

## Ford/Lincoln® Carlite® by Carlex™

### GENERAL INDUSTRY GUIDELINES AND PROCEDURES FOR REMOVAL AND REPLACEMENT OF GLASS PARTS INSTALLED WITH URETHANE ADHESIVE (1)

- 1 Remove all moldings, clips, windshield wipers, cowling, 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 or locating pins (if so equipped) to get the correct positioning of the part top to bottom and side to side. 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 pinch weld primer depending on the 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 appropriate 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. Note: For Ford/Lincoln OEM parts the foam dam comes with the windshield.
- 9 Apply a 1/2" to 5/8" high triangular bead of 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 From time of full cut method (step 5) new part must be installed in less than 2 hours.
- 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 Must use Ford/Lincoln OEM glass as replacements - OEM only\*

1) For vehicle specific information see the Ford Workshop Manuals at [Motorcraftparts.com](http://Motorcraftparts.com)

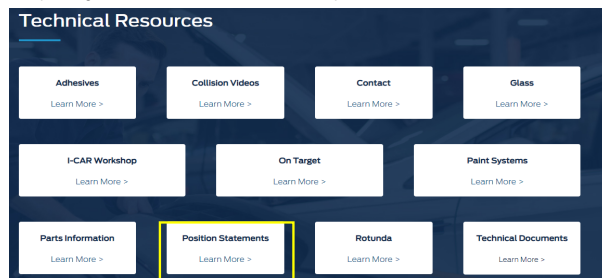
ADAS - Ford IPMA Procedure 419-07, can be purchased from [Motorcraftparts.com](http://Motorcraftparts.com)

HUD calibration - Follow Ford HUD module Calibration procedure 419-03\*\*

- 1 Ford Equipment to be used in all applications that require calibration
- 2 Carlex offers training if needed (Contact Customer Service or your Regional Sales Manager)
- 3 Pre and Post scans are required and copies of these documents must be kept for 3 years
- 4 Also visit the Carlex website for the latest training videos for ADAS and also review videos from Ford that support use of OEM glass

\*See Ford Motor Company positions statements for glass at [Fordcrashparts.com](http://Fordcrashparts.com) look under "Position Statements"

\*\*Proper targets and tool for HUD vehicle are required.



## Ford Collision Repair Position Statements

