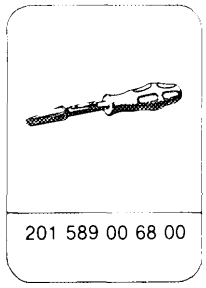
	Job No
Windshield	
Removal and installation of windshield glass	67-I 00
Removal and installation of ornamental frame on windshield	120
Rear window	
Removal and installation of rear window	200
Removal and Installation of ornamental frame on rear window	220

67-100 Removal and installation of windshield glass

Data

Primer edge on glass: top and laterally 10 mm; below 30 mm wide
Primer edge on body flange: top and laterally across entire width of fold; below 30 mm wide.

Special tools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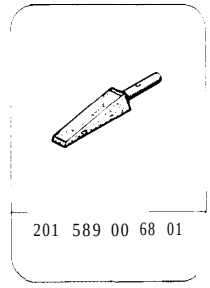
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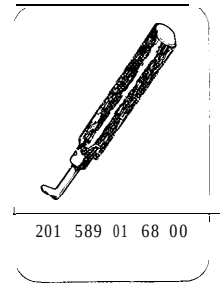
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Conventional tool	Order number	e.g. company
Siphon	602-2	Karl Assfalg KG Buchstraße 149 D-7070 Schwabisch Gmünd

Note

The windshield glass is glued to body by means of Butyl tape. During removal and installation of windshield glass the tape is made plastic by heating. This is done best by electrical heating of a copper wire embedded in center of butyl tape. As an energy source, connect a transformer with 12 V output voltage or a well charged 12 V vehicle battery, which is specially used for repair jobs.

The heating time of the Butyl tape is usually approx. 15 minutes. At **the end of this period the Butyl tape attains approx.** 50 °C within connected range of copper wire. **This temperature is adequate for safe removal of glass.**

The following factors will influence the heating-up time:

1. Dia. of copper wire; 0.3, 0.4, 0.7 mm (the thicker, the shorter the heating time)

2. Age of Butyl tape (the older, the longer the heating time)

3. Temperature of glass and vehicle body (the colder, the longer the heating time)

4. Condition of glass (glass which is already damaged can be removed after a short heating up time by applying increased force).

Renewal of windshield glass requires use of repair kit for glazing, Part No. 126 670 01 93. The contents of this repair kit have been selected for use with models 107, 126 and 201.
The primer 126 670 00 93 is separately available, if required.

Contents of repair kit:

1 Butyl tape, 4200 mm long, 10 ± 0.7 mm dia.

2 Bottle with primer, component part A.

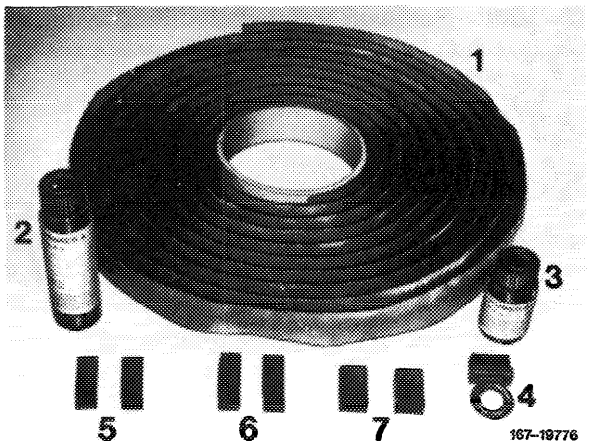
3 Bottle with primer, component part B.

