

Component Procedures: Windshield

Table of Contents

1. Windshield Replacement (Article 10282)
2. Windshield Replacement - Brazil (Article 10283)
3. Windshield Frame Weatherstrip Replacement (Article 10280)
4. Windshield Frame Weatherstrip Retainer Replacement (Article 10281)
5. Adhesive Installation of Windshields (Article 10260)
6. All New Technical Service Bulletins (itype_432)
7. All Technical Service Bulletins (itype_100)
8. Repair Tips (itype_110)
9. Warranty Information (itype_119)

Component Procedures: Windshield

Windshield Replacement (Article 10282)

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 hood.
- Remove the windshield wiper arms. Refer to Windshield Wiper Arm Replacement .
- Remove the air inlet grille. Refer to Air Inlet Grille Panel Replacement .
- Remove the inside rearview mirror. Refer to Inside Rearview Mirror Replacement .
- Remove the remote control door receiver antenna. Refer to Remote Function Actuator Module Replacement .
- Cover to protect the following parts from broken glass:
- The upper dash pad
- The defroster outlets and A/C outlets
- The seats and carpeting
- Remove the lower windshield supports from the cowl panel, if equipped.
- 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](#)
- This will allow the urethane adhesive to be separated from the windshield. [Click for full-size image](#)
- Leave a base of urethane on the pinchweld flange.
- The only suitable lubrication is clear water.
- Remove the windshield (1) from the vehicle with the aid of an assistant (2). [Click for full-size image](#)

Installation Procedure

- Install a stationary window into the opening. Refer to Adhesive Installation of Windshields .
- Install the remote control door receiver antenna. Refer to Remote Function Actuator Module Replacement .
- Install the inside rearview mirror. Refer to Inside Rearview Mirror Replacement .
- Install the air inlet grille. Refer to Air Inlet Grille Panel Replacement .
- Install the windshield wiper arms. Refer to Windshield Wiper Arm Replacement .
- Close the hood.
- Remove the double layer of masking tape from around the perimeter of the painted surfaces and the interior trim.

Windshield Replacement - Brazil (Article 10283)

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 hood.
- Remove the windshield wiper arms and blades. Refer to Windshield Wiper Arm Replacement .
- Remove the air inlet grille. Refer to Air Inlet Grille Panel Replacement .
- Remove the windshield side garnish moldings. Refer to Windshield Side Garnish Molding Replacement .
- Remove the sunshades. Refer to Sunshade Replacement .
- Remove the inside rearview mirror. Refer to Inside Rearview Mirror Replacement .
- Lower the front 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.
- Cover the following parts to protect from broken glass:
- Upper dash pad
- Defroster outlets and A/C outlets
- Seats and carpeting
- 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](#)
- Remove the 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 .

- Start the cut between the center of the windshield and the "A" pillar.
- Do this from inside the vehicle, insert the tool S-0201964 - Bonded, Glass Removing Device (1) between the "A" pillar and the windshield, 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 windshield 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 of 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](#)
- With an assistant, use the glass handling cups, align the windshield locating pins to the slots located in each corner of the pinch-weld flange. Lower the windshield to touch the auto-adhesive. [Click for full-size image](#)
- Remove the glass handling cups.
- Gently depress the windshield on the auto-adhesive bead until the windshield 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](#)
- Make sure to observe the auto- adhesive curing time before releasing the vehicle per auto- 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 windshield. [Click for full-size image](#)
- Inspect the windshield for leaks.
- If any leaks are found, use a plastic paddle in order to apply extra auto-adhesive at the leak point.
- Retest the windshield for leaks.
- Maintain the following conditions in order to properly cure the auto-adhesive:
- Partially lower a door windshield in order to prevent pressure buildups when closing doors before the auto-adhesive cures.
- 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](#)
- Install the air inlet grille. Refer to [Air Inlet Grille Panel Replacement](#) .
- Install the windshield wipers arms and blades. Refer to [Windshield Wiper Arm Replacement](#) .
- Install the windshield side garnish moldings. Refer to [Windshield Side Garnish Molding Replacement](#) .
- Install front edge of the headliner.
- Install the sunshades. Refer to [Sunshade Replacement](#) .
- Install the inside rearview mirror. Refer to [Inside Rearview Mirror Replacement](#) .
- Ensure that all electrical components operate properly.
- Close the hood.

