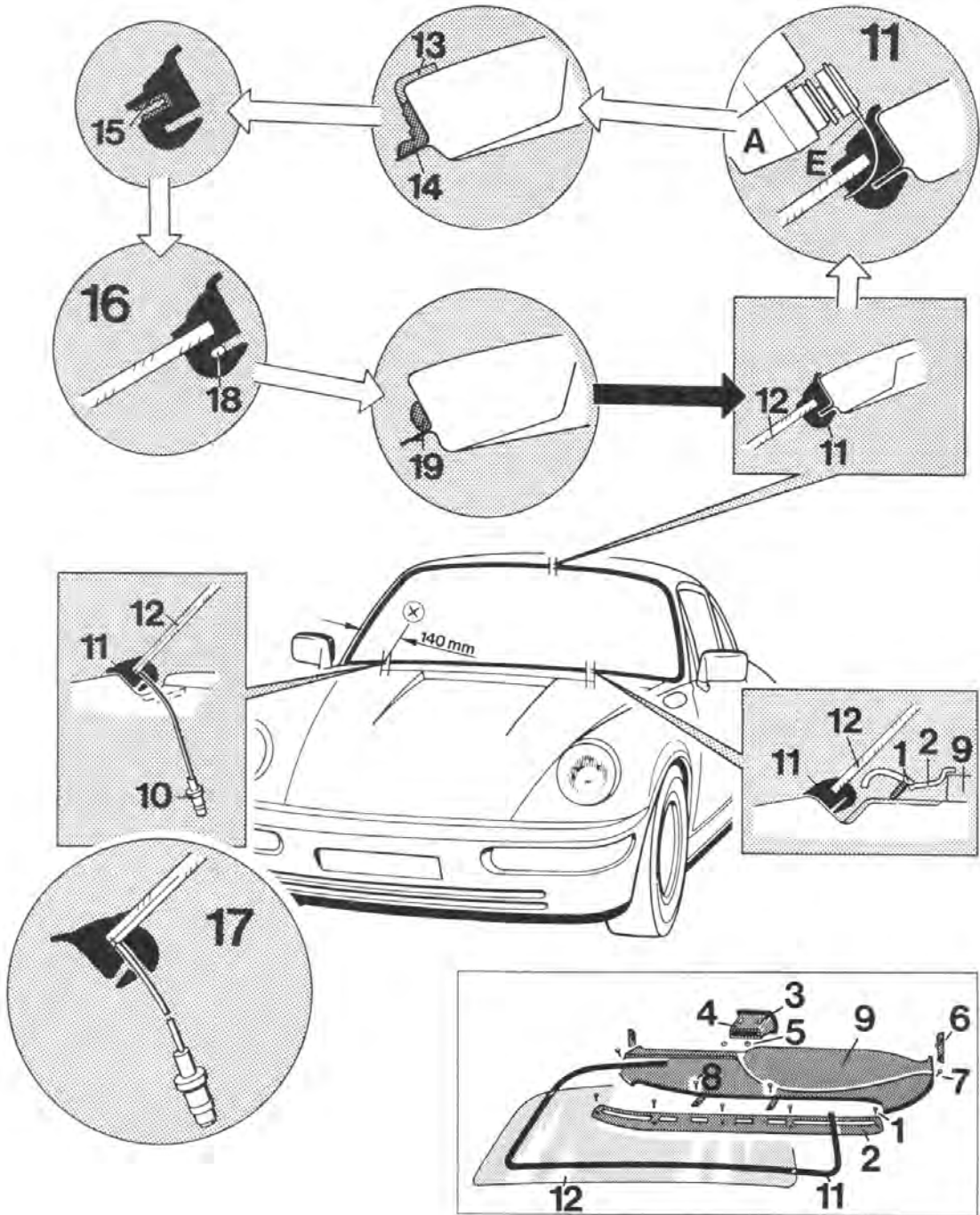
The following tools and materials are required for removing and installing the windshield, the rear side-windows and the rear window:



64 - 114

A	Cutter	VAG 1561	VW Werk AG
B	Double-suction cups	VAG 1344	CS equipment sales
C	Glue gun	VAG 1344/1	
D	Scraper	6.39.03.113.02.2	e.g. C & E FEIN GmbH & Co. Postfach 172 7000 Stuttgart 1
E	Angled blade	6.39.03.103.01.7	
F	Adhesive sealant	999.915.400.40	Porsche parts service
G	Body primer	999.915.487.40	
H	Cleaning solution	999.915.478.40	