4 Application sponge for primer.

5 Spacing pads for windshield (required on model 107 only).
Dimensions: 30 mm x 10 mm x 6 mm.

6 Spacing pads for side window glass (required on model 107 only).
Dimensions: 30 mm x 10 mm x 6 mm.

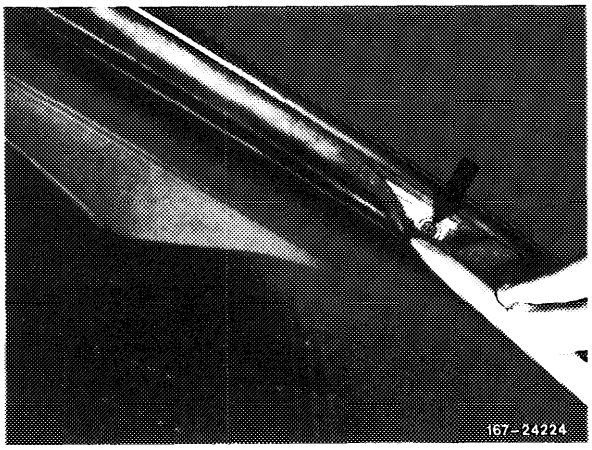
7 Spacing pads for rear window glass (required on model 107 only).
Dimensions: 20 mm x 13 mm x 10 mm.



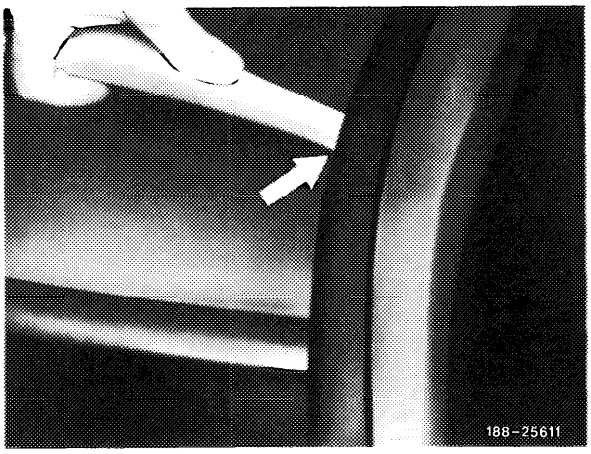
Removal

1 Remove cover at air inlet (Group 83).

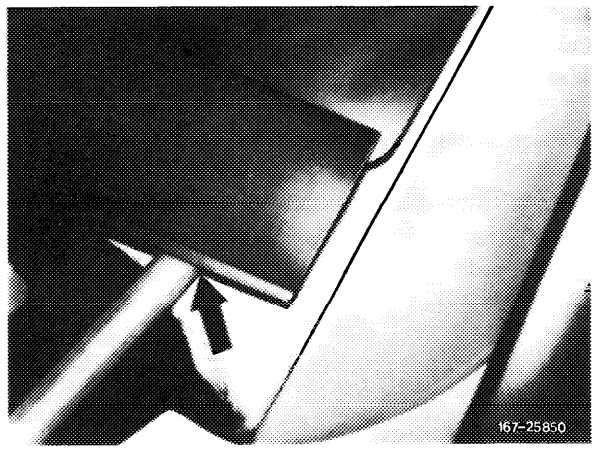
2 Push rubber lip on ornamental molding at the left and right sideways and unscrew the 4 screws underneath.



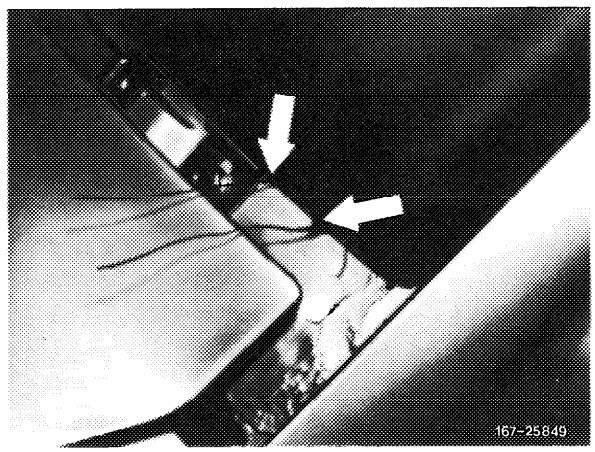
3 Pull ornamental molding left and right in roof range out of front holding clamps and remove.