Windshield Frame Weatherstrip Replacement (Article 10280)

Callout Component Name

Preliminary Procedures Place the folding top in the full down position. Remove the left and right side windshield side garnish molding. Refer to [Windshield Side Garnish Molding Replacement](#) .

Preliminary Procedures

- Place the folding top in the full down position.
- Remove the left and right side windshield side garnish molding. Refer to [Windshield Side Garnish Molding](#)

Replacement .

1 Windshield Frame Weatherstrip Retainer (Qty: 2) Procedure Remove the windshield frame weatherstrip retainers located in the left and right ends of the weatherstrip.

Procedure

Remove the windshield frame weatherstrip retainers located in the left and right ends of the weatherstrip.

2 Windshield Frame Weatherstrip Nut (Qty: 2) Caution: Refer to Fastener Caution . Tighten 10 Nm (89 lb in) 10 Nm (89 lb in)

3 Windshield Frame Weatherstrip Procedure Remove the weatherstrip from the windshield frame channel, full the weatherstrip gently to disengage the foam adhesive tape. Use a solution of 50/50 isopropyl alcohol and water to clean the adhesive surface. The upper inner part of the weatherstrip lip must be over the header garnish molding for a good seal. Tip: Water test the vehicle to ensure no leaks.

- Remove the weatherstrip from the windshield frame channel, full the weatherstrip gently to disengage the foam adhesive tape.

- Use a solution of 50/50 isopropyl alcohol and water to clean the adhesive surface.

- The upper inner part of the weatherstrip lip must be over the header garnish molding for a good seal.

Windshield Frame Weatherstrip Retainer Replacement (Article 10281)

Callout Component Name

1 Windshield Frame Weatherstrip Retainer Screw (Qty: 3) Procedure Open the folding top to the full open position. Remove the windshield frame weatherstrip. Refer to Windshield Frame Weatherstrip Replacement . Tip:

No trim needs to be removed to replace the weatherstrip retainer. Start at the left pillar and pull the weatherstrip up and out of the retainer across to the right side. When installing use a plastic tool to insert the weatherstrip into the retainer.

Procedure

- Open the folding top to the full open position.

- Remove the windshield frame weatherstrip. Refer to Windshield Frame Weatherstrip Replacement .

2 Windshield Frame Weatherstrip Retainer Tip: Water test the vehicle to ensure no leaks.

Adhesive Installation of Windshields (Article 10260)

- 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 (1) to the opening in order to determine the correct position. Click for full-size image

- 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
- Align the masking tape (1) lines on the window (2) and the body. Click for full-size image
- Press the window firmly into place. 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 New Technical Service Bulletins (itype_432)

Tsbs

- Rear and Side Tempered Glass Spots (Quench Marks) (25-NA-311, 2025/09/30)

All Technical Service Bulletins (itype_100)

Tsbs

- Rear and Side Tempered Glass Spots (Quench Marks) (25-NA-311, 2025/09/30)
- Warranty Administration – Guidelines for Claiming 2020380 – Windshield Replacement (05-08-48-001D, 2014/02/10)
- Mirrors - Inside Mirror Loose/Bracket Fell Off (PI1290, 2014/08/07)

Repair Tips (itype_110)

Tsbs

- Mirrors - Inside Mirror Loose/Bracket Fell Off (PI1290, 2014/08/07)

Warranty Information (itype_119)

Tsbs

- Warranty Administration – Guidelines for Claiming 2020380 – Windshield Replacement (05-08-48-001D, 2014/02/10)