

Component Procedures: Quarter Window Glass

Table of Contents

1. Quarter Window Replacement (Convertible) (Article 10271)
2. Quarter Window Replacement (Coupe) (Article 10272)
3. Quarter Window Replacement - Brazil (Article 10270)

Component Procedures: Quarter Window Glass

Quarter Window Replacement (Convertible) (Article 10271)

Callout Component Name

Warning: Refer to Glass and Sheet Metal Handling Warning . Preliminary Procedure Remove the quarter window reveal molding. Refer to Quarter Window Reveal Molding Replacement . Remove the weatherstrip from the upper pinchweld flange only. Refer to Front Side Door Weatherstrip Replacement - Body Side . Remove the quarter trim panel insert. Refer to Quarter Trim Panel Insert Replacement .

Preliminary Procedure

- Remove the quarter window reveal molding. Refer to Quarter Window Reveal Molding Replacement .
- Remove the weatherstrip from the upper pinchweld flange only. Refer to Front Side Door Weatherstrip Replacement - Body Side .

- Remove the quarter trim panel insert. Refer to Quarter Trim Panel Insert Replacement .

1 Quarter Window Nut (Qty: 2) Caution: Refer to Fastener Caution . Tighten 10 Nm (89 lb in)

10 Nm (89 lb in)

2 Quarter Window Note: Place the window on a clean dry surface.

Quarter Window Replacement (Coupe) (Article 10272)

Special Tools

- BO-24402-A - Glass Sealant Remover (Cold Knife) .
- BO-39032 - Stationary Glass Removal Tool , or equivalent in order to remove the window.
- Use a urethane adhesive systems which meet GM Specification GM 3651G

For equivalent regional tools, refer to Special Tools

Removal Procedure

- Remove the rear quarter upper trim. Refer to Quarter Upper Trim Panel Replacement .

- Cover to protect the following parts from broken glass:

- Upper dash pad
- Defroster outlets and A/C outlets
- Seats and carpeting

- Carefully cut around the inside of the quarter modular window to expose the urethane adhesive bead. Use care not to damage the retainers. If the retainer get damaged it will be necessary to use mask tape to tape it in place while curing.

- Keep the cutting edge of the tool against the inside of the window. This will allow the urethane adhesive to be separated from the window.

- Leave a base of urethane on the pinch-weld flange.

- The only suitable lubrication is clear water.

- Remove the quarter modular window (1) from the pinch-weld flange. Click for full-size image

Installation Procedure

- Install the quarter modular window into the opening. Refer to Adhesive Installation of Bodyside Stationary Windows .

- Install the rear quarter upper trim panel. Refer to Quarter Upper Trim Panel Replacement .

- Remove the double layer of masking tape around the perimeter of the painted surfaces and the interior trim.

Quarter Window Replacement - Brazil (Article 10270)

Special Tools

- S-0201964 - Bonded, Glass Removing Device
- Glass Handling Suction Cups

- Use an auto-adhesive that is approved by GM

For equivalent regional tools, refer to Special Tools .

Removal Procedure

- Remove the quarter window from the auto-adhesive as follows:

- Leave a base of auto-auto-adhesive approximately 2 mm (0.078 in) on the pinch-weld flange.

- The only suitable lubrication is clear water.

- Use S-0201964 - Bonded, Glass Removing Device .

- Protect the following parts from broken glass, seats and carpeting.

- Start the cut between the quarter and the "B" pillar.

- Do this from inside the vehicle, insert the tool S-0201964 - Bonded, Glass Removing Device (1) between the quarter and the "B" pillar, thus perforating the adhesive.

- Move the cutting wire along the outside edge of the window.

- Remove the tool S-0201964 - Bonded, Glass Removing Device .
- Do this from inside the vehicle, install the cutting wire special tool S-0201964 - Bonded, Glass Removing Device (1).
- Do this from outside the vehicle, install the cutting wire special tool S-0201964 - Bonded, Glass Removing Device (2).
- With an assistant, use the special tool S-0201964 - Bonded, Glass Removing Device (1) to hold the cutting wire, pull it starting from the outside, back and forth releasing the window from the adhesive.
- While cutting the window reposition the cutting wire and special tools, so as to cut the adhesive along the window completely.
- Remove the window (1) from the vehicle. Click for full-size image
- Installation Procedure
- If reusing or replacing the window, use the appropriate tool, remove the auto-adhesive bead on the window surface and pinch-weld flange to approximately 2 mm (0.078 in).
- Clean the bonding area on the window. Click for full-size image
- Apply bonded-glass primer and let dry per auto-adhesive instructions by the manufacturer's. Click for full-size image
- Apply the auto-adhesive primer-application (2) around the perimeter of the rear window (1) and let dry per auto-adhesive instructions by the manufacturer's. Click for full-size image
- Cut the applicator nozzle to provided a V cut to apply the auto-adhesive. Click for full-size image
- Gently press the quarter window into the auto-adhesive bead until it fully seats evenly in the open.
- Use masking tape to hold the window in the position until the auto-adhesive completely cures.
- Make sure to observe the auto-adhesive curing time before releasing the vehicle per auto-adhesive instructions by the manufacturer's.
- Remove the double layer of masking tape around the perimeter of the painted surfaces and the interior trim.
- Use a soft spray of warm water in order to immediately water test the window.
- Inspect the window for leaks.
- If any leaks are found, use a plastic paddle in order to apply extra auto-adhesive at the leak point.
- Retest the window for leaks.
- Maintain the following conditions in order to properly cure the auto-adhesive:
- Partially lower a door window in order to prevent pressure buildups when closing doors before the auto-adhesive cures.
- Do not drive the vehicle until the auto-adhesive is cured. Refer to the above curing times.
- Do not use compressed air in order to dry the auto-adhesive.
- Clean any excess auto-adhesive from the body. Click for full-size image