4 **Pull off ornamental frame at bottom from the 5 holding clamps and remove.**

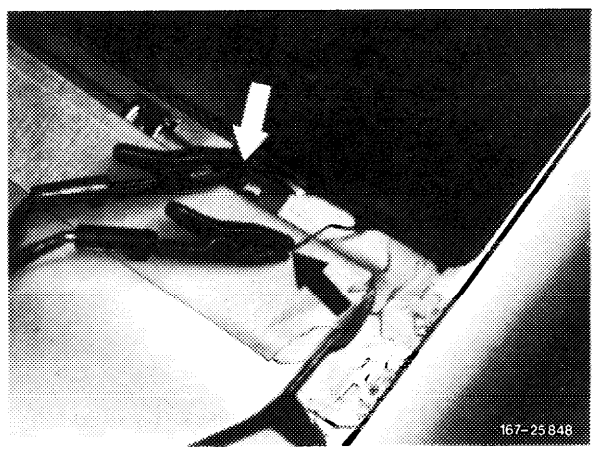


5 **Expose copper wire in adhesive cord and make bright at ends with emery paper.**

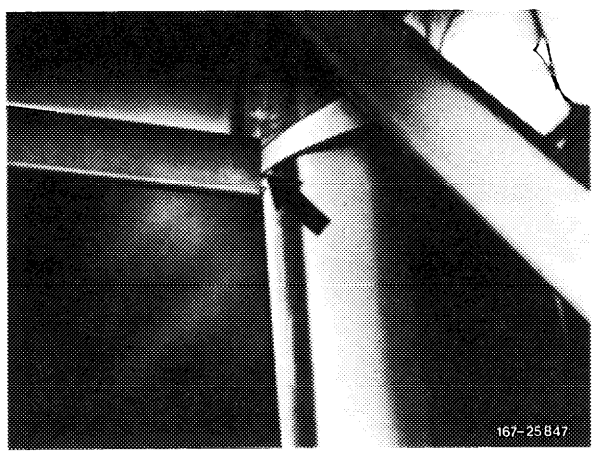


6 **Glue adhesive tape to the area of engine hood adjacent to windshild glass.**
Connect copper wire to current source (12 volts), e.g. vehicle battery, specially provided for heating-up, or to transformer (12 volts).

Note: When connecting, current will not be taken-up unless a spark has been generated. Heating-up time is approx. 15 min.



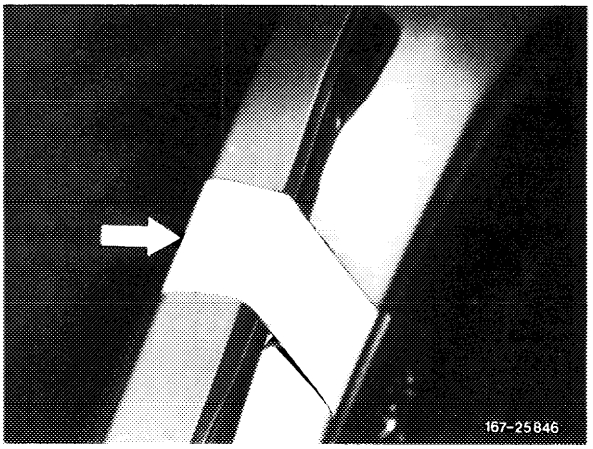
7 **Push ornamental frame at top out of the 5 holding clamps.**



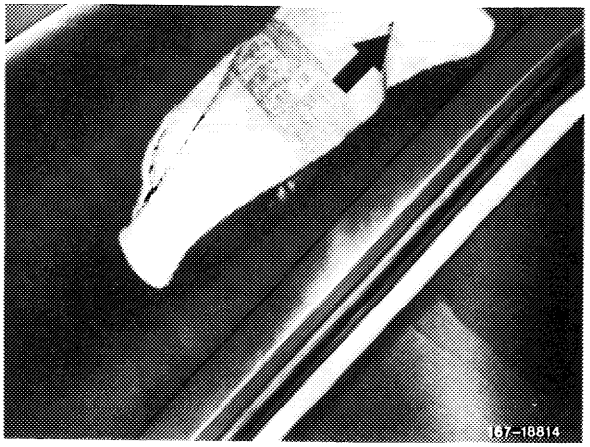
8 Pull ornamental molding on front wall pillar left and right carefully outwards and attach by adhesive tape.

