

**Data**

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Rim for primer on windshield	Width: 10 mm
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**Conventional tool**

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Syphon	e.g. made by Karl Assfalg KG Buchstr. 149 D-7070 Schwäbisch Gmünd order No.: 602-2
Removing tool (Glas-Ex and cutting wire)	e.g. made by Manfred Herrmann Johann-Sebastian-Bach-Str. 6 D-8023 Pullach im Isartal order No. 58 671 Glas-Ex order No. 58 672 cutting wire filling-up package 200 m

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**Note**

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The rear window on model 107 can be glued-in with varying glueing materials: Solbit, Betaseal or Butyl.

**Solbit:** Solbit is an electrothermically fully curing synthetic rubber profile with inserted heating wire.

**Characteristics:** Firm glueing compound, inserted heating wire. This material has been used in series production.

**Betaseal:** Betaseal is a pumpable polyurethane single-component adhesive compound for making very firm, but elastic connections.

**Characteristics:** Permanently elastic glueing compound, without heating wire. This material is included in repair package 107 586 03 67 available up to now.

**Butyl:** Butyl is a permanently elastic adhesive molding with inserted heating wire (adhesive cord).

**Characteristics:** Permanently elastic glueing compound, with heating wire. This material is included in repair package 126 586 00 67.

Prior to removing glass, check in accordance with characteristics named above which type of glueing material has been used for installation. For removal, use method fitting the respective adhesive material.

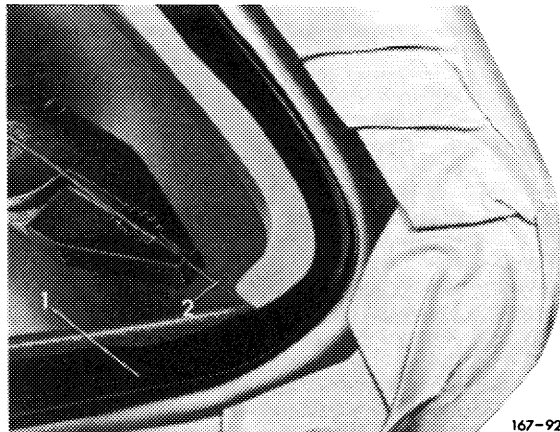
- Removal with cutting wire (Solbit and Betaseal).
- Removal by heating resistance wire (Butyl).

## Removal with cutting wire

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- 1 Remove ornamental frame on side window (68–570).
- 2 Remove reveal molding top and bottom on side window (68–420 or 425).
- 3 Cover coupe top in range of side window with adhesive tape to avoid damaging paintwork.
- 4 Cut-off cutting wire to approx. 900 mm.
- 5 Introduce cutting wire (2) on long removing tool (14) laterally into end of handle and clamp down with knurled nut. Guide cutting wire (2) at lower end through bore in outward direction (Fig, refer to item 7).

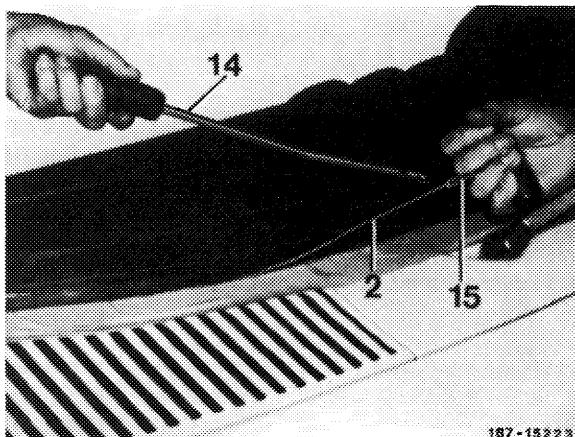
6 Stick end of cutting wire (2) with pliers from inside through adhesive cord (1) (if possible, close to flange).



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7 Thread other end of cutting wire at short handle (15) and clamp down with knurled screw.

