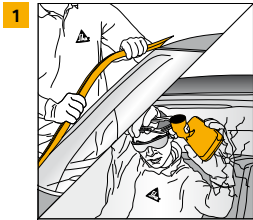


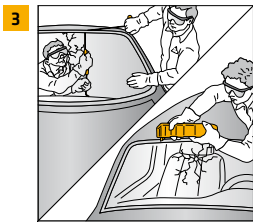
BLACK-PRIMERLESS PROCESS AUTO GLASS REPLACEMENT



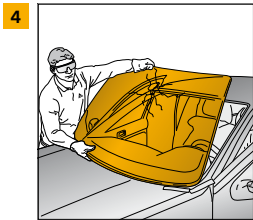
- 1 Remove all decorative trims



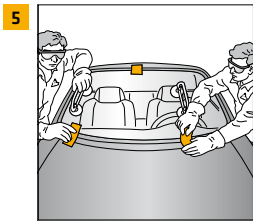
- 2 Cover the aperture with masking tape



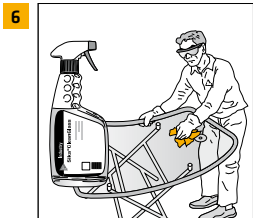
- 3 Cut out damaged windshield using an electrical knife, cutting wire, cold knife etc.



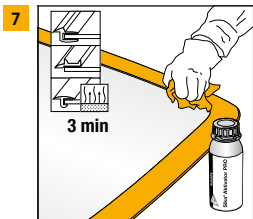
- 4 Remove damaged windshield



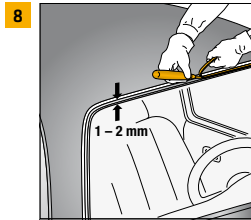
- 5 Dry fit new windshield



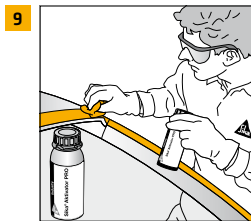
- 6 Clean the new windshield with Sika® Cleaner G+P



- 7 Activate the bonding surface of the glass using Sika® Aktivator PRO



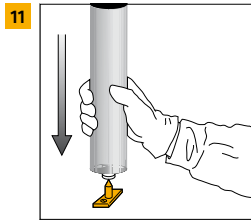
- 8 Trim back the remaining adhesive bead to 1-2 mm



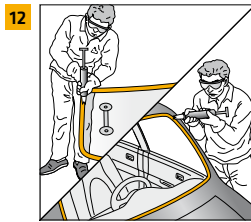
- 9 Clean the aperture using Sika® Cleaner G+P and activate the remaining bead with Sika® Aktivator PRO



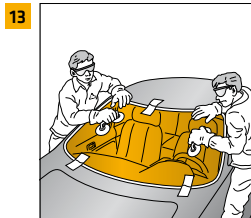
- 10 Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification



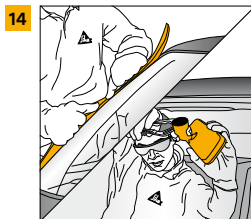
- 11 Open the cartridge or the unipack



- 12 Apply a triangular bead of adhesive either to the glass or the aperture



- 13 Place the windshield in position within the open time of the adhesive



- 14 Refit trims and mouldings



BONDING SURFACE

Float Glass and Ceramic coated Glass*
Bare Metal Scratch < 5 cm²
Bare Metal 5 cm² to 150 cm²
Intact OEM Paint
Repair Paint (after complete curing of paint)
PVC/RIM Encapsulation
Fresh Cut Bead
Pre-applied adhesive system
Polycarbonate**
PMMA**

BLACK PRIMERLESS PROCESS

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● = Sika® Primer-207 ● = Sika® Aktivator PRO

* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.