9 Place suction lifter on glass.

Note: When replacing the glass, the new windshield can be prepared during the heating-up time (refer to item 17-23).

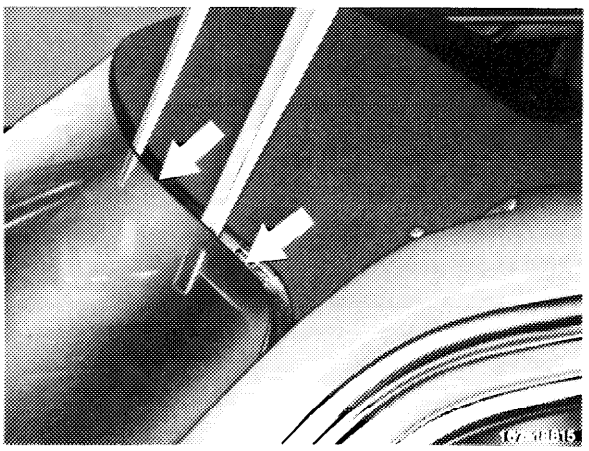


10 Push glass outwards in upper range with leg.



Shown on model 126

11 Insert assembly wedges in resulting gap between glass and body.

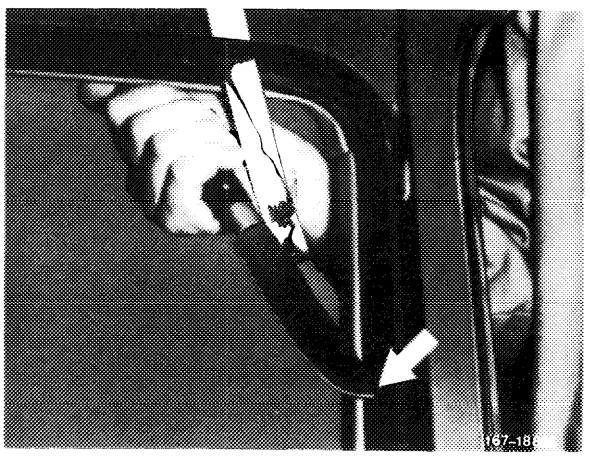


Shown on model 126

12 Carefully cut adhesive cord all around with an industrial knife, while inserting additional assembly wedges at cut spots to prevent successive gluing down

13 Remove windshield glass.

14 Disconnect current source.



Shown on model 126

Installation

15 Cut remains of adhesive cord with angular knife except for a few tenths of a millimeter from body flange and from glass, making sure that the paintwork and the glass are not damaged.

Note: The remaining adhesive material need not be removed.

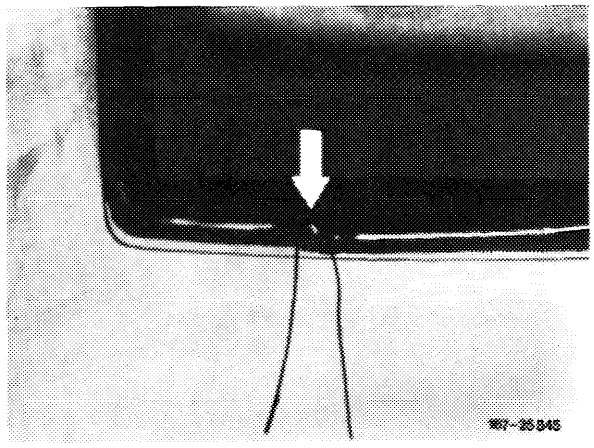
16 Check body flange for possible paintwork damage and repair, if required (pay attention to drying time).

17 Mix primer from repair kit. For this purpose, fill contents of the small bottle with component B into the large bottle, add component A and shake well.

18 Clean adhesive surfaces (on body and glass), from which the adhesive material has been completely removed, with benzine and rub dry. Then apply primer from repair kit and apply with sponge. Let primer air-dry for 5 minutes.