8 Tension cutting wire (2) inside with removing tool (14).



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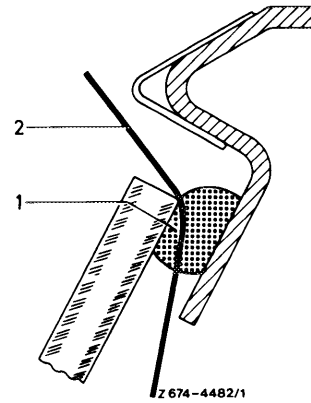
Shown on windshield glass

9 Let a second person pull on short handle and cut adhesive cord (1), while guiding cutting wire (2) in such a manner that the glass edge is not damaged. If required, push cutting wire (2) and cutting edge against body flange by means of a wedge. Cut carefully at glass corners in steps of 10 mm.

10 Remove side window.

11 Mechanically clean body flange by means of a wooden or plastic wedge.

**Note:** When using removed glass again, clean likewise.



#### Removal by heating-up resistance wire

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#### Note

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The side window is glued to body by means of an adhesive cord. For removal and installation of a side window, the adhesive cord is converted into a plastic condition by heating. This is done best by connecting the copper wire located in center of adhesive cord to a source of electric energy. Such a source is a well charged 12-volt vehicle battery.

The heating-up period of adhesive cord generally amounts to approx. 15 minutes for a wire dia. of 0.3 mm. At the end of this period, the adhesive cord has a temperature of approx. 50°C in connection range of copper wire. This temperature is enough for removing the glass free of damage.

The following factors are influencing the heating-up period:

- a) Diameter of copper wire: 0.3, 0.4, 0.7 mm (the thicker, the shorter the heating period).
- b) Aging of adhesive cord (the older, the longer the heating period).
- c) Temperature of glass and body (the colder, the longer the heating period).
- d) Condition of glass (glass already damaged can be pushed out by applying increased force after a short heating-up period).

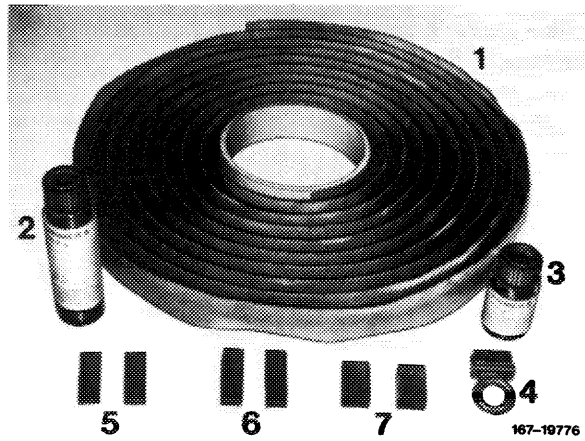
Replacement of side window glass requires repair kit for glazing, part No. 126 586 00 67.

The contents of the repair kit are selected for use both on model 126 and on model 107.

**Contents of repair kit:**

1. Adhesive cord, 4200 mm long,  $10 \pm 0.7$  mm dia.
2. Glass bottle with primer, component part A.
3. Glass bottle with primer, component part B.
4. Sponge for applying primer.
5. Spacing blocks for windshield.\*  
Dimensions: 30 mm x 10 mm x 3.5 mm.
6. Spacing blocks for side window.\*  
Dimensions: 30 mm x 10 mm x 6 mm.
7. Spacing blocks for rear window.\*  
Dimensions: 20 mm x 13 mm x 10 mm.

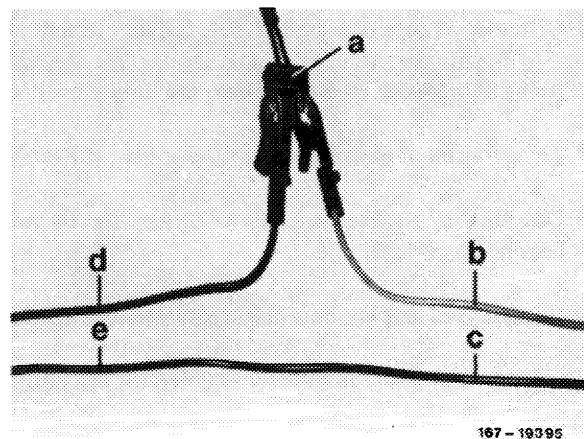
\* These parts are required for model 107 only.