Removing and installing the windshield



64-115

Removing and installing the windshield

No.	Action	Procedure
	Remove the windshield wiper	Unscrew the hexagon nut, remove spring washer and wiper.
	Open the door window	Lower the door window.
	Remove internal mirror	Remove the interior mirror upwards from the fastening plate parallel to the window.
1	Remove defroster panel	Undo 5 countersunk self-tapping screws and remove the defroster panel.
2	- <i>countersunk screws</i> - <i>defroster panel</i>	
3	Remove the central nozzle	Press 2 fastening nuts downwards and pull out the central nozzle.
4	- <i>fastening lugs</i> - <i>central nozzle</i>	
5	Remove the upper part of the switchboard	Unscrew a hexagon nut from the threaded bolts for the central switchboard fastening on each side of the recess for the central nozzle. Remove 2 cover panels. Undo the self-tapping screws below the cover panels. Undo 2 self-tapping screws from the top of the switchboard fastening. Remove the upper part of the switchboard.
6	- <i>hexagon nuts</i>	
7	- <i>cover panels</i>	
8	- <i>self-tapping screws</i>	
9	- <i>self-tapping screws</i> - <i>upper part of switchboard</i>	
10	Pull off the windshield antenna plug	Disconnect the windshield antenna plug from the antenna amplifier. (The antenna amplifier is mounted in the - x - area on the body, under the upper part of the switchboard).
11	Cut through the <i>rubber seal</i>	Fit the angled blade (E) into the cutter (A). Sharpen the blade with a grinding stone with the cutter running. Insert the blade into the rubber seal, set the vibration controller to position 6 and cut through the rubber seal between windshield and body all round. Note: The windshield antenna cable in the - x - area must not be damaged.

No.	Action	Procedure
12	Remove the <i>windshield</i>	
	Remove any rubber from the body	
13	Stick <i>adhesive tape</i> to the body	To protect the paintwork, apply adhesive tape to the visible area of the body round the window cutout.
14	Cut away <i>adhesive sealant</i> on the body	Fit the scraper (D) to the cutter (A) and cut away the adhesive sealant on the body until a covering residual layer remains.
	Clean the body round the window cutout	Clean the body round the window cutout thoroughly with cleaning solution (H). Note: No cleaning solution may remain on the body.
	Apply a coat of primer to any damaged areas on the body	Apply body primer (G) to any lacquer damage round the window cutout which will not be visible.
	Cut away the adhesive sealant on the windshield (<i>only if the windshield is undamaged</i>)	Cut away the adhesive sealant from the windshield with a fixed blade. A covering residual layer may remain. Note: If the vehicle is fitted with a <i>Sekuriflex</i> windshield, under no circumstances may the protective foil on the sealant side be damaged.
	Clean the windshield	Rub the windshield thoroughly with cleaning solution (H). Note: No cleaning solution may remain on the windshield.

No.	Action	Procedure
	Check the windshield for notches Inspect	the edge of the windshield all round for damage. If the windshield is damaged and has notches, this must not be reinstalled.
	Clean the <i>rubber seal</i>	Clean the window channel in the rubber seal with cleaning solution (H) Note: No cleaning solution may remain in the window channel.
	Perforate the rubber seal	Perforate the rubber seal in the area of the antenna cable for the cable to pass through (see Item 17).
15	Apply <i>adhesive sealant</i> into the window channel of the rubber seal	Insert a cartridge with adhesive sealant (F) into the glue gun (C) and apply the sealant all round the window channel of the rubber seal (you require approx. 85 mm adhesive sealant). Note: The windshield must be installed into the vehicle max. 4 hours after the adhesive is applied.
16	Mount the rubber seal onto the windshield	
17	Pull the antenna cable, including plug, through the hole in the rubber seal	
18	Lay <i>anassembly cord</i> into the rubber seal	Lay the assembly cord into the rubber seal to fit the windshield. The ends of the cord must cross over around the middle of the roof area.
	Position the double-suction cups to the outside of the windshield	
19	Apply <i>adhesive sealant</i> to the body	Using the glue gun (C), apply the adhesive sealant (F) to the body all round the area of the window cutout (approx. 70 ml adhesive sealant).

No.	Action	Procedure
	Mount the windshield into the body	Lay the preassembled, prepared windshield into the window cutout, align and press down with the double-suction cups (B). From inside the vehicle, fit the rubber seal by pulling the assembly cord against the fold in the body.
	Clean the window	Emergent adhesive sealant must be removed immediately and the window area cleaned with cleaning solution (H).
	Connect the windshield antenna plug to the antenna amplifier	
	Install the upper part of the switchboard	Switchboard fastening: 2 self-tapping screws at the top, one self-tapping screw each on the right-hand side and left-hand side, 2 hexagon nuts in the middle. Replace the left and right cover panels.
	Install the central nozzle	Press the fastening lugs downwards and slide the central nozzle into the recess on the switchboard.
	Install the defroster panel	Secure the defroster panel with 5 countersunk self-tapping screws.
	Fit the internal mirror	Slide the internal mirror into the fastening plate parallel to the windshield.
	Install the windshield wipers	Mount the windshield wipers, fit spring washers and secure with hexagon nuts.

Note: Vehicles fitted with Airbag

The following outline conditions must be observed to ensure that the bonded connection is adequately strong for vehicles with Airbag:

Hardening time	10 h
Temperature	at least 15°C
Relative humidity	at least 40%

Should the temperature or relative humidity be lower than these values, the hardening time is longer. These vehicles must not be put into operation before the hardening time has expired.

Vehicles without Airbag may be put into operation after the assembly work has been completed.