19 Place glass on a suitable support.

20 Place adhesive cord (butyl tape) from repair kit all-around on glass and apply slight pressure. Start at bottom left.

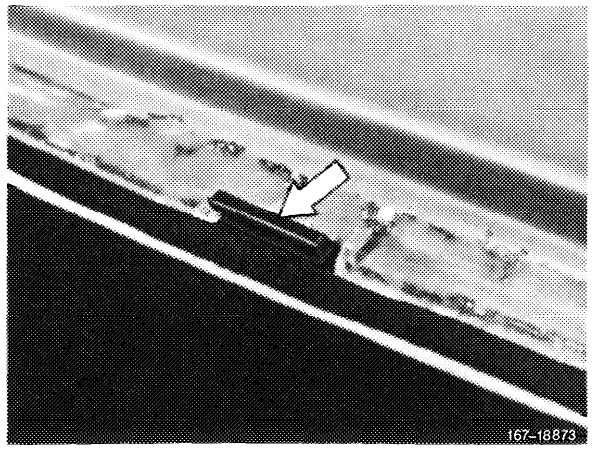


21 Cut off remaining length. Expose copper wire at ends of adhesive cord and rub to a bright finish with sanding paper.

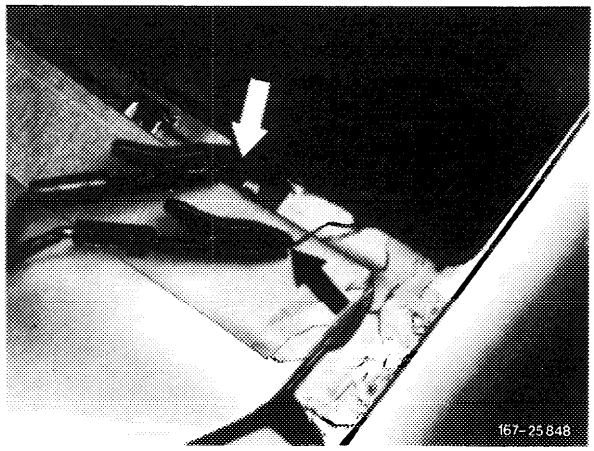
22 Connect ends of adhesive cord again by pushing these ends against each other.

23 Check whether space holder at top left is in body flange.

24 Mount windshield pane at lower angle brackets, center and carefully insert into body flange.



25 At both wire ends, connect power source (12 V), e.g. vehicle battery, which is made available specially for heating up, or transformer (12 V) and heat butyl cord. Push uniformly against pane and mount ornamental frame (the insertion depth is determined by the precisely fitting assembly of ornamental frames).



26 Disconnect power source.

27 Position wire ends of butyl cord against bottom edge of pane (do not cut off).

28 Continue installation in vice-versa sequence.

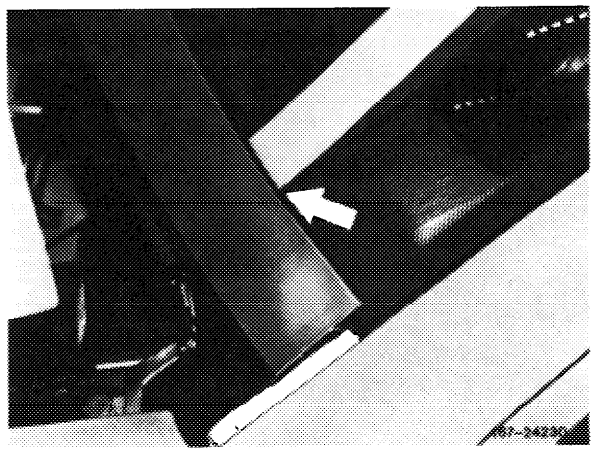
Note: The adhesive requires no drying time. Rain test can be made upon completion of the assembly jobs. Leaks, if any, can be sealed with MB universal sealing compound, part No. 003 989 01 71.