- 1 Remove ornamental frame on side window (68–570).
- 2 Expose copper wire in adhesive cord on side window bottom front and bare ends with emery paper.

- 3 Connect consumers with a capacity of approx. 200 watts between adhesive cord and battery in series. For example, the heatable rear window of coupe top.

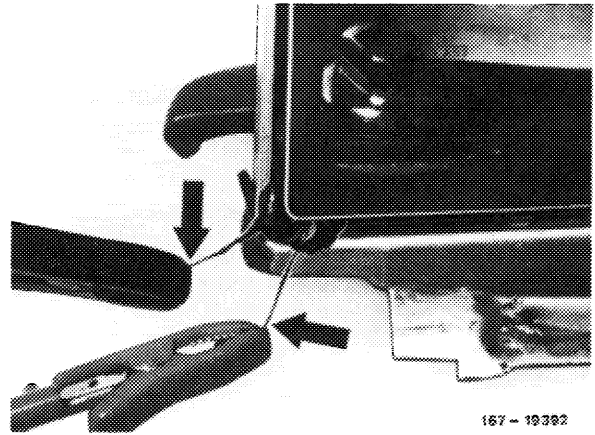
- a = Plug connection of heatable rear window
- b = Positive line to power source (vehicle battery)
- c = Negative line to power source (vehicle battery)
- d = Positive line to copper wire in adhesive cord
- e = Negative line to copper wire in adhesive cord



4 Connect copper wire in adhesive cord and with a wire dia. of 0.3 mm heat-up for approx. 10 minutes.

5 Push glass outward in upper range.

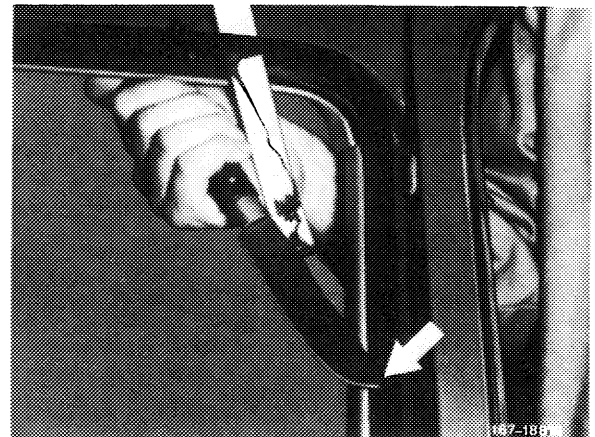
6 Insert assembly wedges into gap established between glass and body.



7 Carefully cut all-around through adhesive cord by means of an industrial knife, while inserting additional assembly wedges at cut spots to prevent renewed glueing down.

8 Remove side window.

9 Disconnect vehicle battery.

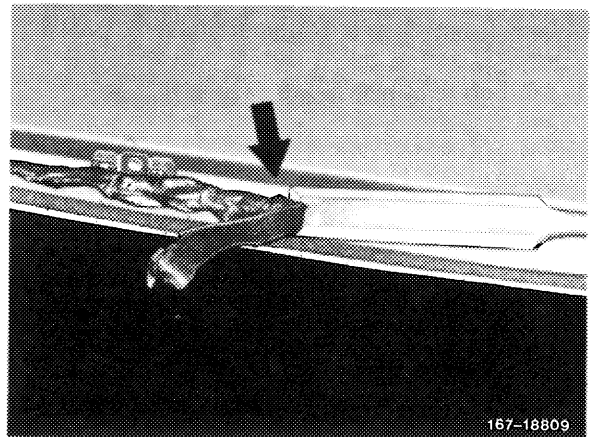


Shown on model 126 windshield

### Installation

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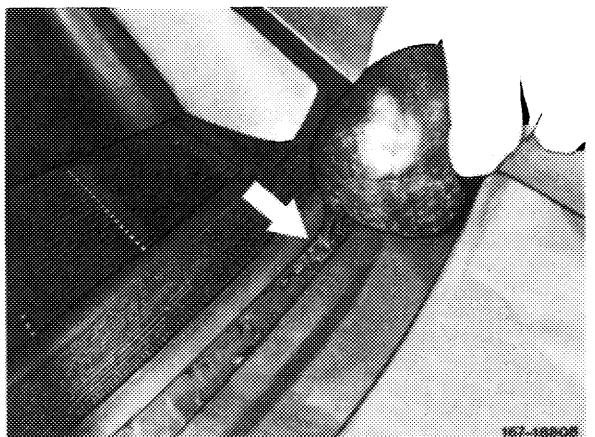
10 Remove remains of adhesive cord from body flange by means of a scraper or the like, while making sure that the paintwork is not damaged.



