

Component Procedures: Window Glass

Table of Contents

1. Adhesive Installation of Bodyside Stationary Windows (Article 10257)
2. All New Technical Service Bulletins (itype_432)
3. All Technical Service Bulletins (itype_100)
4. Customer Interest Bulletins (itype_109)
5. Repair Tips (itype_110)
6. OEM Policies and Procedures (itype_120)

Component Procedures: Window Glass

Adhesive Installation of Bodyside Stationary Windows (Article 10257)

- 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 of the window in the opening.
 - 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 lines on the window and the body.
 - 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

- Information on Glass Ultraviolet (UV) Ray Protection and Tint Percentage (21-NA-152, 2021/06/28)
- Body - Broken Rear Window Defogger Grid Detection (04-08-48-001D, 2012/04/17)
- Information on Side Window Glass Not Clearing Molding When Indexing Down During Door Opening (09-08-64-014E, 2023/10/12)
- Rear and Side Tempered Glass Spots (Quench Marks) (25-NA-311, 2025/09/30)
- Information on Side Door Window Glass Chipping Caused by Hanging Vehicle Key Lock Box (06-08-64-001D, 2016/11/10)
- Body - Front/Rear Side Door Windows Bind/Noisy/Move Slowly (PI0018B, 2013/11/08)

Customer Interest Bulletins (itype_109)

Tsbs

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

Repair Tips (itype_110)

Tsbs

- Body - Front/Rear Side Door Windows Bind/Noisy/Move Slowly (PI0018B, 2013/11/08)

OEM Policies and Procedures (itype_120)

Tsbs

- Information on Glass Ultraviolet (UV) Ray Protection and Tint Percentage (21-NA-152, 2021/06/28)
- Information on Side Door Window Glass Chipping Caused by Hanging Vehicle Key Lock Box (06-08-64-001D, 2016/11/10)