Removal

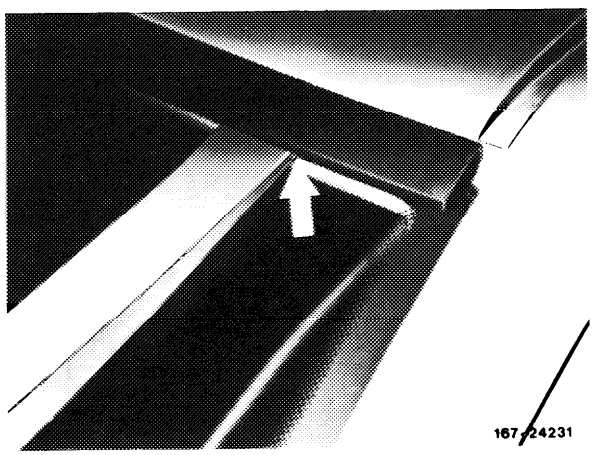
1 Remove ornamental molding on front wall pillar and on roof (88–855).

2 Remove wiper arm (group 82).

3 Push ornamental frame below out of 5 clips by means of plastic wedge and pull out of air intake cover in upward direction.



4 Push ornamental frame at top out of 5 holding clips by means of plastic wedge and remove.

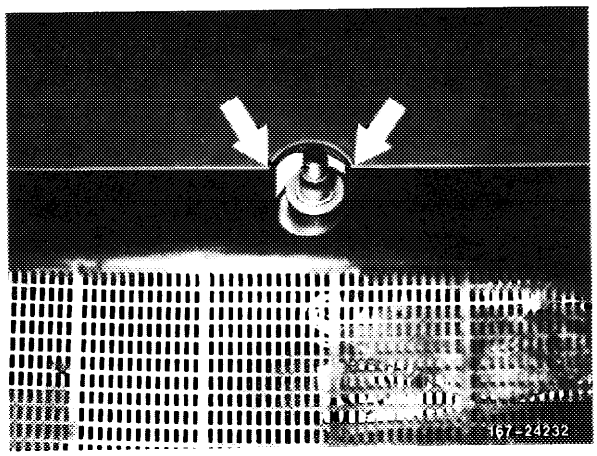


Installation

5 Slip ornamental frame below over air intake cover while centering ornamental frame on cutout for wiper shaft.

6 Push ornamental frame into 5 clips.

7 For further installation proceed vice versa.

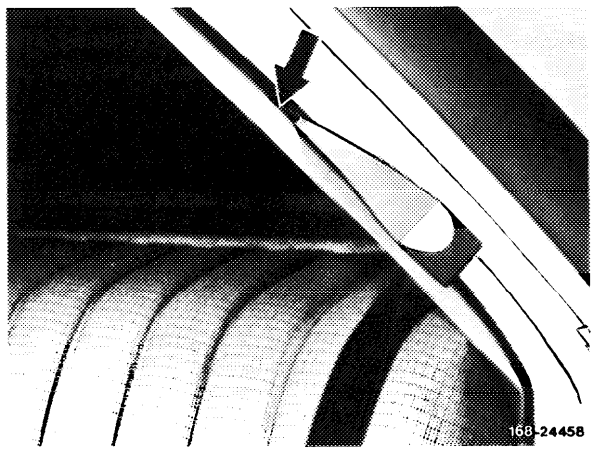


Removal

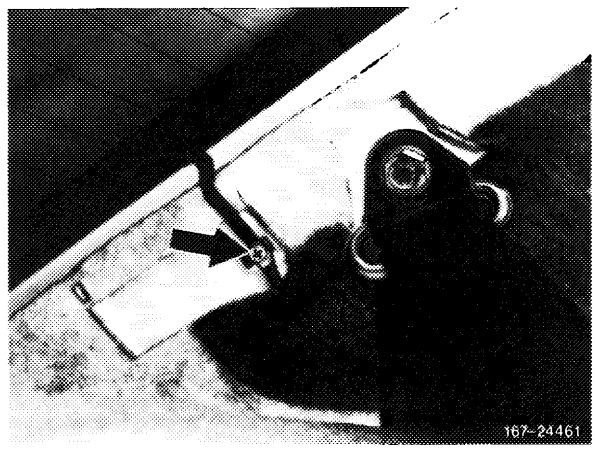
1 Remove hat rack (68-458).

2 Pull off edge protection in range of panelling (trim) on rear pillar left and right.

3 Force off holding clips on linings of rear pillar, front, with wedge toward center of vehicle, slip in upward direction and put down in rear passenger compartment.



