

Carlite



CARLITE AFTERMARKET INSTALLATION PROCEDURES FOR GLASS PARTS INSTALLED WITH URETHANE ADHESIVE

1. Remove all moldings, clips, windshield wipers, cowlings, screws, nuts, and bolts in the glass replacement area. (Note: Interior moldings and headliner should be left in place unless specific job conditions require removal.)
2. With a soft brush, vacuum or air hose, clean dirt and road debris from the pinchweld area before cutting out the windshield or other glass part and then again after it is cut out. This step minimizes later contamination of the urethane on the pinchweld to which the new adhesive is applied.
3. Cut the adhesive to remove the glass. Care must be taken to avoid scratching the pinchweld. Once the glass is removed from the opening, repeat step 2.
4. Dry fit the new part by centering it side-to-side and by adjusting setting blocks (if so equipped) to get the correct positioning of the part top to bottom. Make alignment marks with tape or non-staining grease pencil on both the glass and the vehicle body.
5. Trim the remaining urethane on the pinchweld using only the full cut method. In this method, most of the existing urethane is removed leaving a level bed around the entire pinchweld approximately 1/16" thick. Again, employ great care to avoid scratching the pinchweld.
6. Prime all pinchweld scratches with **the appropriate Pinchweld Primer depending on the approved adhesive system being used. Follow the manufacturer's recommended dry time for their primers.**
7. Clean the inside surface of the windshield paying particular attention to the ceramic paint area. Next, prep **and/or prime** the inner surface of the glass on the outer periphery of the ceramic paint **with the approved prep or primer depending on the adhesive system being used.** Be sure to duplicate the path of the preps, primers and urethane used on the original windshield. This is particularly important along the cowl side of the windshield where the path may not be along the outermost perimeter. **Always follow manufacturers' recommended instructions for appropriate dry time.**
8. Use new foam dam if the vehicle was originally equipped with one.
9. Apply a 1/2" to 5/8" high triangular bead of a Carlite authorized urethane to the pinchweld on top of the existing bed of urethane. The urethane may also be applied to the glass, but care must be taken to ensure that the location of the bead will match up with the existing urethane on the pinchweld. [Note: If the vehicle originally had a double bead of urethane along the windshield cowl, be sure to duplicate this.]
10. Install the windshield before urethane skins over.



11. Replace all moldings, clips, windshield wipers, cowling, screws, nuts and bolts removed at the beginning of the process. Test run the wipers after installation to ensure proper positioning. Adjust positioning if necessary.
12. Perform a leak test to ensure that the seal is complete. Ultrasonic or other methods may be employed.
13. Thoroughly clean both sides of the glass and vacuum all glass and other debris from the vehicle. Run the defrost air on high to blow out any glass fragments or other debris that may have dropped into the defroster ducts.
14. Allow all glass parts installed with urethane ample time to cure, taking into account temperature and humidity. (Refer to urethane manufacturer's "safe drive away" time recommendations and procedures for cold weather installations).
15. We recommend all Ford application glass replacements be "Ford" or "Carlite" trademarked (this is a requirement for Ford warranty work, Ford company cars, Hertz & Budget vehicles, and Red Carpet Lease vehicles before turn-in).

The following is a list of Carlite's approved urethanes:

ESSEX

- Essex U-216 Beta Seal Two-Part (Installation at 0 Deg + and a 1 hour cure)
- Essex 400 HV (Installation at 70 Deg & 50% Relative Humidity) with an 24 hour cure time
- Essex Preps & Primers: 401, 402 & 413 Pinchweld Primer

3M

- 3M Rapid Two-Part (RTP) (Installation at 45 Deg + and a 2 hour cure time)
- 3M Fast Cure One-Part (Installation at 70 Deg & 50% Relative Humidity) with an 8 hour cure time
- 3M Preps & Primers: 3M Degreaser, 3M Black Urethane Primer

SIKA

- p SikaTack - Plus Booster Two Part with Sika Aktivator (Installation at 30 Deg + and a 2 hour cure time)
- p Sika Preps & Primers: Sika Primer 206 G + P

TITAN

- p Titan 800EM (Installation at 70 Deg & 50% Relative Humidity) with 12 hour cure time.
- p Titan Preps & Primers: Titan GP60, WIP-40

NOTE: The only approved urethanes for Ford Warranty work are the Essex U-216 & 400HV

(Carlite is continuing to evaluate other urethane manufacturers to get their adhesive systems added to its list of approved adhesives for aftermarket use.)