Shown on model 126 windshield

11 If Butyl has been used for the previous glazing job, glue cut-off adhesive cord into a ball and dab the remaining adhesive on body flange with ball.

**Note:** When the removed windshield glass is used again, clean in a similar manner.



Shown on model 126 windshield

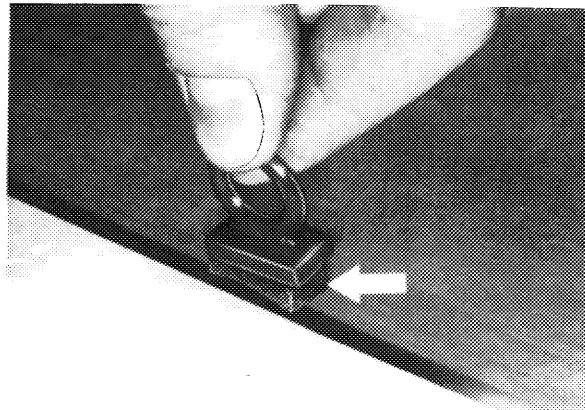
12 Clean adhesive surface on body flange and on side window with benzine.

13 Check body flange for damage to paintwork, if any, and touch up, if required (pay attention to drying time).

14 Mix primer from repair kit. For this purpose, fill contents of small bottle with component B into large glass bottle with component A and shake energetically.

15 Apply primer to side window and body flange with coating sponge from repair kit. Width of primer rim approx. 10 mm.

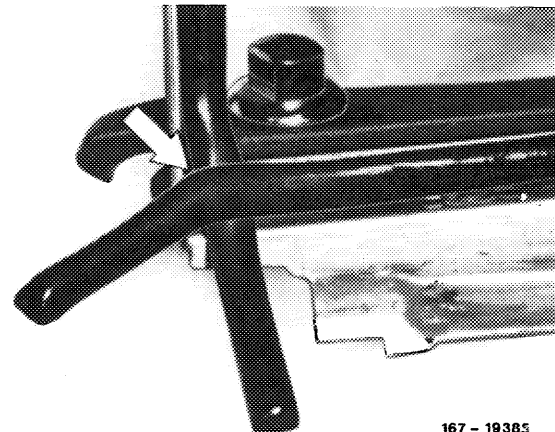
**Note:** Air-dry primer for 5 minutes.



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16 Place adhesive cord from repair kit into center of body flange. Start at bottom front.

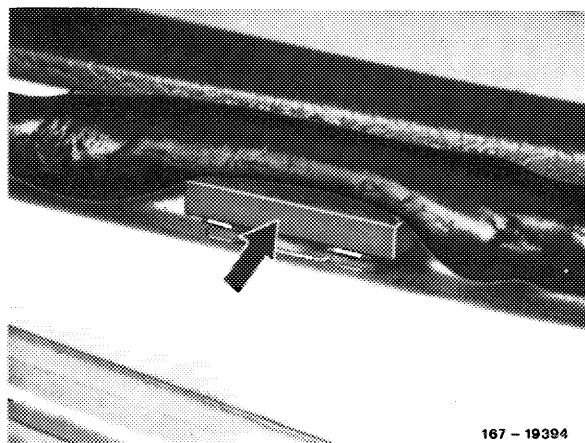
17 Cut off remaining length of adhesive cord.



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18 Place two spacing blocks (6), 30 mm x 10 mm x 6 mm, from repair kit on clips for fastening lower trim strip.