4 Separate electric connections on cable connector on lefthand and righthand rear pillar.

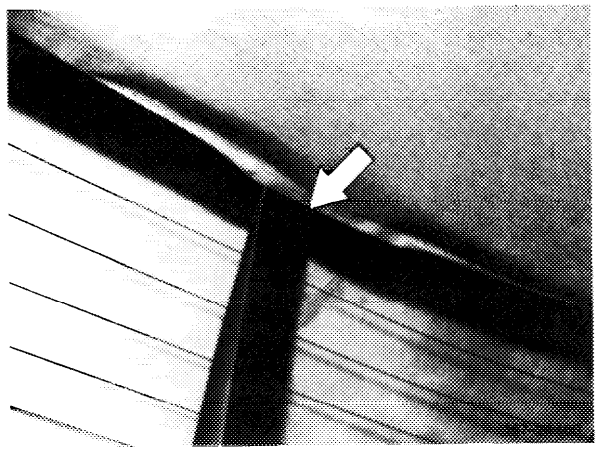


5 Push back rubber frame on vehicle inner side by means of a plastic wedge behind spot weld flange of window opening.

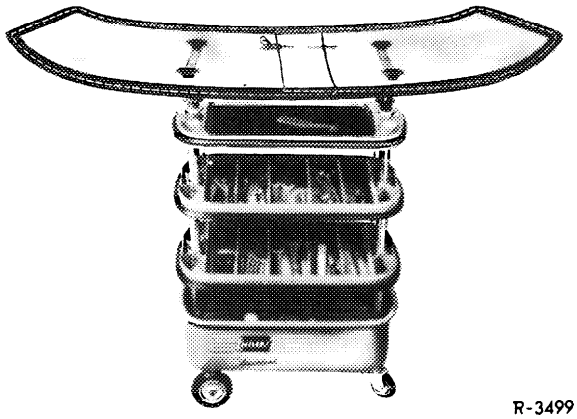
6 Carefully push rear window from inside in outward direction and remove. Pay attention to contact wires or lateral bus bars, respectively.

7 Remove ornamental frame on rear window (67–220)

8 Remove sealing frame from rear window.



Installation



R-3499

9 Place rear window with crown in downward position on corresponding base.

10 Pull sealing frame on rear window.

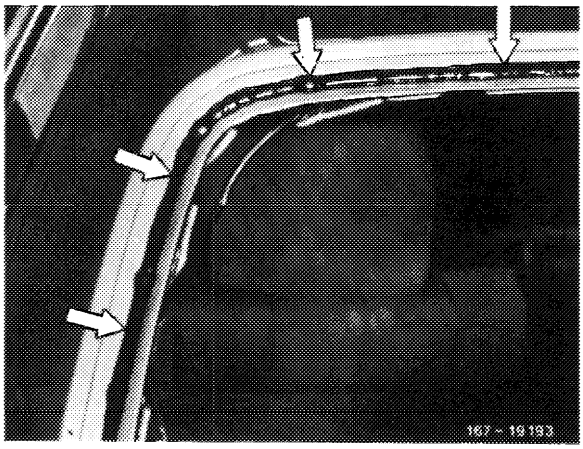
11 Install ornamental frame in sealing frame (67–220).

Note: Fill upper joint abutment of ornamental frame prior to assembly of cover with MB glass sealing compound, so that no water can flow over window glass.

12 Insert two greased cords into holding slot of sealing frame and rub sealing frame with soap water.

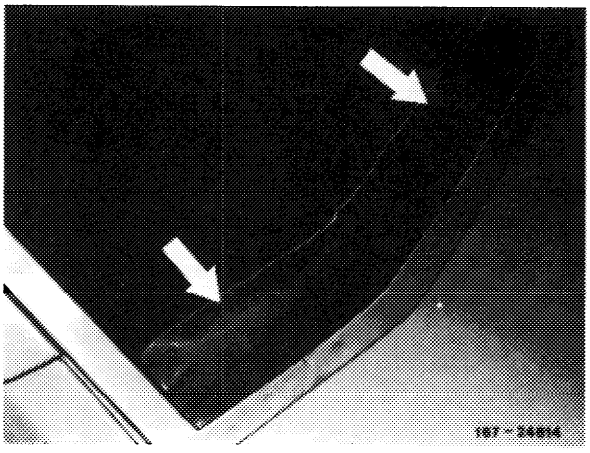
13 Apply MB glass sealing compound all-around in body flange.

