

# **Component Procedures: Back Window Glass**

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# Component Procedures: Back Window Glass

## Rear Window Replacement (Article 10274)

### 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

- Open the rear compartment lid.
- Remove the rear window lower seal.
- Disconnect the rear window defogger electrical connectors.
- Cover to protect the following parts from broken glass:
  - Upper dash pad
  - Defroster outlets and A/C outlets
  - Seats and carpeting
- Using the appropriate tool, carefully cut around the lace, start in the center working from side to side of the window to access the urethane adhesive bead, if equipped.
- This will allow the urethane adhesive to be separated from the window. [Click for full-size image](#)
- Leave a base of urethane on the pinchweld flange.
- The only suitable lubrication is clear water.
- With the aid of an assistant lift the rear window (1) from the opening. [Click for full-size image](#)

### Installation Procedure

- Install the rear window into the opening. Refer to Adhesive Installation of Rear Windows .
- Install the rear window lower seal.
- Connect the rear window defogger electrical connectors.
- Close the rear compartment lid.
- Remove the double layer of masking tape around the perimeter of the painted surfaces and the interior trim.

## Rear Window Replacement - Brazil (Article 10276)

### Special Tools

- S-0201964 - Bonded, Glass Removing Device
- Glass Handling Suction Cups
- Use an adhesive that is approved by GM

For equivalent regional tools, refer to Special Tools .

### Removal Procedure

- Open the rear compartment lid.
- Remove the sealing strip from the lower edge of the rear window .
- Disconnect the electrical connectors from the rear window defogger bus bar.
- Disconnect the connector from the radio antenna module.
- Lower the rear edge of the headliner this will allow the special tool S-0201964 - Bonded, Glass Removing Device to cut across the top of the window and not damage the headliner edge.
- Protect the following parts from broken glass, seats and carpeting.
- Remove the rear window from the auto-adhesive as follows:
  - Leave a base of urethane 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 .
- Using the appropriate tool, carefully cut around the lace (1), start in the center working from side to side of the window to access the urethane adhesive bead, if equipped. [Click for full-size image](#)
- Start the cut between the center of the rear window and the roof.
- Do this from inside the vehicle, insert the tool S-0201964 - Bonded, Glass Removing Device (1) between the center of the rear window and the roof, 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 .
- 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 rear window from the vehicle with an assistant, use the glass handling suction cups. 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) 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
- Install the sealing strip to the bottom of the rear window.
- With an assistant, use the glass handling cups, align the window locating pins to the slots located in each corner of the pinch-weld flange. Lower the window to touch the auto-adhesive. Click for full-size image
- Remove the glass handling cups.
- Gently depress the window on the auto-adhesive bead until the window is seated 1 mm (0.039 in) below the roof. Click for full-size image
- Use masking tape (1) to hold the window (2) in the position until the auto-adhesive completely cures. Click for full-size image
- Connect the rear window defogger electrical connectors to the bus bars.
- Connect the connector from the radio antenna module.
- Install the rear edge of the headliner.
- 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. Click for full-size image
- 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
- Close the rear compartment lid.
- Ensure that the electrical components are working properly.

### **Adhesive Installation of Rear Windows (Article 10258)**

- Use a urethane adhesive systems which meet GM Specification GM 3651G
- Remove all mounds or loose pieces of urethane adhesive from the pinch-weld area.
- If the original window is being reused, remove all but approximately 2 mm (3/64 in) of the existing bead of urethane adhesive from the pinch-weld flange by using a clean utility knife or razor blade scraper.
- Inspect for any of the following problems in order to help prevent future breakage of the window:
- High weld
- Solder spots on the pinchweld
- Hardened sealer
- Any other obstruction or irregularity in the pinch-weld flange
- After repairing the opening as indicated, perform the following steps:
- Remove all traces of broken glass from the outer cowl panel, seats, floor and defroster ducts.
- Clean around the edge of the inside surface of the window with a 50/50 mixture of isopropyl alcohol and water by volume on a dampened lint free cloth.
- Verify all primers and urethane adhesive are within expiration dates.
- Shake the pinch-weld primer black #3 for at least 1 minute.
- Use a new dauber in order to apply the primer to the surface of the pinch-weld flange.
- Allow the pinch-weld primer to dry for approximately 10 minutes.
- With the aid of an assistant, dry fit the window to the opening in order to determine the correct position.
- Use masking tape in order to mark the locations (1) of the window (2) in the opening. Click for full-size

image

- Cut the masking tape in the center and remove the window from the opening.
- Use a new dauber in order to apply glass prep clear #1 to the area approximately 10–16 mm (3/8–5/8 in) around the entire perimeter of the window inner surface. Immediately wipe the glass primed area using a clean, lint-free cloth. [Click for full-size image](#)
- Apply a second coat of the glass prep clear #1 to the same area of the glass. [Click for full-size image](#)
- Shake the glass primer black #2 for at least 1 minute. [Click for full-size image](#)
- Use a new dauber in order to apply the glass primer black #2 to the same areas (2) that glass prep clear #1 was applied.
- Allow the glass primer to dry for approximately 10 minutes.
- Cut the applicator nozzle in order to provide a bead of 8 mm (0.316 in) wide and 12.7 mm (1/2 in) high. [Click for full-size image](#)
- Use a cartridge-type caulking gun in order to apply a smooth, continuous bead of urethane adhesive. [Click for full-size image](#)
- Use the edge of the window as a guide for the nozzle in order to apply the urethane adhesive (1) to the inner surface of the window (3). [Click for full-size image](#)
- With an assistant, align the window (1) and locator pins (2) to the locator slots in each corner of the upper pinch-weld flange, set the window (1) in place. [Click for full-size image](#)
- Align the masking tape (1) lines on the window (2) and the body. [Click for full-size image](#)
- Press the window firmly into place, 1 mm (0.039 in) below surface. [Click for full-size image](#)
- Tape the window to the body in order to minimize movement until the urethane adhesive cures.
- Clean any excess urethane adhesive from the body. [Click for full-size image](#)
- Use a soft spray of warm water in order to immediately water test the window. [Click for full-size image](#)
- Inspect the window for leaks.
- If any leaks are found, use a plastic paddle in order to apply extra urethane adhesive at the leak point.
- Retest the window for leaks.
- For the moisture-curing type of urethane adhesive, allow a minimum of 6 hours at 21°C (70°F) or greater and with at least 30 percent relative humidity. Allow at least 24 hours for the complete curing of the urethane adhesive.
- For the chemical-curing type of urethane adhesive, allow a minimum of 1 hour .
- Maintain the following conditions in order to properly cure the urethane adhesive:
- Partially lower a door window in order to prevent pressure buildups when closing doors before the urethane adhesive cures.
- Do not drive the vehicle until the urethane adhesive is cured. Refer to the above curing times.
- Do not use compressed air in order to dry the urethane adhesive.
- Complete the window installation.

## **All Technical Service Bulletins (itype\_100)**

Tsbs

- Body - Broken Rear Window Defogger Grid Detection (04-08-48-001D, 2012/04/17)

## **Customer Interest Bulletins (itype\_109)**

Tsbs

- Body - Broken Rear Window Defogger Grid Detection (04-08-48-001D, 2012/04/17)