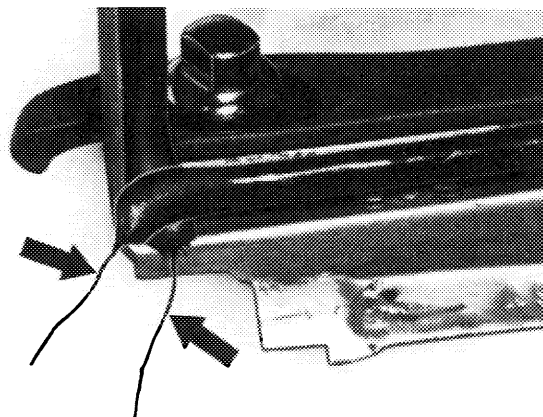
19 Taper adhesive cord in range of spacing blocks so that the glueing compound cannot be visibly pushed out in upward direction when applying pressure to glass.



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20 Expose copper wire at end of adhesive cord and bare.

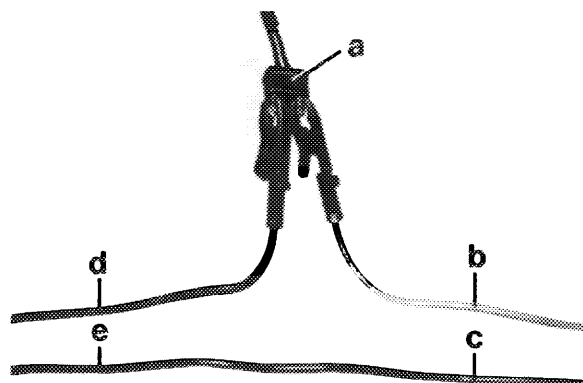
21 Center side window and place on adhesive cord.



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22 Connect consumers with a capacity of approx. 200 watts between adhesive cord and battery in series, for example, the heatable rear window of coupe top.

- a = Plug connection of heatable rear window
- b = Positive line to power source (vehicle battery)
- c = Negative line to power source (vehicle battery)
- d = Positive line to copper wire in adhesive cord
- e = Negative line to copper wire in adhesive cord

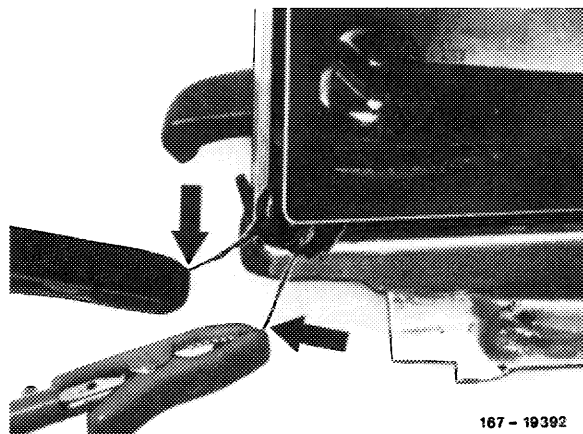


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23 Connect vehicle battery (12 V) at both wire ends and heat-up adhesive cord. Push-in glass uniformly and mount ornamental frame. (The immersion depth is determined when the ornamental frame is fitted).

24 Disconnect vehicle battery.

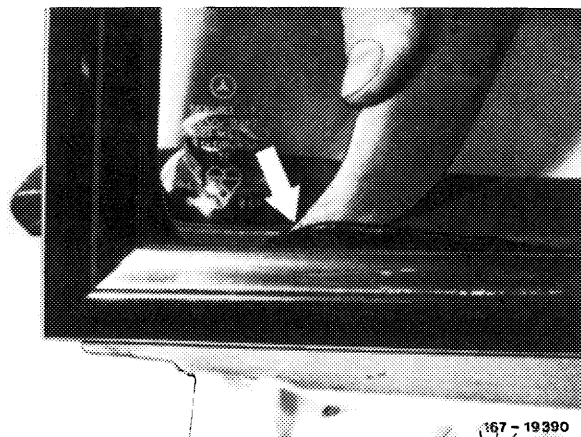
25 Place wire ends of adhesive cord into gap between glass and body flange (do not cut off).



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**Note:** Adhesive material which is visibly pushed-out at linings can be cut off with a moistened industrial knife.

26 For further installation proceed vice-versa.



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