14 Insert pre-assembled rear window with sealing frame from outside to window opening and align.



Shown on model 126

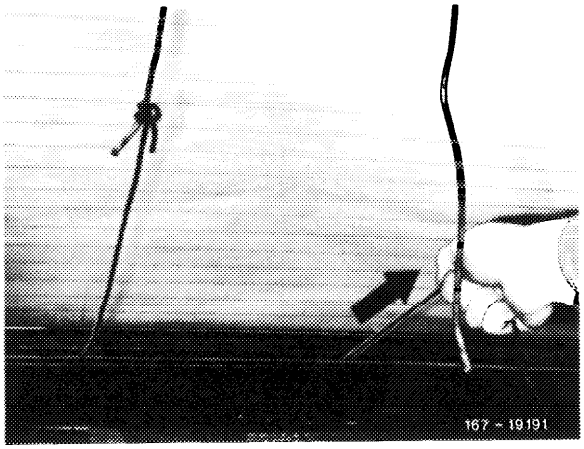
15 To avoid wind noises, align height of rear window in such a manner that upon installation the upper edge of the ornamental frame is O-I mm lower than the roof panelling.



Shown on model 126

16 Press lightly against rear window, while simultaneously letting a helper inside vehicle carefully pull out cord to lift the rubber lip of the sealing frame starting from below over spot weld flange of window opening.

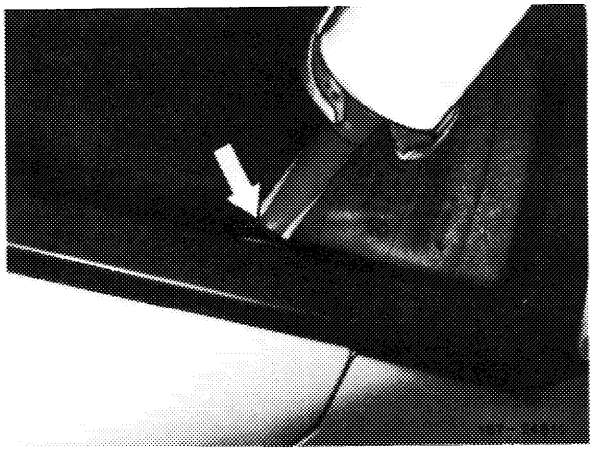
Note: Pull off cord in parallel with glass to prevent damaging rubber lip.



17 Seal with MB glass sealing compound all-around between glass and outside of sealing frame.

18 Continue installation in vice-versa sequence.

Note: Excess sealing material can be removed by dabbing with adhesive tape.



67–220 Removal and installation of ornamental frame on rear window

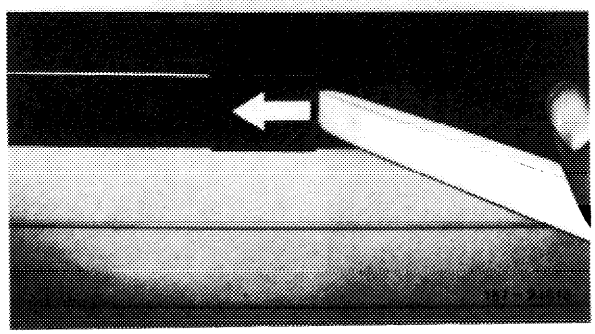
Removal

1 Remove rear window (67–200).

2 Set rear window on a suitable base.

3 Slide cover at top sideways.

4 Starting from above, push ornamental frame out of sealing frame by means of a plastic wedge.



Installation

Note: Prior to installing ornamental frame, slightly coat slot on sealing frame with benzine. Fill upper joint abutment of ornamental frame prior to assembly of cover with MB gl'ass sealing compound, so that no water can flow over rear window glass under cover.

5 For installation proceed vice versa.